

☒ FAIR  
☐ PRODUCTION  
  
☐ PATTERN  
☐ OTHER

Carondelet Division  
 Pevely, MO 63070  
 Phone: (636)475-2159 Fax (636)475-3999

CO# 43465  
 Date: 3/31/06  
 Sheet 1 OF 1

## LAYOUT INSPECTION REPORT

CUSTOMER <u>EIO</u>	P.O. #	METAL <u>CF8MMAMMO</u>
DRAWING # <u>SE-141-141 REV.0</u>	PART TRACEABILITY NUMBER <u>RT1</u>	
PATTERN # <u>SE-141-141 SHORT</u>	ITEM NUMBER <u>2104914</u>	CERT NUMBER <u>582720-1</u>
		<input type="checkbox"/> MACHINED <input checked="" type="checkbox"/> AS CAST CASTING WEIGHT <u>5.8</u>

ITEM	BP Zone Tolerance	B/P DIMENSION	ACTUAL DIM	ACC	REJ
1	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11	7.127	7.36	✓	
2	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11	4.367	4.35	✓	
3	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11	Ø1.66 2x	1.40 x2	✓	
4	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11	2.75	3.00	✓	
5	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11	1.38	1.51	✓	
6	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11	.06	NOT MACH	✓	
7	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11	.75	1.03	✓	
8	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11	1.38	1.52	✓	
9	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11				
10	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11				
11	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11				
12	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11				
13	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11				
14	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11				
15	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11				
16	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11				
17	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11				
18	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11				
19	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11				
20	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11				

INSPECTOR: <u>JARROR R. BOYER</u>	<input checked="" type="checkbox"/> ACCEPT <input type="checkbox"/> REJECT	SIGNATURE / DATE: <u>[Signature]</u> <u>3/31/06</u>
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CUSTOMER <i>EIO</i>		P.O. #		METAL <i>CF8MMAMMO</i>	
DRAWING # <i>SE-141-141 REV. 0</i>		PART TRACEABILITY NUMBER <i>RT 2</i>		CASTING WEIGHT <i>5.8</i>	
PATTERN # <i>SE-141-141 SHORT</i>		ITEM NUMBER <i>2104914</i>	CERT NUMBER <i>5827201</i>	<input type="checkbox"/> MACHINED	<input checked="" type="checkbox"/> AS CAST
ITEM	BP Zone Tolerance	B/P DIMENSION	ACTUAL DIM	ACC	REJ
1	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11	<i>7.127</i>	<i>7.40</i>	<input checked="" type="checkbox"/>	
2	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11	<i>4.367</i>	<i>4.35</i>	<input checked="" type="checkbox"/>	
3	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11	<i>Ø1.66 2X</i>	<i>Ø1.40 X2</i>	<input checked="" type="checkbox"/>	
4	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11	<i>2.75</i>	<i>2.97</i>	<input checked="" type="checkbox"/>	
5	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11	<i>1.38</i>	<i>1.52</i>	<input checked="" type="checkbox"/>	
6	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11	<i>.06</i>	<i>NOT MACH</i>	<input checked="" type="checkbox"/>	
7	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11	<i>.75</i>	<i>1.05</i>	<input checked="" type="checkbox"/>	
8	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11	<i>1.38</i>	<i>1.52</i>	<input checked="" type="checkbox"/>	
9	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11				
10	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11				
11	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11				
12	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11				
13	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11				
14	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11				
15	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11				
16	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11				
17	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11				
18	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11				
19	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11				
20	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11				
INSPECTOR: <i>JANOR R BOYER</i>		<input checked="" type="checkbox"/> ACCEPT <input type="checkbox"/> REJECT	SIGNATURE / DATE: <i>Janor R Boyer 3/31/06</i>		

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## LAYOUT INSPECTION REPORT

CUSTOMER <u>EIO</u>	P.O. #	METAL <u>CF8MAMMO</u>
DRAWING# <u>SE-141-141 REV.0</u>	PART TRACEABILITY NUMBER <u>RT3</u>	CASTING WEIGHT <u>5.8</u>
PATTERN# <u>SE-141-141 SHORT</u>	ITEM NUMBER <u>Z104914</u>	CERT NUMBER <u>582720-1</u>
		<input type="checkbox"/> MACHINED <input checked="" type="checkbox"/> AS CAST

ITEM	BP Zone Tolerance	B/P DIMENSION	ACTUAL DIM	ACC	REJ
1	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11	7.127	7.37	✓	
2	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11	4.367	4.36	✓	
3	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11	Ø1.66 2x	Ø1.40 x2	✓	
4	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11	2.75	3.00	✓	
5	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11	1.38	1.55	✓	
6	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11	1.06	NOT MACH	✓	
7	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11	1.75	1.05	✓	
8	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11	1.38	1.52	✓	
9	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11				
10	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11				
11	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11				
12	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11				
13	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11				
14	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11				
15	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11				
16	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11				
17	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11				
18	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11				
19	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11				
20	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11				

INSPECTOR: <u>JARRO R BOYER</u>	<input checked="" type="checkbox"/> ACCEPT <input type="checkbox"/> REJECT	SIGNATURE / DATE: <u>Jarro R Boyer 3/31/06</u>
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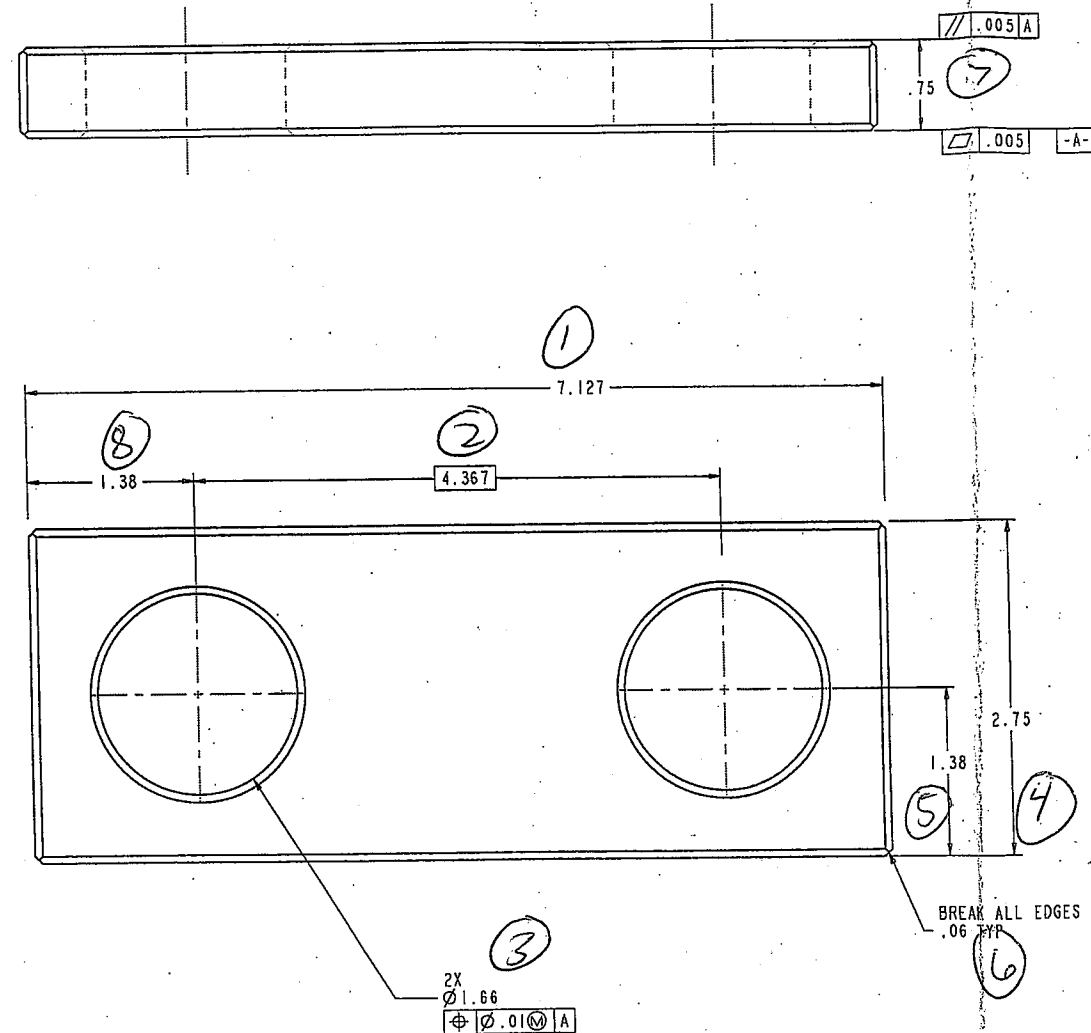
CUSTOMER <i>EIO</i>	P.O. #	METAL <i>CF8MMMO</i>
DRAWING # <i>SE-141-141 REV. 0</i>	PART TRACEABILITY NUMBER <i>RT4</i>	CASTING WEIGHT <i>5.8</i>
PATTERN # <i>SE-141-141 SHORT</i>	ITEM NUMBER <i>2104914</i>	CERT NUMBER <i>582720-1</i>
		<input type="checkbox"/> MACHINED <input checked="" type="checkbox"/> AS CAST

ITEM	BP Zone Tolerance	B/P DIMENSION	ACTUAL DIM	ACC	REJ
1	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11	7.127	7.38	✓	
2	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11	4.367	4.38	✓	
3	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11	Ø1.66 2x	Ø1.40 x2	✓	
4	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11	2.75	3.02	✓	
5	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11	1.38	1.52	✓	
6	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11	1.06	NOT MACH	✓	
7	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11	1.75	1.04	✓	
8	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11	1.38	1.52	✓	
9	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11				
10	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11				
11	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11				
12	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11				
13	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11				
14	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11				
15	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11				
16	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11				
17	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11				
18	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11				
19	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11				
20	Zone <input type="checkbox"/> DWG <input type="checkbox"/> CT-11				

INSPECTOR: <i>JACKOR R. BOYER</i>	<input checked="" type="checkbox"/> ACCEPT <input type="checkbox"/> REJECT	SIGNATURE / DATE: <i>Jack R. Boyer 3/31/06</i>
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- NOTES:

1. DRAWING PREPARED IN ACCORDANCE WITH ASME Y14.100.
2. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M.
3. DIMENSIONS ARE IN INCHES.
4. DIMENSIONS APPLY AT ROOM TEMPERATURE. OPERATING TEMP 80K.
5. SEE LATEST REVISION OF SPECIFICATION NCSX-CSPEC-141-03 FOR ADDITIONAL REQUIREMENTS.



 Jerry Siegel

2008.01.12  
09:00:51  
-0500'

AR	X	-1	BEARING PLATE-SHORT	UNS S31600	1
CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPECIFICATION	FIN NO	
	← NEXT ASSEMBLY		PARTS LIST		

										SCALE AS NOTED										Oak Ridge National Laboratory Request for the Department of Energy to R. L. CROMBIE, CONTRACT NO. AC40-77-0725 BATTTELLE, LLC Oak Ridge, Tennessee									
										DES. B. NELSON 1-08 DWG. G. LOWETT 1-08 TOLERANCES UNLESS OTHERWISE SPECIFIED CHK. N. COLE 1-08 SECTION DEPT. 1-08 PL. D. WILLIAMSON 1-08 CR. 1-08 PJ. 1-08 REO. 1-08 PPPL. DAVE J. SIEGEL 1-08 FINISH UNLESS OTHERWISE SPECIFIED DRAWING APPROVALS DATE										NATIONAL COMPACT STELLARATOR EXPERIMENT MCWF POLOIDAL BREAK BEARING PLATE DETAIL TYPE "A" SHORT									
INITIAL RELEASE REV DESCRIPTION										GEL 12/09 BY DATE CHK DEPT DATE FC REO DATE ORNL DOC DATE										VERSION NO. 4 PLANT X-10 RELEASE LEVEL Fabrication SE141-141 REV 0									