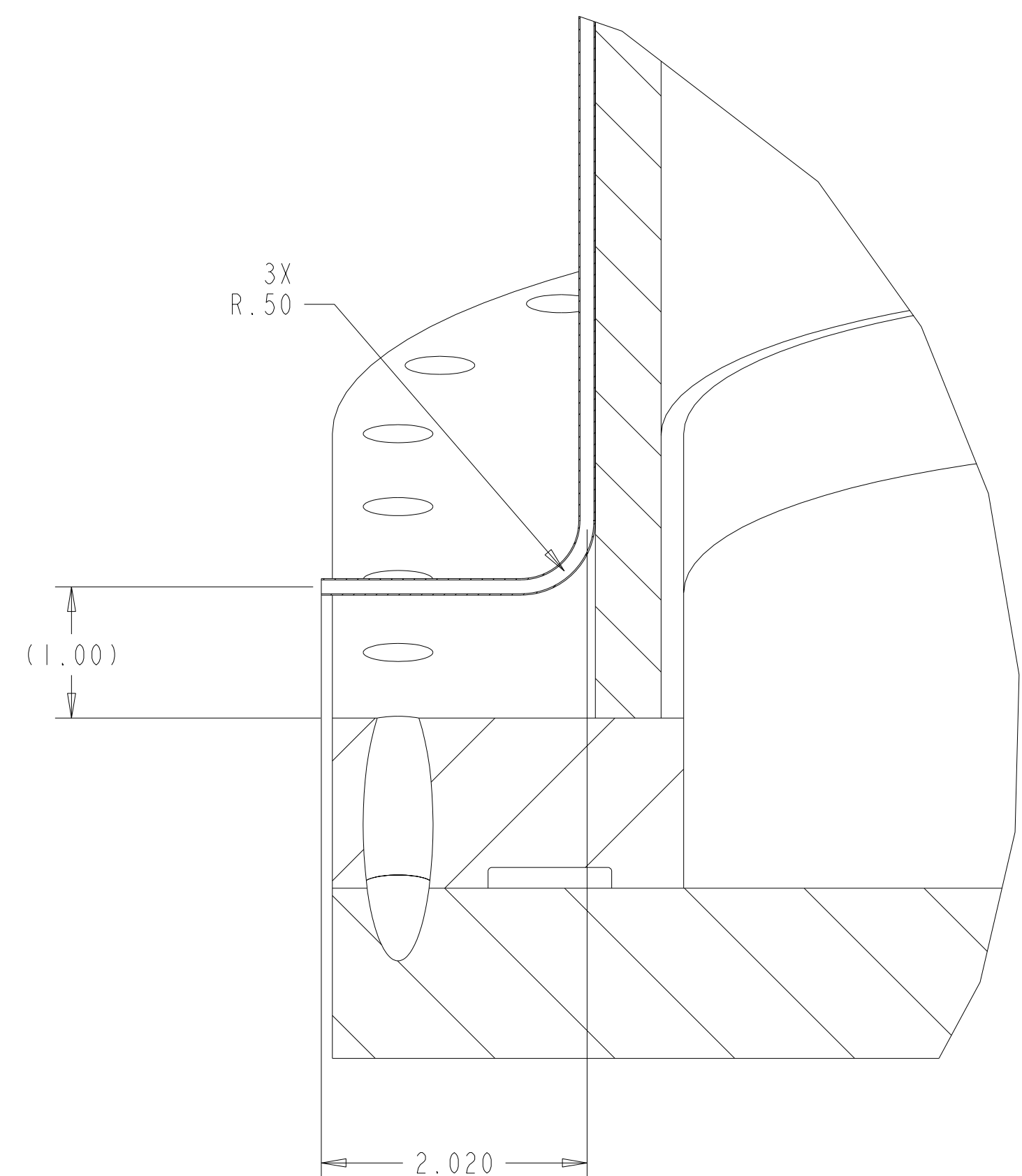
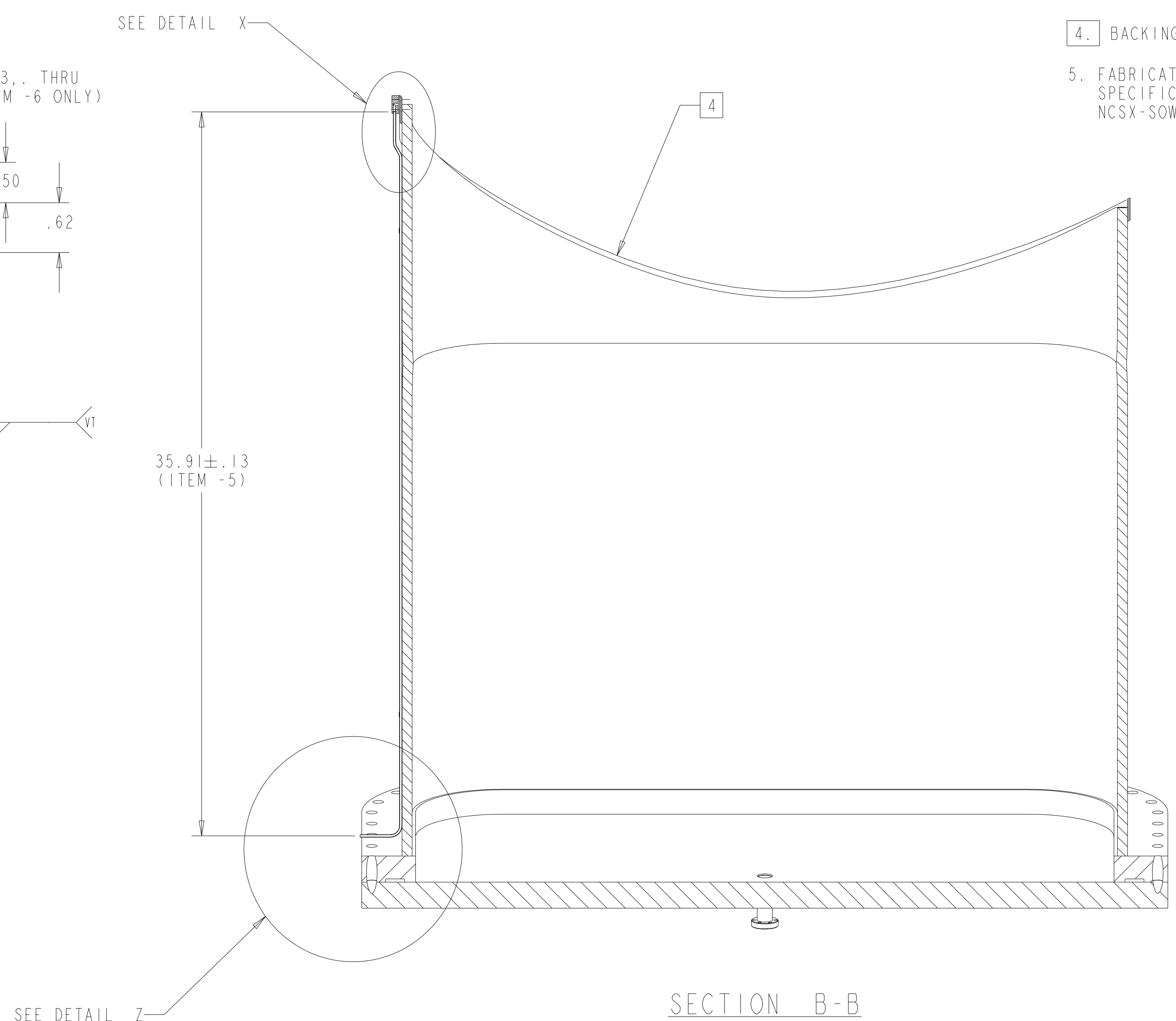
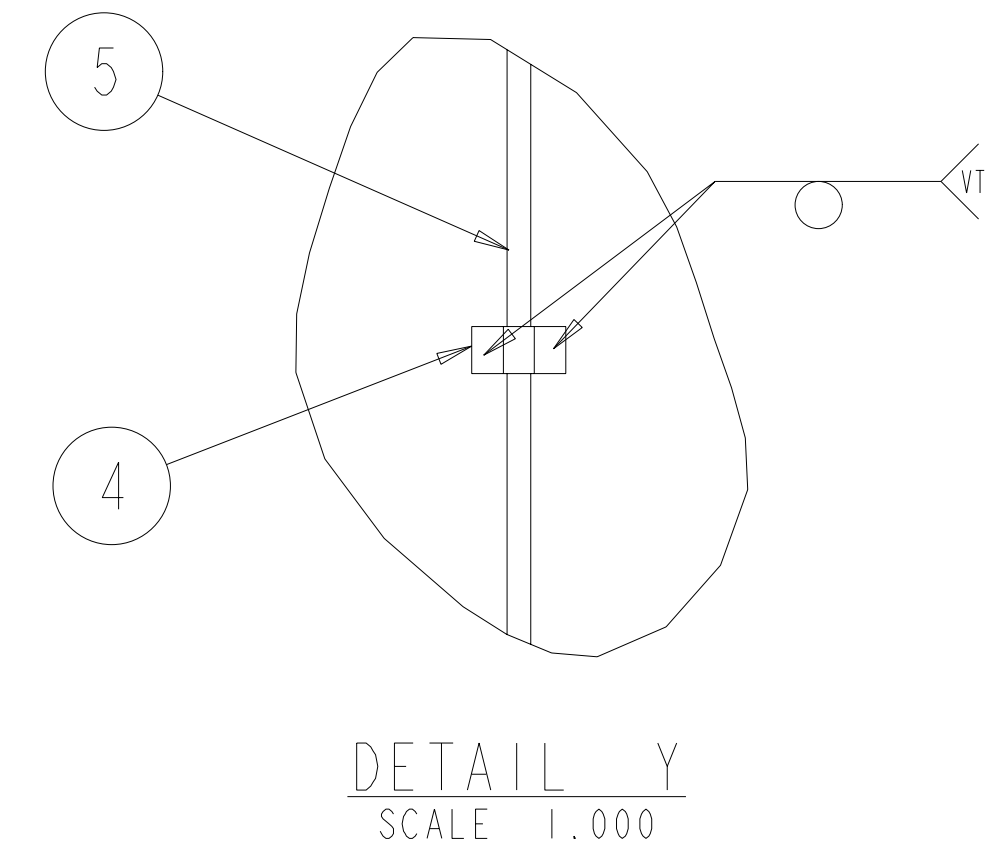
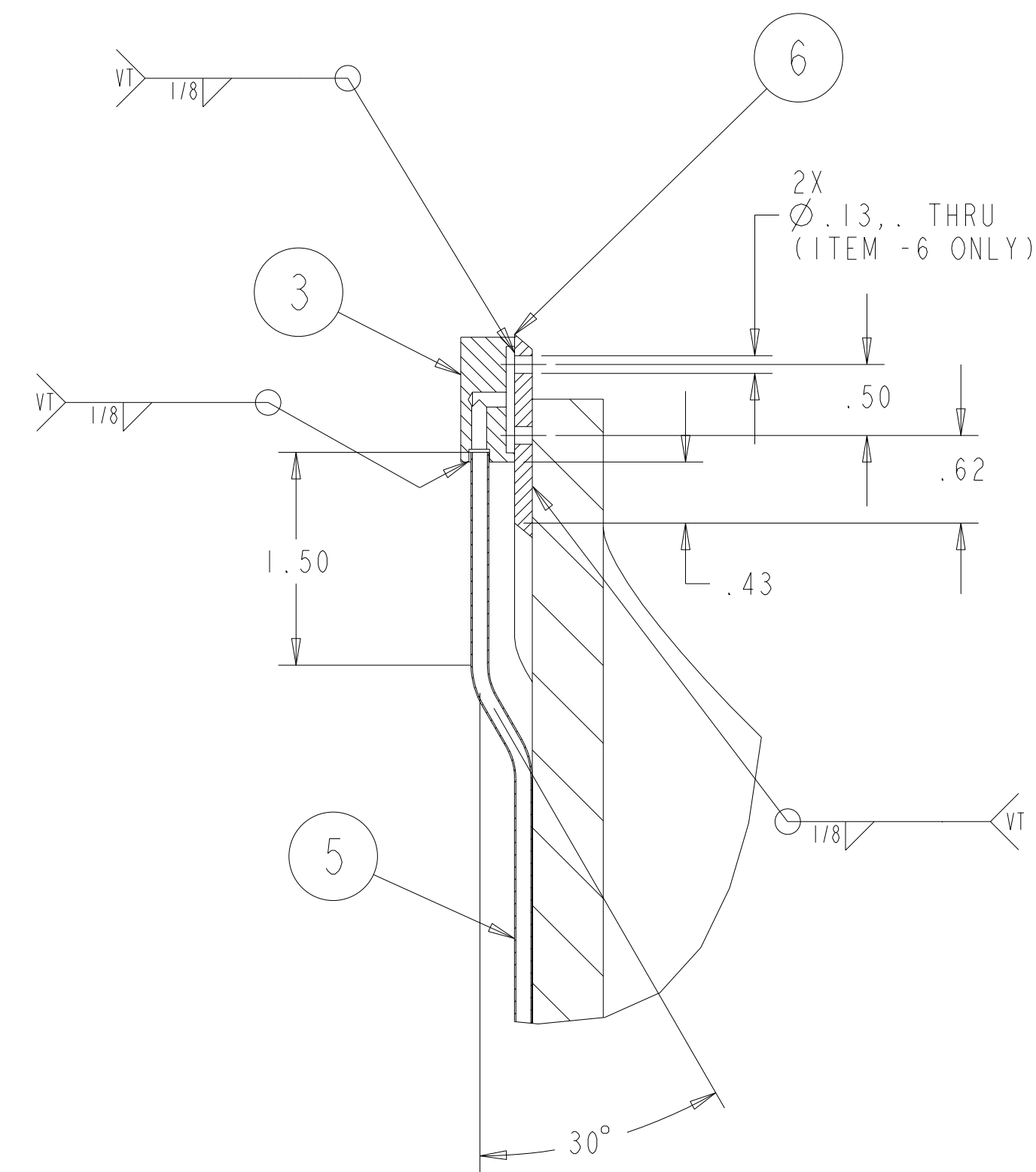
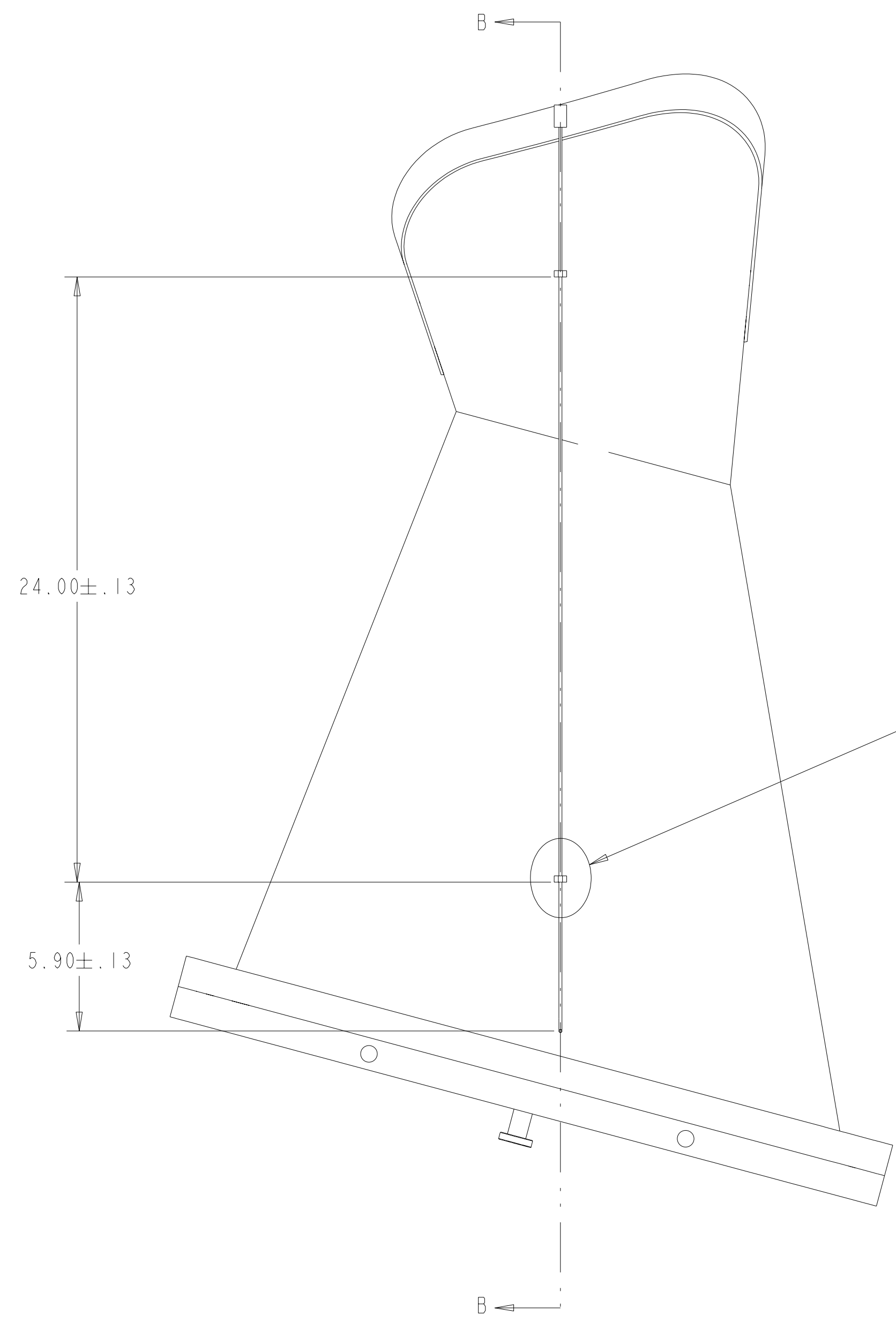


- NOTES:
1. INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M
  2. DIMENSIONS ARE IN INCHES
  3. PORT 4A WELDMENT AND PORT 4B WELDMENT CREATED AT SE120-003, AS A RESULT OF MATCH MARKING FOR RE-ASSEMBLY.
  4. BACKING RING PROFILE 1/2" OFFSET FROM VACUUM VESSEL. CUT NORMAL TO PORT 4.
  5. FABRICATION, INSPECTION, AND TESTING SHALL BE PERFORMED IN ACCORDANCE WITH SPECIFICATION NCSX-CSPEC-121-02 AND STATEMENT OF WORK NCSX-SOW-121-03.



1 2 SCALE .250

**Rev 0-a: ECN-5109 (RFD-12-004) approved replacement of the /32" fillet weld with a braze joint using a silver-free braze material (Microbraze) – Applicable to All 3 VVSAs.**

**Rev 0-b: ECN-5110 (RFD-12-003) clarified that any gauge within the tolerance range of 0.01" to 0.02" is acceptable, provided that the material is Incoloy 625 alloy and is found to perform adequately – Applicable to All 3 VVSAs.**

**RELEASED FOR FABRICATION / INSTALLATION**  
PPPL Drafting:

WELDING ENGINEER  
APPROVED R PARSELLS DATE: 6/04

REV	AR	AR	DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
	1	1	-7	WELD, FILLER METAL		7
	1	1	-6	PORT 4 BACKING RING	UNS N06625	6
	AR	AR	-5	TUBEING 1/8 X.035 WALL	316L SST	5
	2	2	SE120-005-39	CLIP		4
	1	1	SE122-105	BLOCK		3
3	AR	X	-2	PORT 4B WELDMENT		2
3	AR	X	-1	PORT 4A WELDMENT		1

← CAGE CODE PART OR IDENTIFYING NO NOMENCLATURE OR DESCRIPTION MATERIAL SPECIFICATION FIND NO  
NEXT ASSEMBLY

NO REPRESENTATION OR WARRANTY, EXPRESSED OR IMPLIED, IS MADE AS TO THE ACCURACY, COMPLETENESS OR USEFULNESS OF THE INFORMATION OR STATEMENTS CONTAINED IN THESE DRAWINGS, OR THAT THE USE OR DISCLOSURE OF ANY INFORMATION, APPARATUS, METHOD OR PROCESS DISCLOSED IN THESE DRAWINGS MAY NOT INFRINGE PRIVATE RIGHTS OF OTHERS. NO LIABILITY IS ASSUMED WITH RESPECT TO THE USE OF, OR FOR DAMAGES RESULTING FROM THE USE OF, ANY INFORMATION, APPARATUS, METHOD OR PROCESS DISCLOSED IN THESE DRAWINGS. DRAWINGS MADE AVAILABLE FOR INFORMATION TO BIDDERS ARE NOT TO BE USED FOR OTHER PURPOSES, AND ARE TO BE RETURNED UPON REQUEST OF THE FORWARDING CONTRACTOR.

**P** THIS DRAWING PRODUCED ON PRO-ENGINEER

REV	DESCRIPTION	BY	DATE	CHK	DEPT	DATE	PE	REQ	DATE	ORNL	DOE	DATE

SCALE NOTED	DES. P. L. GORANSON 8/03	UT-BATTELLE Oak Ridge National Laboratory managed for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT CONTRACT DE-AC05-00OR22725 UT-BATTELLE, LLC, Oak Ridge, Tennessee
TOLERANCES UNLESS OTHERWISE SPECIFIED	DRW. G. H. JONES 8/03	
FRACTIONS	CHK. M. COLE 6/04	
XX DECIMALS ±.01		
XXX DECIMALS ±.005		PROJECT NAME
ANGLES ±0°15'		NATIONAL COMPACT STELLARATOR EXPERIMENT
BREAK SHARP EDGES .06 MAX		VACUUM VESSEL
FINISH .125 UNLESS OTHERWISE SPECIFIED	PPPL DRFT J. SIEGEL 6/04	PORT EXTENSION
		WELDMENT
		VERSION NO. 23
		PLANT X-10
		BLDG 5700
		FL 3
		SHT 1
		OF 1
		TYPE I
		CLASS S
		REV 0
		RELEASE LEVEL Fabrication
		SE122-006