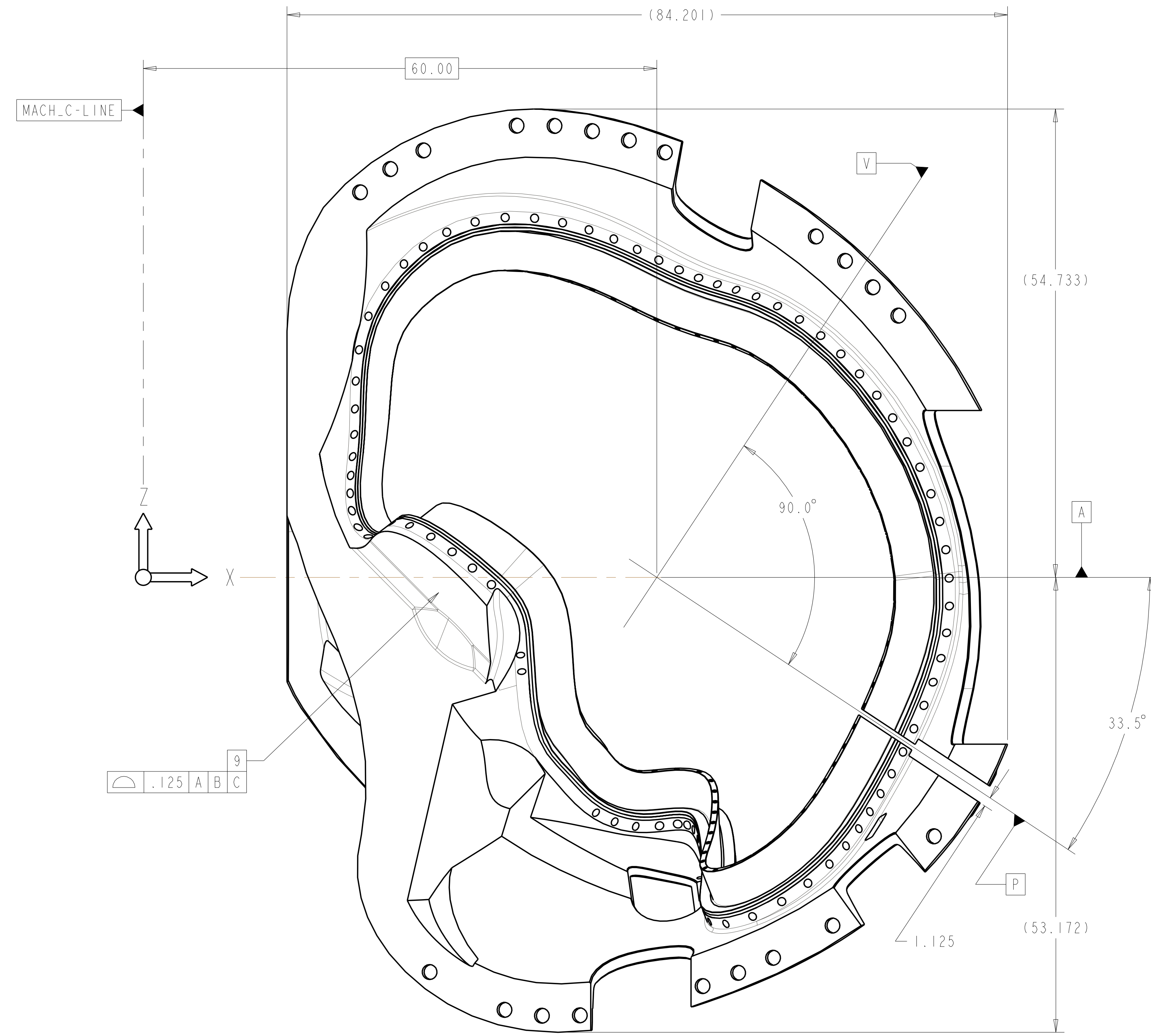
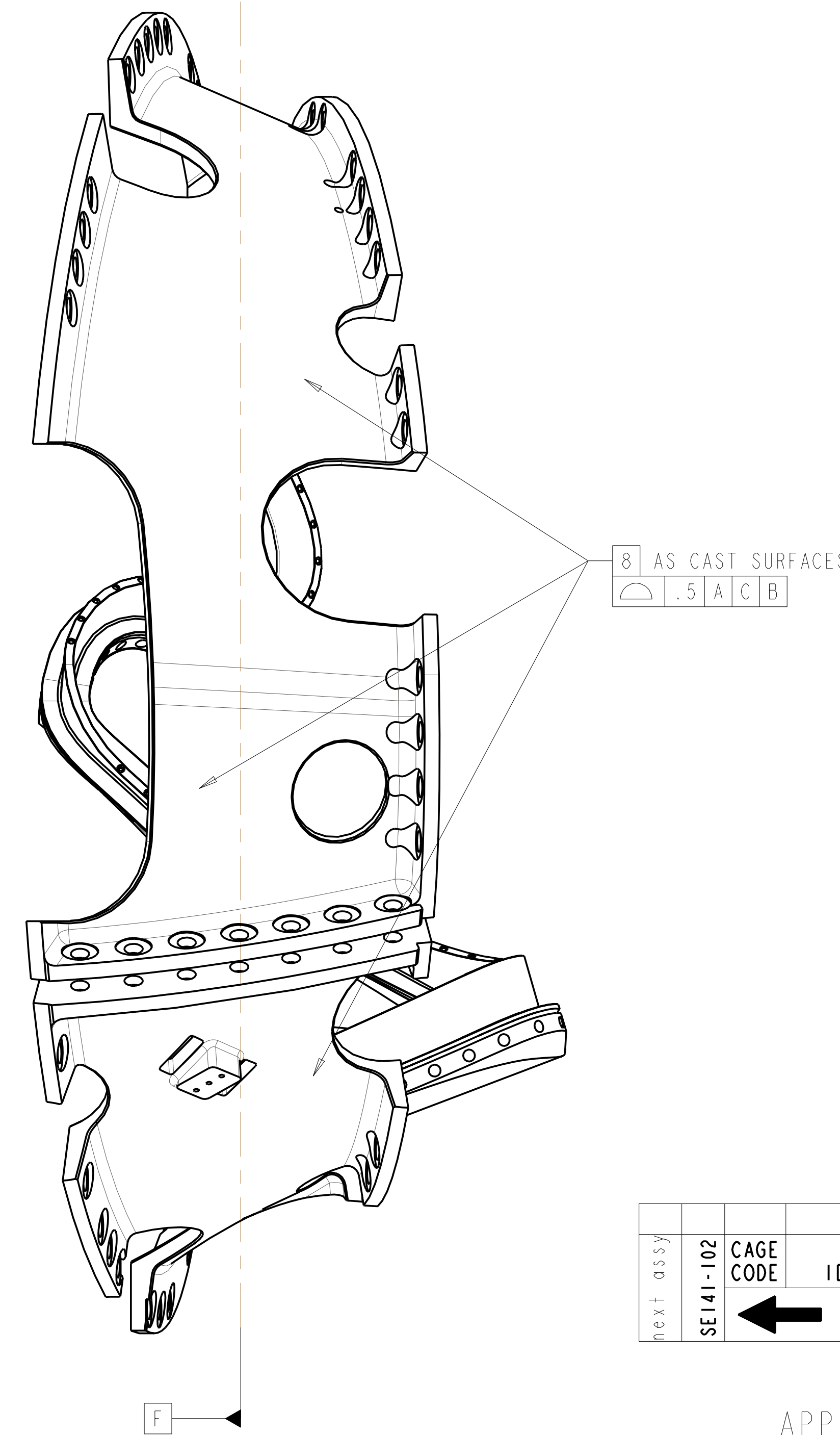


ISOMETRIC VIEW



DATUM PLANE A = PLANE THRU "XY"
 DATUM PLANE B = PLANE THRU "YZ"
 DATUM PLANE C = PLANE THRU "XZ"



NOTES:

1. INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M
2. DIMENSIONS ARE IN INCHES
3. BACK SPOTFACE ALL THRU HOLES MINIMUM TO CLEAN UP
- 4 SEE SPECIFICATION, NCSX-CSPEC-141-03, FOR ADDITIONAL REQUIREMENTS
5. GEOMETRY IS DEFINED IN PRO/ENGINEER CAD MODEL, SEI41-115B.PRT
6. DRAWING AND MODELS COMBINED SHALL DEFINE FINISHED PART
- 7 MACHINE FINISHED SURFACES TO CAD DATA, PROFILE WITHIN 0.020" UNLESS OTHERWISE SPECIFIED. PROFILE TOLERANCE IS BILATERAL, I.E. 0.010" EITHER SIDE OF REFERENCE SURFACE.
- 8 AS-CAST SURFACES SHOWN IN NOMINAL MATERIAL CONDITION WITH THICKNESS TOLERANCE OF +/- 0.25". SURFACE PROFILE MUST BE WITHIN 0.5" OF CAD DATA, EXCEPT IN REGIONS OF INTERSECTING SURFACES WHERE FILLETS ARE EXPECTED.
- 9 DESIGNATED SURFACE PROFILES MUST BE WITHIN 0.125" OF CAD DATA
10. DIMENSIONS ARE AT ROOM TEMPERATURE, OPERATING TEMP IS 80-K.

next assy	SEI41-115B		MODULAR COIL TYPE-B WINDING FORM	SEE NOTE #4	SEE NOTE #4	FIND NO
	CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	
SEI41-102						

PARTS LIST

APPROXIMATE WEIGHT = 5001 LBS

SCALE NOTED

TOLERANCES UNLESS OTHERWISE SPECIFIED	DES T BROWN	DRW MT BROWN	S/04
FRACTIONS	CHK D WILLIAMSON	SECT :	
XX DECIMALS ±.01	DEPT :		
XXX DECIMALS ±.005	PE :		
ANGLES ±0°15'	PJ :		
BREAK SHARP EDGES 06 MAX	RED :		
FINISH .125 UNLESS OTHERWISE SPECIFIED	PPPL DRFT :		

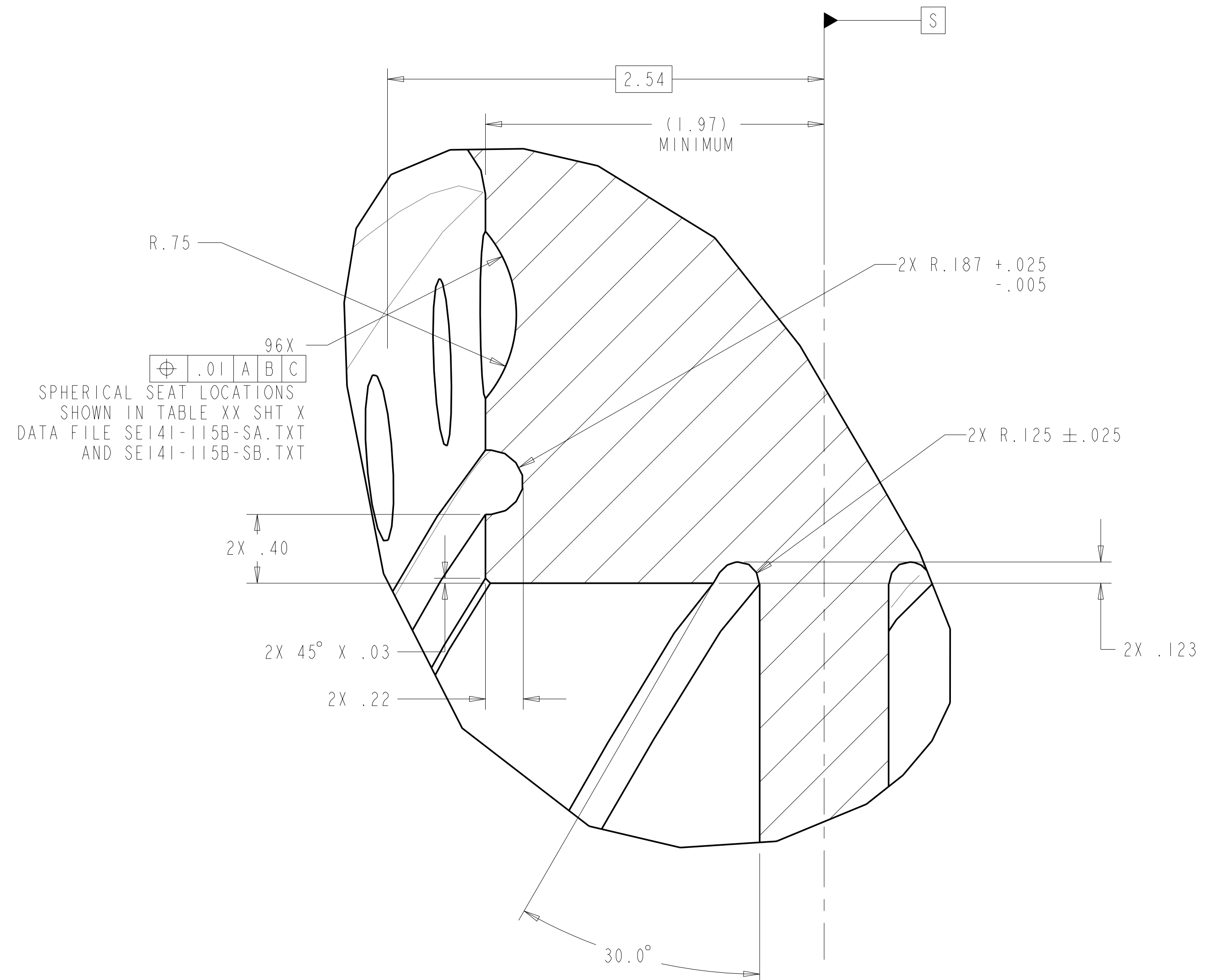
UT-BATTELLE		Oak Ridge National Laboratory managed for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT contract DE-AC05-00OR22725 UT-BATTELLE, LLC. Oak Ridge, Tennessee			
NATIONAL COMPACT STELLARATOR EXPERIMENT					
MODULAR COIL TYPE-B WINDING FORM					
*					
VERSION NO.	PLANT	BLDG	FL	SHT OF	TYPE CLASS
WILDFIRE	X-10	5700	3	1	81 S U
RELEASE LEVEL					REV 0
WIP					

REV	DESCRIPTION	BY	DATE	CHK	DEPT	DATE	PE	REQ	DATE	ORNL	DOE	DATE

P THIS DRAWING PRODUCED ON PRO-ENGINEER

NO REPRESENTATION OR WARRANTY, EXPRESSED OR IMPLIED, IS MADE AS TO THE ACCURACY, COMPLETENESS OR USEFULNESS OF THE INFORMATION OR STATEMENTS CONTAINED IN THESE DRAWINGS, OR THAT THE USE OR DISCLOSURE OF ANY INFORMATION, APPARATUS, METHOD OR PROCESS DISCLOSED IN THESE DRAWINGS MAY NOT INFRINGE PRIVATE RIGHTS OF OTHERS. NO LIABILITY IS ASSUMED WITH RESPECT TO THE USE OF, OR FOR DAMAGES RESULTING FROM THE USE OF, ANY INFORMATION, APPARATUS, METHOD OR PROCESS DISCLOSED IN THESE DRAWINGS. DRAWINGS MADE AVAILABLE FOR INFORMATION TO BIDDER ARE NOT TO BE USED FOR OTHER PURPOSES, AND ARE TO BE RETURNED UPON REQUEST OF THE FORWARDING CONTRACTOR.

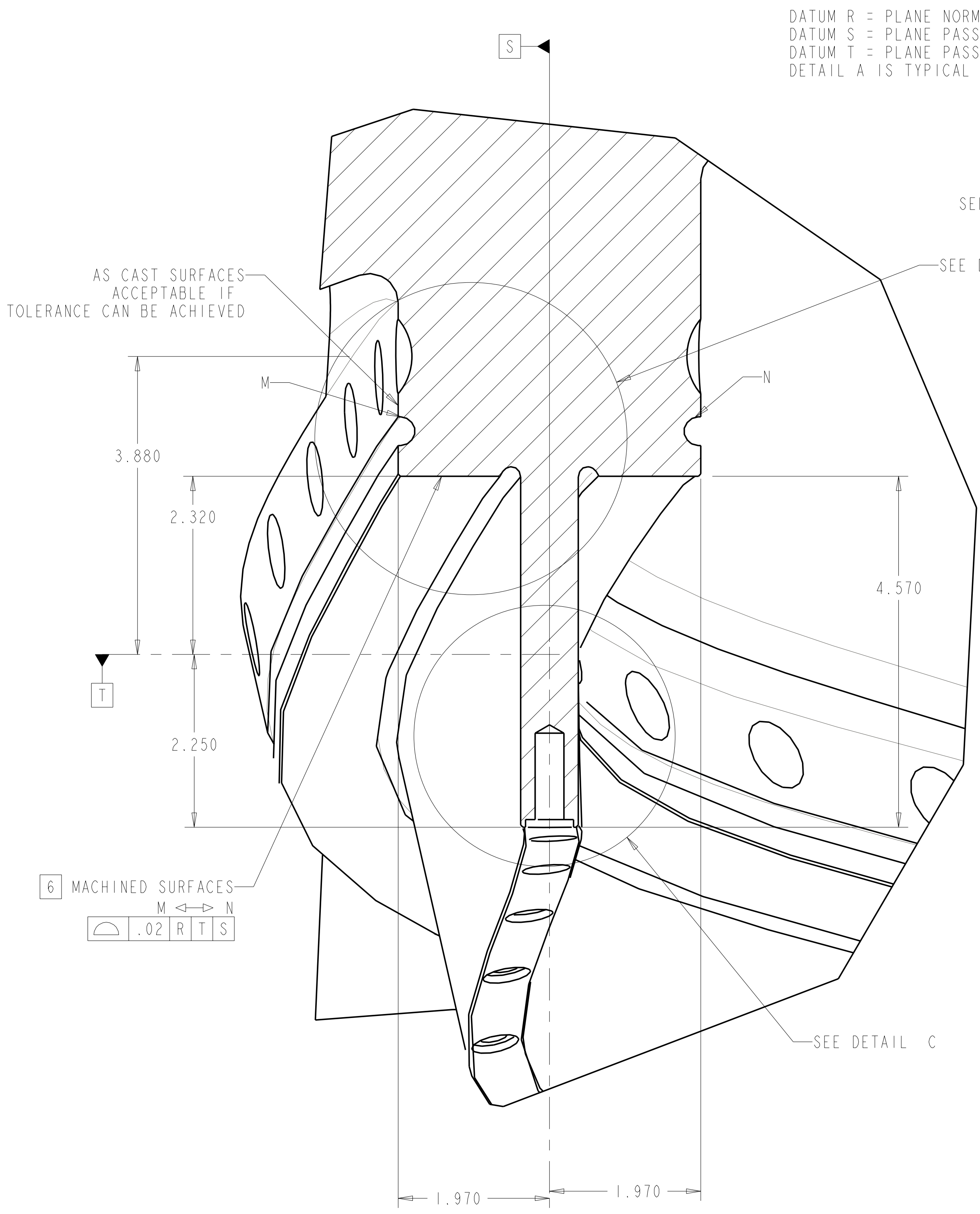
H
G
F
E
D
C
B
A



SPHERICAL SEAT LOCATIONS SHOWN IN TABLE XX SHT X DATA FILE SE141-115B-SA.TXT AND SE141-115B-SB.TXT

VPI GROOVE TO BE MACHINED BY BALL END MILL OR DISK CUTTER IF SAME TOLERANCE CAN BE ACHIEVED.

DETAIL B
SCALE 2.000

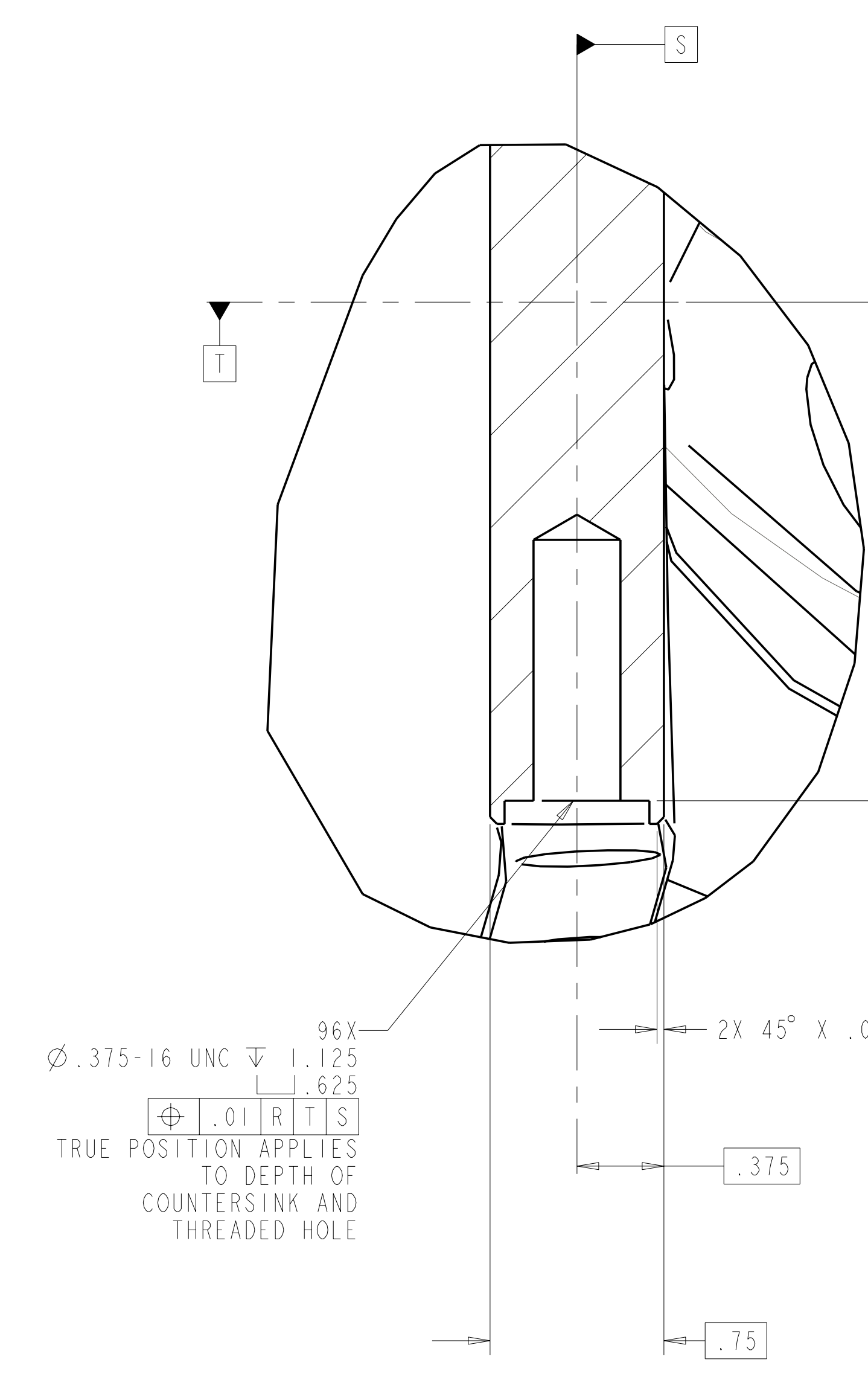
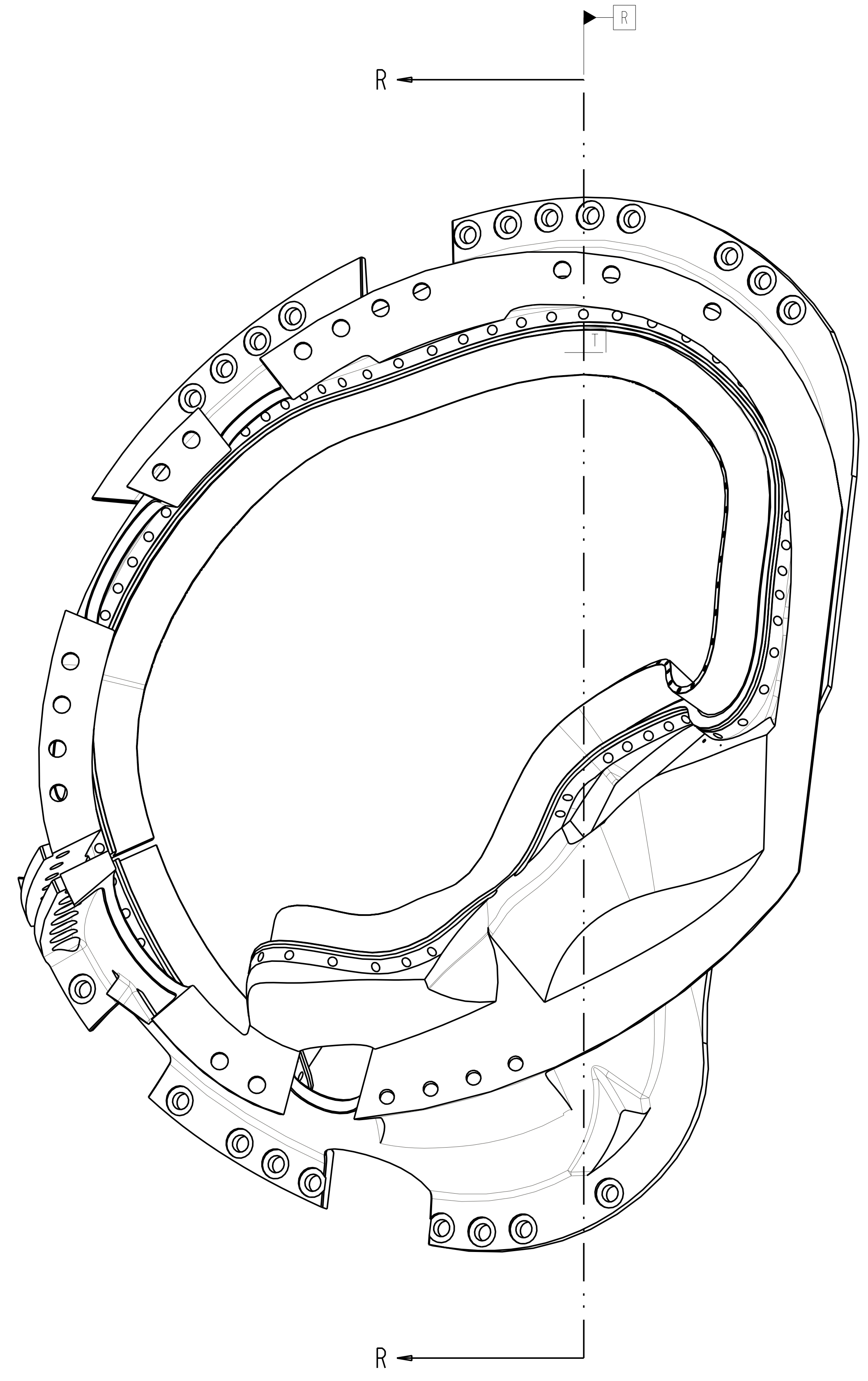


AS CAST SURFACES ACCEPTABLE IF TOLERANCE CAN BE ACHIEVED

6 MACHINED SURFACES
M ↔ N
R T S
.02

DETAIL A
SCALE 1.000

DATUM R = PLANE NORMAL TO WINDING CENTER
DATUM S = PLANE PASSING THRU WINDING CENTER AND X VECTOR AT DATUM R
DATUM T = PLANE PASSING THRU WINDING CENTER ORTHOGONAL TO DATUM S
DETAIL A IS TYPICAL TO ALL POINTS ALONG WINDING CENTER

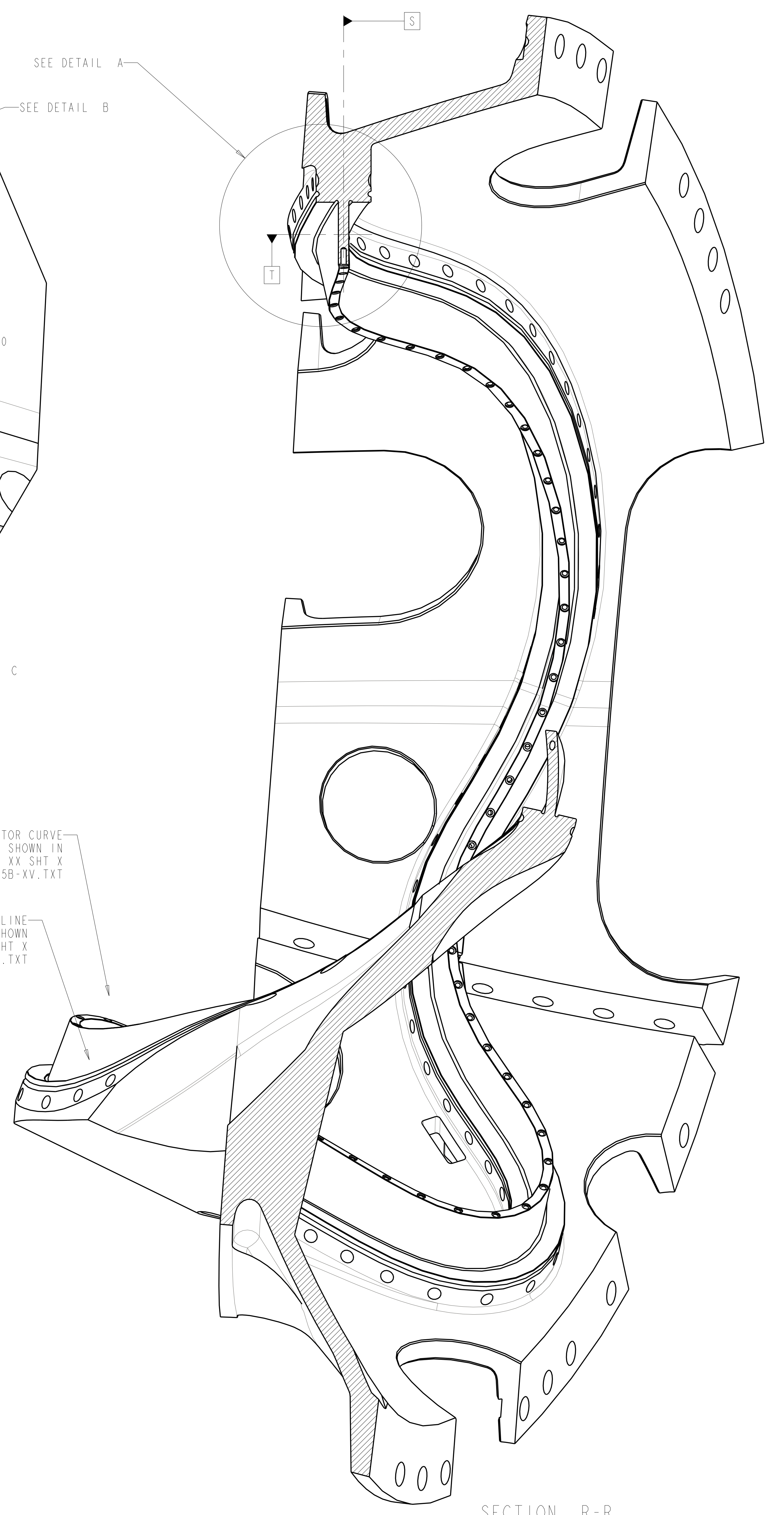


TRUE POSITION APPLIES TO DEPTH OF COUNTERSINK AND THREADED HOLE

DETAIL C
SCALE 2.000

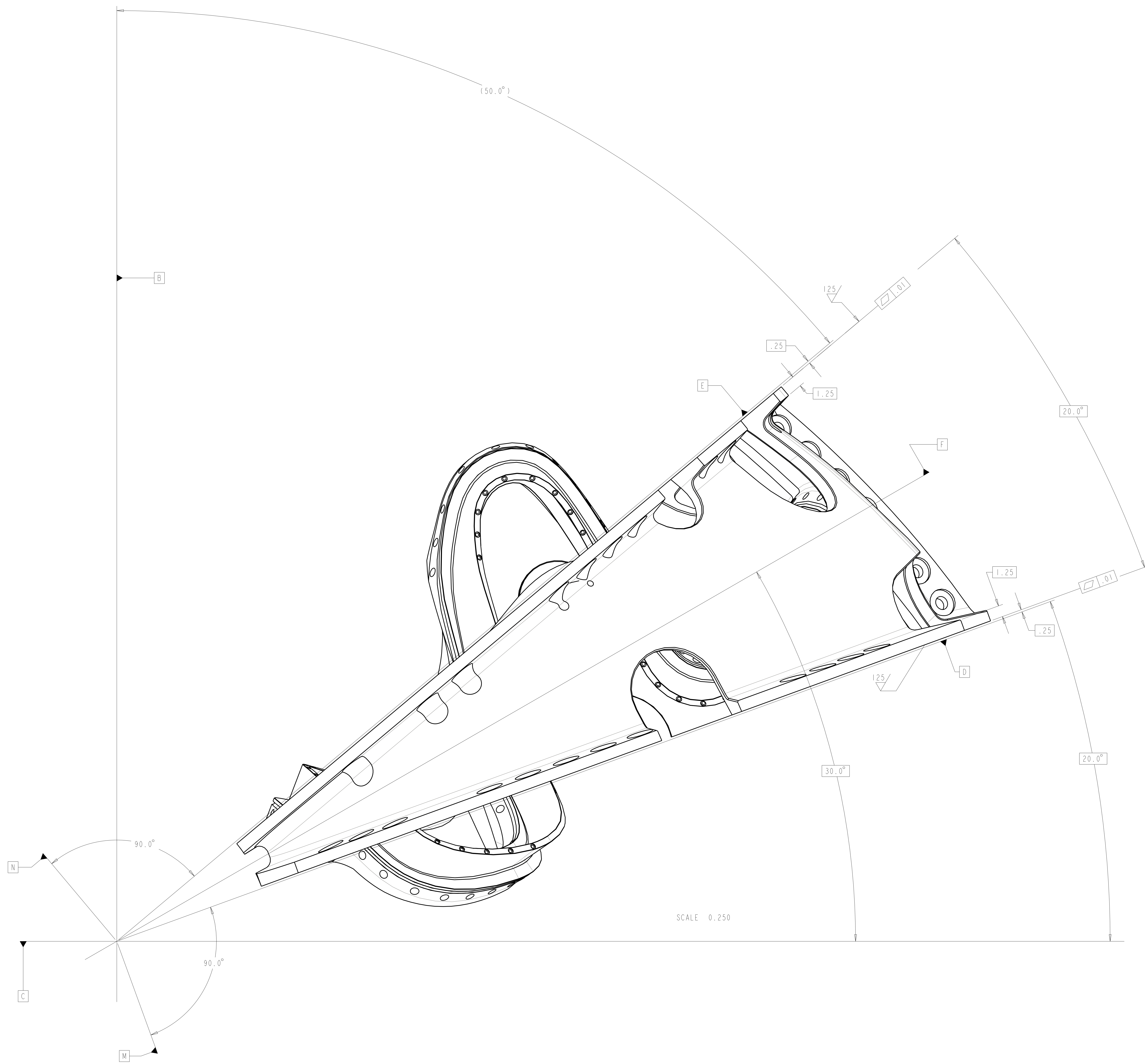
X-VECTOR CURVE SPLINE PASSING THRU POINT SHOWN IN TABLE XX SHT X DATA FILE SE141-115B-XV.TXT

WINDING CENTER SPLINE PASSING THRU POINTS SHOWN IN TABLE X, SHT X DATA FILE SE141-115B-WC.TXT



SECTION R-R
SCALE 0.250

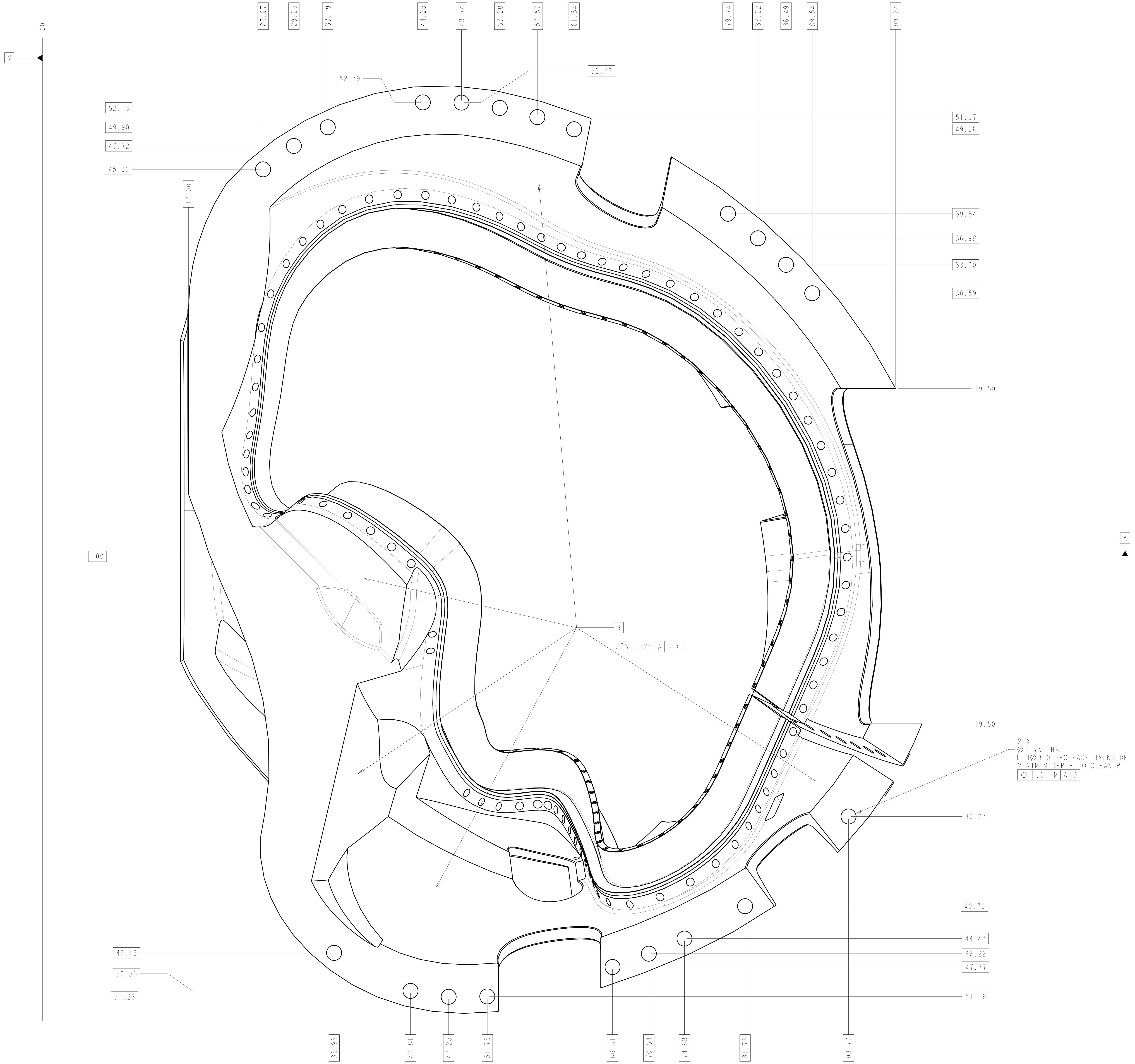
Oak Ridge National Laboratory managed for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT contract DE-AC05-00OR22725 UT-BATTELLE, LLC, Oak Ridge, Tennessee						
NATIONAL COMPACT STELLARATOR EXPERIMENT MODULAR COIL TYPE-B WINDING FORM						
VERSION NO.	PLANT	BLDG	FL	SHT OF	TYPE	CLASS
WILDFIRE				28	U	U
RELEASE LEVEL				SEI41-115		REV
WIP						*



Oak Ridge National Laboratory managed for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT contract DE-AC05-00OR22725 UT-BATTELLE, LLC, Oak Ridge, Tennessee							
UT-BATTELLE							
NATIONAL COMPACT STELLARATOR EXPERIMENT MODULAR COIL TYPE-B WINDING FORM *							
VERSION NO.	PLANT	BLDG	FL	SHT OF	TYPE	CLASS	
5+	X-10	5700	3	3 8	S	U	
RELEASE LEVEL		SEI41-115				REV	0
WIP							

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SEI41-115



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 UT-BATTELLE, LLC. Oak Ridge, Tennessee

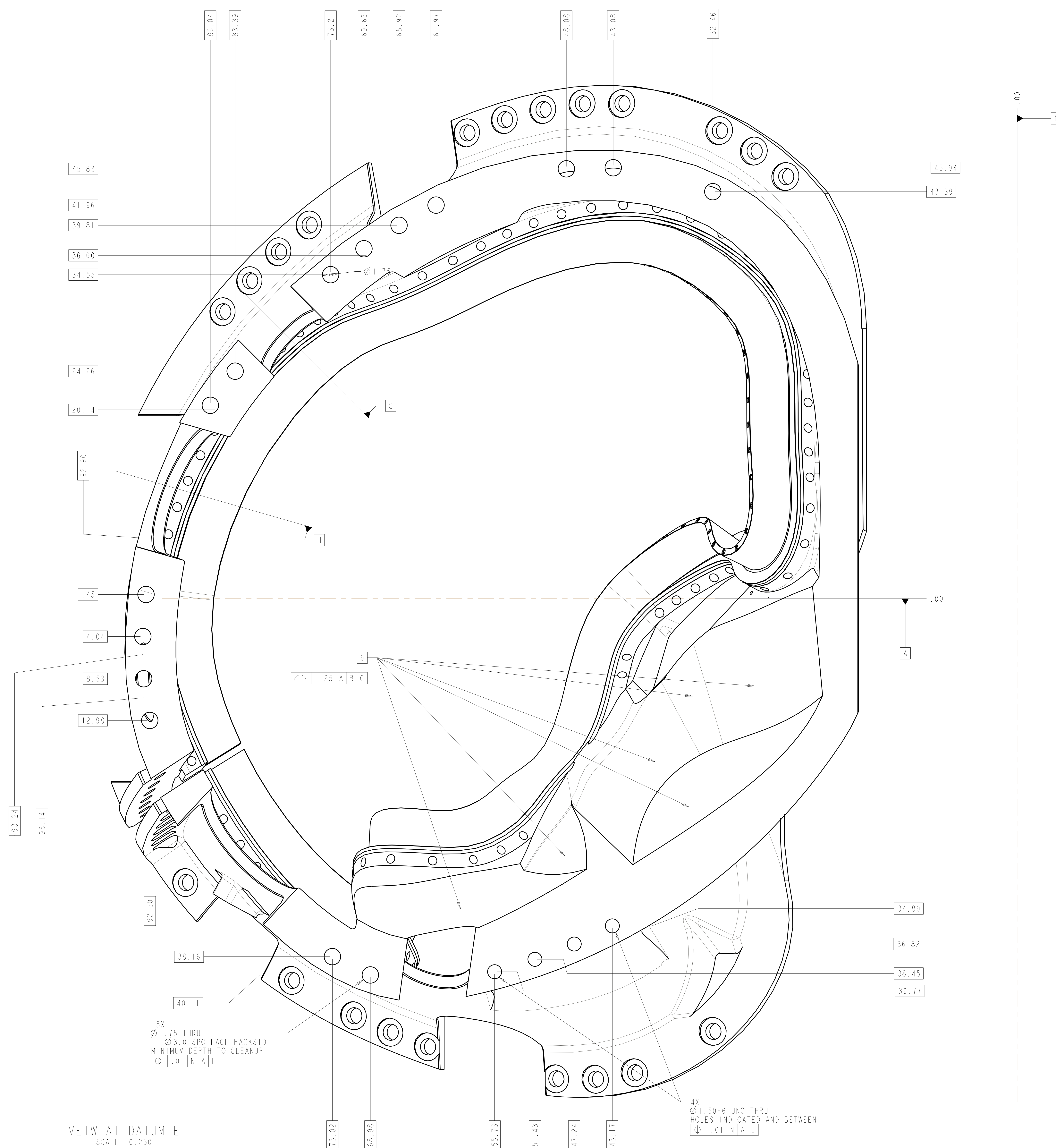
UT-BATTELLE

NATIONAL COMPACT STELLARATOR EXPERIMENT
 MODULAR COIL TYPE-B WINDING FORM

VERSION NO.	PLANT	BLDG	FL	SHT OF	TYPE	CLASS
5+	X-10	5700	3	4 8	S	U
RELEASE LEVEL	SEI41-115					REV
WIP						0

SCALE 0.250

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C
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A



VIEW AT DATUM E
SCALE 0.250

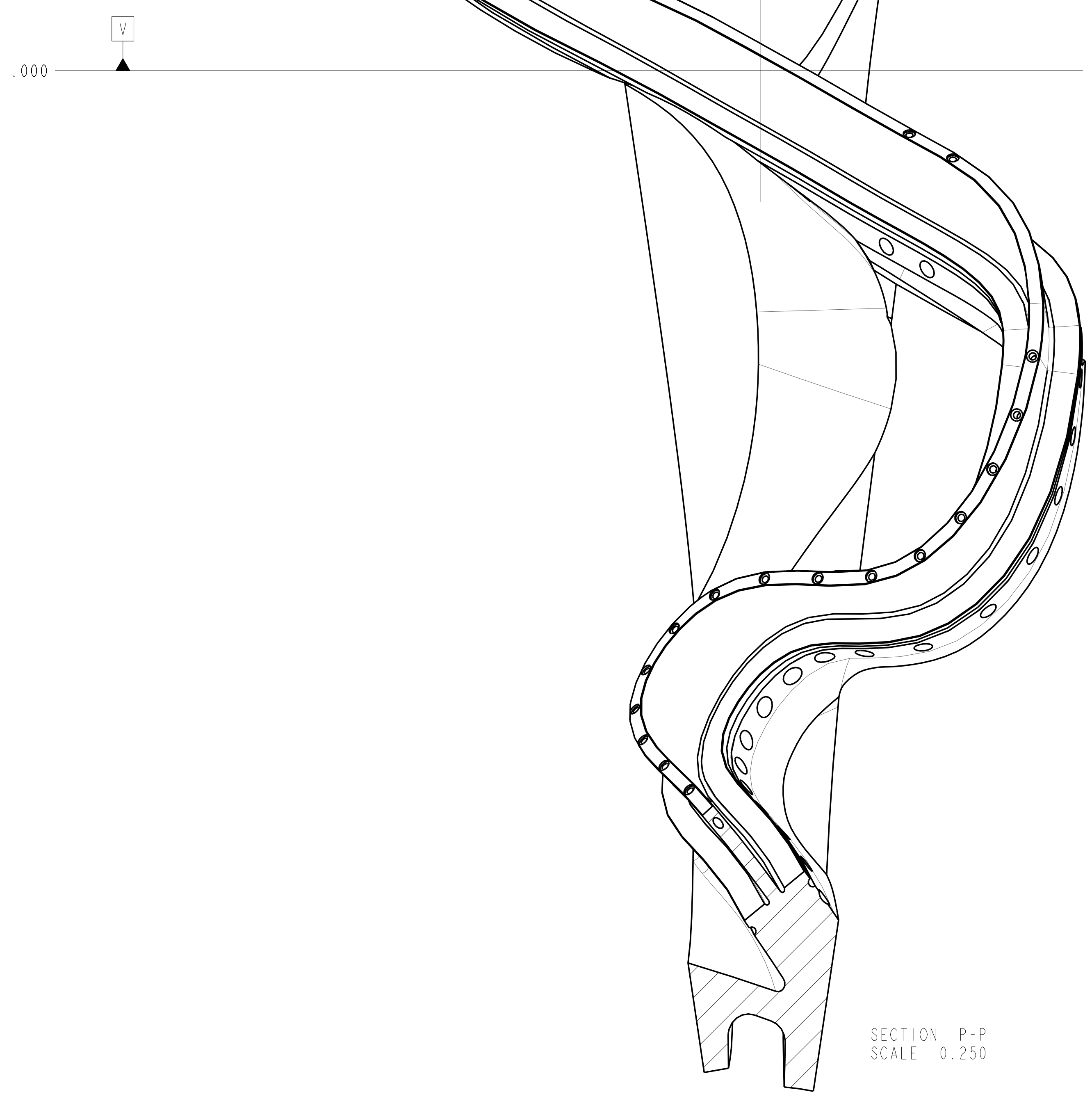
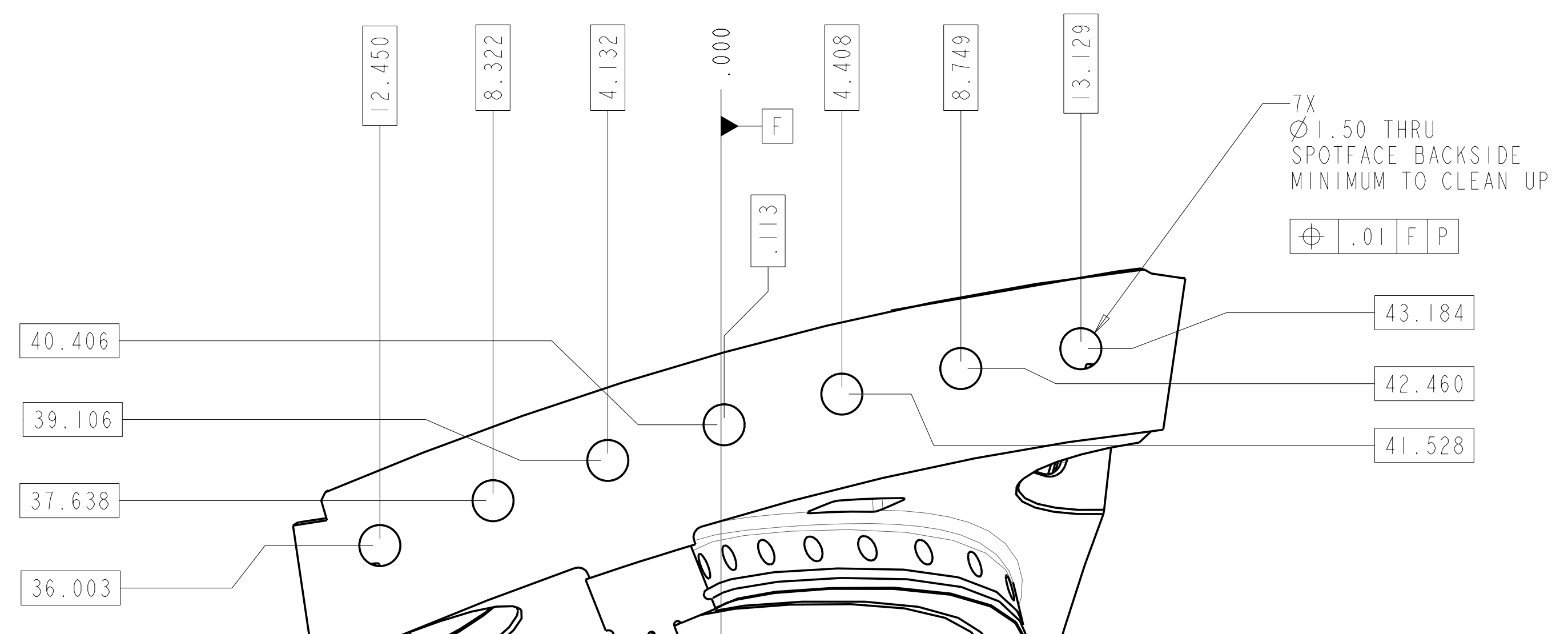
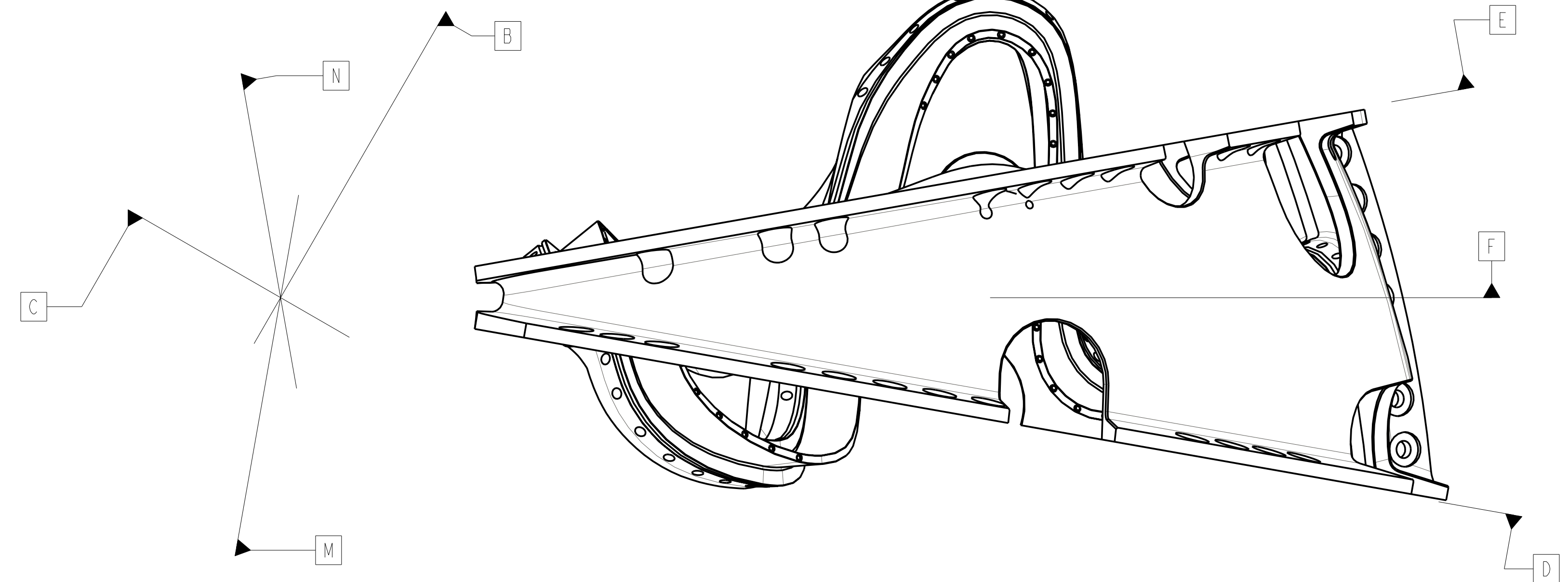
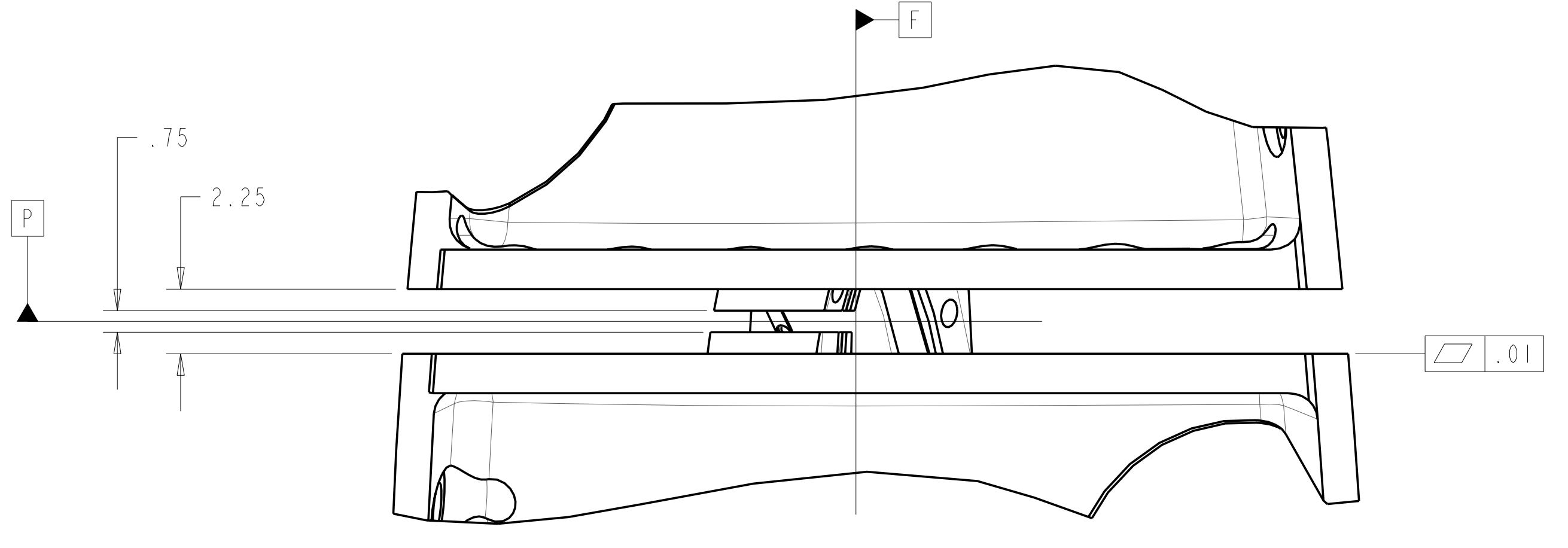
15X
Ø1.75 THRU
Ø3.0 SPOTFACE BACKSIDE
MINIMUM DEPTH TO CLEANUP
±.01 N/A E

4X
Ø1.50-6 UNC THRU
HOLES INDICATED AND BETWEEN
±.01 N/A E

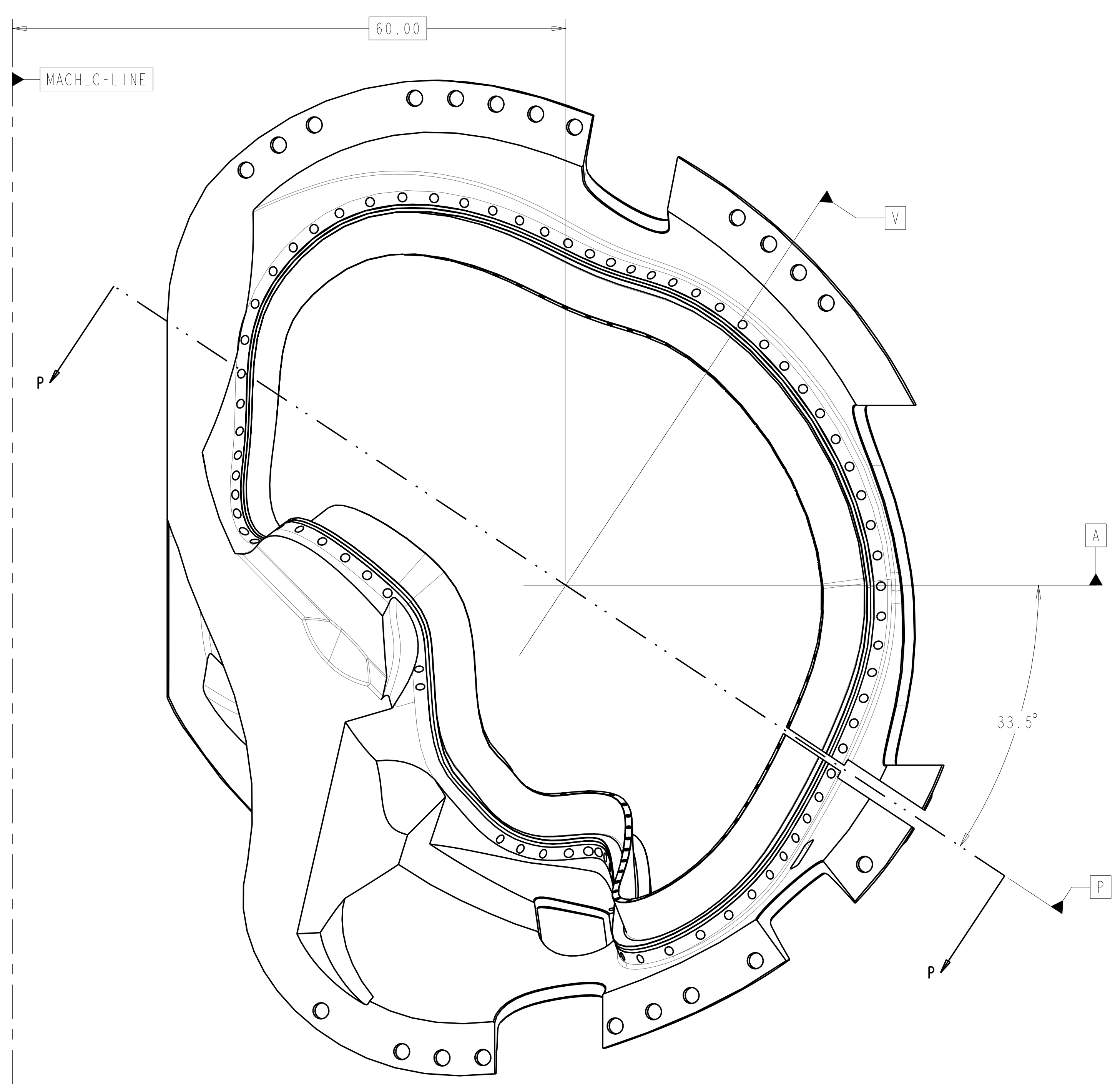
Oak Ridge National Laboratory managed for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT contract DE-AC05-00OR22725 UT-BATTELLE, LLC, Oak Ridge, Tennessee PROJECT NAME						
UT-BATTELLE NATIONAL COMPACT STELLARATOR EXPERIMENT MODULAR COIL TYPE-B WINDING FORM *						
VERSION NO.	PLANT	BLDG	FL	SHT OF	TYPE	CLASS
5+	X-10	5700	3	5 8	S	U
RELEASE LEVEL		SEI41-115			REV 0	
WIP						

SEI41-115

A



SECTION P-P
SCALE 0.250

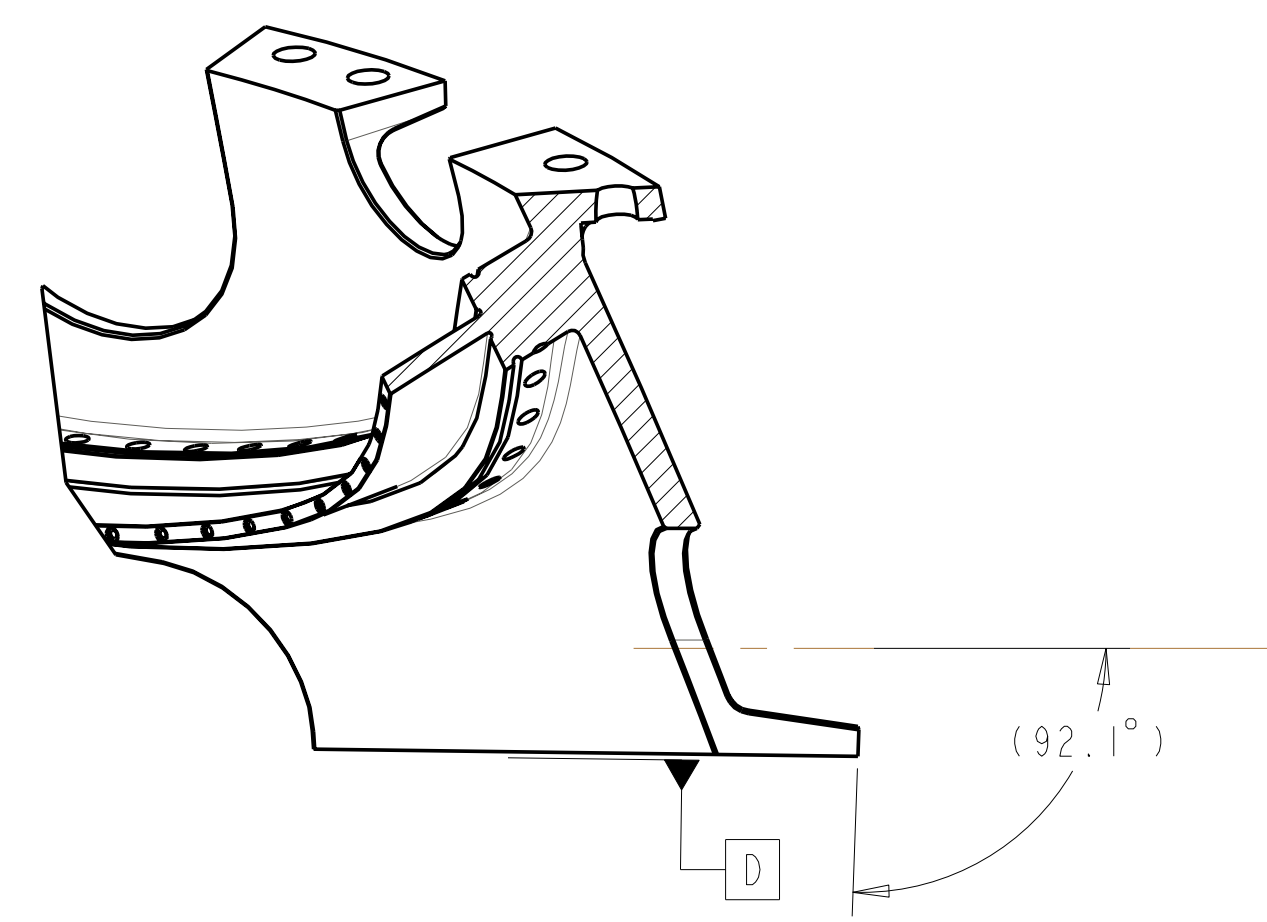


SCALE 0.125

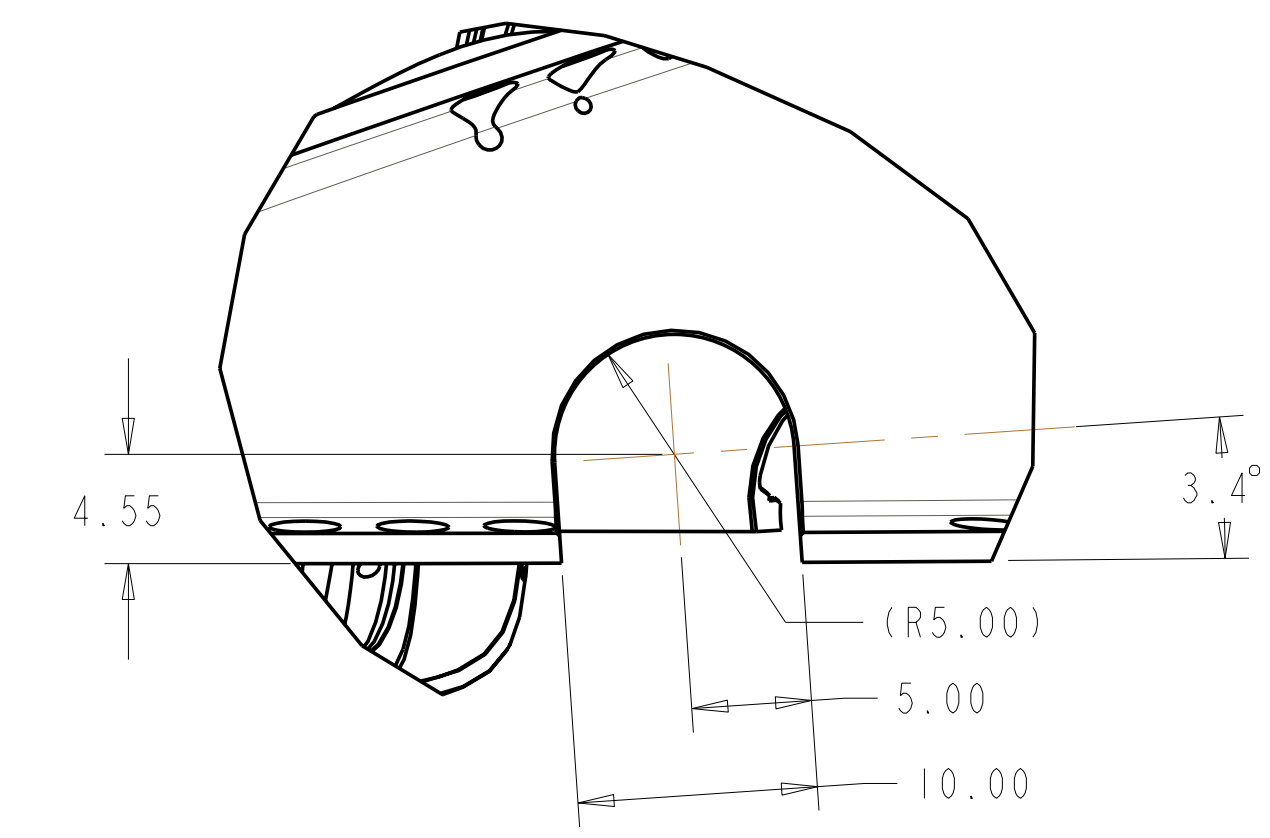
Oak Ridge National Laboratory managed for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT contract DE-AC05-00OR22725 UT-BATTELLE, LLC, Oak Ridge, Tennessee							
UT-BATTELLE							
NATIONAL COMPACT STELLARATOR EXPERIMENT MODULAR COIL TYPE-B WINDING FORM							
*							
VERSION NO.	PLANT	BLDG	FL	SHT OF	TYPE	CLASS	
5+	X-10	5700	3	6	8	S	U
RELEASE LEVEL		SEI41-115				REV	
WIP						0	

SEI41-115

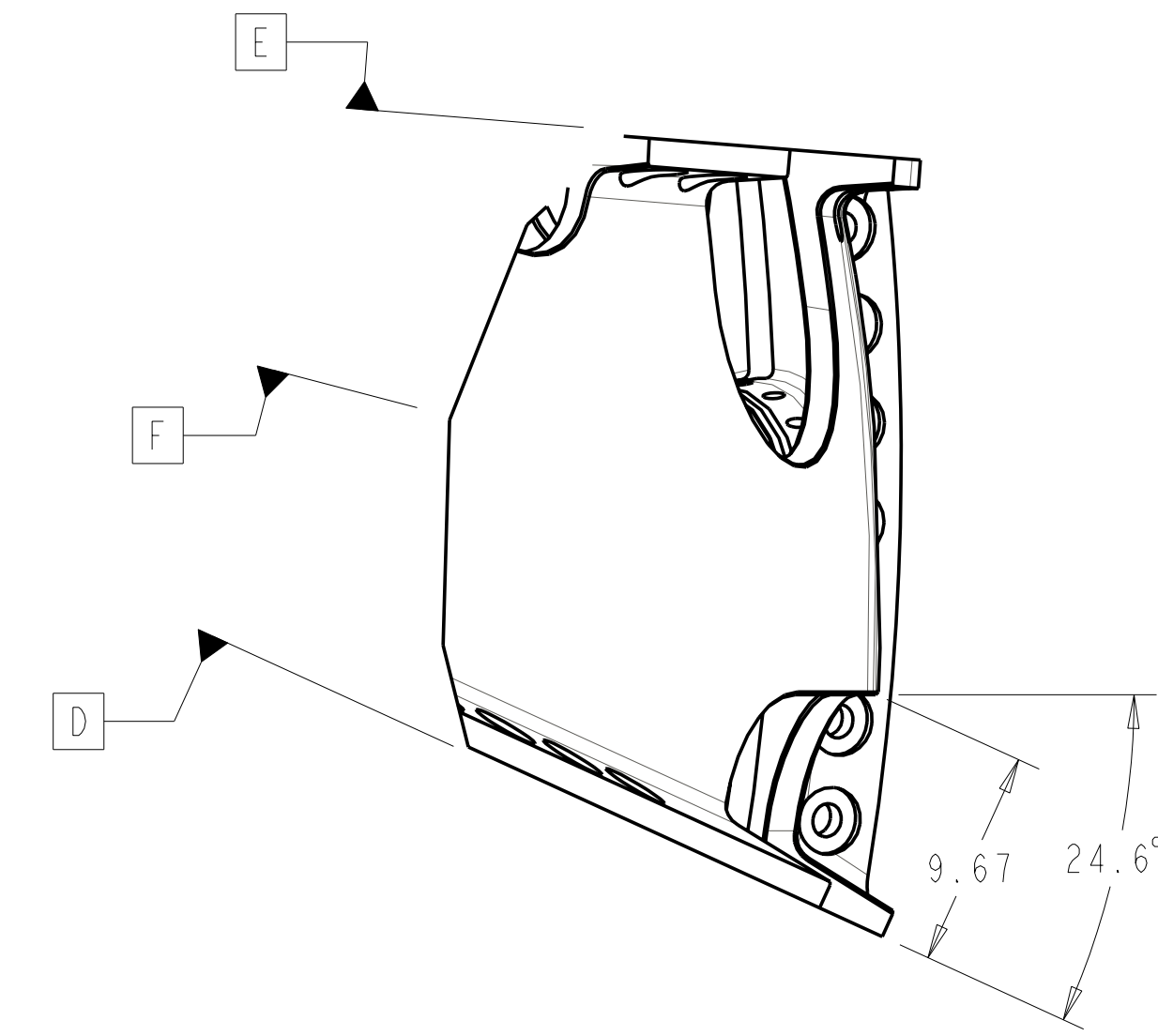
A



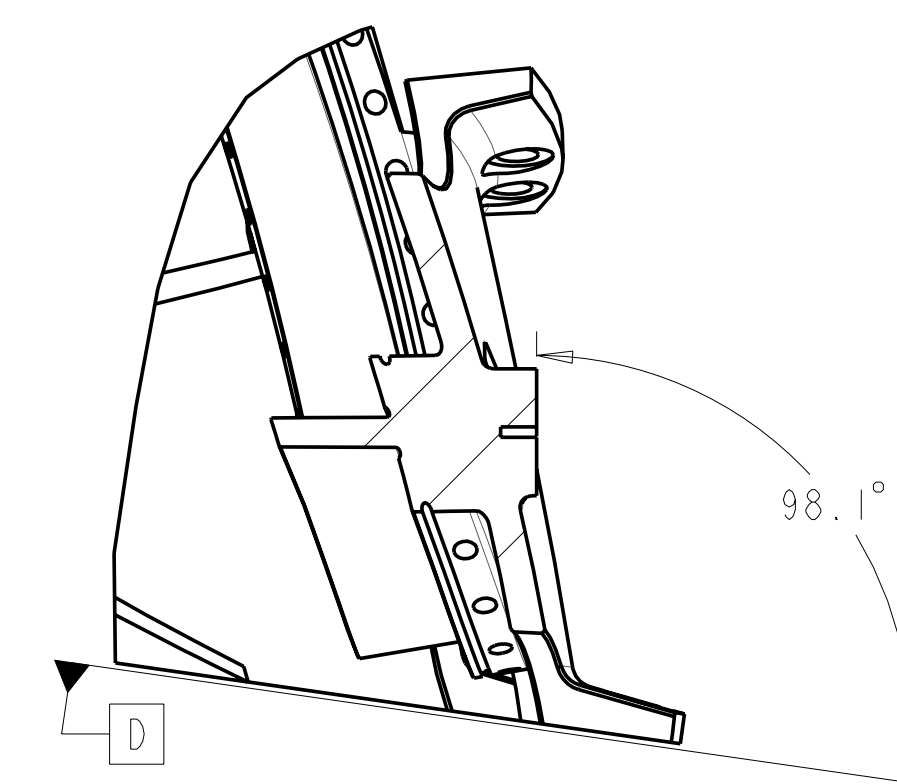
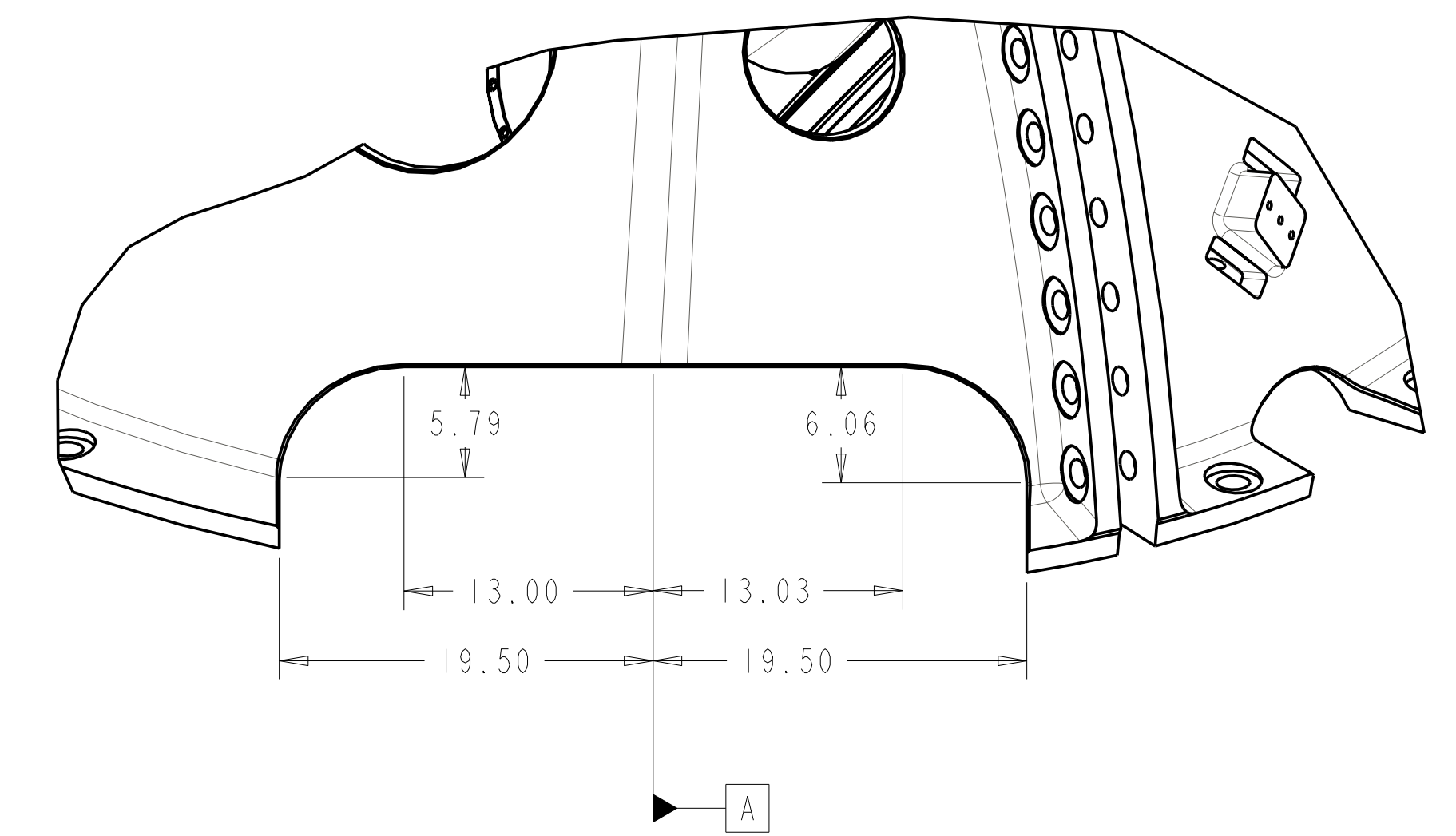
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SCALE 0.125



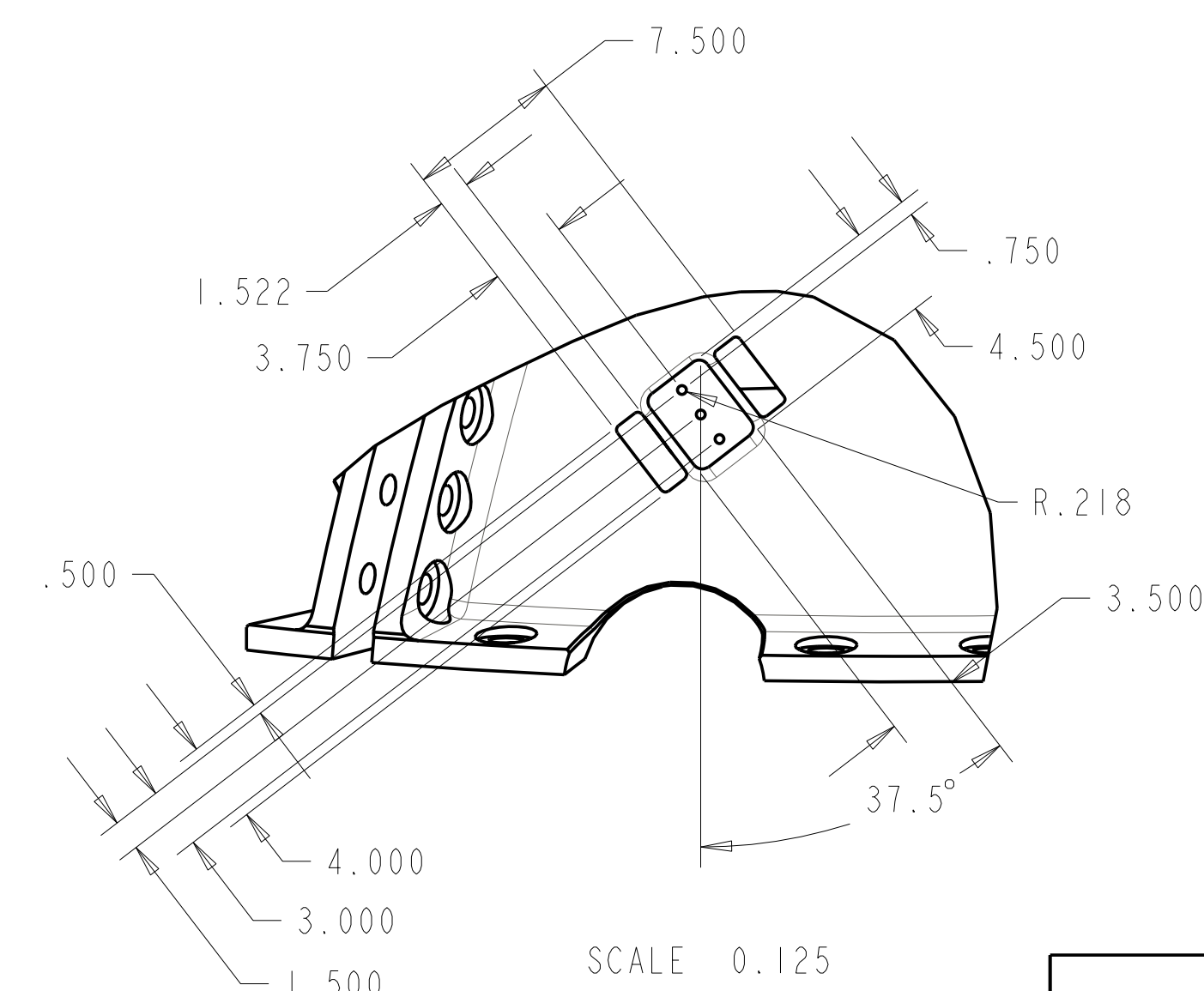
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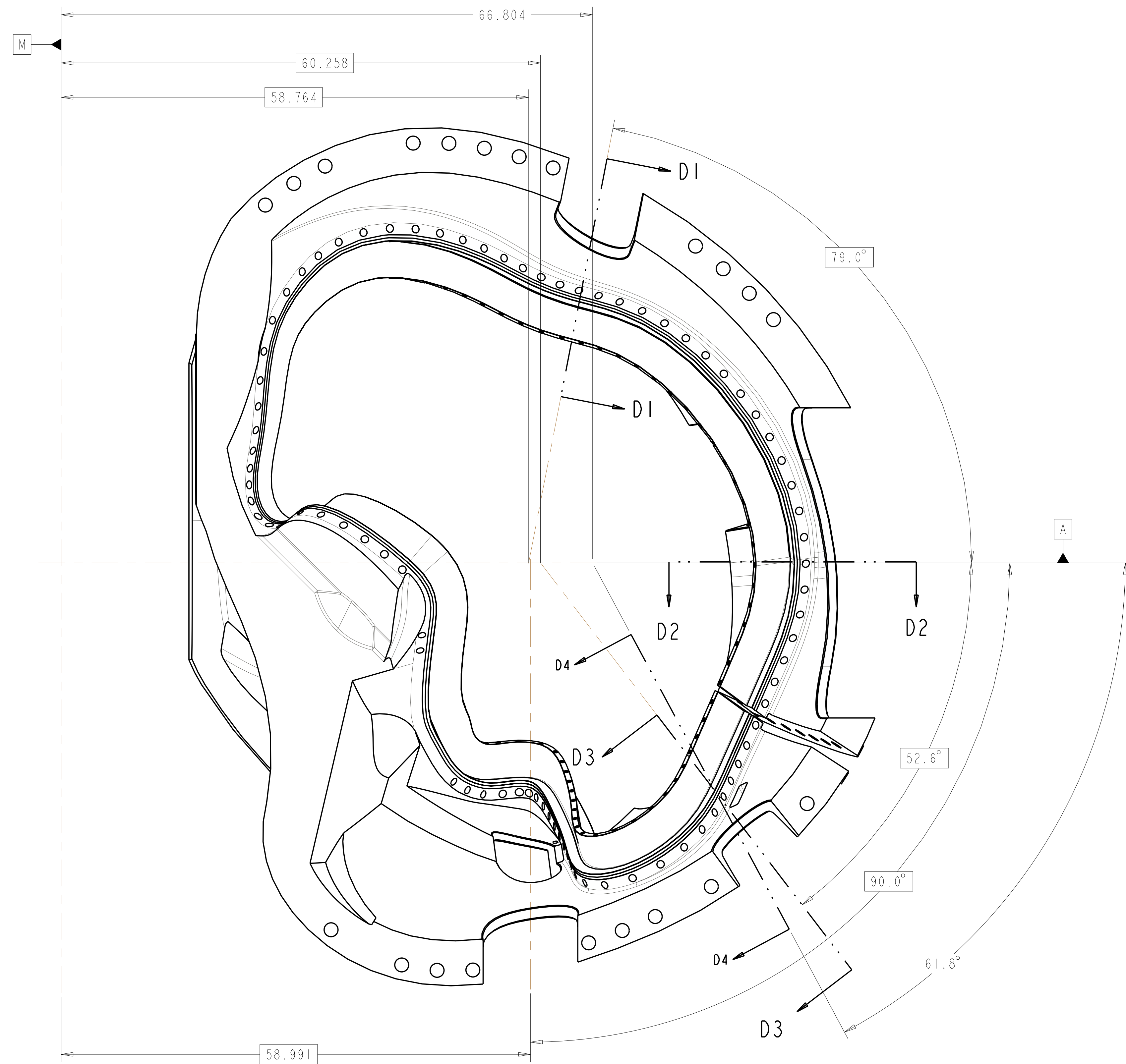
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SCALE 0.125



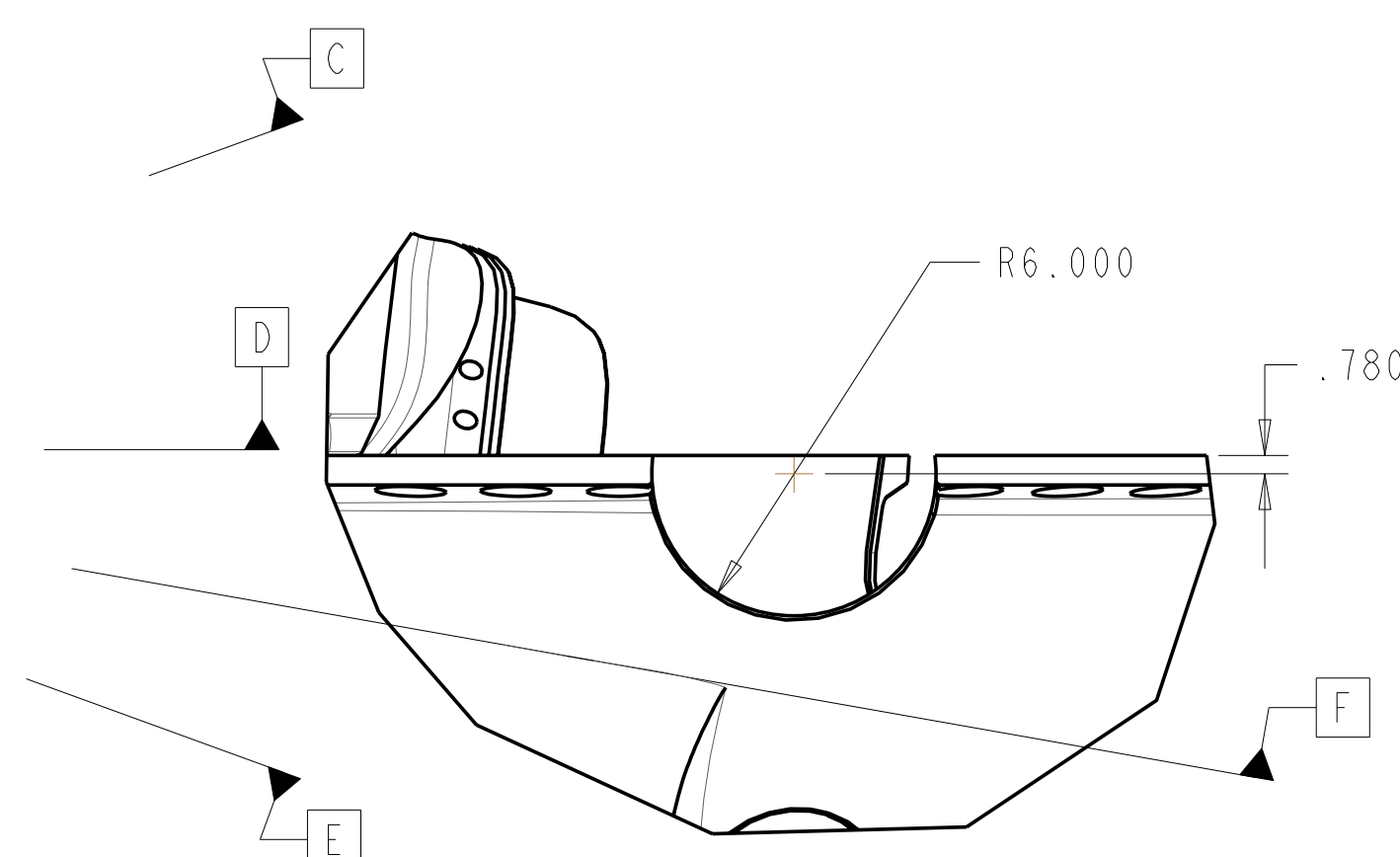
SECTION D4-D4



SCALE 0.125

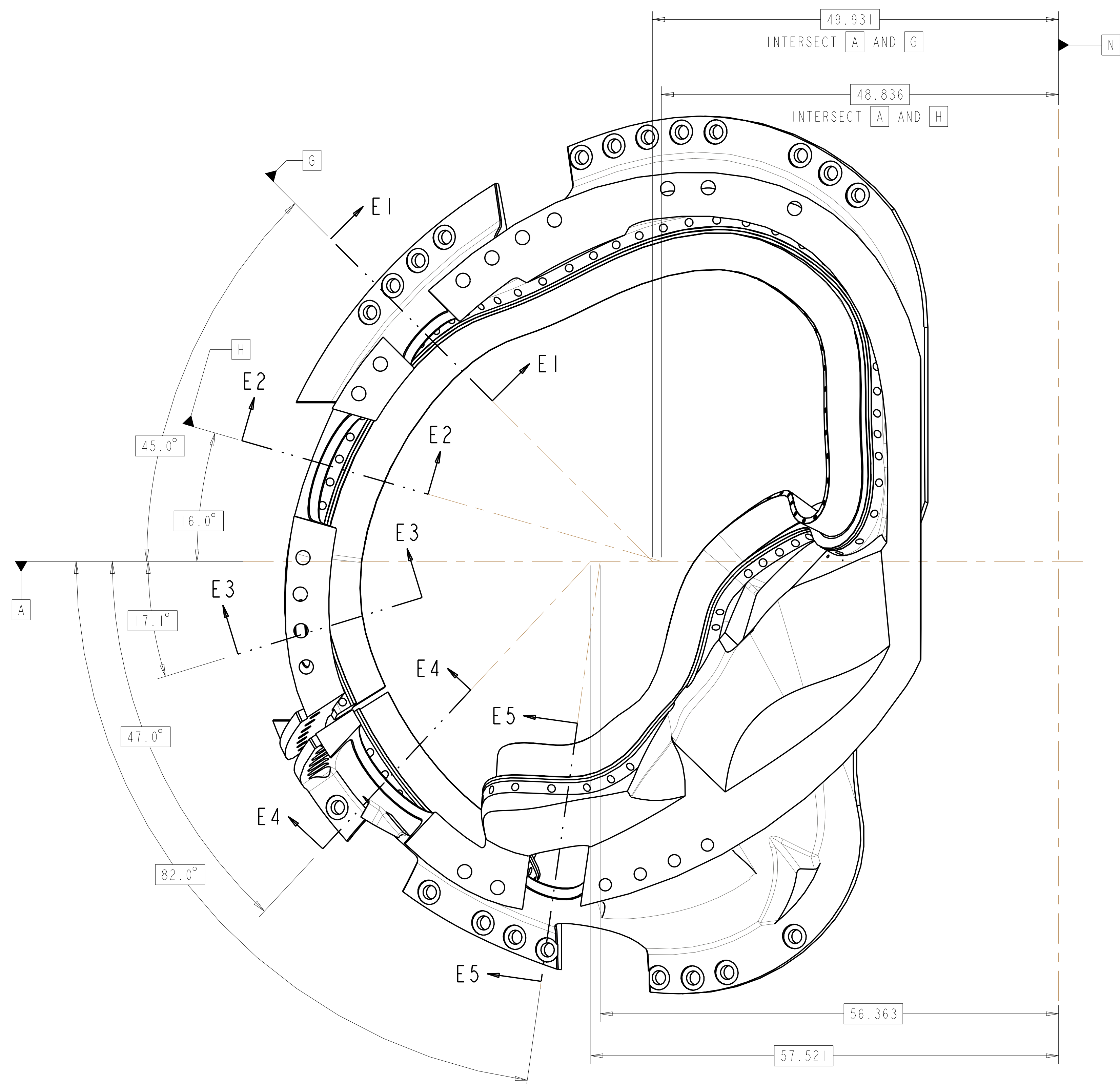


VIEW AT DATUM D
SCALE 0.125

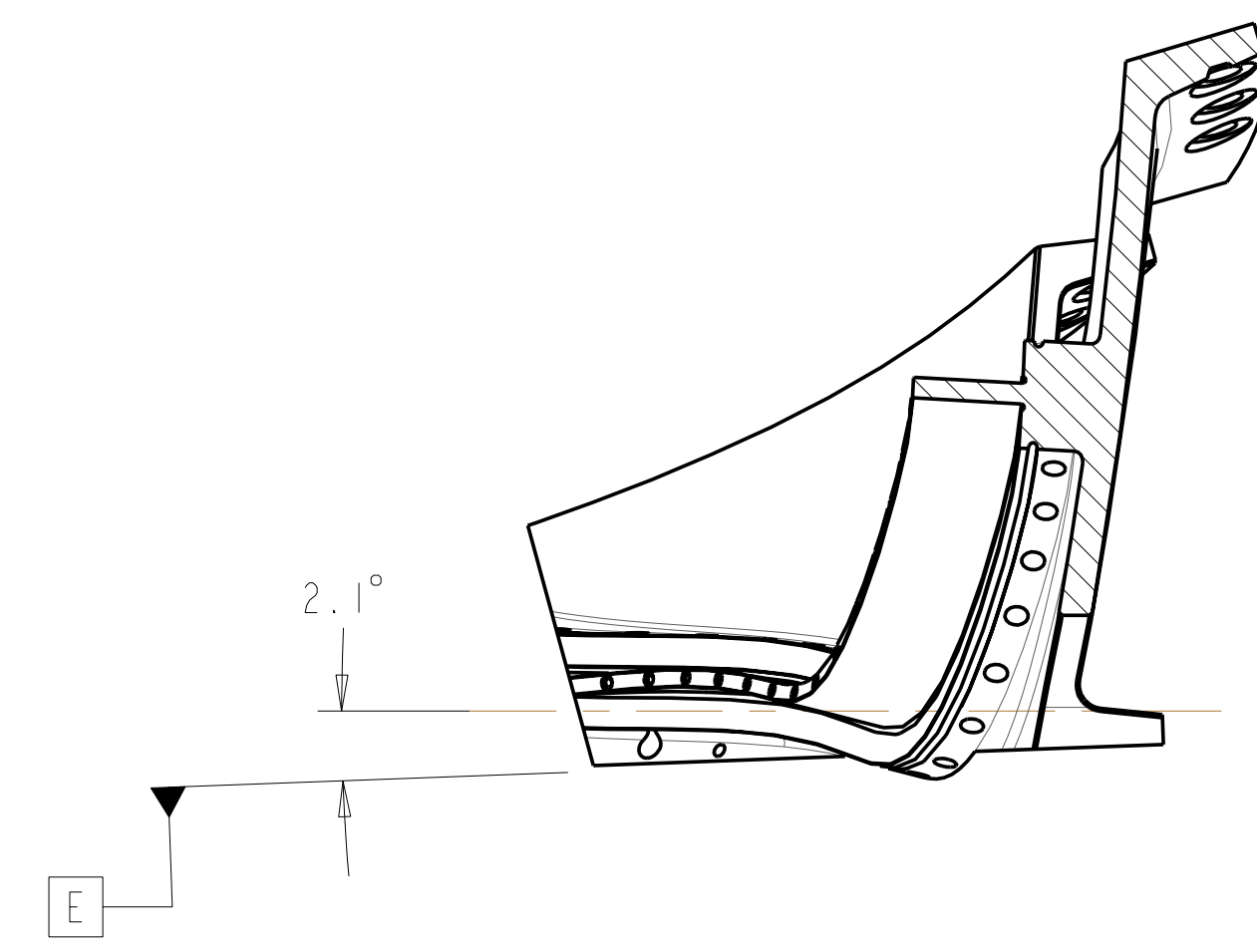


VIEW PROJECTED
FROM DATUM D

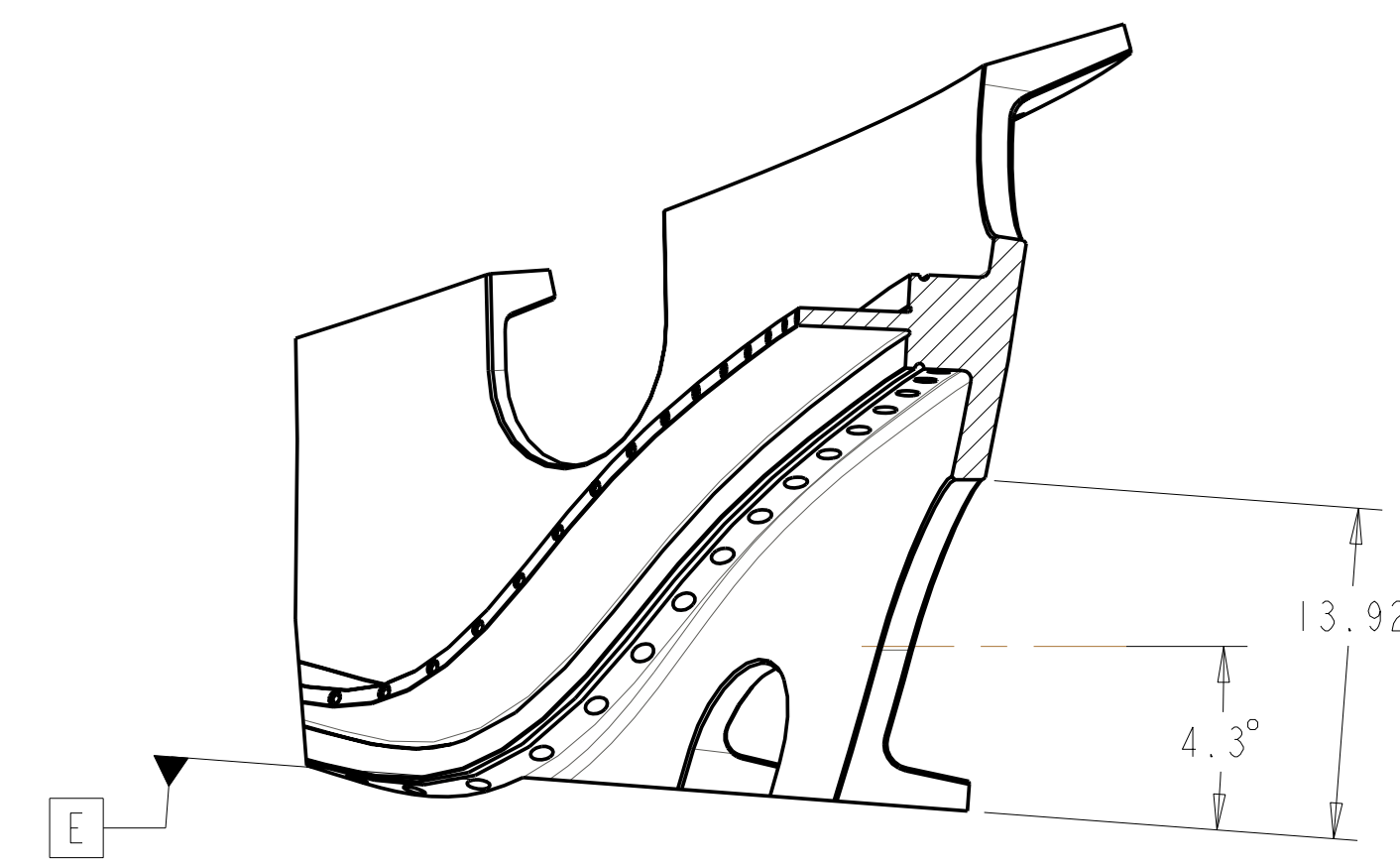
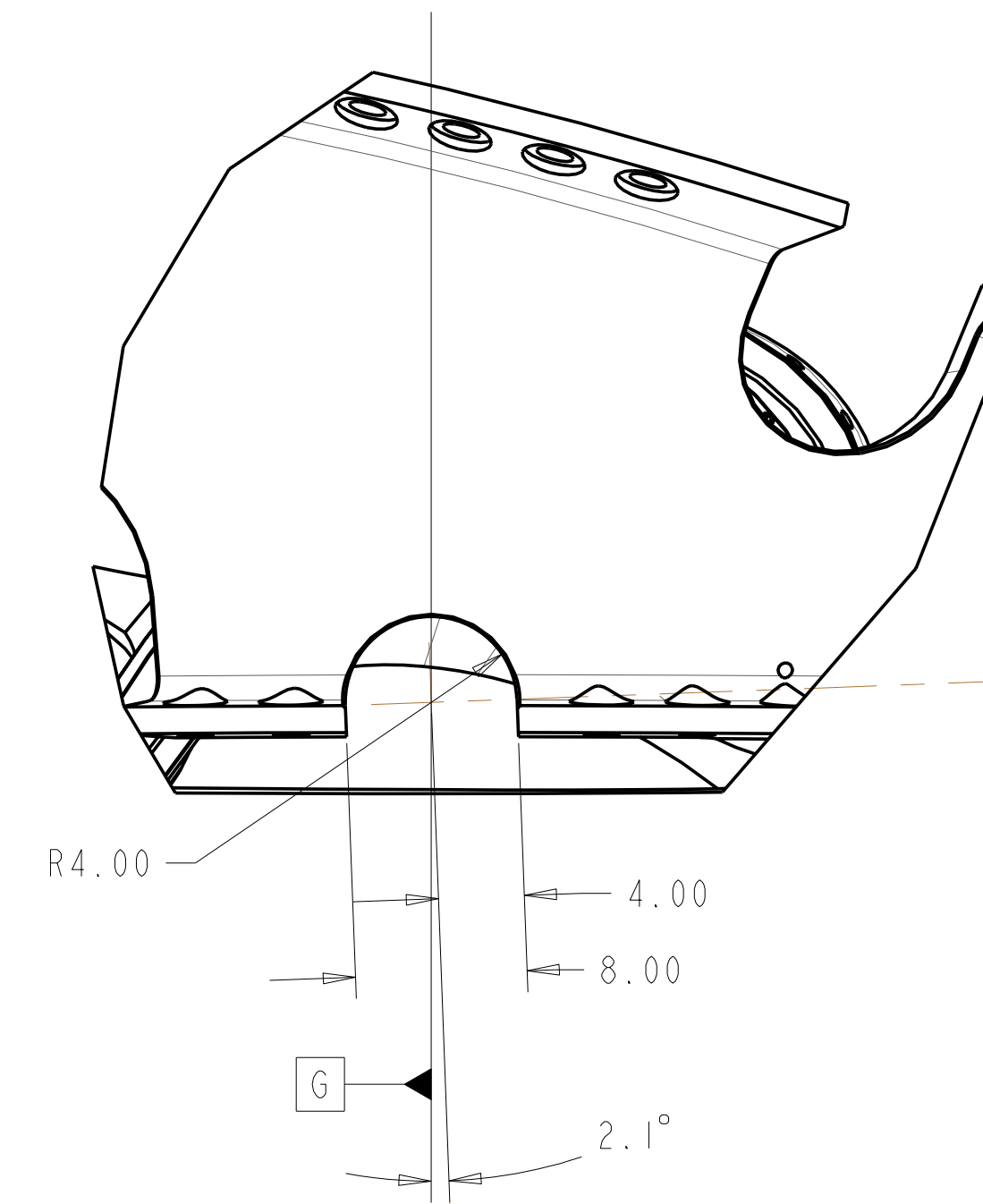
Oak Ridge National Laboratory managed for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT contract DE-AC05-00OR22725 UT-BATTELLE, LLC, Oak Ridge, Tennessee							
UT-BATTELLE							
NATIONAL COMPACT STELLARATOR EXPERIMENT MODULAR COIL TYPE-B WINDING FORM							
*							
VERSION NO.	PLANT	BLDG	FL	SHT OF	TYPE	CLASS	
5+	X-10	5700	3	7 8	S	U	
RELEASE LEVEL WIP							REV 0
SEI41-115							



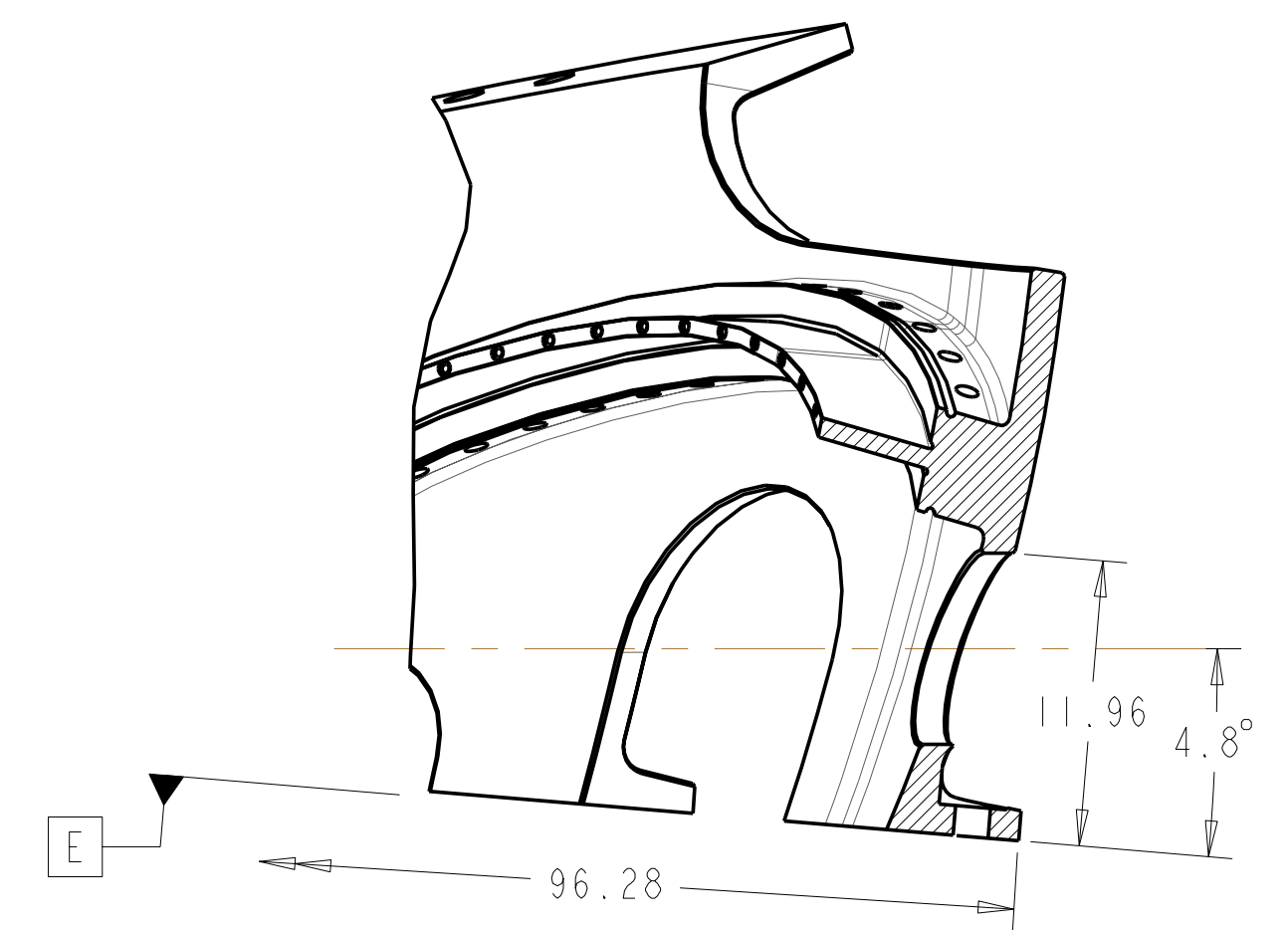
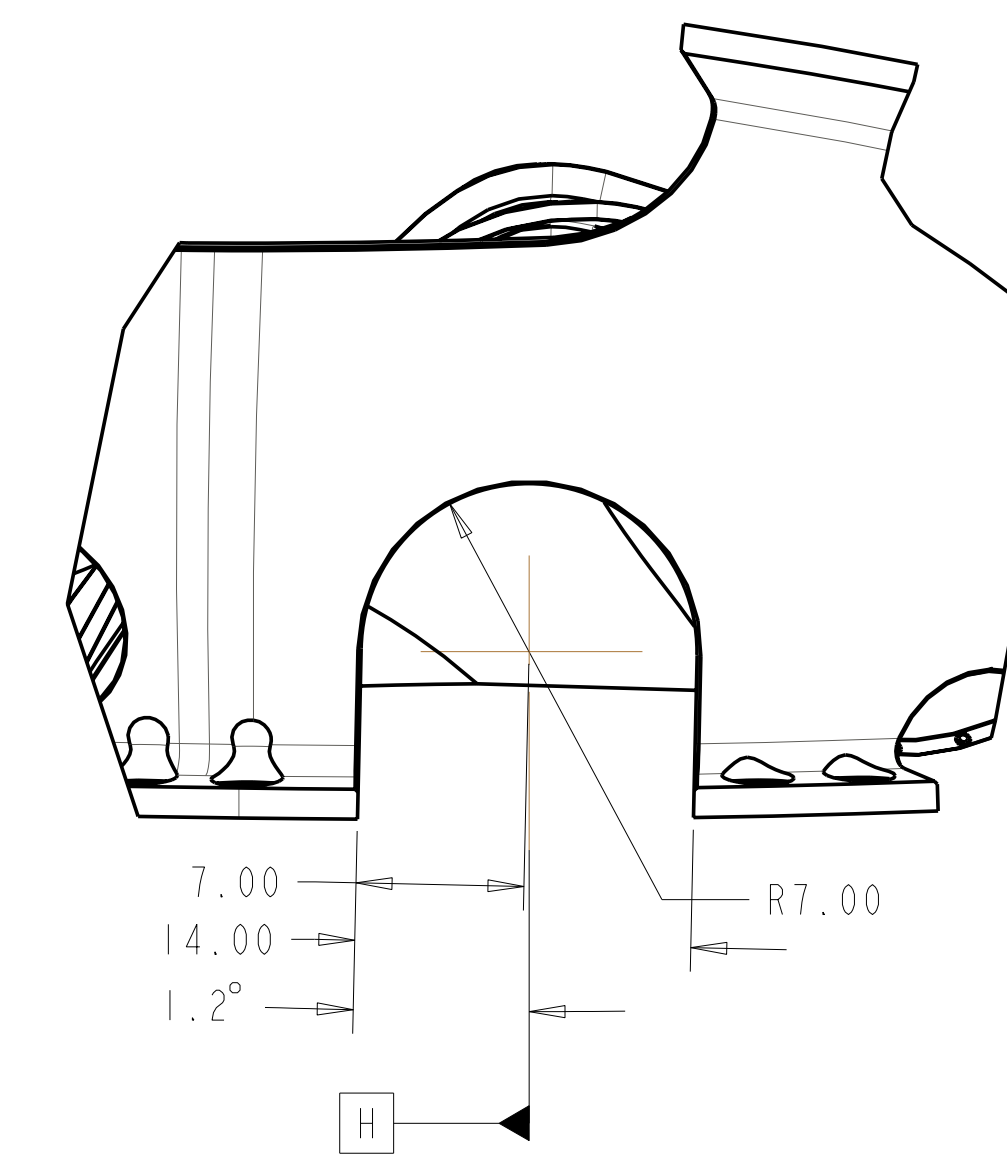
VIEW AT DATUM E
SCALE 0.125



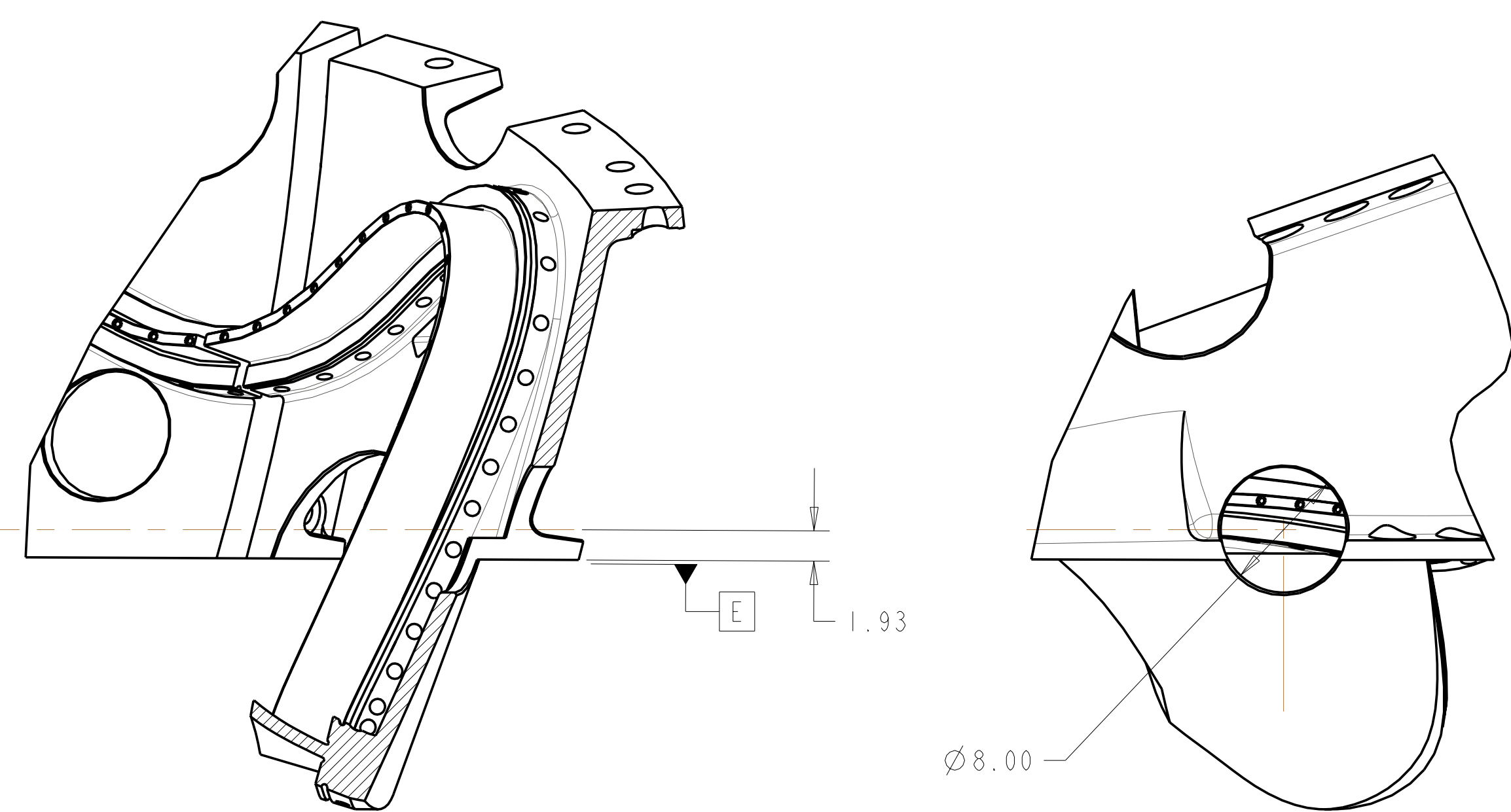
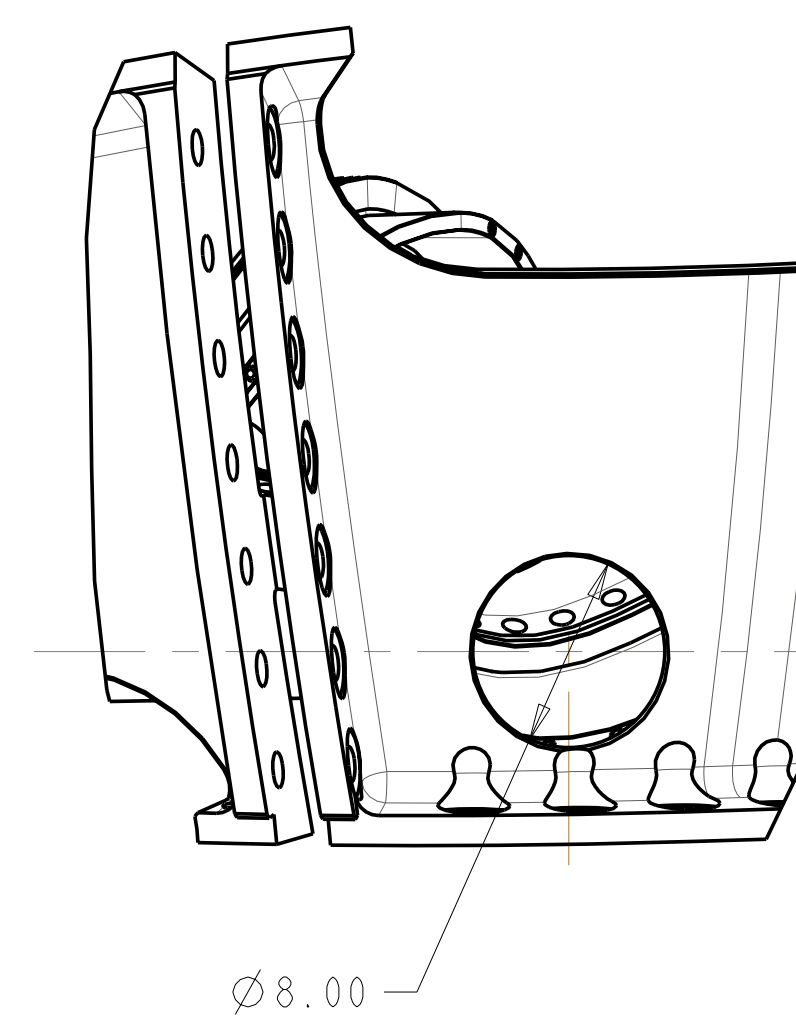
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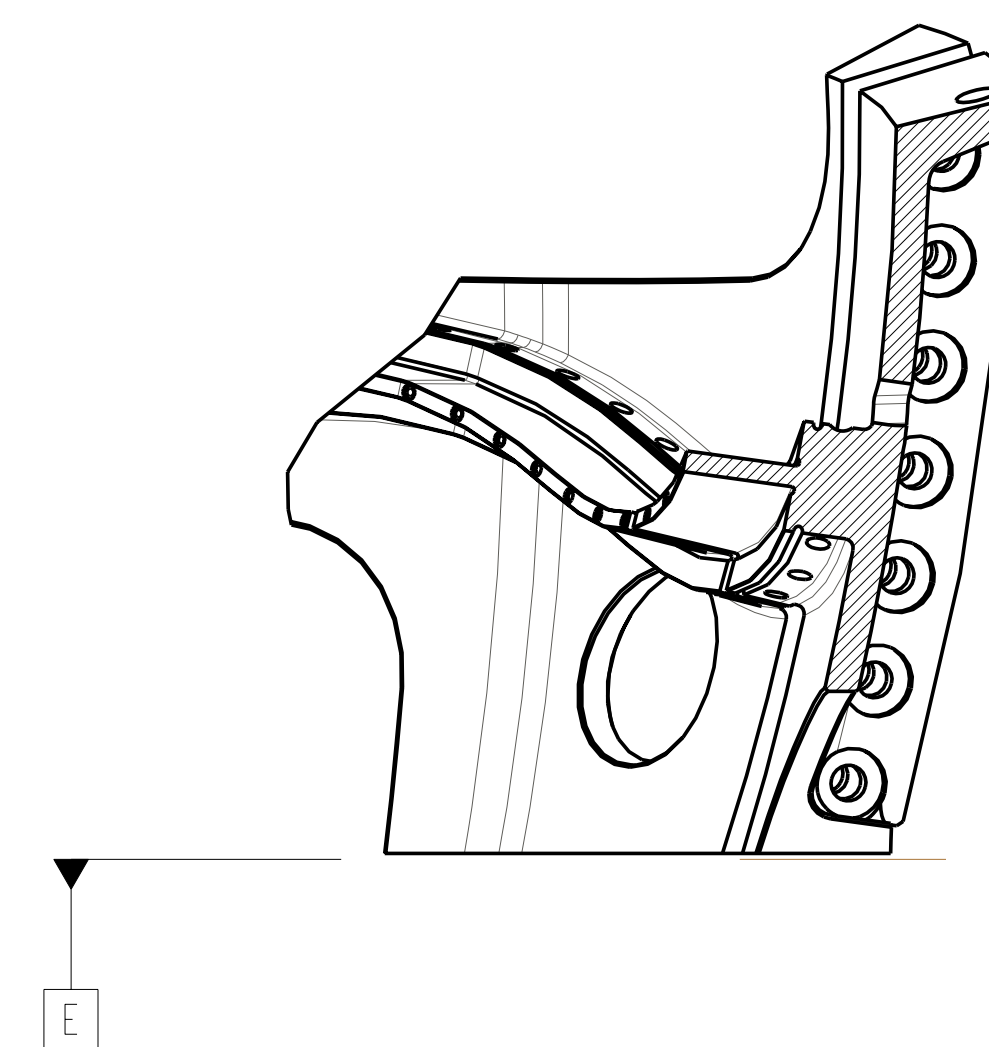
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SCALE 0.125



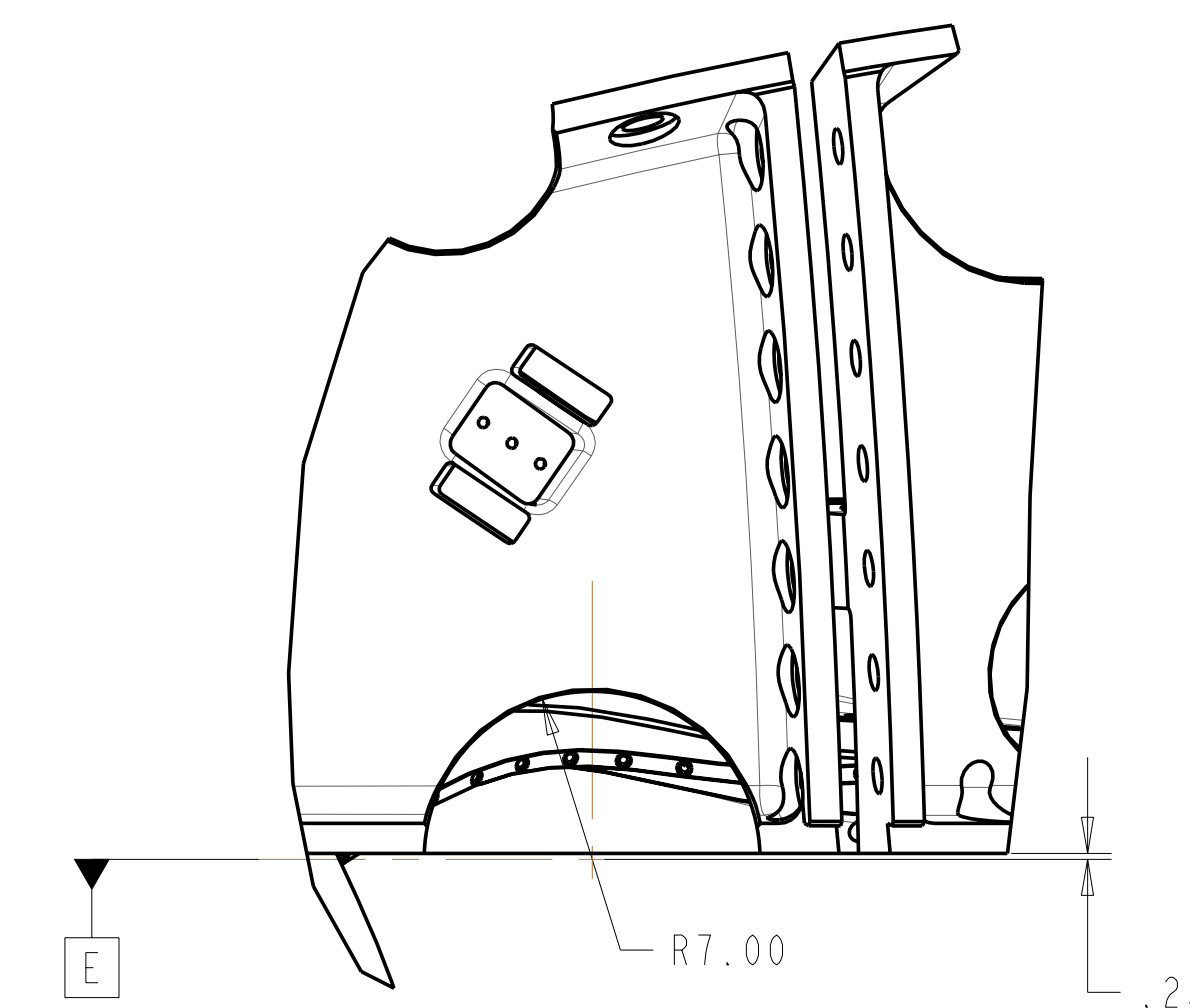
SECTION E3-E3
SCALE 0.125



SECTION E5-E5
SCALE 0.125



SECTION E4-E4
SCALE 0.125



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							
NATIONAL COMPACT STELLARATOR EXPERIMENT MODULAR COIL TYPE-B WINDING FORM							
*							
VERSION NO.	PLANT	BLDG	FL	SHT OF	TYPE	CLASS	
5+	X-10	5700	3	8	8	S	U
RELEASE LEVEL		SEI41-115				REV	
WIP						0	