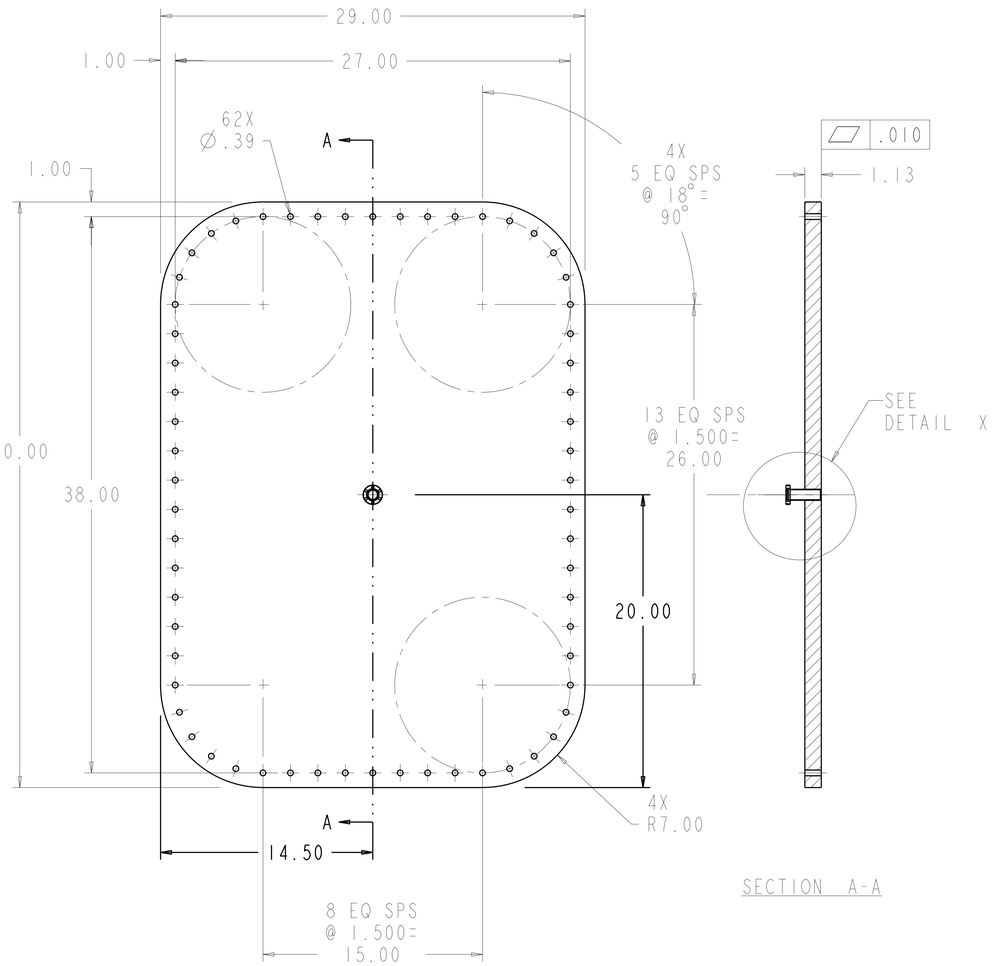
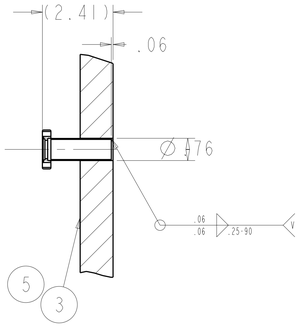
NOTES:
1. INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M.
2. DIMENSION ARE IN INCHES.
3. REQUIREMENTS FOR FABRICATING THE VACUUM VESSEL SPACER SPACER ARE DEFINED IN THE DRAWINGS, MODELS, AND SPECIFICATION.
4. GEOMETRY OF VACUUM VESSEL SPACER FLANGE IS DEFINED IN CAD MODELS/FILES SE121-016.PRT.
5. MEASURE AND MACHINE TO FIT AT ASSEMBLY, SE120-014.
6. ADDITIONAL TOLERANCE LIMITS ARE DEFINED IN DOCUMENT NCSX-I2-I22002-PH.



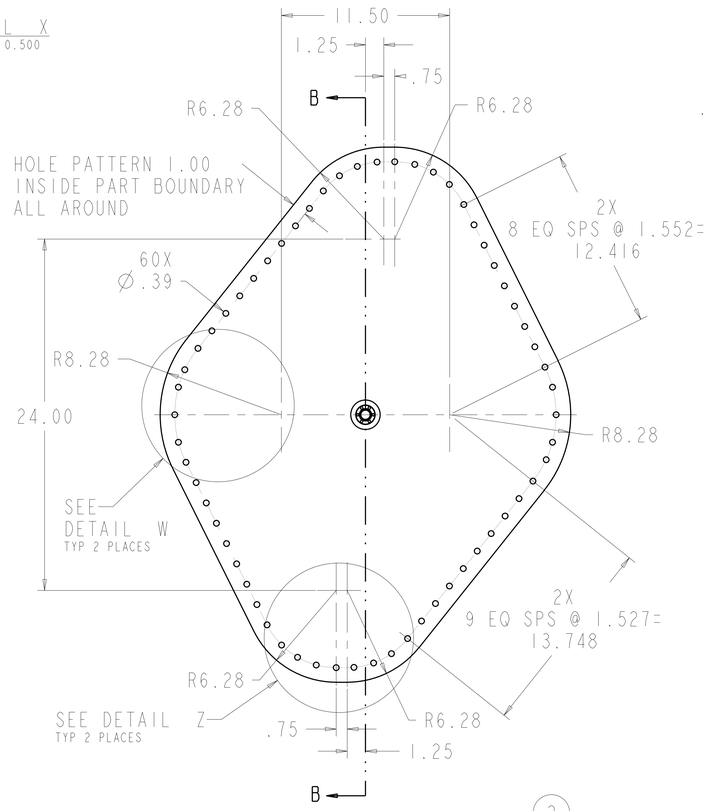
1

SCALE: .25

SECTION A-A



DETAIL X
SCALE 0.500



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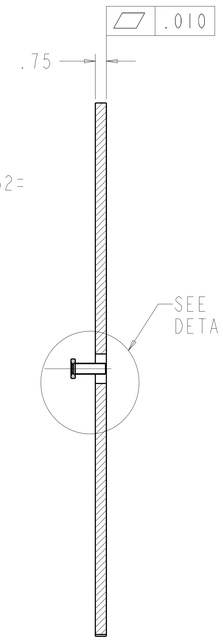
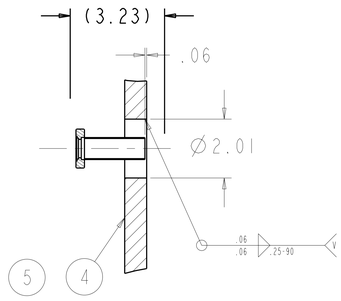
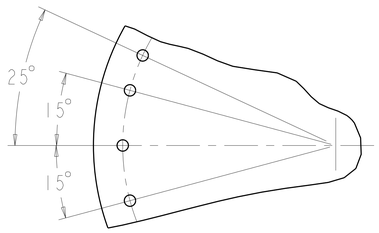
SCALE: .25

SECTION B-B

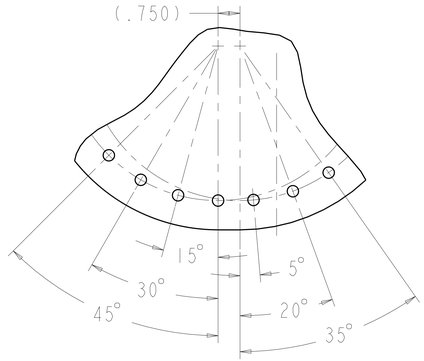




DETAIL Y
SCALE 0.500



DETAIL W
SCALE 0.500



DETAIL Z
SCALE 0.500

next assy				CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
		AR	AR		-6	WELD FILLER METAL			6
		1	1		-5	2 INCH HALF NIPPLE CONFLAT FLANGE			5
		1			-4	NB PORT COVER TEST FLANGE			4
			1		-3	PORT 4A COVER TEST FLANGE			3
	AR	X			-2	NB PORT COVER TEST FLANGE WELDMENT			2
	AR		X		-1	PORT 4A COVER TEST FLANGE WELDMENT			1
SE120-XXX	-2	-1		← NEXT ASSEMBLY		PARTS LIST			

QUALITY VERIFICATION
MECHANICAL AND STRUCTURAL
REFERENCE ORNL QA-605

QV CLAUSE	DOCUMENTS REQUIRED	APPLICABLE TO PART NO ▾
303	MATERIAL MILL TEST REPORT	
325	MATERIAL SELLER CERT	X
326	SPECIAL MATERIAL INSPECTION REPORT	
205	MANUFACTURING, INSPECTION, AND TEST PLAN	X
312	FIELD INSPECTION AND TEST PLAN	X
321	WELD AND BRAZE INSPECTION REPORT	X
322	HEAT TREAT REPORT (MICHARET)	
310	LEAK TEST REPORT	X
315	CLEANING CERT	X
318	DEVIATION REQUEST	X
319	NONCONFORMANCE REPORT	X
323	DIMENSIONAL REPORT	X
330	FUNCTIONAL TEST REPORT	
100	DOCUMENTTION	X

▾ SYMBOL X INDICATES APPLICABLE TO ALL PARTS OR ITEMS

QA COORDINATOR ..... DATE .....

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P THIS DRAWING PRODUCED ON PRO-ENGINEER

REV | ORNL | QA

SCALE NOTED
TOLERANCES UNLESS OTHERWISE SPECIFIED

FRACTIONS	.
XX DECIMALS	±.01
XXX DECIMALS	±.005
ANGLES	±0°15'
BREAK SHARP EDGES	.06 MAX
FINISH	125 UNLESS OTHERWISE SPECIFIED

DES	P. L. GORANSON	8/03
DRW	G.H. JONES	8/03
CHK		
SECT		
DEPT		
PE		
CR		
PJ		
REQ		
PPPL DRFT		

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UT-BATTELLE, LLC. Oak Ridge, Tennessee

PROJECT NAME
NATIONAL COMPACT STELLERATOR EXPERIMENT

VACUUM VESSEL
PORT COVER TEST FLANGE
WELDMENT

VERSION NO.	PLANT	BLDG	FL	SHT	OF	TYPE	CLASS
▪▪▪	XX	XX	XX	1	1	XX	U

RELEASE LEVEL ▪▪▪ | SE122-172 | REV A

SE122-172