

- 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. PROFILE TOLERANCE IS BILATERAL, I.E., 0.1875 EITHER SIDE OF REFERENCE SURFACE.
5. LEAK CHECK ITEM -8 (REDUCING NIPPLE) IS OPTIONAL. BLANK FLANGE MAY BE SUBSTITUTED.

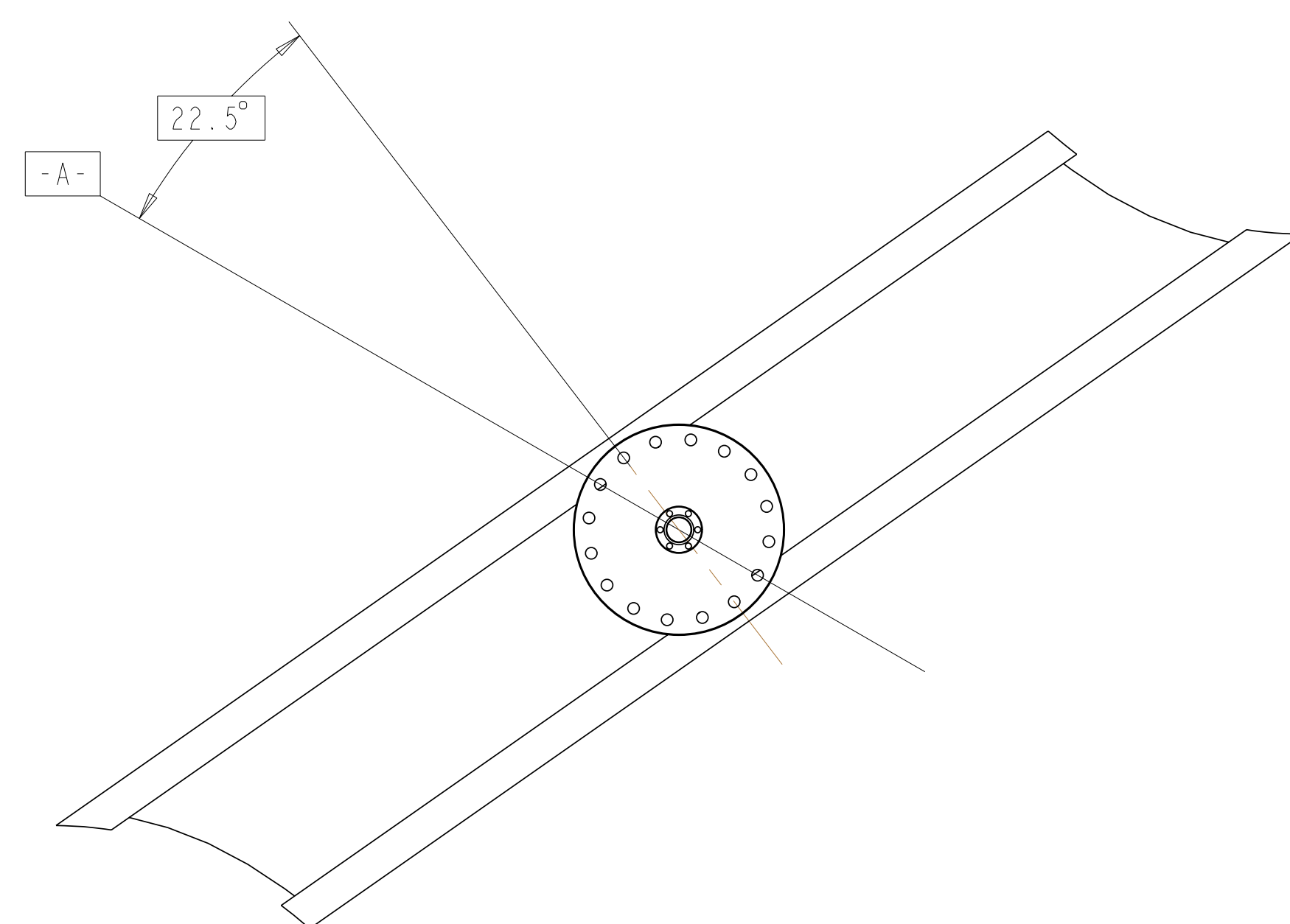
		AR	-9	WELD, FILLER METAL				9
		I	FA06000133	6 INCH REDUCING NIPPLE		VARIAN VACUUM TECHNOLOGIES 121 HARTWELL AVE. LEXINGTON, MA 02421 OR EQUIVALENT		8
		I	191013	GASKET, COPPER 4.0I OD, PKG 10 REF 6.00 FLG				7
		I	190058	BOLT SET 4.63 OD & 6.00 FLG 12 PT BOLT,SILVER PLTG, PKG Z5		MDC YACUUM PRODUCTS CORP. 23842 CABOT BOULEVARD HAYWARD, CA. 94545-1651 OR EQUIVALENT		6
		I	130026	CONFLAT , 6.00 O.D. TAPPED				5
		AR	-4	PIPE 3 1/2 SCH 40				4
4		2	-3	SPACER FLANGE		UNS N06625		3
4		I	-2	SPACER				2
		AR	-1	SPACER WELDMENT				1
extassy	SECT	CAGE	PART OR	NOMENCLATURE	MATERIAL	SPECIFICATION	FIND	
-020	1.	CODE	IDENTIFYING NO	OR DESCRIPTION			NO	

WELDING ENGINEER

APPROVED R. PARSELLS DATE: 6/04

[illegible]


FOR NOTES AND PARTS LIST SEE SHEET 1



AUX VIEW

ALLX VIEW

99 36

	375	A	B	C
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\varnothing	.250	A	B	C
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 (60°)

SCALE 0.250

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DATUM A = PLANE THRU "XY"
DATUM B = PLANE THRU "XZ"
DATUM C = PLANE THRU "YZ"
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- B -

		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 SPACER WELDMENT								
VERSION NO.	PLANT	BLDG	FL	SHT	OF	TYPE	CLASS	
I	X-10	5700	3	2	2	S	U	
RELEASE LEVEL		SEI21-014					REV I	
Fabrication							REV I	

NATIONAL COMPACT STELLARATOR EXPERIMENT								
VACUUM VESSEL SPACER WELDMENT								
VERSION NO. 	PLANT X-10	BLDG 5700	FL 3	SHT 2	OF 2	TYPE S	CLASS U	
RELEASE LEVEL Fabrication		SEI21-014					REV I	

<p style="text-align: center;">VACUUM VESSEL SPACER WELDMENT</p>								
VERSION NO. I	PLANT X-10	BLDG 5700	FL 3	SHT 2	OF 2	TYPE S	CLASS U	
RELEASE LEVEL Fabrication		SEI21-014					REV I	

VERSION NO. 1	PLANT X-10	BLDG 5700	FL 3	SHT 2	OF 2	TYPE S	CLASS U
RELEASE LEVEL Fabrication		SE121-014					REV 1

VERSION NO. 1	PLANT X-10	BLDG 5700	FL 3	SHT 2	OF 2	TYPE S	CLASS U
RELEASE LEVEL Fabrication		SE121-014					REV 1