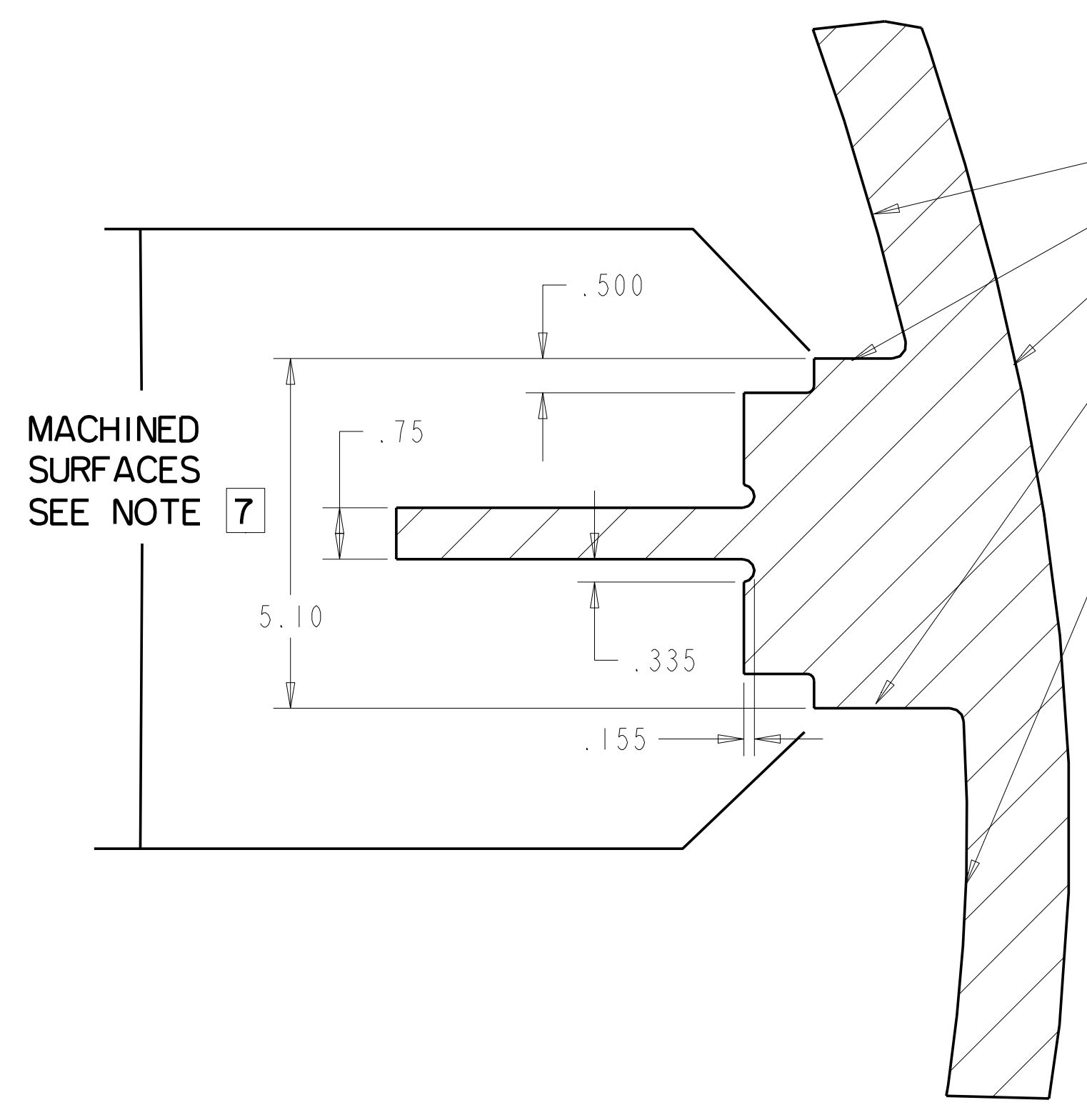
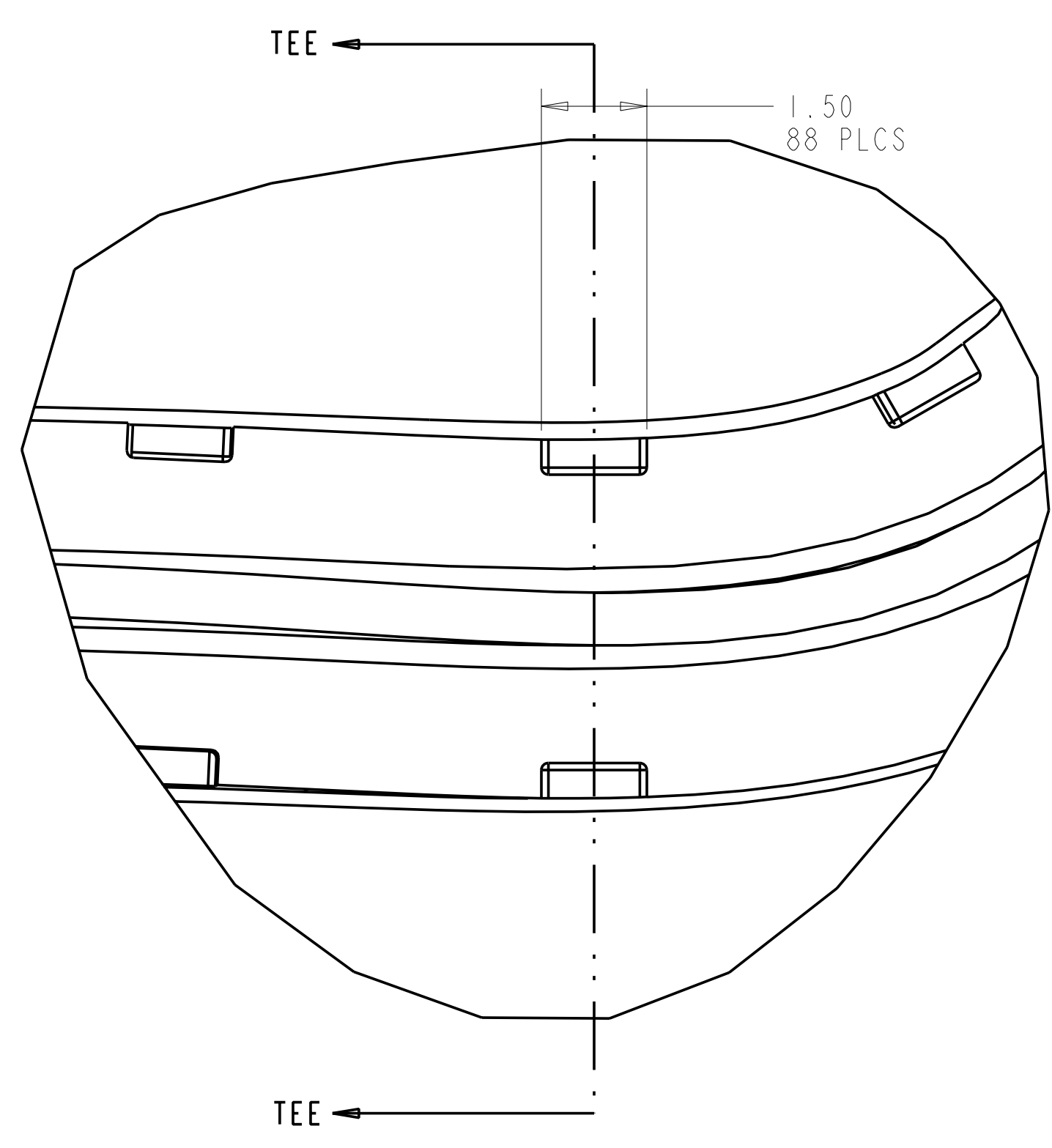
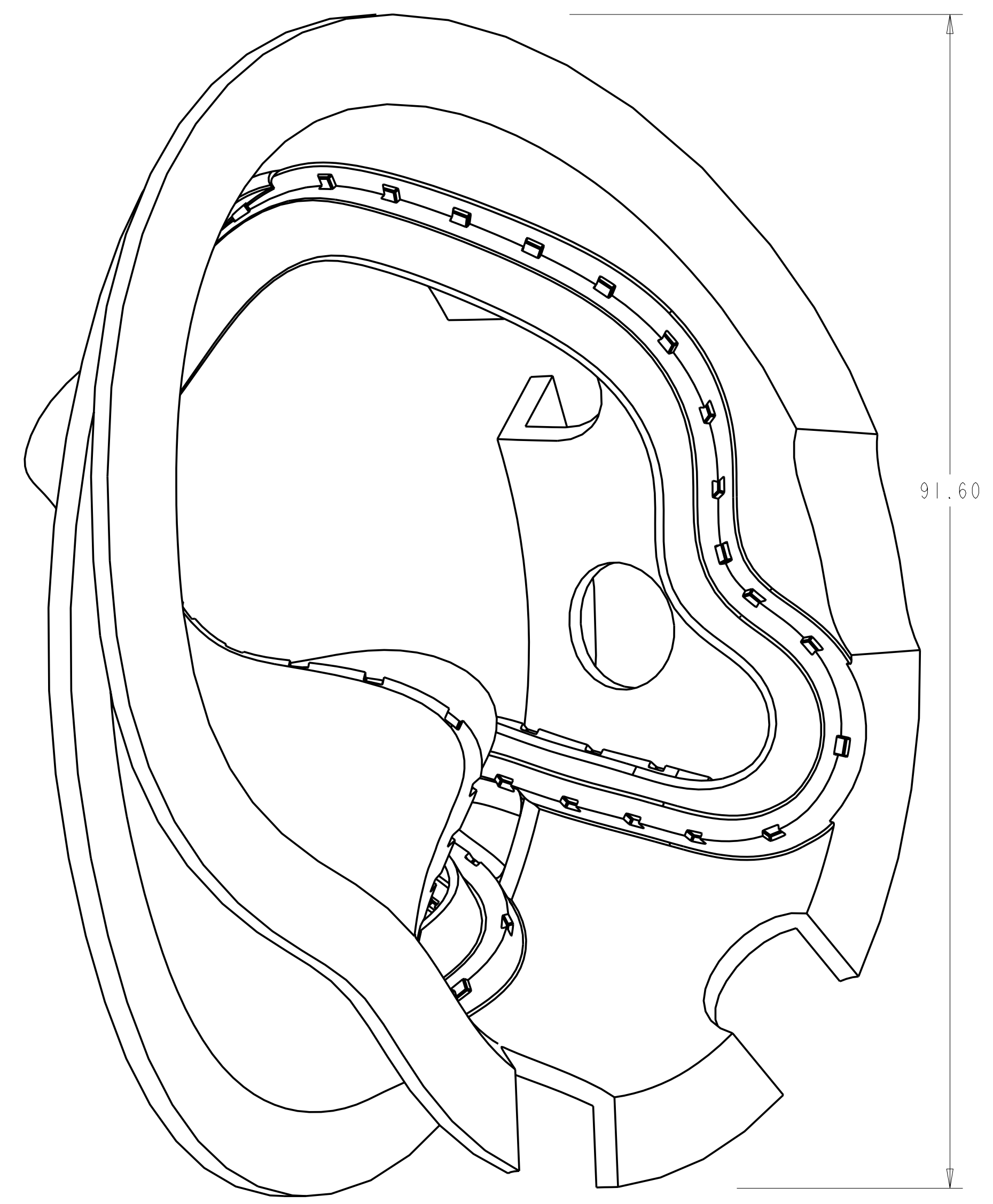
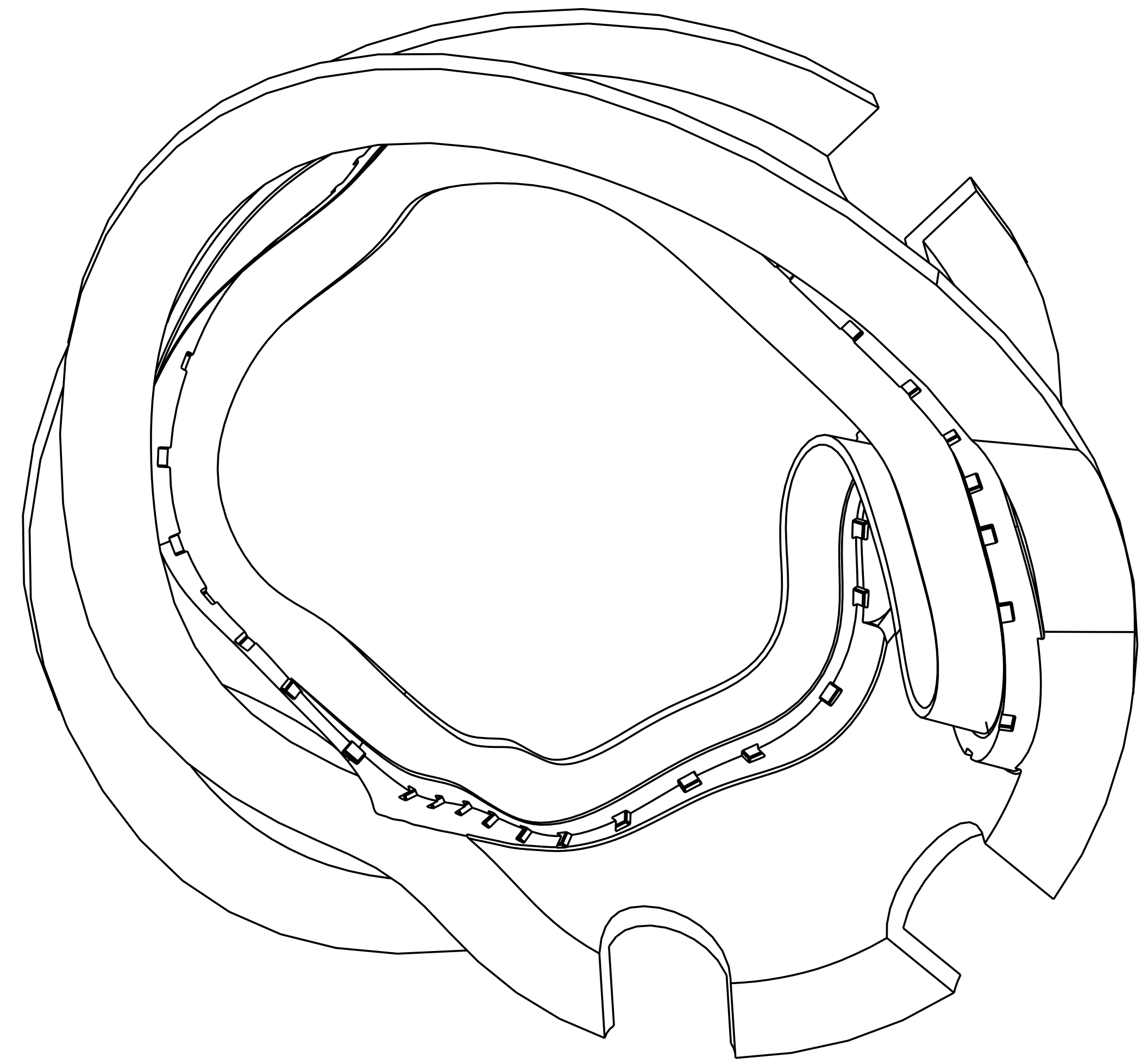


- NOTES:
1. INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M
 2. DIMENSIONS ARE IN INCHES
 3. REMOVE ALL DIRT, GREASE, AND OIL. VISUALLY INSPECT AFTER CLEANING.
 4. SEE SPECIFICATION, NCSX-CSPEC I41-01-01, FOR ADDITIONAL REQUIREMENTS.
 5. GEOMETRY IS DEFINED IN PRO ENGINEER CAD MODELS/FILES SEI41-015.PRT.
 6. DRAWING AND MODELS COMBINED DEFINE FINISHED MACHINED PART.
 7. MACHINED FINISHED SURFACES TO CAD DATA, PROFILE WITHIN 0.020" PROFILE TOLERANCE IS BILATERAL, i.e. 0.010" EITHER SIDE OF THE REFERENCE SURFACE.
 8. AS-CAST SURFACES SHOWN IN NOMINAL MATERIAL CONDITION, THICKNESS TOLERANCE +/- 0.25. SURFACE PROFILE MUST BE WITHIN 0.5 INCHES OF CAD DATA, EXCEPT IN REGIONS OF INTERSECTING SURFACES WHERE FILLETS ARE EXPECTED.
 9. APPROXIMATE WEIGHT IS 4542 LBS.
 10. DIMENSIONS APPLY AT ROOM TEMPERATURE. OPERATING TEMP 80 K.



AS CAST SURFACES SEE NOTE 8

PRELIMINARY
 FOR INFORMATION ONLY

CAGE CODE	PART OR IDENTIFYING NO	M13 SHELL NOMENCLATURE OR DESCRIPTION	SEE NOTE 4 MATERIAL	SEE NOTES SPECIFICATION	FIND NO
next assy					

QUALITY VERIFICATION		
MECHANICAL AND STRUCTURAL REFERENCE ORNL QA-605		
QV CLAUSE	DOCUMENTS REQUIRED	APPLICABLE TO PART NO *
30.3	MATERIAL MILL TEST REPORT	
32.5	MATERIAL SELLER CERT	X
32.6	SPECIAL MATERIAL INSPECTION REPORT	
20.5	MANUFACTURING INSPECTION AND TEST PLAN	X
31.2	FITTED INSPECTION AND TEST PLAN	
32.1	WELD AND GRADE INSPECTION REPORT	X
32.2	HEAT TREAT REPORT (MATERIAL)	X
31.0	CLEAN 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

TYPICAL SECTION THRU COIL "TEE" WINDING

SCALE 0.500

REV	DESCRIPTION	A-E	BY	CHK	SECT	DEPT	DATE	PE	REQ. DATE	ORNL DATE	DOE DATE	QA	CV	EC	EE	EM	IE	M	PD	SE	ST	XAD	PES
-	ISSUE FOR INFORMATION ONLY																						

SCALE .125 UNO

DES: DAVID WILLIAMSON 3-20-03
 DRW: GARY LOVETT 3-20-03

UT-BATTELLE
 NATIONAL COMPACT STELLERATOR EXPERIMENT

TYPE "C" WINDING FORM

VERSION NO.	PLANT	BLDG	FL	SHT OF	TYPE	CLASS
5	X-10	9201-2	X	1	I	U

RELEASE LEVEL: WIP

SEI41-015

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P THIS DRAWING PRODUCED ON PRO-ENGINEER

H
G
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