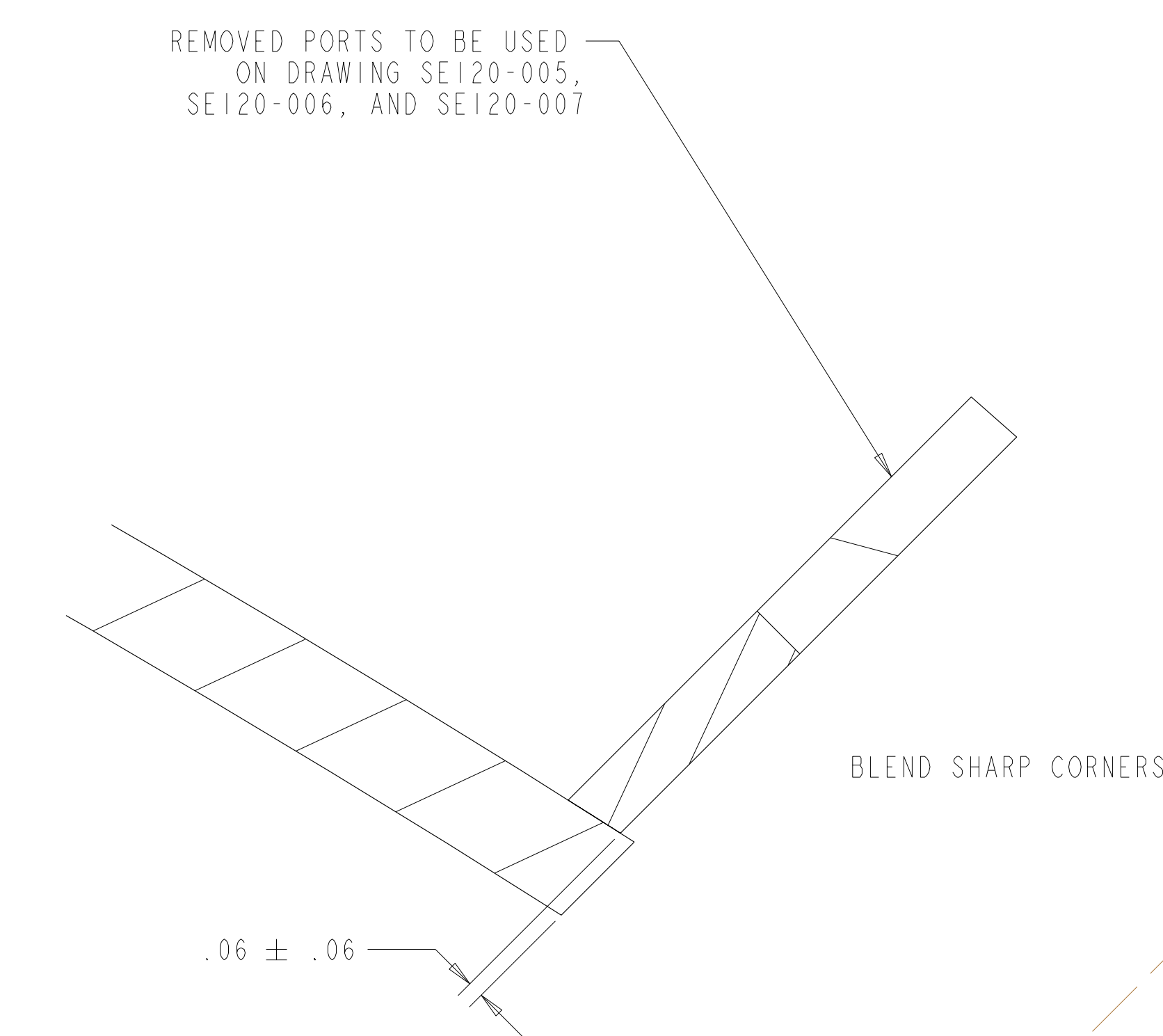
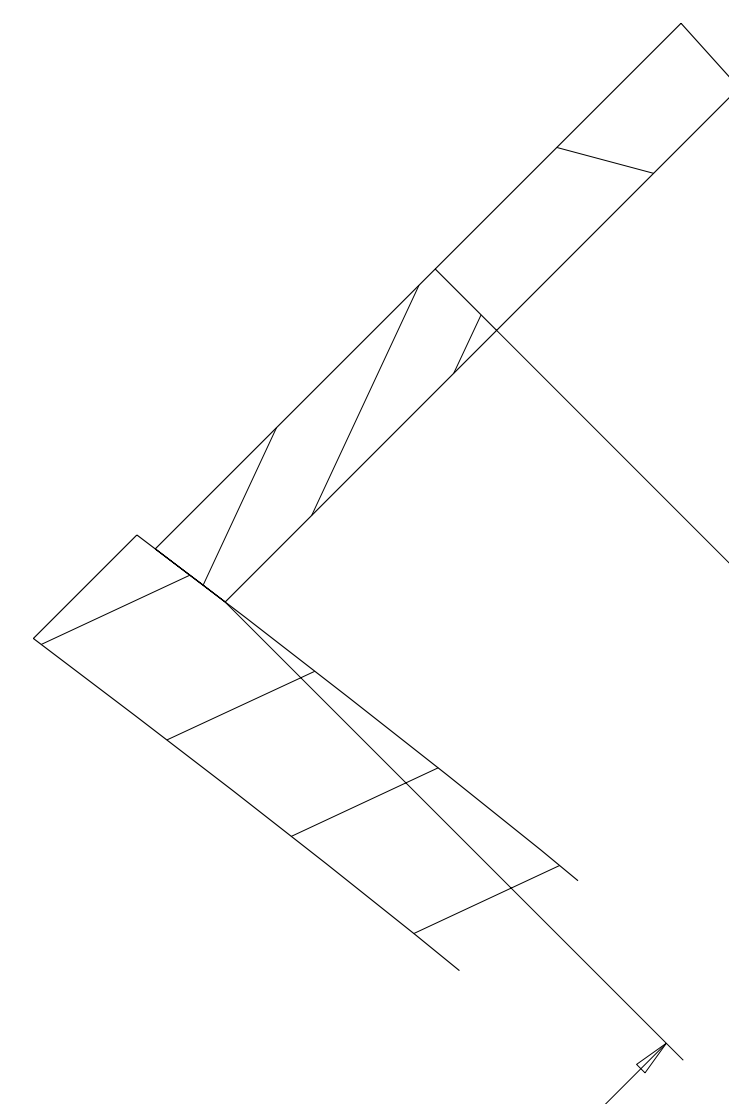


FOR NOTES AND PARTS LIST SEE SHEET 1.



BLEND SHARP CORNERS

 $.06 \pm .06$ 

TYPICAL FOR ALL PORTS
 EXCEPT VERTICAL PORT 12 AND NEUTRAL BEAM PORT
 SECTION PORT02-PORT02
 FROM SHT 2
 SCALE 2.00




WELD PREP STUB AND PORT
AS SHOWN - AFTER CUTTING

BEVEL ON INSIDE ONLY-

— 0 - .06
ALL AROUND
TYP BOTH PIECES

REMOVE PORTS
1.00^{+.00}_{-.06} FROM OUTSIDE SURFACE
OF VACUUM VESSEL EXCEPT
PORT 12 (VERTICAL PORT) AND NB PORT.

TYPICAL PORT WELD PREP DETAIL
FOR ALL PORTS
EXCEPT VERTICAL PORT 12, NEUTRAL BEAM PORT, AND PORT 4
SECTION PORT02-PORT02 SHOWN
FROM SHEET 2
SCALE 2:00

	Oak Ridge National Laboratory managed for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT CONTRACT DE-AC05-80OR21722 UT-BATTELLE, LLC Oak Ridge, Tennessee					
	PROJECT NAME					
NATIONAL COMPACT STELLARATOR EXPERIMENT						
VACUUM VESSEL PERIOD ASSEMBLY AND REMOVED PORT EXTENSIONS						
VERSION NO.	PLANT	BLDG	FL	SHT	OF TYPE	CLASS
3	X-10	5700	3	4	A	U
RELEASE LEVEL						REV
Fabrication		SEI20-003				

8

7

6

5

4

3

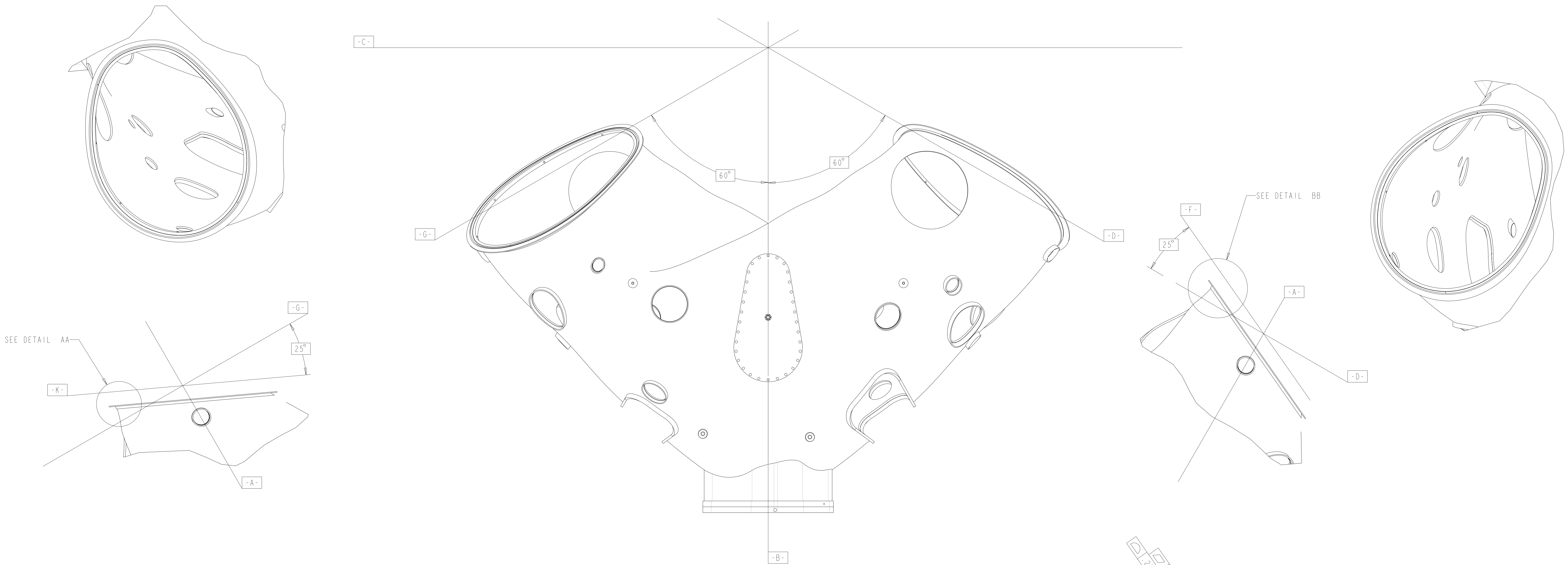
2

1

NEXT ASS'Y:

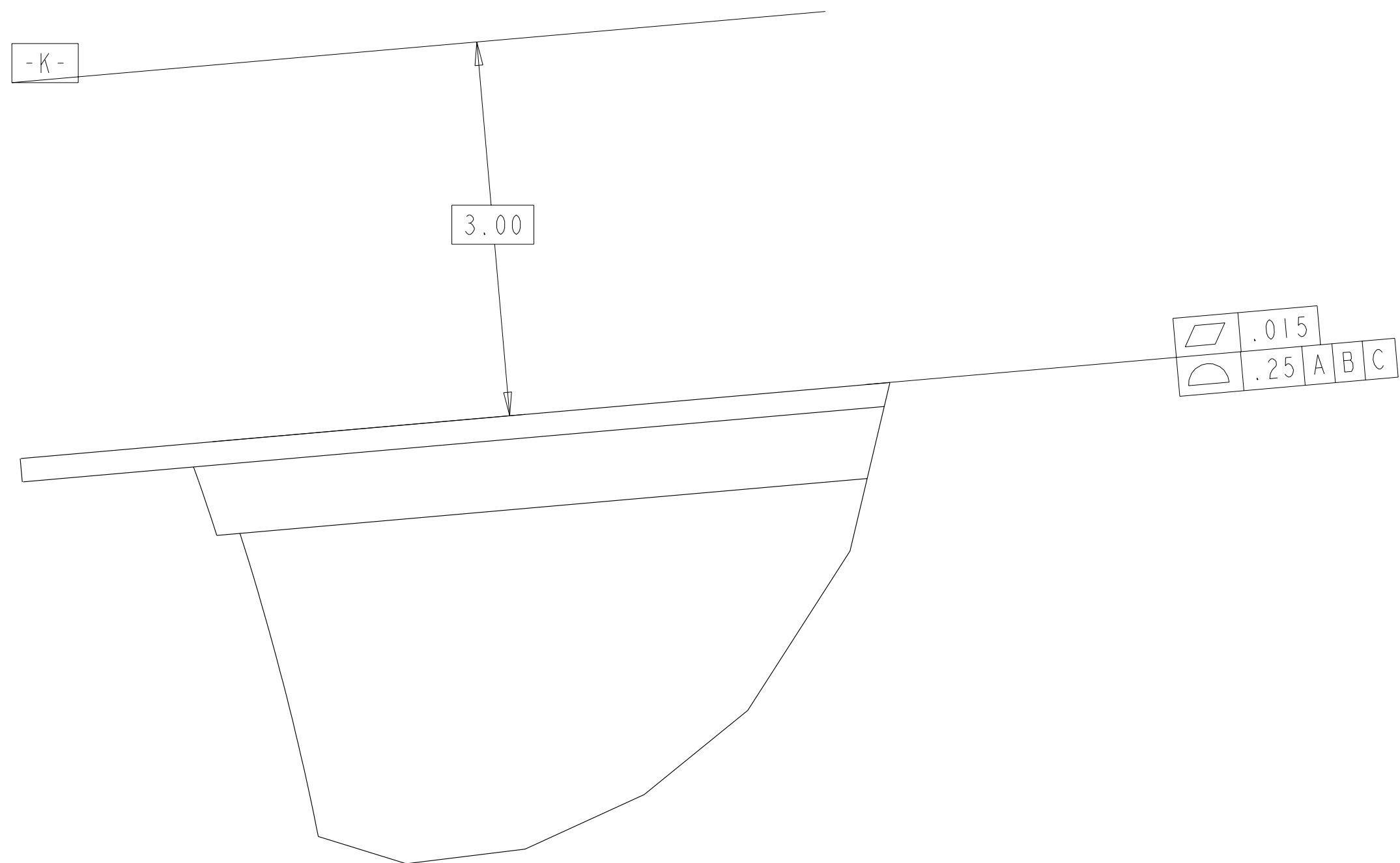
FINAL ASS'Y:

FOR NOTES AND PARTS LIST SEE SHEET 1.



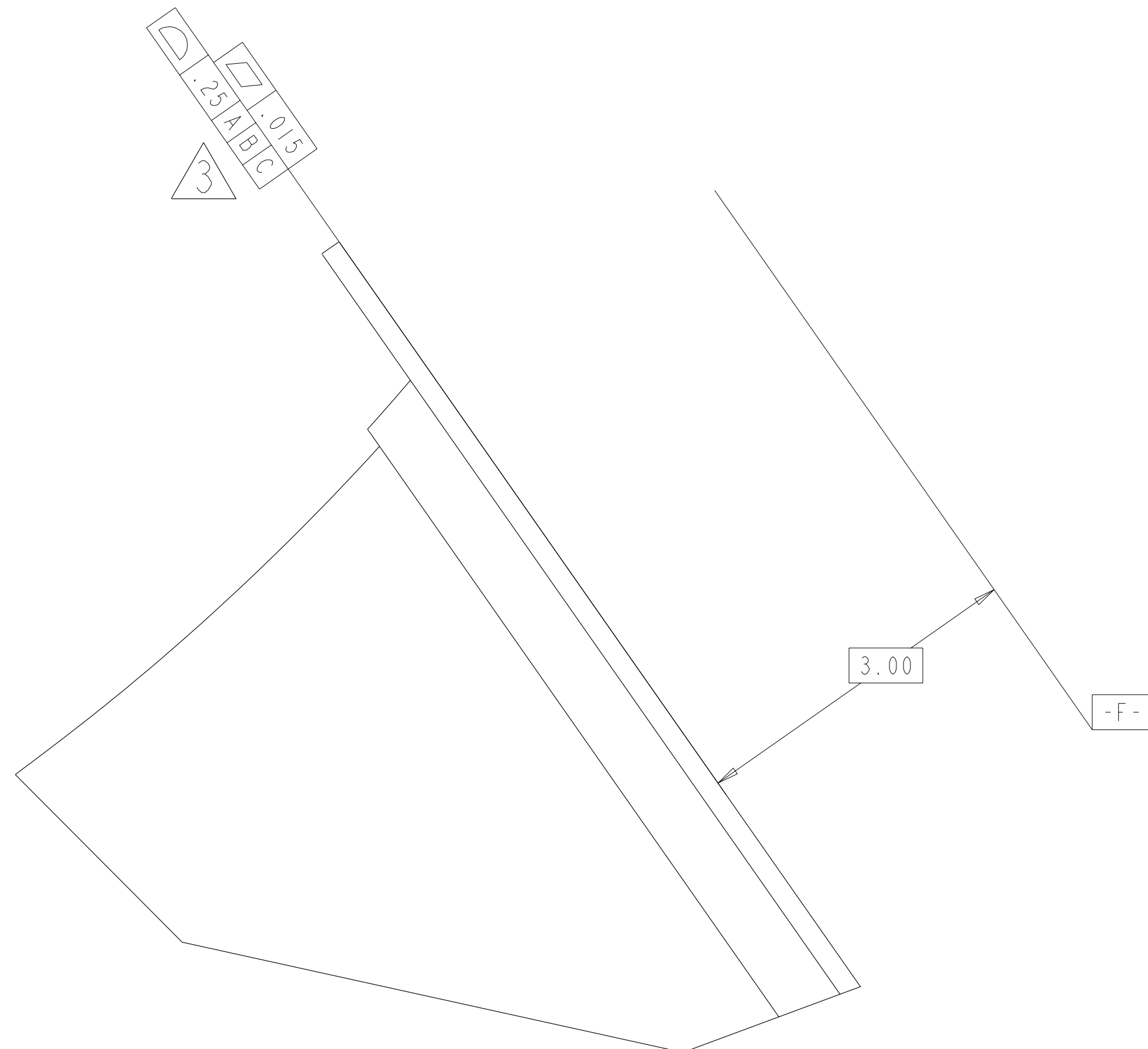
TOP VIEW

SCALE 0.13



DETAIL AA

SCALE 1.00



DETAIL BB

SCALE 1.00

Oak Ridge National Laboratory managed for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT contract DE-AC05-00OR22725 UT-BATTELLE, LLC. Oak Ridge, Tennessee							
PROJECT NAME							
NATIONAL COMPACT STELLARATOR EXPERIMENT							
VACUUM VESSEL PERIOD ASSEMBLY AND REMOVED PORT EXTENSIONS							
VERSION NO. 3	PLANT X-10	BLDG 5700	FL 3	SHT OF 4 4	TYPE A	CLASS U	REV I
RELEASE LEVEL Fabrication		SEI20-003					