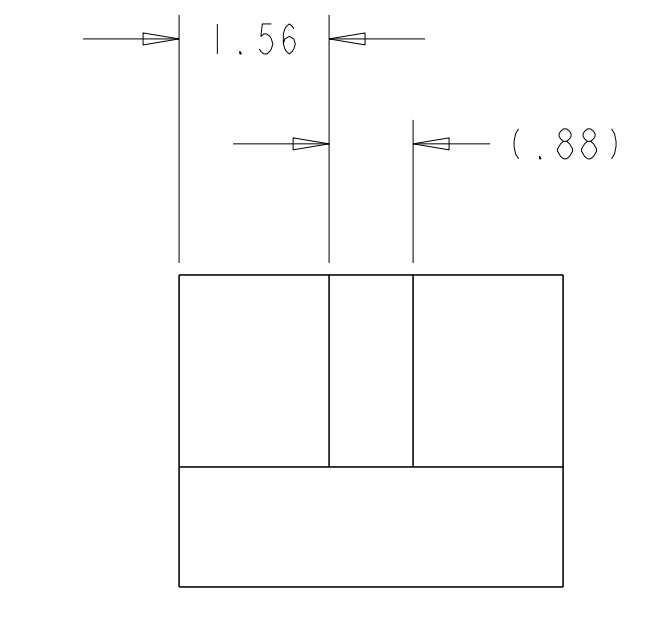
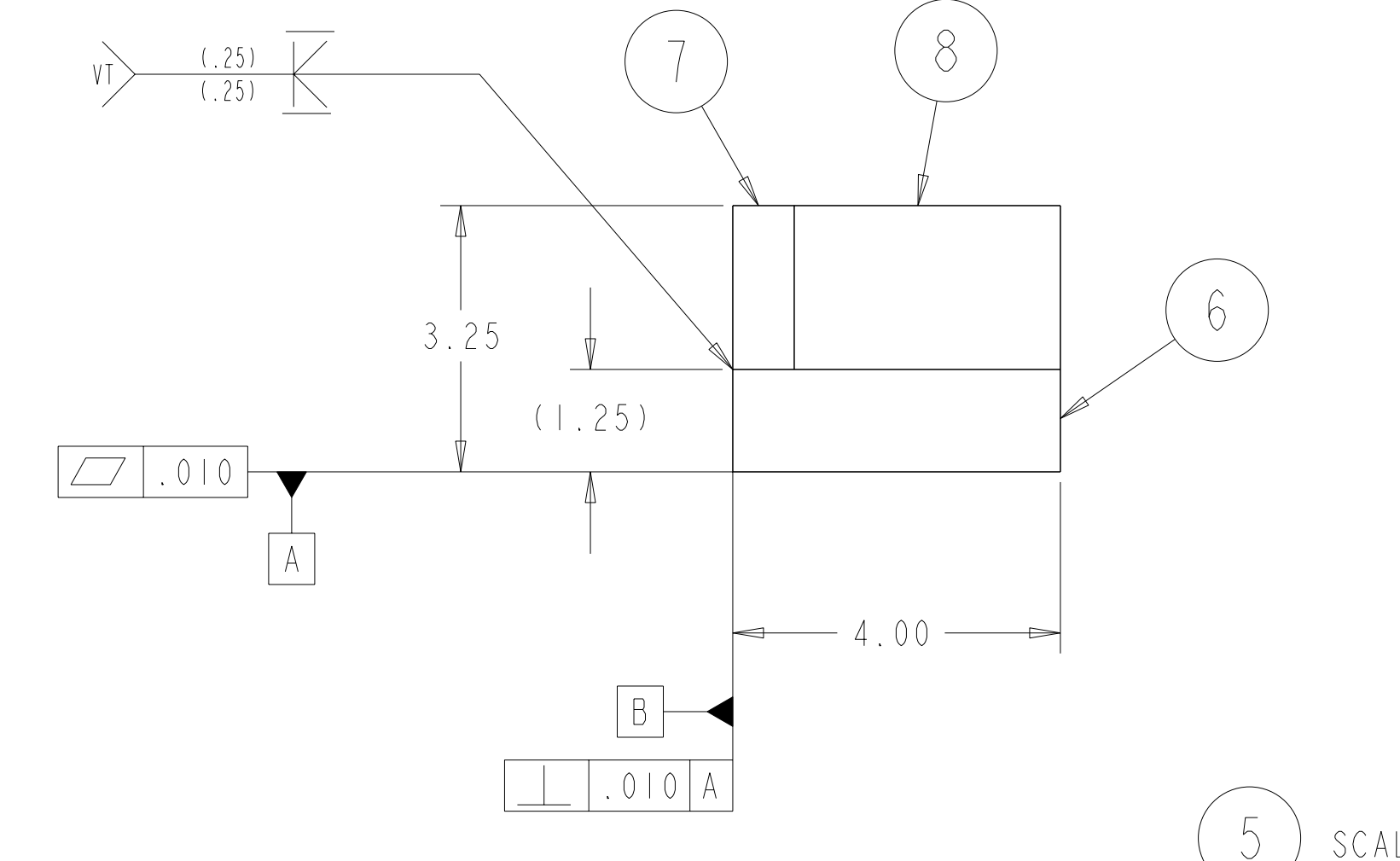
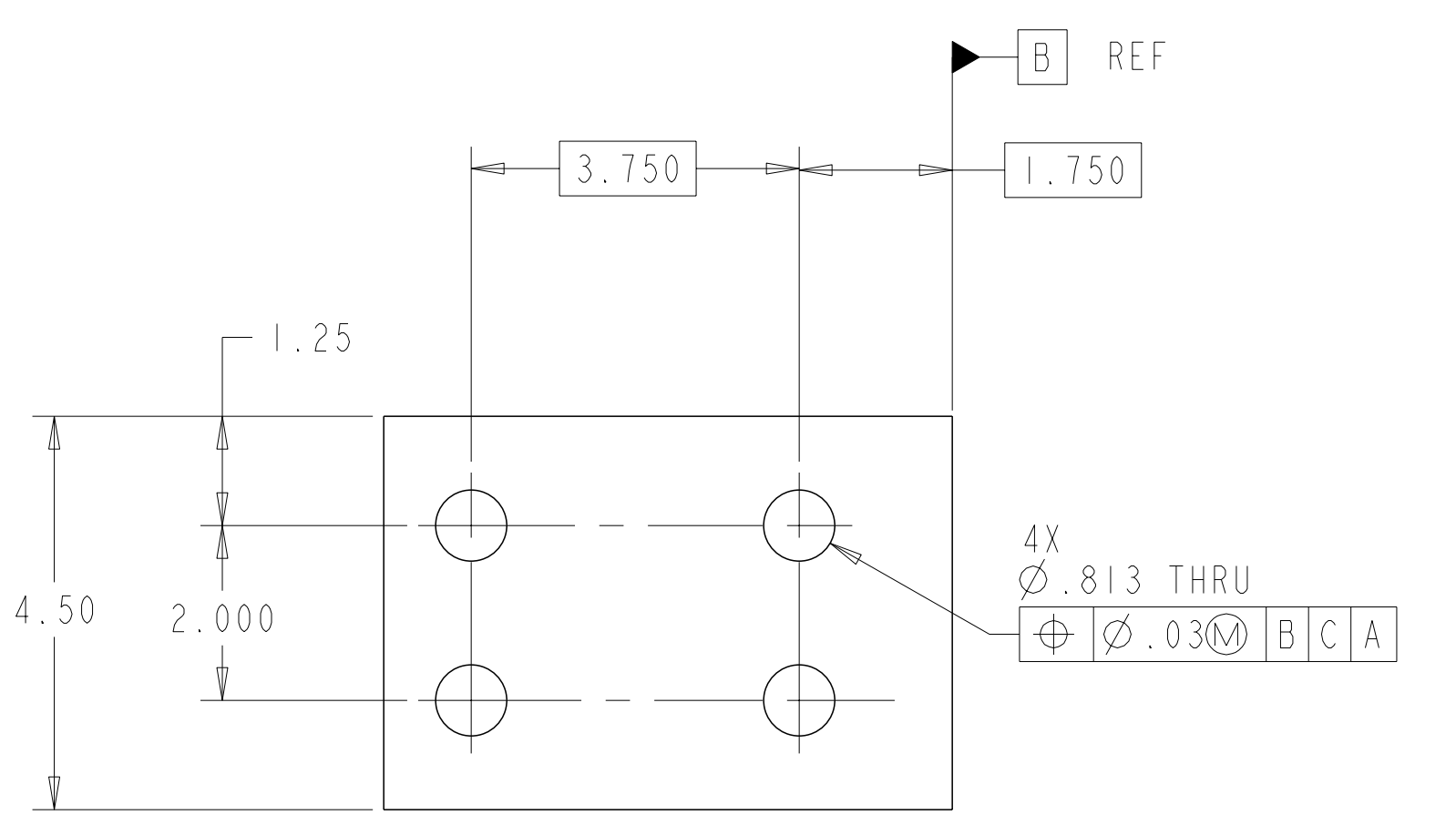
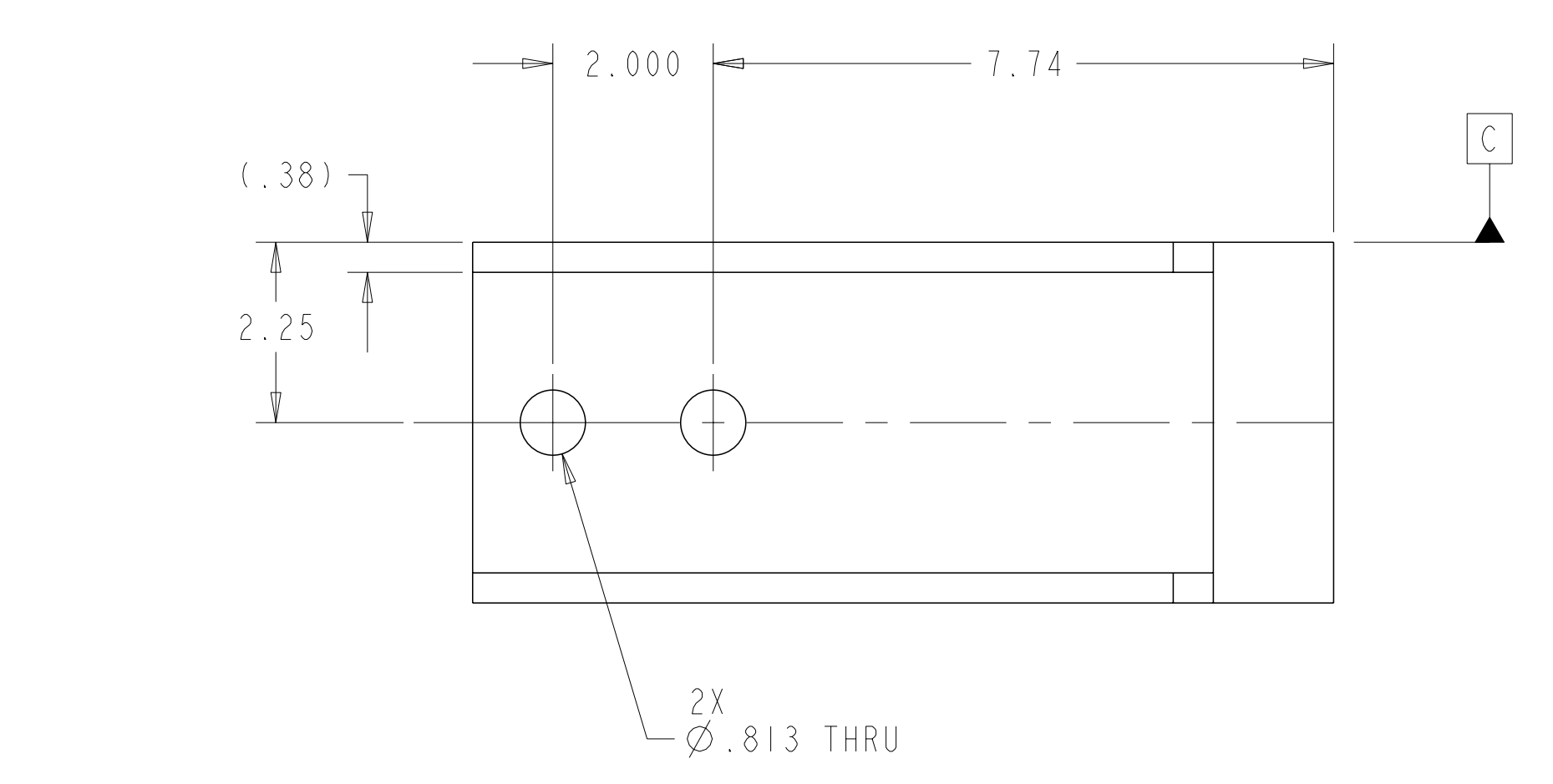
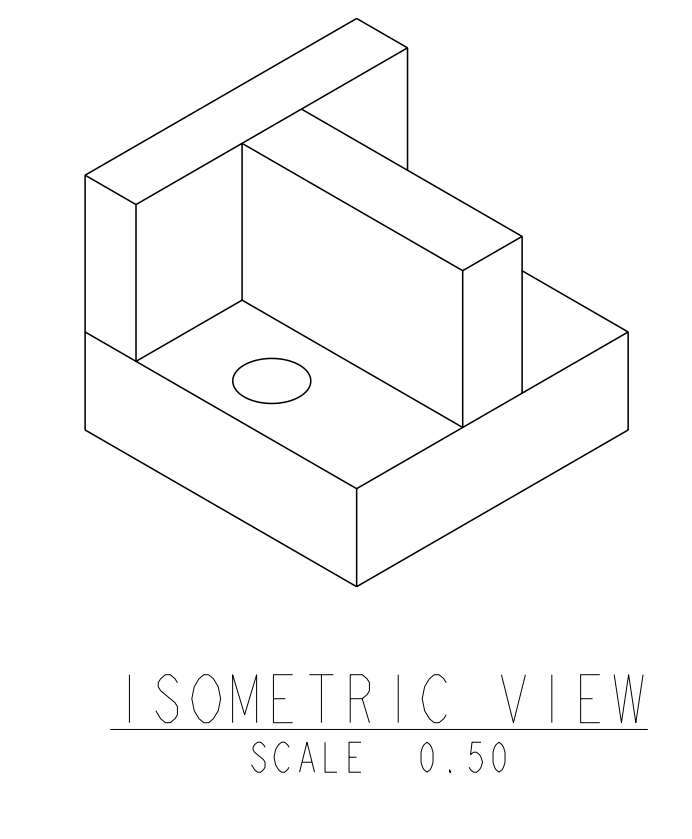
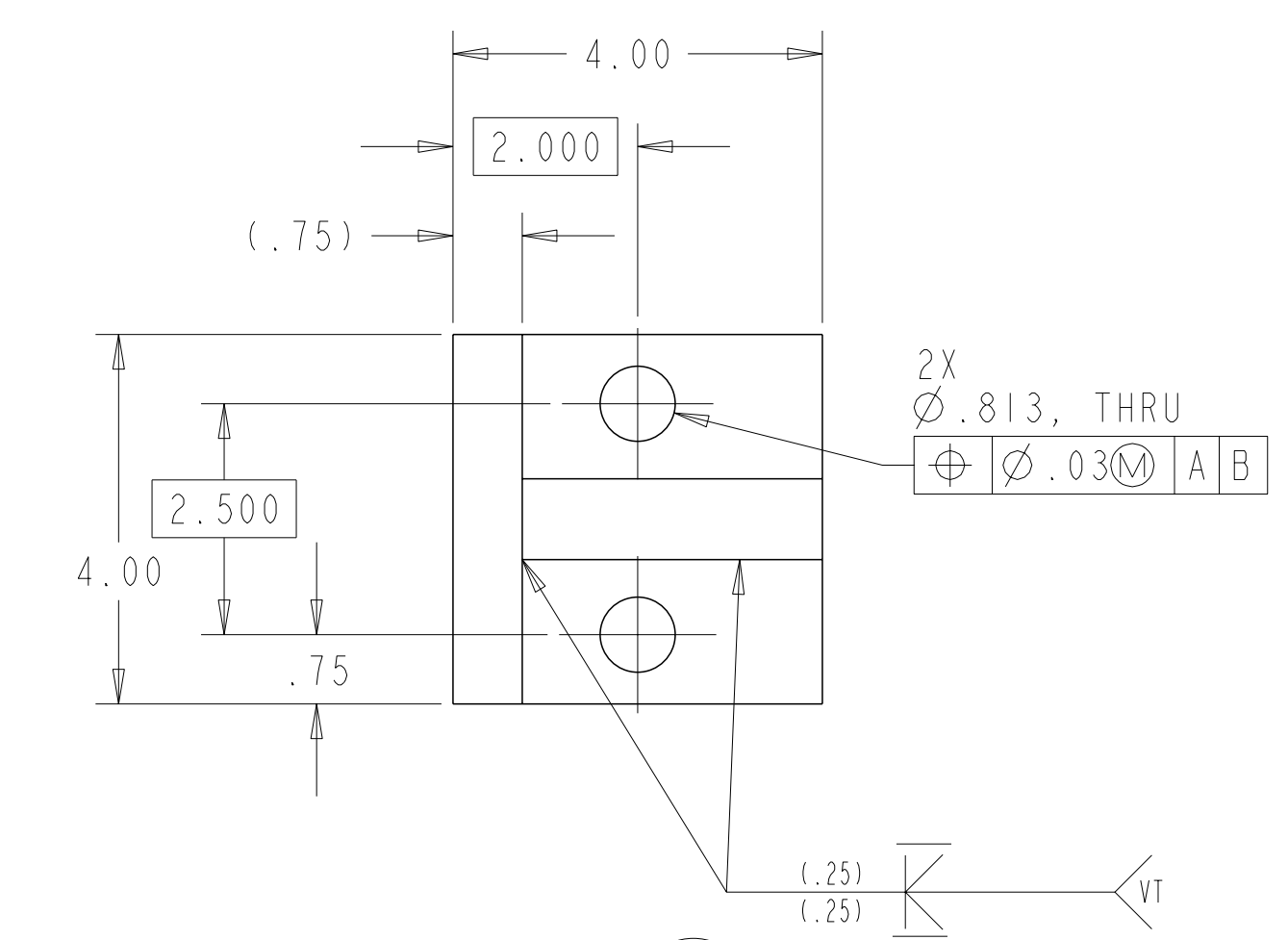
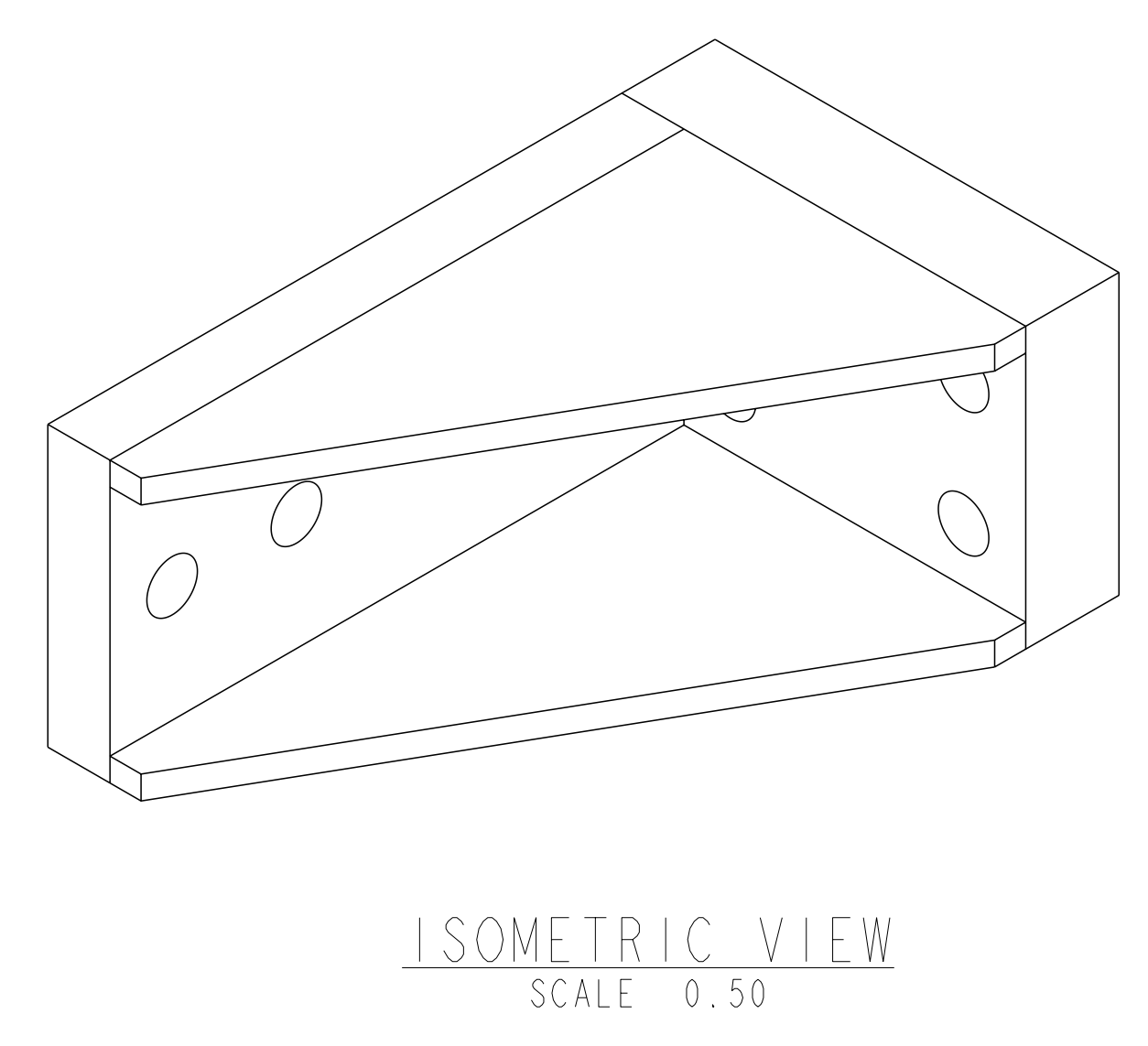
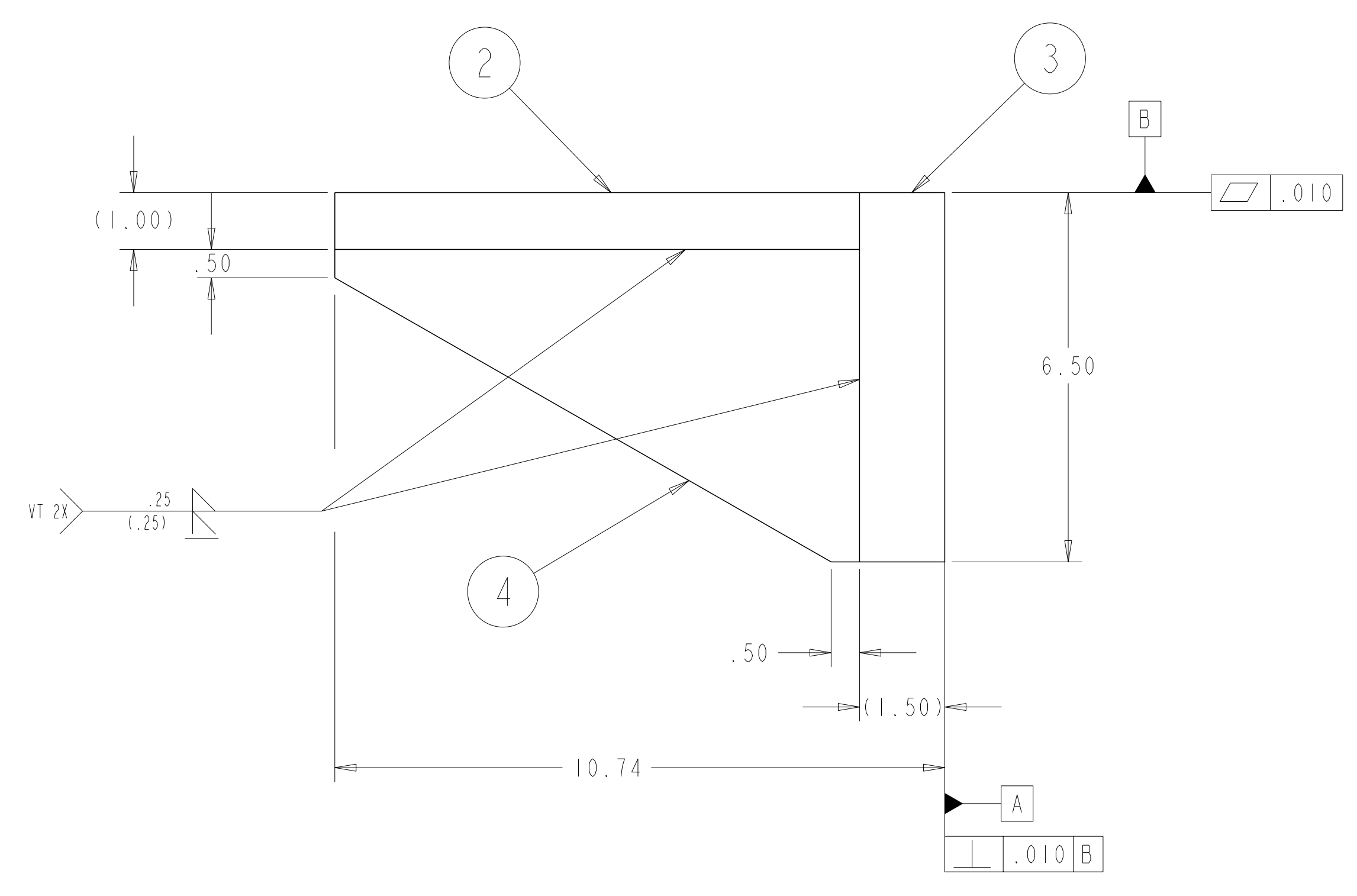
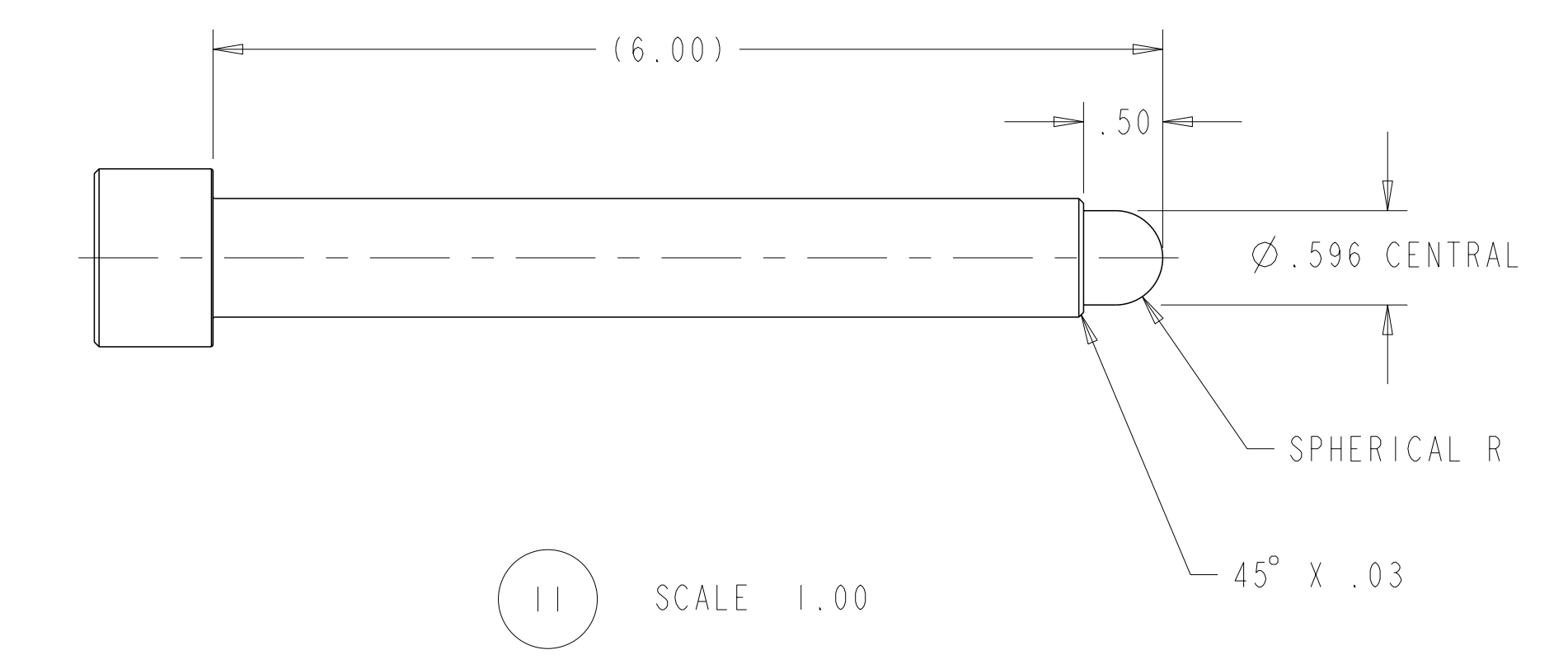
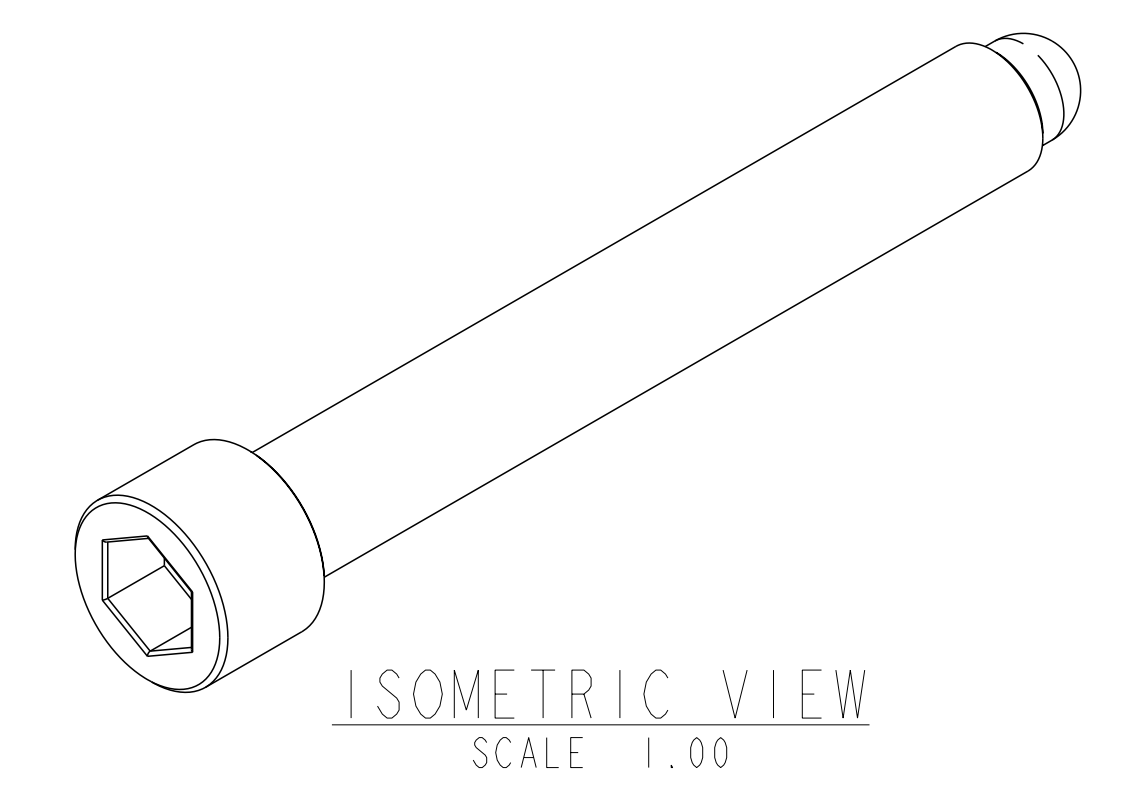
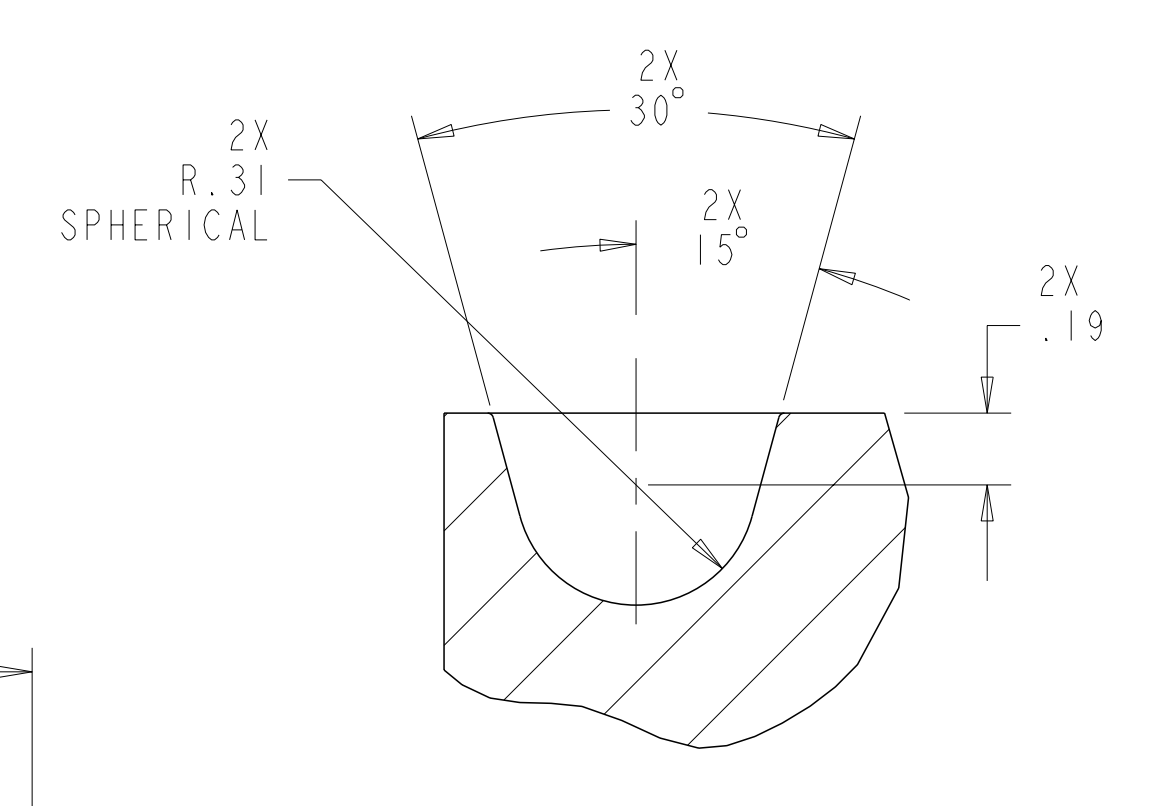


- NOTES:**
1. INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M
  2. DIMENSIONS ARE IN INCHES
  3. WELDING PROCEDURES AND PERFORMANCE QUALIFICATIONS SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF ASME CODE, SECTION IX. WELDS MAY BE MADE BY THE GTAW OR GMAW PROCESSES. WELDS USING SMAW PROCESS ARE NOT PERMITTED.
  4. WELD INSPECTIONS SHALL BE PERFORMED BY VISUAL EXAMINATION: ALL WELDS ARE TO BE VISUALLY INSPECTED IN ACCORDANCE WITH ARTICLE 9, SECTION V OF THE ASME CODE. WELDS DESIGNATED WITH A VT IN THE REFERENCE AREA OF A WELD SYMBOL SHALL ALSO BE VISUALLY EXAMINED WITH 8X MAGNIFICATION. IN ACCORDANCE WITH ARTICLE 6, SECTION V OF THE ASME CODE, THE ACCEPTANCE CRITERIA FOR THE VISUALLY INSPECTED WELDS
  5. DIMENSIONS APPLY AT TEMPERATURE OF 20-30°C (68-86°F)
  6. ITEM -5 MAY BE MACHINED FROM A SINGLE PIECE, AT DISCRETION OF VENDOR.

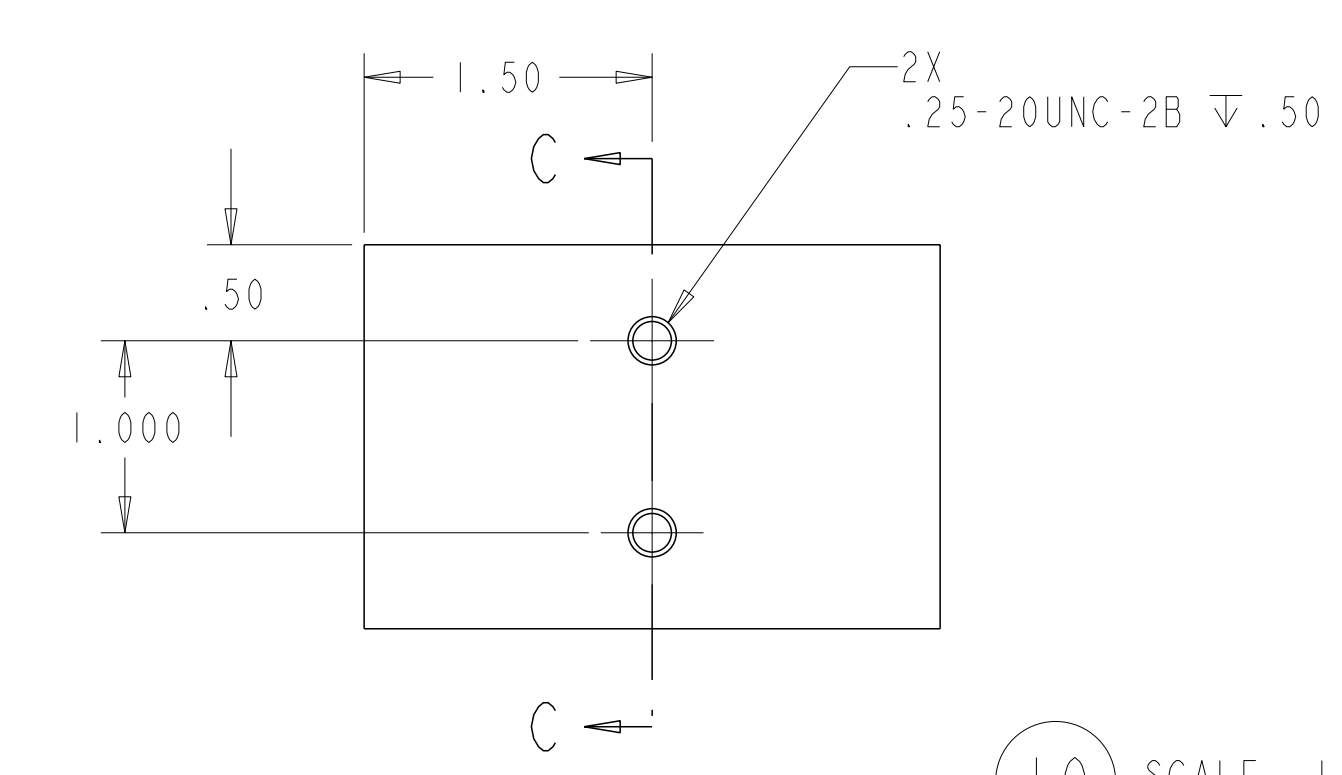
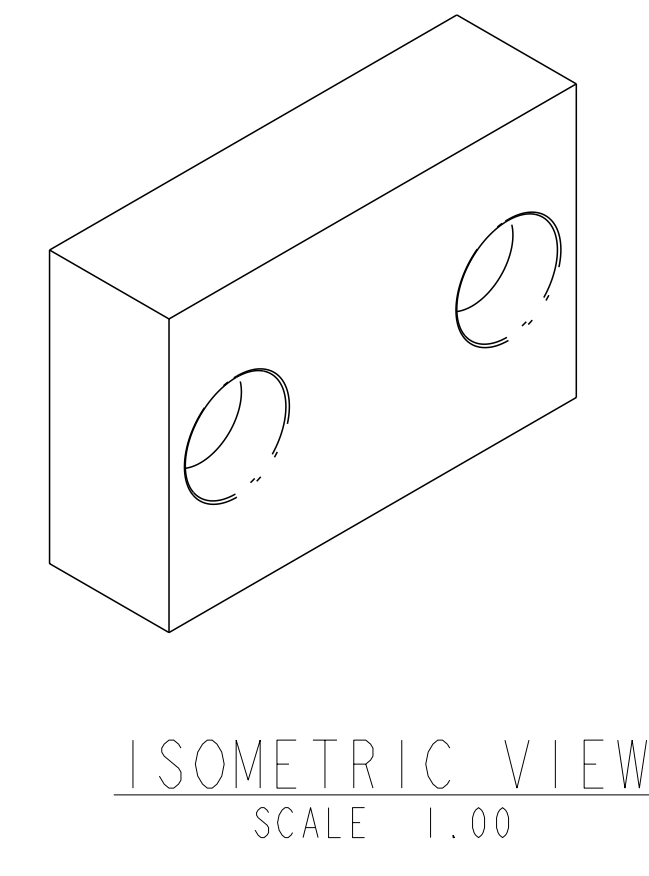
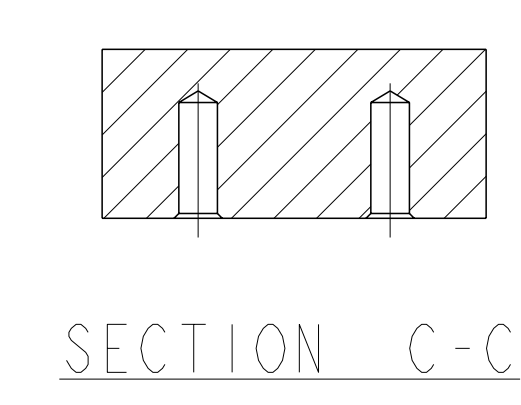
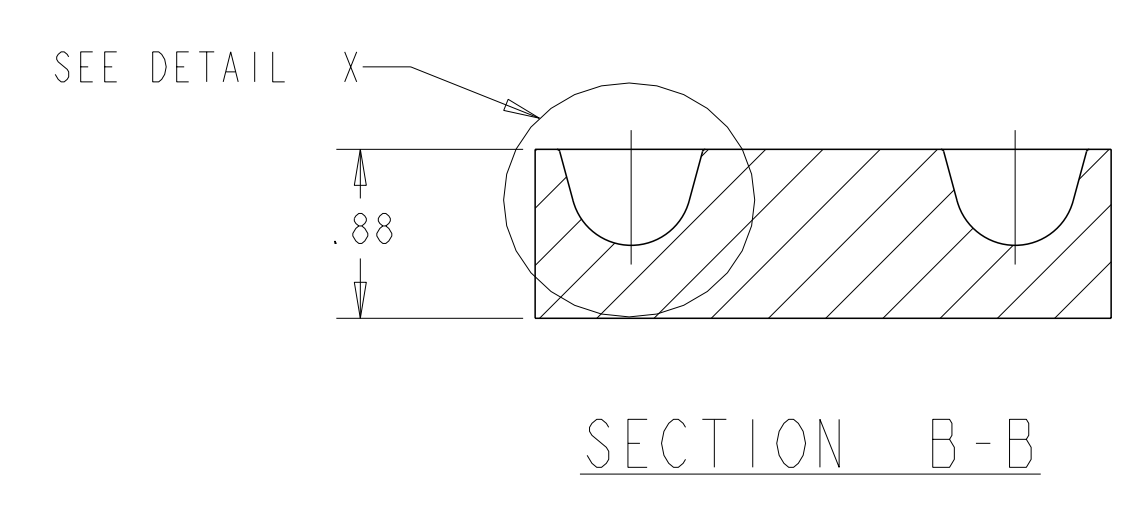
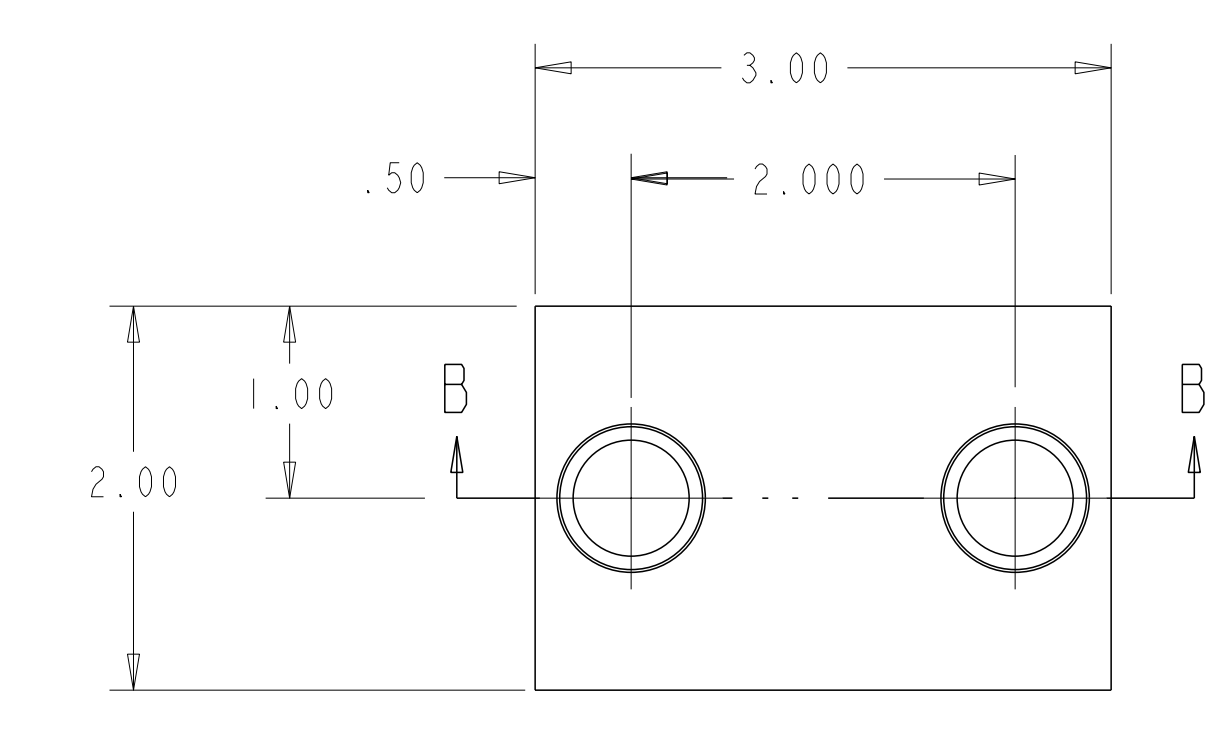


1 SCALE 0.50

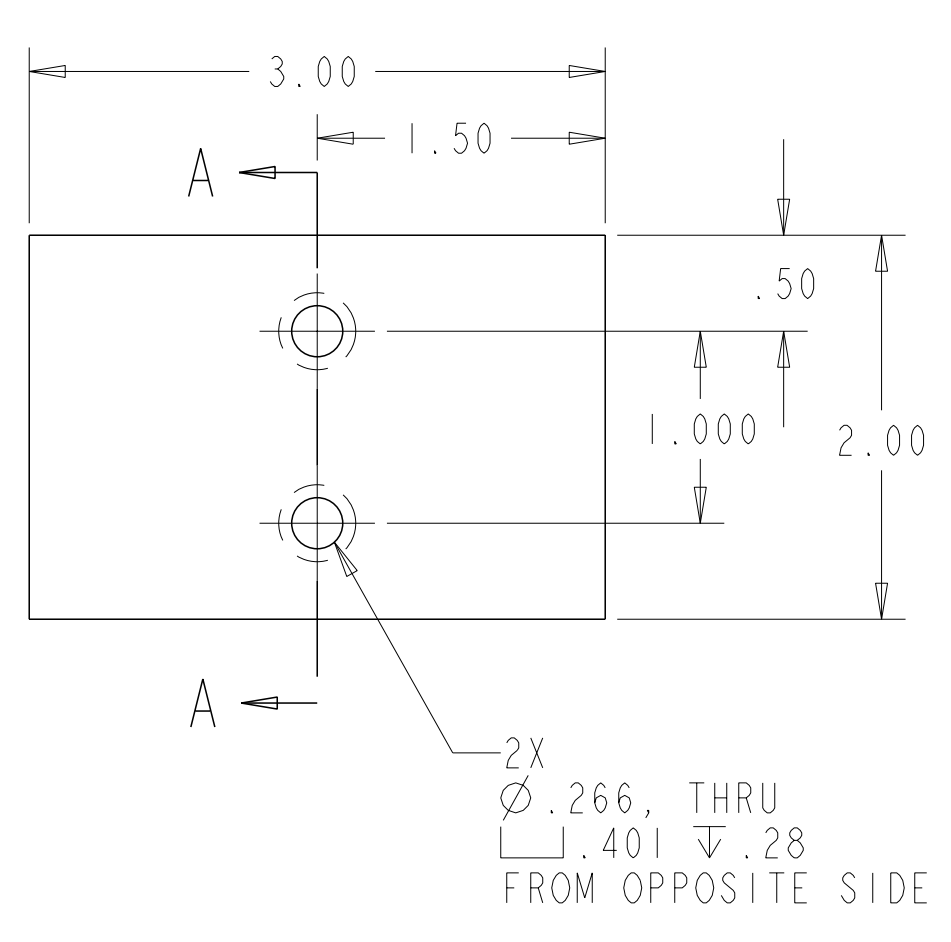
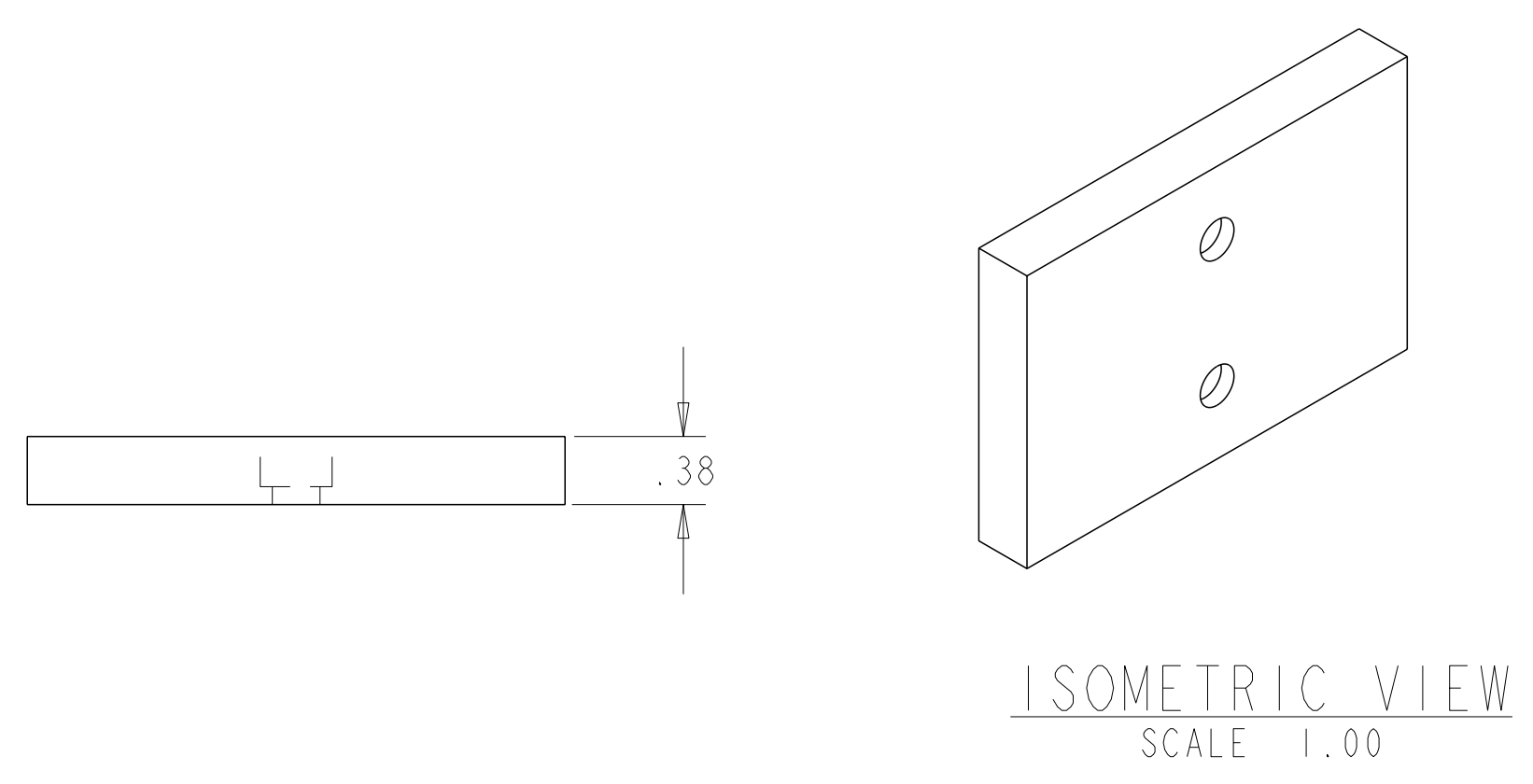
5 SCALE 0.50



11 SCALE 1.00



10 SCALE 1.00



SECTION A-A

9 SCALE 1.00

| REV | DESCRIPTION               | BY  | DATE   | CHK | DEPT | DATE | PE | REQ | DATE | ORNL | DOE | DATE | CLASS |
|-----|---------------------------|-----|--------|-----|------|------|----|-----|------|------|-----|------|-------|
| 0   | ORIGINAL ISSUE            | GHJ | 3/3/05 | JMR |      |      |    |     |      |      |     |      |       |
| 1   | REVISION OR ISSUE PURPOSE |     |        |     |      |      |    |     |      |      |     |      |       |

| AR        | AR  | QTY                 | DESCRIPTION                                | MATERIAL               | SPECIFICATION               | FIND NO  |               |         |
|-----------|-----|---------------------|--|------------------------|-----------------------------|----------|---------------|---------|
| AR        | -12 |                     | WELD, FILLER METAL                         |                        |                             | 12       |               |         |
| AR        | -10 | .75-10UNC X 6.00 LG | SCREW, SOC HD CAP (MODIFIED)               | NICKEL ALLOY A286      | ASME B18.3                  | 11       |               |         |
| AR        | -10 |                     | PAD  | 316 SST                | ASTM 240                    | 10       |               |         |
| AR        | -9  |                     | INSULATING PAD                             | G-11                   |                             | 9        |               |         |
| I         | -8  |                     | WEB, .88 THK                               | 316 SST                | ASTM 240                    | 8        |               |         |
| I         | -7  |                     | FRONT PLATE, .75 THK                       | 316 SST                | ASTM 240                    | 7        |               |         |
| I         | -6  |                     | BASE PLATE, 1.25 THK                       | 316 SST                | ASTM 240                    | 6        |               |         |
| AR        | -5  |                     | NB PORT STOP BRACKET WELDMENT              |                        |                             | 5        |               |         |
|           | -4  |                     | WEB, .38 THK                               | 316 SST                | ASTM 240                    | 4        |               |         |
|           | -3  |                     | SIDE PLATE 1.50 THK                        | 316 SST                | ASTM 240                    | 3        |               |         |
|           | -2  |                     | FRONT PLATE, 1.00 THK                      | 316 SST                | ASTM 240                    | 2        |               |         |
| AR        | -1  |                     | MODULAR COIL WINDING FORM BRACKET WELDMENT |                        |                             | 1        |               |         |
| SE124-071 | -5  |                     | CAGE CODE                                  | PART OR IDENTIFYING NO | NOMENCLATURE OR DESCRIPTION | MATERIAL | SPECIFICATION | FIND NO |

← NEXT ASSEMBLY

| SCALE NOTED | DES           | DATE     | DRW        | DATE     | CHK      | DATE     | SECT | DEPT | PE | CR | PJ | RED | PPPL | DRAFT | FINISH |
|-------------|---------------|----------|------------|----------|----------|----------|------|------|----|----|----|-----|------|-------|--------|
|             | P.L. GORANSON | 02/16/05 | G.H. JONES | 02/16/05 | J.M. RAY | 04-07-05 |      |      |    |    |    |     |      |       |        |

| VERSION NO. | PLANT | BLDG | FL | SHT | OF | TYPE | CLASS |
|-------------|-------|------|----|-----|----|------|-------|
| 64          | ORNL  | 5700 | 3  | 1   | 1  | A    | U     |

RELEASE LEVEL: WIP

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**P** THIS DRAWING PRODUCED ON PRO-ENGINEER

| SCALE NOTED | DES           | DATE     | DRW        | DATE     | CHK      | DATE     | SECT | DEPT | PE | CR | PJ | RED | PPPL | DRAFT | FINISH |
|-------------|---------------|----------|------------|----------|----------|----------|------|------|----|----|----|-----|------|-------|--------|
|             | P.L. GORANSON | 02/16/05 | G.H. JONES | 02/16/05 | J.M. RAY | 04-07-05 |      |      |    |    |    |     |      |       |        |

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**UT-BATTELLE**

NATIONAL COMPACT STELLARATOR EXPERIMENT

LATERAL SUPPORT MODULAR COIL WINDING FORM BRACKET WELDMENTS & DETAILS

SE124-073