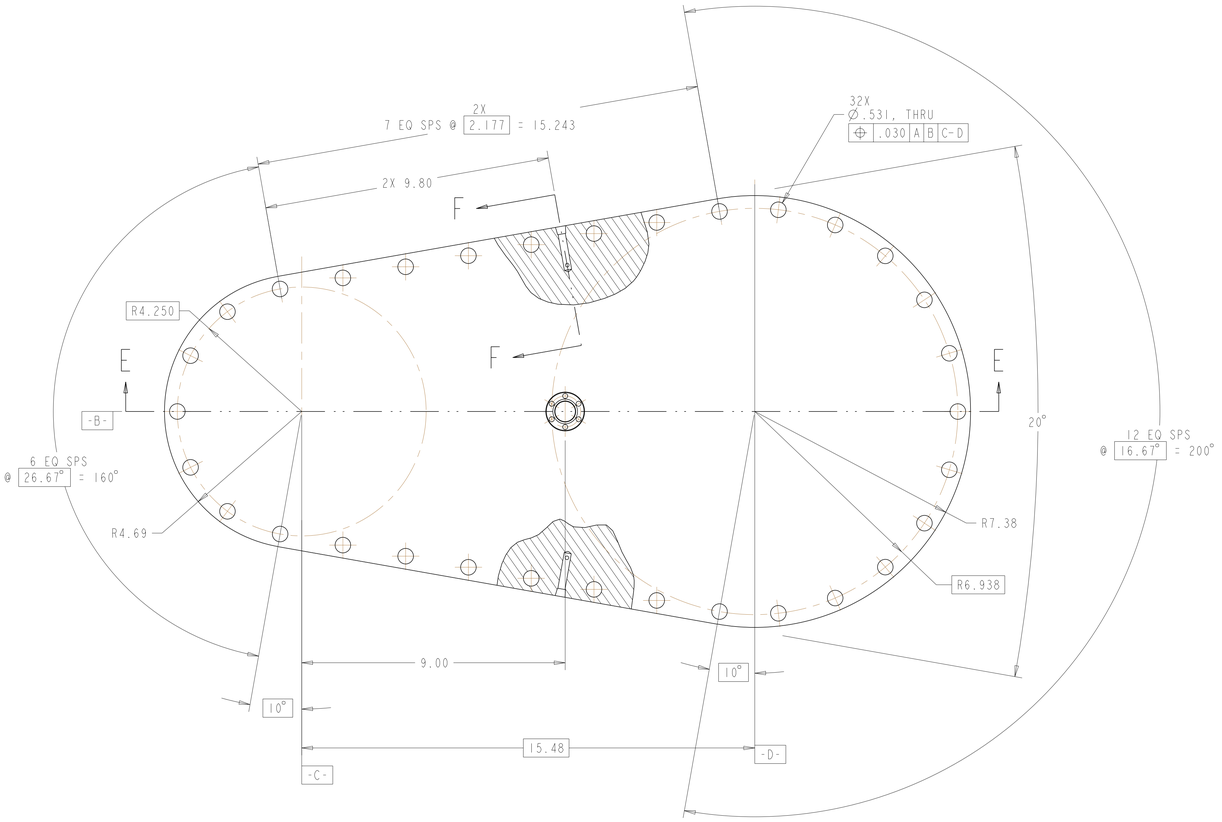
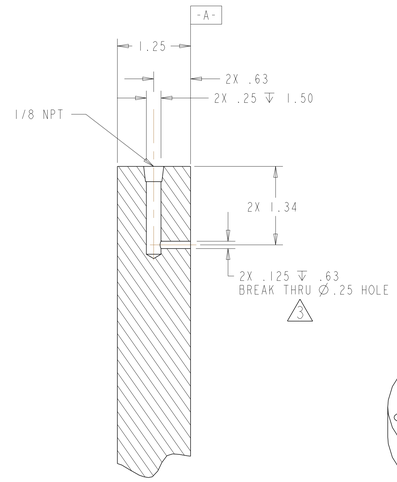
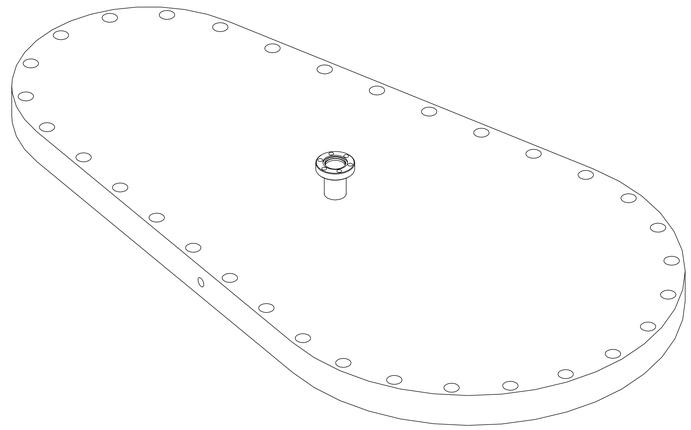
NEXT ASS'Y: FINAL ASS'Y:





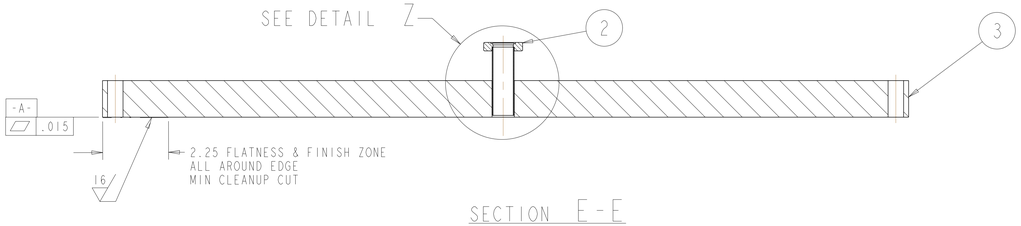
SECTION F-F
SCALE 1.00



ISOMETRIC VIEW

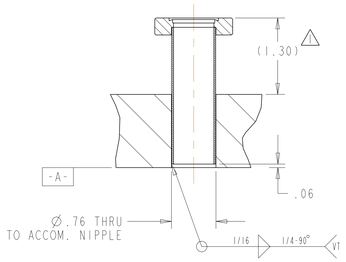
NOTES:

1. INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M.
2. DIMENSION ARE IN INCHES.
3. FABRICATION, INSPECTION, AND TESTING SHALL BE PERFORMED IN ACCORDANCE WITH SPECIFICATION NCSX-CSPEC-121-02 AND STATEMENT OF WORK NCSX-SOW-121-03.
4. (2) LEAK CHECK ITEM -2 (HALF NIPPLE) OPTIONAL.



SECTION E-E

	AR		-4	WELD, FILLER METAL		4
	1		-3	PORT 12 FLANGE	316L SST	3
	1		-2	HALF NIPPLE 1 1/3 DEL-SEAL CF CUSTOM LENGTH 2.50"	MDC VACUUM PRODUCTS CORP. 23842 CABBOT BOULEVARD HAYWARD, CA. 94545-1651	2
	AR		-1	PORT 12 COVER TEST FLANGE WELDMENT		1
SEI20-004	-	CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPECIFICATION	FIND NO
		← NEXT ASSEMBLY		PARTS LIST		



DETAIL Z
SCALE 1.00

WELDING ENGINEER
APPROVED R. PARSELLS DATE: 6/04

1 SCALE: .50

REV	DESCRIPTION	BY	DATE	CHK	DEPT	DATE	PE	REQ	DATE	ORNL	DOE	DATE
2	△ ADDED NOTE 4 △ MODIFIED DEPTH											
	REVISED PER ECN-4945	GHJ	2/28/05	MJC								
1	△ ADDED REF DIMENSION											
	REVISED PER ECN-4933	MJC	11/02/04	PLG								

REVISION OR ISSUE PURPOSE — REVISION APPROVAL

SCALE NOTED
TOLERANCES UNLESS OTHERWISE SPECIFIED
FRACTIONS :
XX DECIMALS ±.01
XXX DECIMALS ±.005
ANGLES ±0°15'
BREAK SHARP EDGES .06 MAX
FINISH 125 UNLESS OTHERWISE SPECIFIED

DRAWING APPROVALS		DATE
DES	P.L.GORANSON	8/03
DRW	G.H.JONES	8/03
CHK	M. J. COLE	6/04
SECT	:	:
DEPT	:	:
PE	:	:
CR	:	:
PJ	:	:
REQ	:	:
PPPL DRFT	J. SIEGEL	6/04
	:	:
	:	:

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P THIS DRAWING PRODUCED ON PRO-ENGINEER

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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
PORT 12 COVER TEST FLANGES
WELDMENT

VERSION NO.	PLANT	BLDG	FL	SHT	OF	TYPE	CLASS
1	X-10	5700	03	1	1	S	U

RELEASE LEVEL: Fabrication
SEI22-104
REV 2

SEI22-104