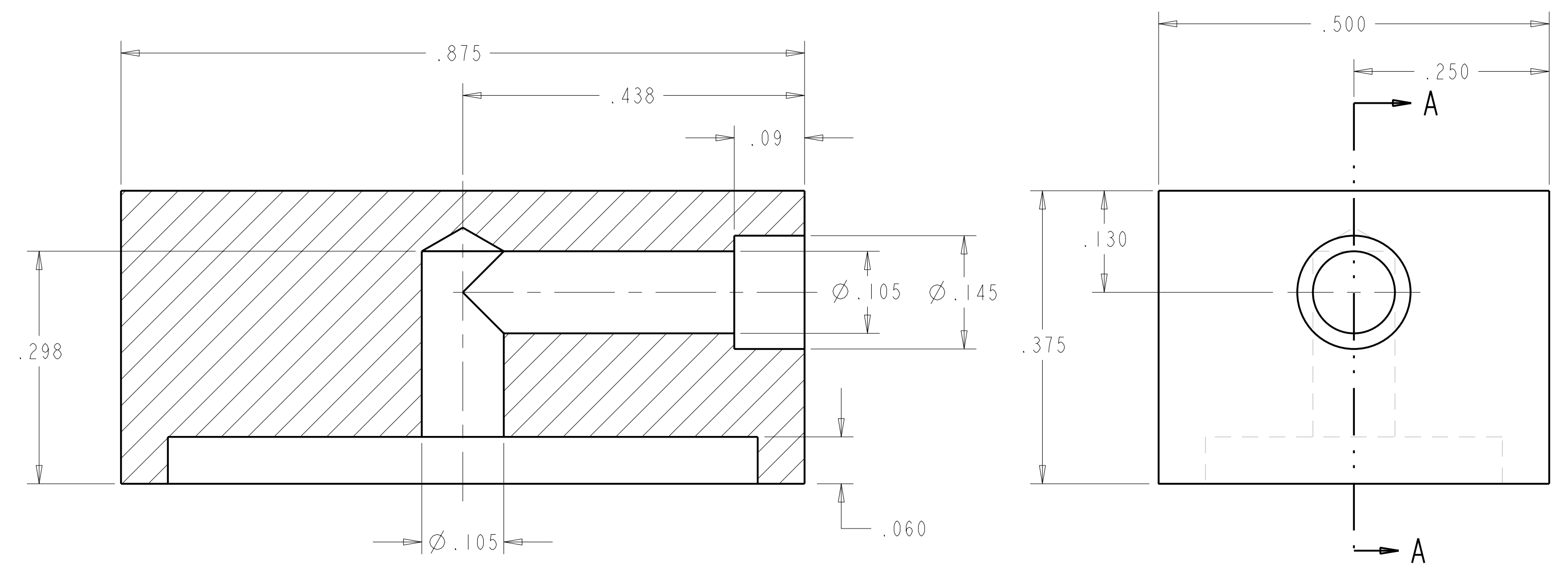
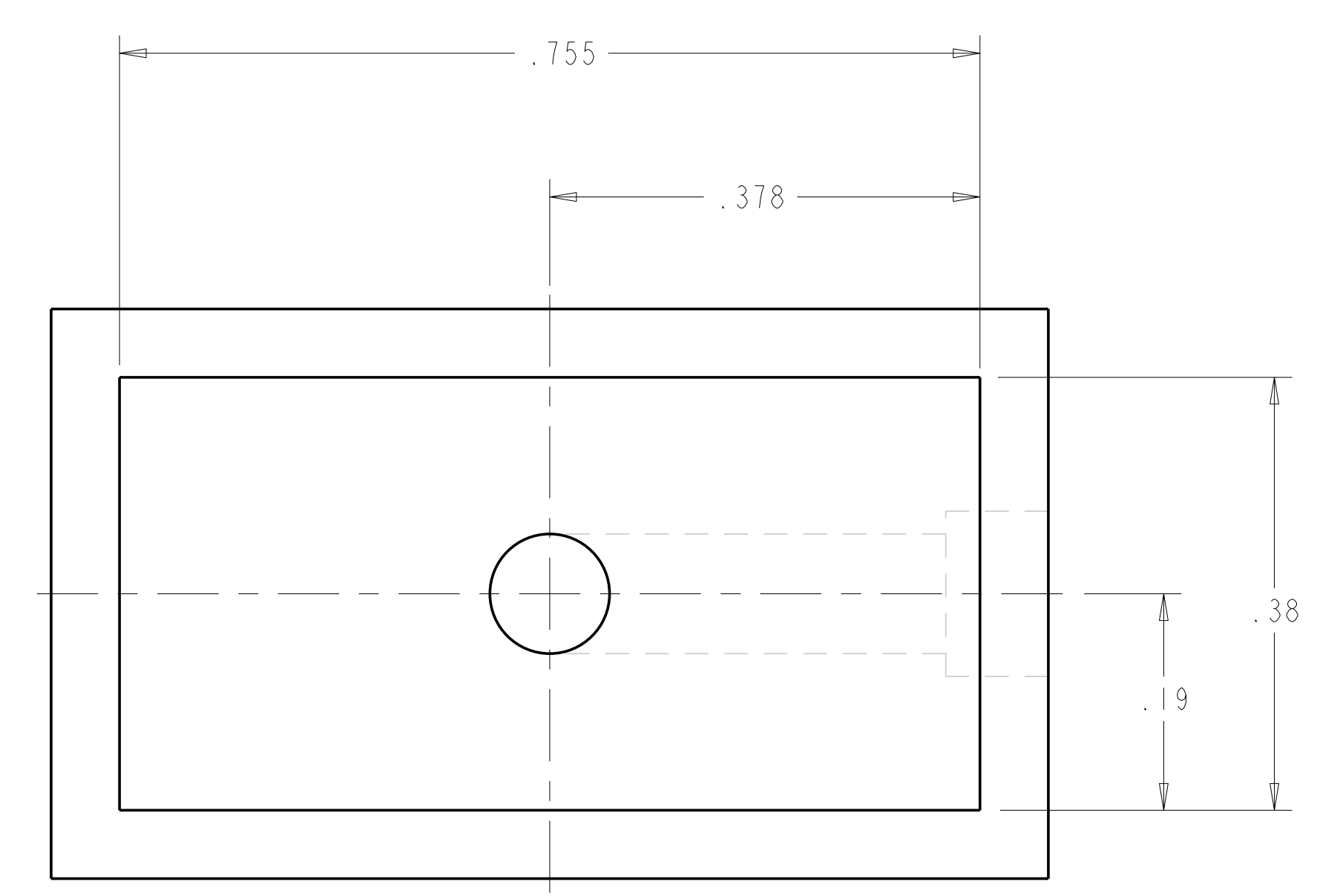


- NOTES:
1. INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M.
 2. DIMENSION ARE IN INCHES.
 3. REQUIREMENTS FOR FABRICATING THE VACUUM VESSEL SPACER SPACER ARE DEFINED IN THE DRAWINGS, MODELS, AND SPECIFICATION.
 4. GEOMETRY OF VACUUM VESSEL SPACER FLANGE IS DEFINED IN CAD MODELS/FILES SEI21-016.PRT.
 - 5 MEASURE AND MACHINE TO FIT AT ASSEMBLY, SEI20-014.
 6. ADDITIONAL TOLERANCE LIMITS ARE DEFINED IN DOCUMENT NCSX-12-122002-PH.



SECTION A-A
SCALE 8:000



(I)

next assy	AR	CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
SEI20-XXX	-I			LEAK TEST BLOCK			
				NEXT ASSEMBLY			

QV CLAUSE	DOCUMENTS REQUIRED	APPLICABLE TO PART NO *
30.3	MATERIAL MILL TEST REPORT	
32.5	MATERIAL SELLER CERT	X
32.6	SPECTRUM MATERIAL INSPECTION REPORT	X
30.5	MANUFACTURING INSPECTION AND TEST PLAN	X
31.2	FIELD INSPECTION AND TEST PLAN	X
32.1	WELD AND BRAZE INSPECTION REPORT	X
32.2	WELD TEST REPORT (NICKER)	X
31.0	LEAK TEST REPORT	X
31.5	CLEANING CERT	X
31.8	DEVIATION REQUEST	X
31.9	NONCONFORMANCE REPORT	X
32.3	DIMENSIONAL REPORT	X
33.0	FUNCTIONAL TEST REPORT	
100	DOCUMENTATION	X

SCALE NOTED	DES: P. L. GORANSON 8/03 DRW: G. H. JONES 8/03	UT-BATTELLE Oak Ridge National Laboratory managed for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT contract DE-AC05-00OR22725 UT-BATTELLE, LLC. Oak Ridge, Tennessee
FRACTIONS	CHK: [] SECT: [] DEPT: []	NATIONAL COMPACT STELLERATOR EXPERIMENT
XX DECIMALS ± .01	PPPL DRFT	VACUUM VESSEL LEAK TEST BLOCK
XXX DECIMALS ± .005		VERSION NO. [] PLANT [] BLDG [] FL [] SHT OF [] TYPE [] CLASS []
ANGLES ± 0°15'		RELEASE LEVEL []
BREAK SHARP EDGES .06 MAX		SEI22-105
FINISH .125 UNLESS OTHERWISE SPECIFIED		REV U

REV	DESCRIPTION	DATE

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