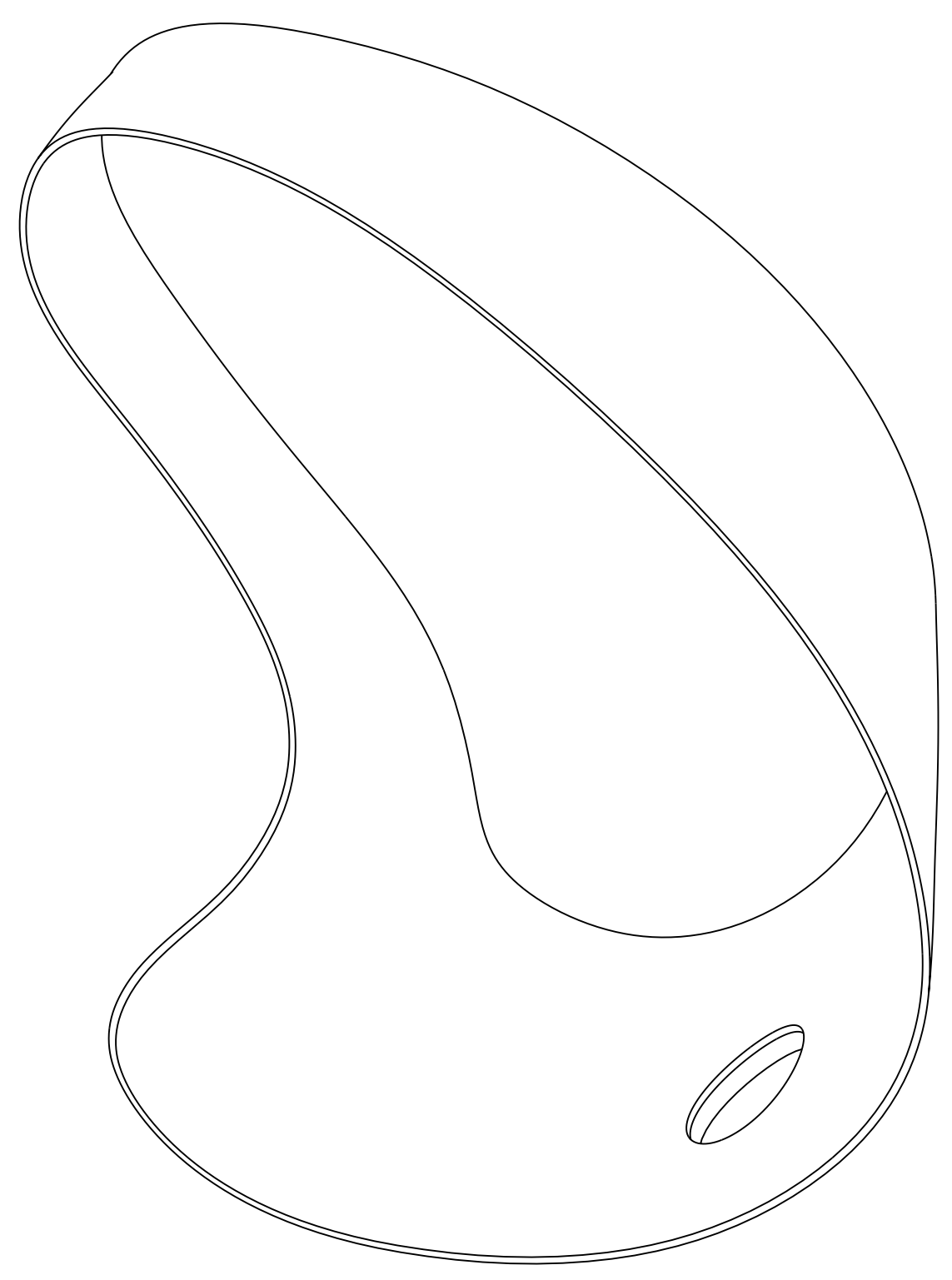
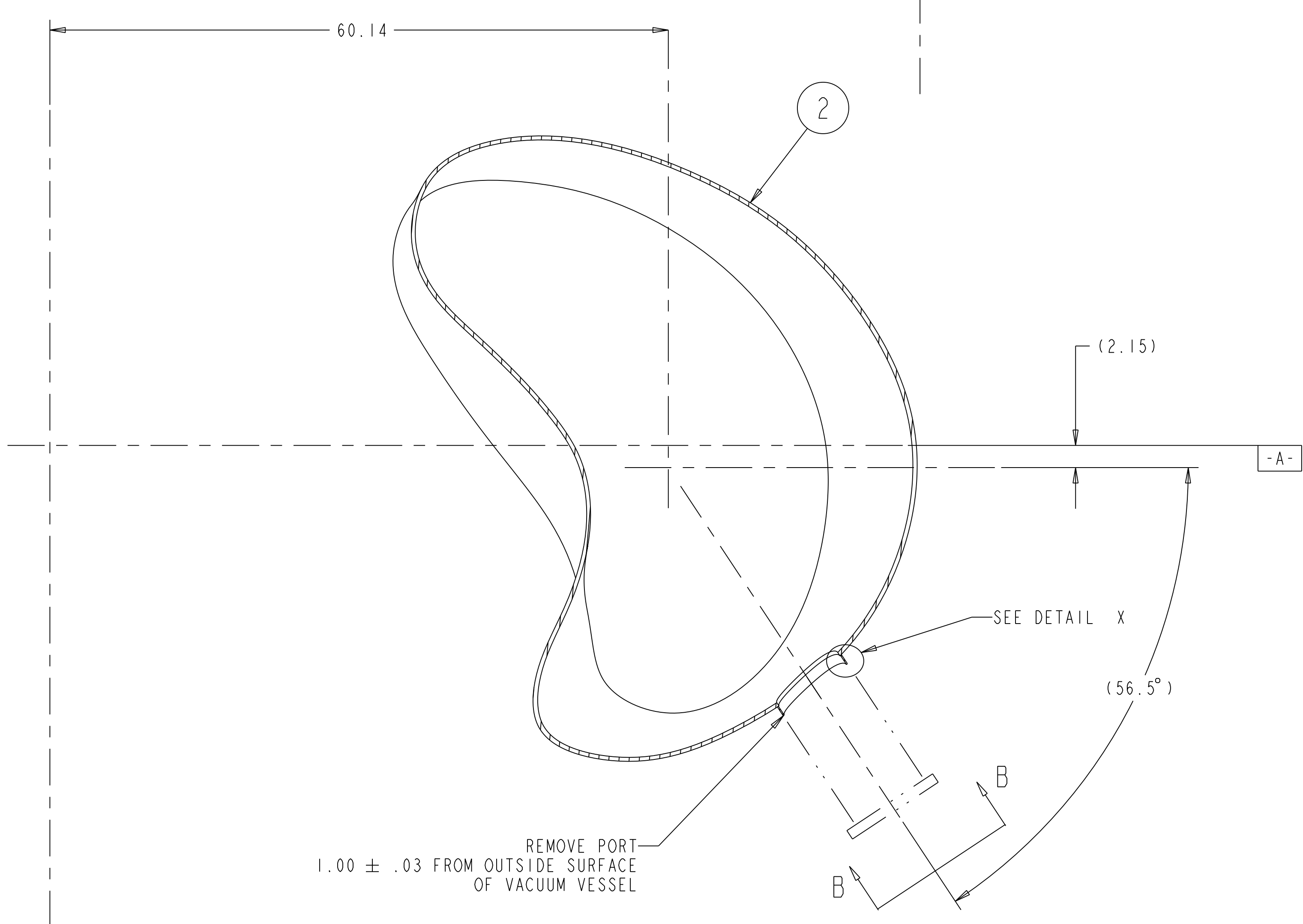
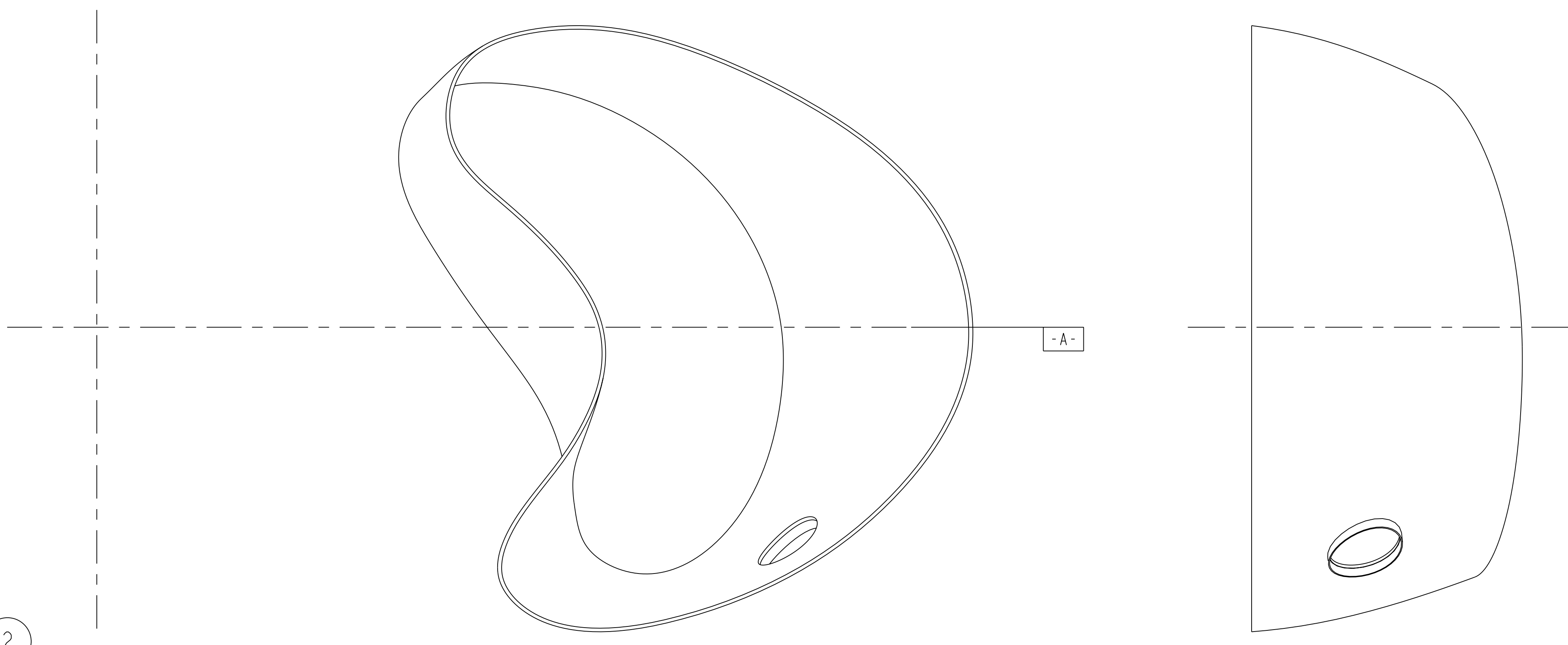
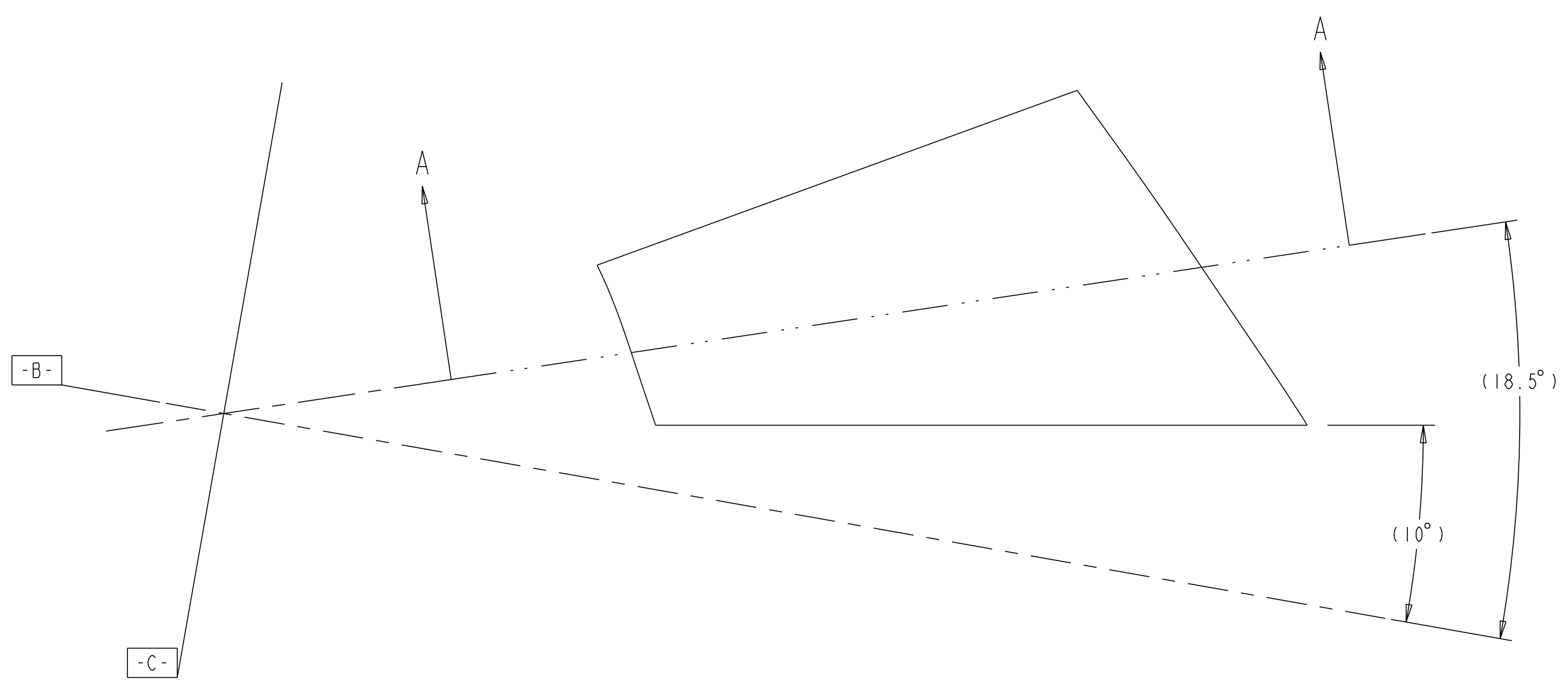


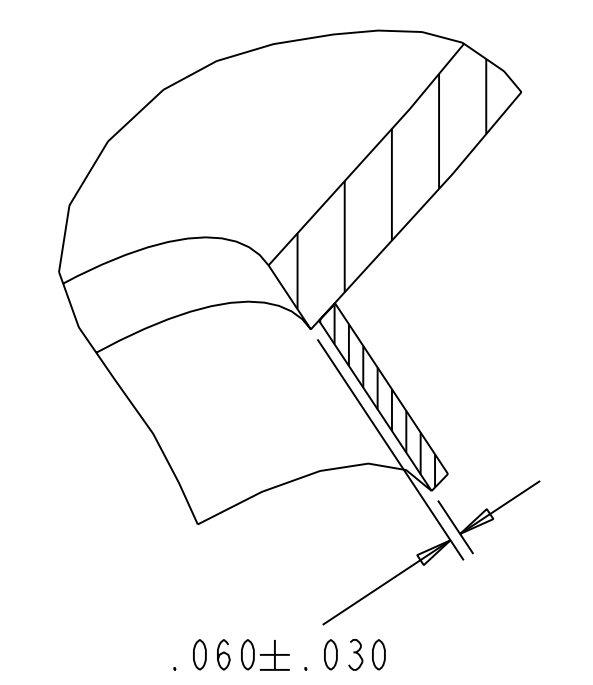
- NOTES:**
- INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M.
  - DIMENSION ARE IN INCHES.
  - REQUIREMENTS FOR FABRICATING THE VACUUM VESSEL PROTOTYPE ARE DEFINED IN THE DRAWINGS, MODELS, AND SPECIFICATION, NCSX-CSPEC-121-01-00 AND STATEMENT OF WORK, NCSX-SOW-121-01-01.
  - GEOMETRY OF VACUUM VESSEL PROTOTYPE IS DEFINED IN CAD MODELS/FILES SE121-001P.ASM, SE121-002P.ASM, AND SE121-003P.ASM.



ISOMETRIC VIEW



SECTION A-A



DETAIL X  
SCALE: 1.00

① SCALE: .12

SE121-003P	AR	SE121-001P	PORT WELDMENT	2
		-1	PORT MODIFICATION DETAILS	1
			NOMENCLATURE OR DESCRIPTION	MATERIAL
			SPECIFICATION	FIND NO
			NEXT ASSEMBLY	PARTS LIST

QV CLAUSE	DOCUMENTS REQUIRED	APPLICABLE TO PART NO *
303	MATERIAL MILL TEST REPORT	
325	MATERIAL SELLER CERT	X
326	SPECIM MATERIAL INSPECTION REPORT	X
205	WELDING, INSPECTION AND TEST PLAN	X
312	FIELD INSPECTION AND TEST PLAN	X
321	WELD AND BRAZE INSPECTION REPORT	
322	HEAT TREAT REPORT (W/CRIT)	
318	LEAK TEST REPORT	
315	CLEANING CERT	X
318	DEVIATION REQUEST	X
319	NONCONFORMANCE REPORT	X
323	DIMENSIONAL REPORT	X
330	FUNCTIONAL TEST REPORT	
100	DOCUMENTATION	X

\* SYMBOL X INDICATES APPLICABLE TO ALL PARTS OR ITEMS

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.

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

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

SCALE NOTED		DES P. L. GORANSON		UT-BATTELLE	
TOLERANCES UNLESS OTHERWISE SPECIFIED		CHK G. H. JONES		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 .01		M. J. COLE		PROJECT NAME NATIONAL COMPACT STELLERATOR EXPERIMENT	
XX DECIMALS ± .01				DEPT	
XXX DECIMALS ± .005				PROTOTYPE VACUUM VESSEL SEGMENT PORT MODIFICATIONS	
ANGLES ± 0°15'				DETAILS	
BREAK SHARP EDGES OR MAX FINISH .125 UNLESS OTHERWISE SPECIFIED		PPPL DRFT J. SIEGEL		VERSION NO. 9+	
		DRAWING APPROVALS DATE		PLANT Y-12	
				BLDG 9201-2	
				FL 2	
				SHT 1	
				OF 1	
				TYPE A	
				CLASS U	
				RELEASE LEVEL WIP	
				SE121-002P	
				REV 0	