

Major Tool & Machine, Inc.
1458 East 19th Street
Indianapolis, IN 46218-4289

MTM N/C: 18237

Page: 1
Date: 09/21/05
User ID: BOWLINK

Customer: ENERGY INDUSTRIES OF OHIO

Contact: NANCY HORTON
E-Mail: NKHFlowen@aol.com

Telephone: 216-496-2314
Fax: 216-328-2001

Part: SE141-116 / MODULAR COIL WINDING FORM TYPE
Drawing ID: SE141-116 Revision: 6

Customer P.O.: S005242-F/Ln:1
Serial No./Qty: C1

Reported By: KEVIN BOWLING
E-Mail: kBowling@MajorTool.com

Telephone: 317-636-6433
Fax: 317-634-9420

Problem: AFTER MACHINING SEVERAL MACHINING DEFECTS ON THE OUTSIDE OF THE PART WERE
DETECTED UPON VISUAL EXAMINATION. SEE ADDITIONAL DOCUMENTS FOR MAPS AND LISTS OF
(9) SEPARATE NON-CONFORMING FEATURES.

Proposed Disposition:

SUBMIT TO CUSTOMER CONTINUE MANUFACTURING.

Customer Disposition: ☐ Use As Is ☒ Rework ☐ Repair ☐ Scrap ☐ Replace

ITEM 3 - BLEND TROUGH SMOOTHLY

ITEMS 1, 2, 4, 5, 6, 7, 8, 9 - REMOVE SHARP EDGES, GRIND
FLUSH

Technical Contact Approval:

RLM

Buyer Approval:

Title:

Title: RLM

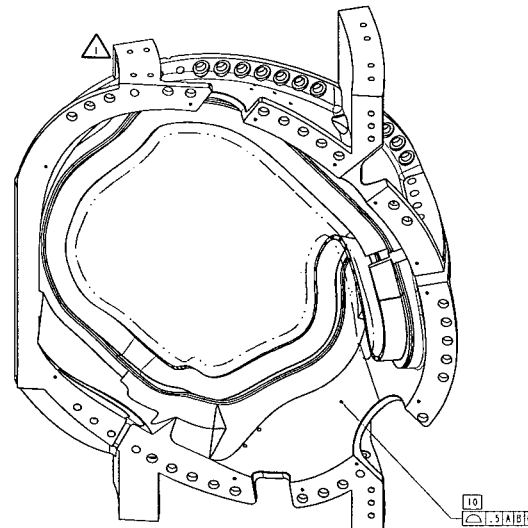
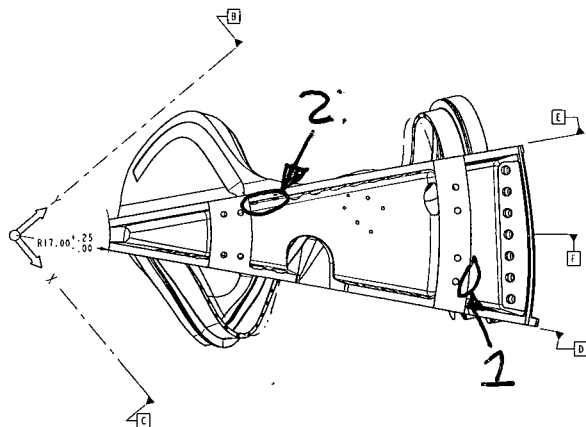
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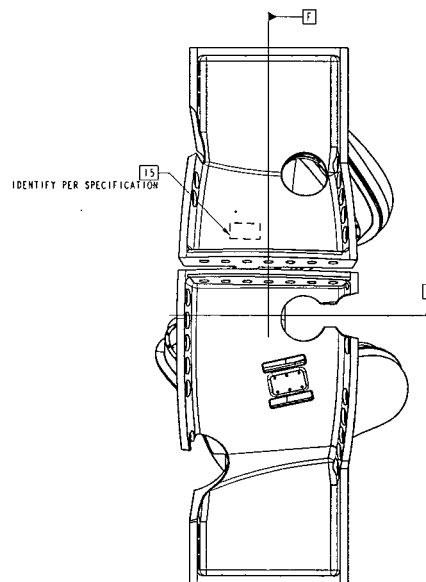
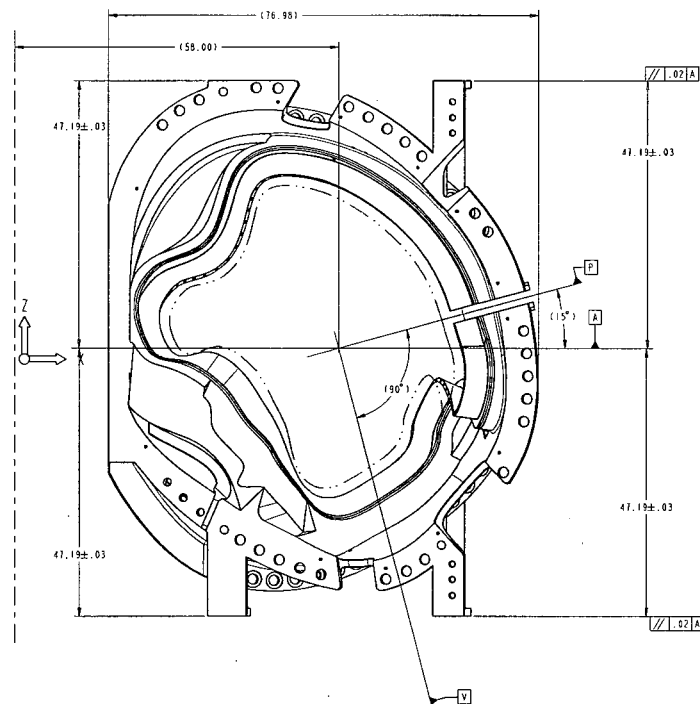
Major Tool Implemented By:

Title:

Date:



ISOMETRIC VIEW



NOTES:

1. DRAWING PREPARED IN ACCORDANCE WITH ASME Y14.2M-1994.
2. INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M-1994.
3. DIMENSIONS ARE IN INCHES.
4. DRAWING DEPICTS FINAL MACHINED STATE OF PART DEFINED BY PRO/ENGINEER FILE SE141-116.PRT.
5. UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE RELATED TO DATUM A - (PRIMARY X-Y PLANE, TOP) DATUM B - (SECONDARY X-Y PLANE, SIDE) DATUM C - (TERTIARY X-Y PLANE, FRONT)
6. DIMENSIONS APPLY AT TEMPERATURE OF 20-30°C (68-86°F)
7. DIMENSIONS AND TOLERANCES EXCLUDE PROCESS MATERIAL ALLOWANCES WHICH MAY ADD MASS.
8. APPROXIMATE WEIGHT = 4898 LBS. WEIGHT OF FINISHED PART NOT TO EXCEED 6000 LBS.
9. UNLESS OTHERWISE SPECIFIED, AS-CAST SURFACE PROFILE TOLERANCE = $\pm .25$ INCH, WITH EXEMPTION FOR INTERSECTING SURFACES WHERE FILLETS ARE EXPECTED. MIN FILLET AND CORNER RADIUS = 0.5 $\pm$ 0.1 IN.
10. DESIGNATED SURFACE REGIONS HAVE PROFILE TOLERANCE = $\pm$ 0.125 IN.
11. MIN THICKNESS PER CAD GEOMETRY, TOLERANCE = $\pm$ 0.25 IN $\pm$ 0.0 IN.
12. PARTING LINE EDGES, FLASH, GATES, RUNNER, AND RISER EXTENSIONS 0.25 IN MAX
13. UNLESS OTHERWISE SPECIFIED, MACHINED SURFACE PROFILE TOLERANCE = $\pm$ 0.01 IN.
14. BACK SPOTFACE ALL THRU HOLES MINIMUM TO CLEAN UP.
15. SEE LATEST REVISION OF SPECIFICATION NCSS-CSPEC-141-03 FOR ADDITIONAL REQUIREMENTS.

RELEASED FOR
FABRICATION / INSTALLATION
PPPL Drawing: Jerry Siegel

AR	X	SE141-116	WINDING FORM TYPE-C	CAST SS	SEE NOTE #15	I
CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO	
1	←	NEXT ASSEMBLY	PARTS LIST			

SCALE .125

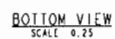
THIS DRAWING PRODUCED ON PRO-ENGINEER

REV	DESCRIPTION	DATE	CHK	DEPT	DATE	FL	REV	DATE	CHK	DEPT	DATE
6	REVISED PART AND DRAWING PER ECR 5009	GLL 11-03-MJC	DEW								
5	REVISED PART AND DRAWING PER ECR 4994	GLL 10-03-MJC	DEW								
4	REVISED DRAWING AND MODEL PER ECR 4985	GLL 10-03-MJC	DEW								
3	REVISED DRAWING AND MODEL PER ECR 4984	GLL 10-03-MJC	DEW								
2	SHEET 14 REMOVED TABLES 111 & 114	GLL 10-03-MJC	DEW								
1	SHEET 2: DETAILS 3 REMOVED, SPHERICAL SEATS MODIFIED TEE RELIEF 10 1 R: .03 CHAMFER WAS .05 PER ECR 4903	DEW 10-03-168	DEW								
1	REMOVED UPPER AND LOWER SUPP POCKETS	DEW 10-03-168	DEW								
1	CHANGED 1/2 IN. (1/2 IN.) DIAMETER	DEW 10-03-168	DEW								
1	MODIFIED 1/2 IN. (1/2 IN.) DIAMETER	DEW 10-03-168	DEW								
1	MODIFIED 1/2 IN. (1/2 IN.) DIAMETER	DEW 10-03-168	DEW								

UT-BATTELLE
NATIONAL COMPACT STELLARATOR EXPERIMENT
PRODUCTION WINDING FORM TYPE-C



DATUMS A B & C ARE MACHINE SPECIFIC.
ALL OTHER DATUMS LISTED ON THIS DRAWING
ARE SPECIFIC TO THIS PART



**RELEASED FOR
FABRICATION / INSTALLATION**

PPPL Drafting:  Jerry Siegel

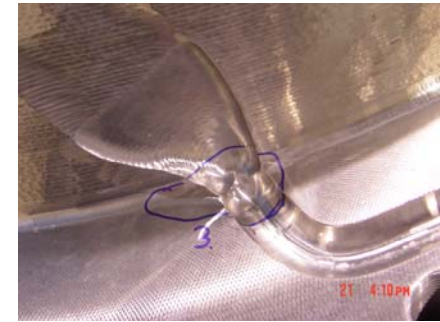
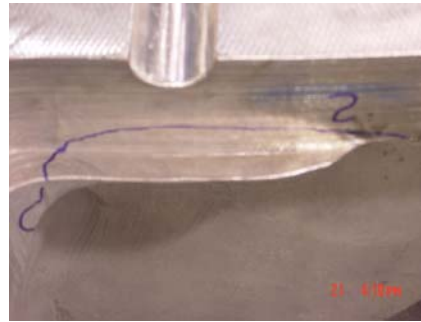
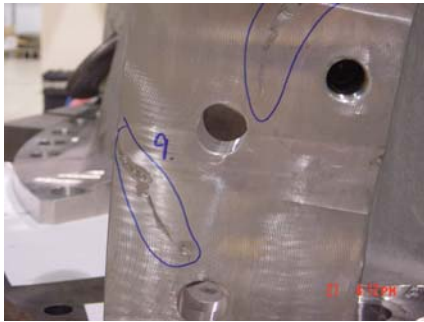
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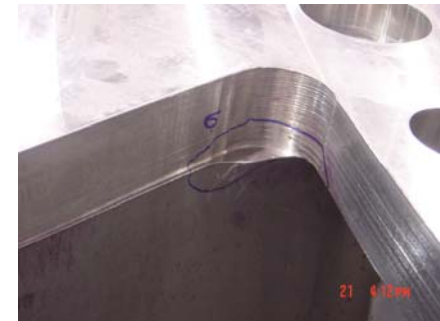
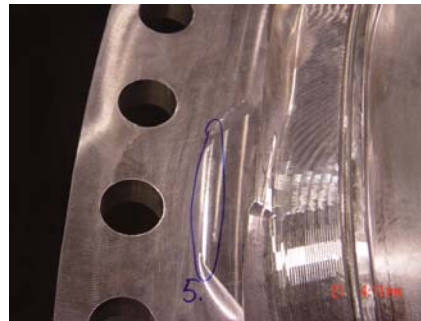
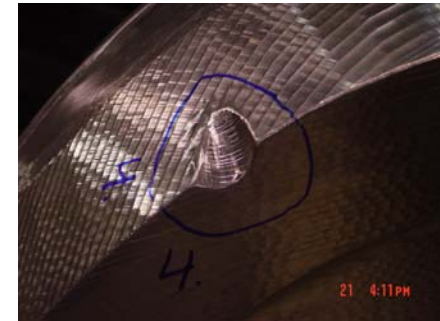
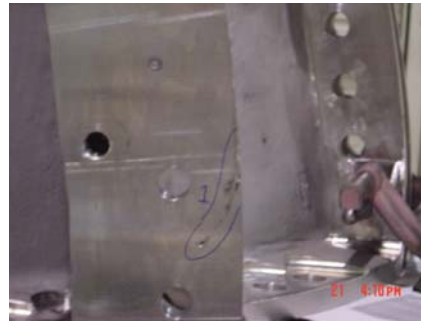
Oak Ridge National Laboratory
Attn: Mr. RICHARD W. DICKSON
P. O. BOX 116
K-5, SCIENTIFIC BUILDING, MS-A428, OAK RIDGE, TENNESSEE
NATIONAL COMPACT STELLARATOR EXPERIMENT

PRODUCTION WINDING FORM TYPE-C

VERSION NO.	PLANT	WIND	IL	3	1st of 11	TYPE CL
4	K-10	5700	3	3	11	6
RELEASE LEVEL Fabrication						
SEI41-116						



C1 MCWF
Photos for NC18237



K. Bowling 21-Sep-05

