

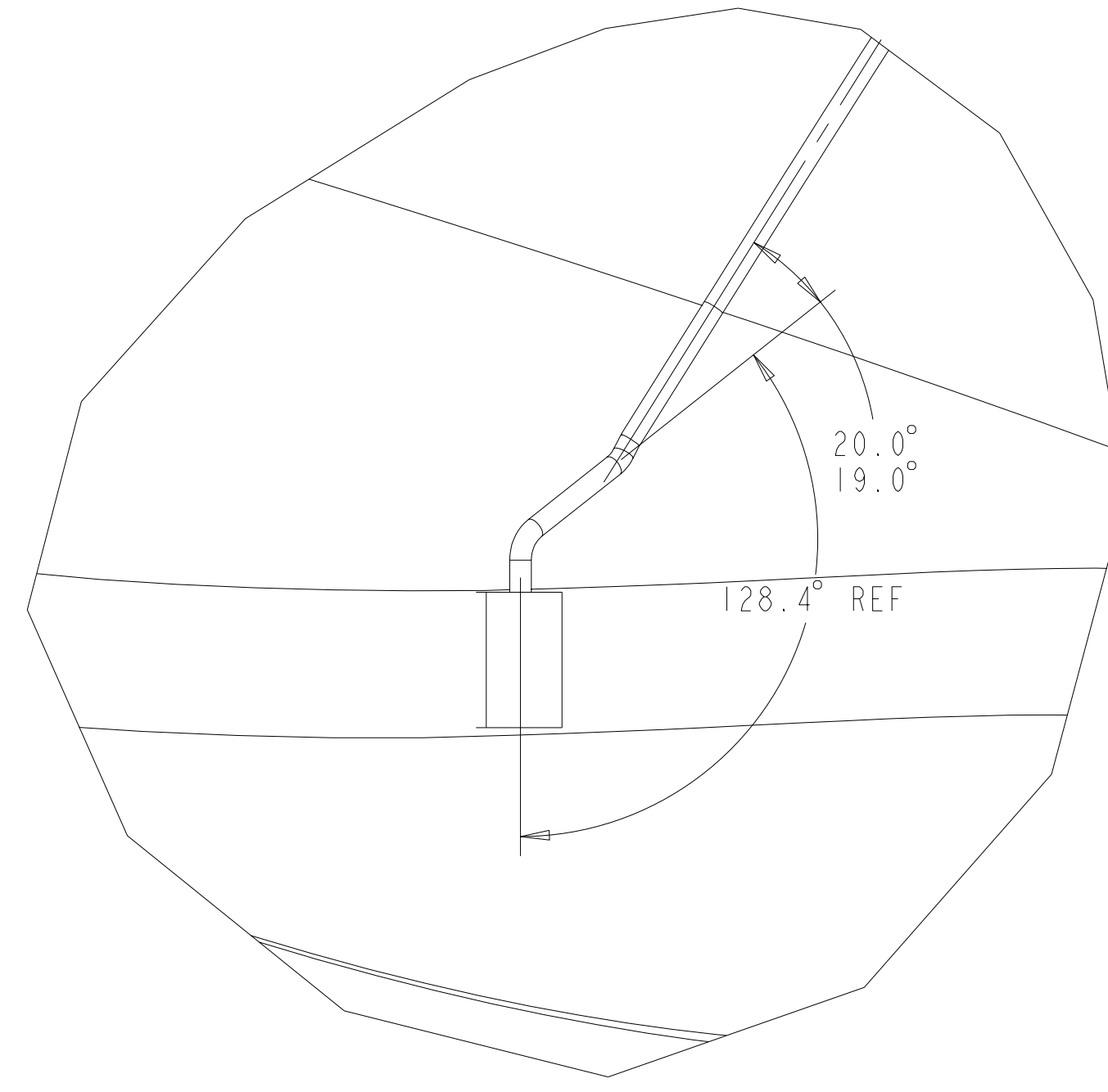
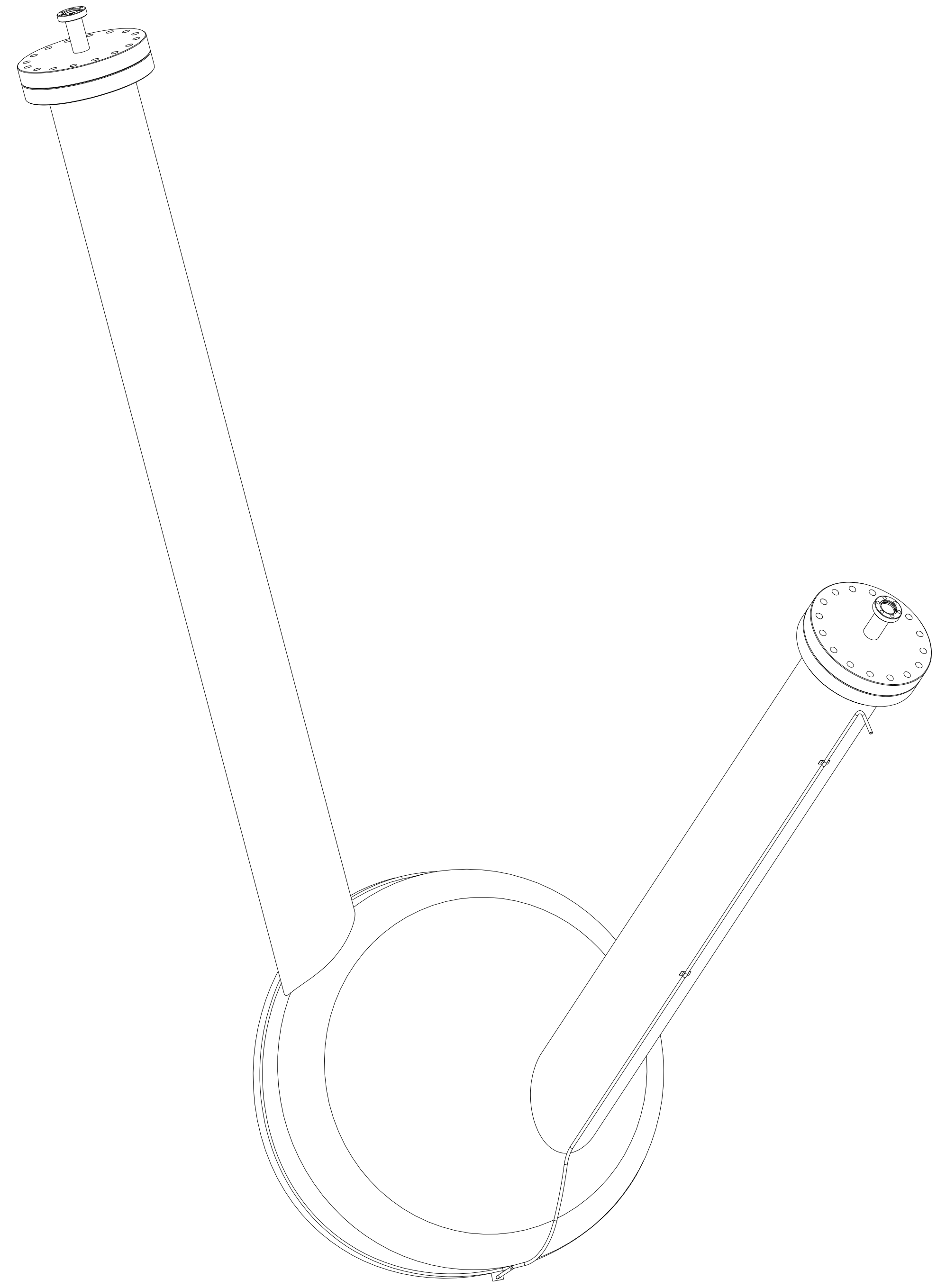
NOTES:

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

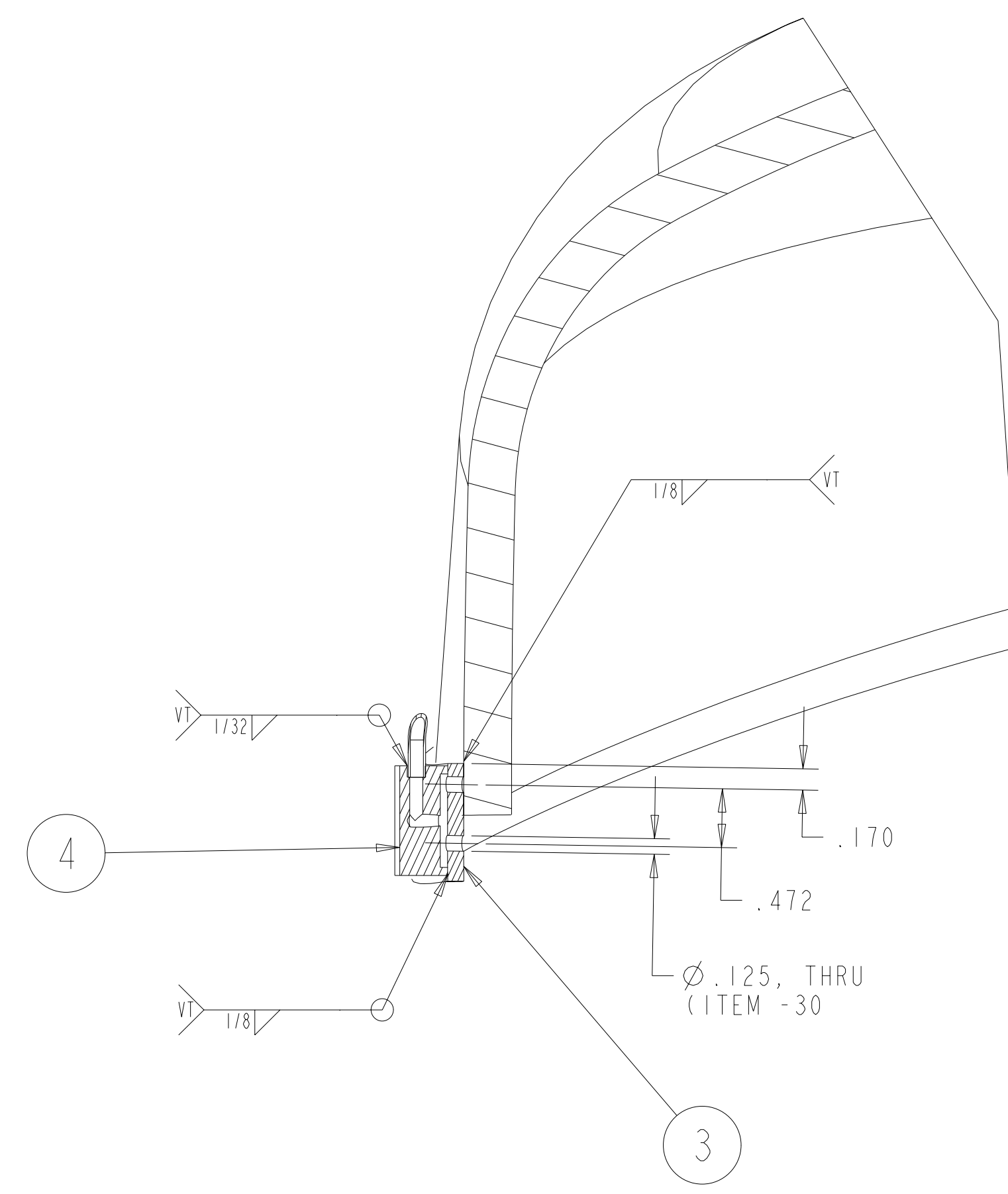
Rev 0-a: ECN-5109 (RFD-12-004) approved replacement of the /32" fillet weld with a braze joint using a silver-free braze material (Nicrobraze) – Applicable to All 3 VVSAs.

Rev 0-b: ECN-5118 (RFD-12-018) 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.

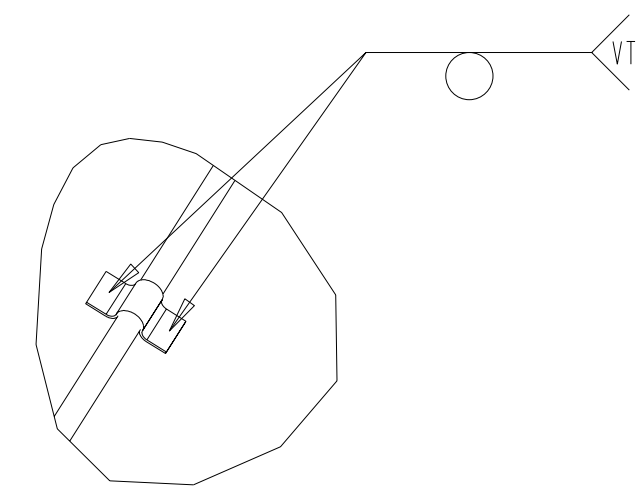
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PPPL Drafting:



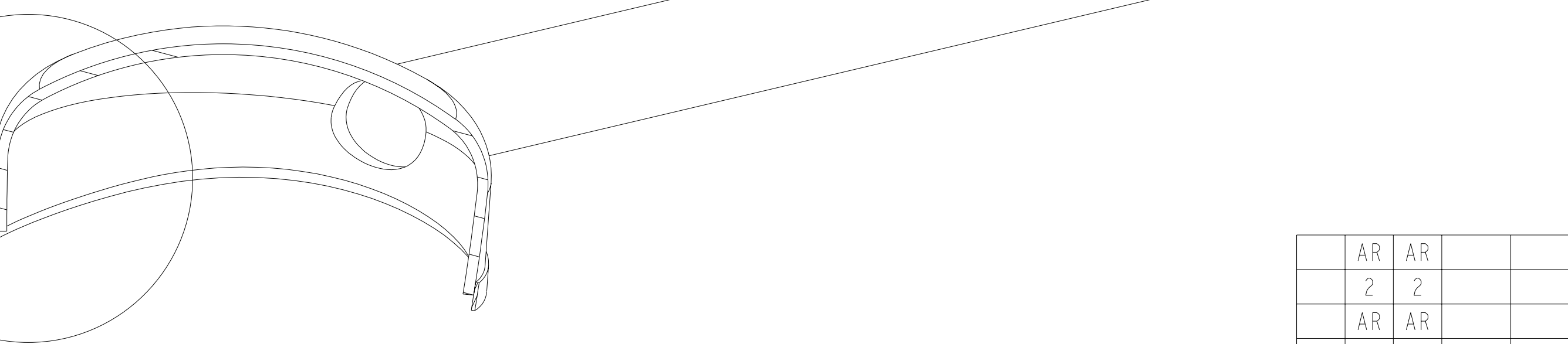
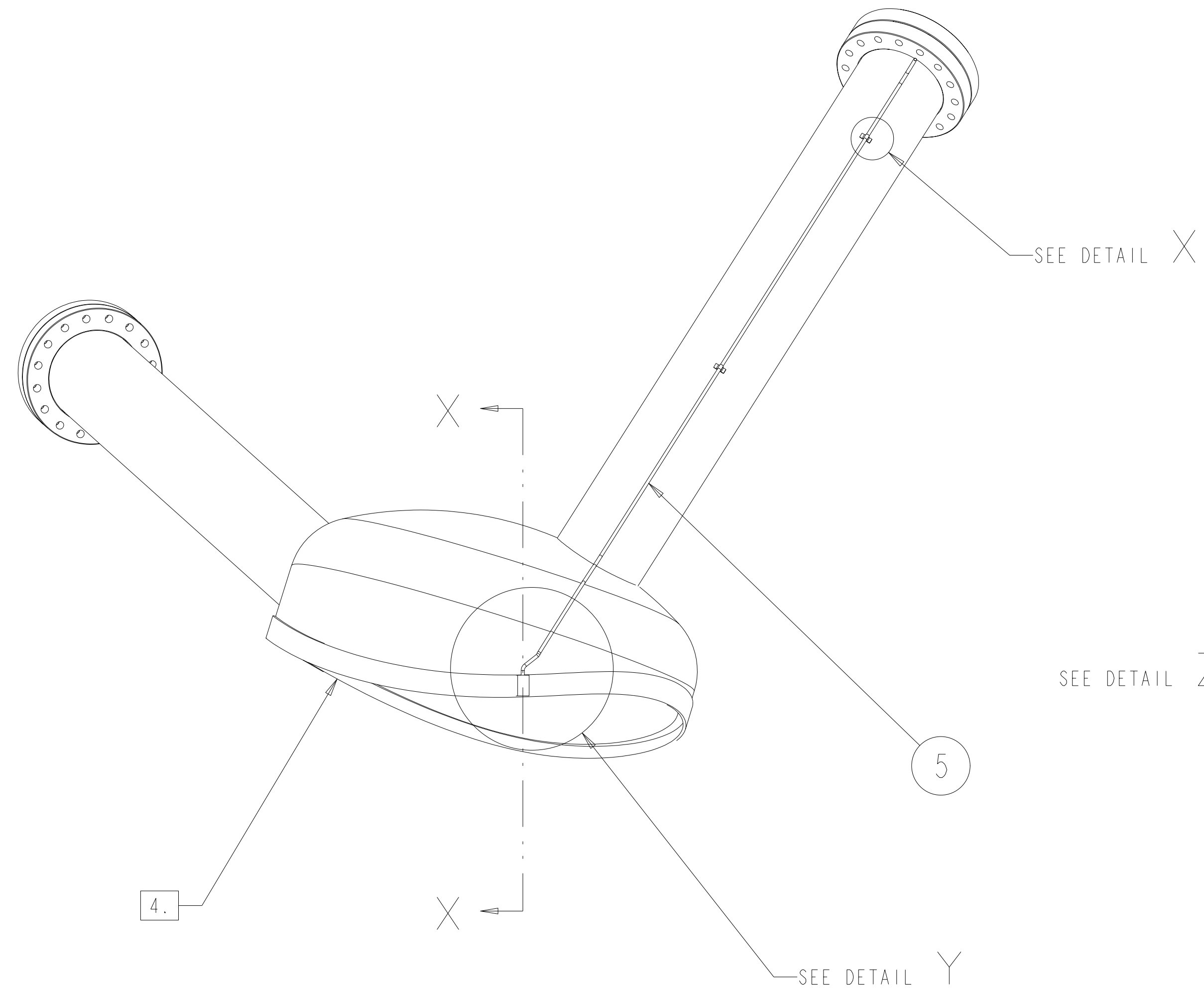
DETAIL Y
SCALE 1.00



DETAIL Z
SCALE 1.00



DETAIL X
SCALE 1.00
SEE SHT 2 FOR CLIP LOCATIONS



SECTION X-X

WELDING ENGINEER
APPROVED R PARSELLS DATE: 6/04

1 2
SCALE .25

REV	AR	AR	DESCRIPTION	QTY	UNIT	REVISION	DATE	BY	CHK	DEPT	DATE	PE	REQ	DATE	ORNL	DOE	DATE
2	2		SE122-005-39		WELD FILLER METAL												
1	1		SE122-105		TUBING 1/8 X .035 WALL												
1	1				CLIP												
3	AR				316L SST												
3	AR				BLOCK												
1	1				DOMES N06625												
3	AR				DOMES N06625												
3	AR				DOMES N06625												
3	AR				DOMES N06625												

CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
SE122-003	-2	WELD FILLER METAL			7
	-1	CLIP			6
		TUBING 1/8 X .035 WALL	316L SST		5
		BLOCK			4
		DOMES N06625	UNS N06625		3
		DOMES N06625	UNS N06625		2
		DOMES N06625	UNS N06625		1

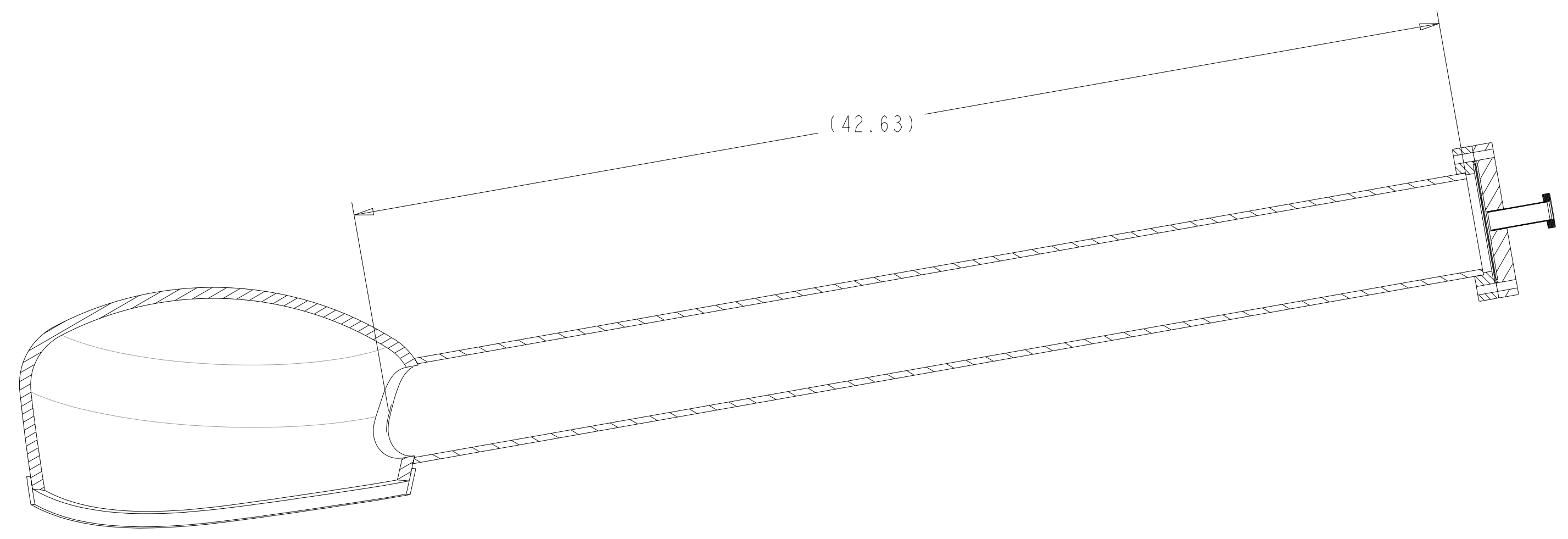
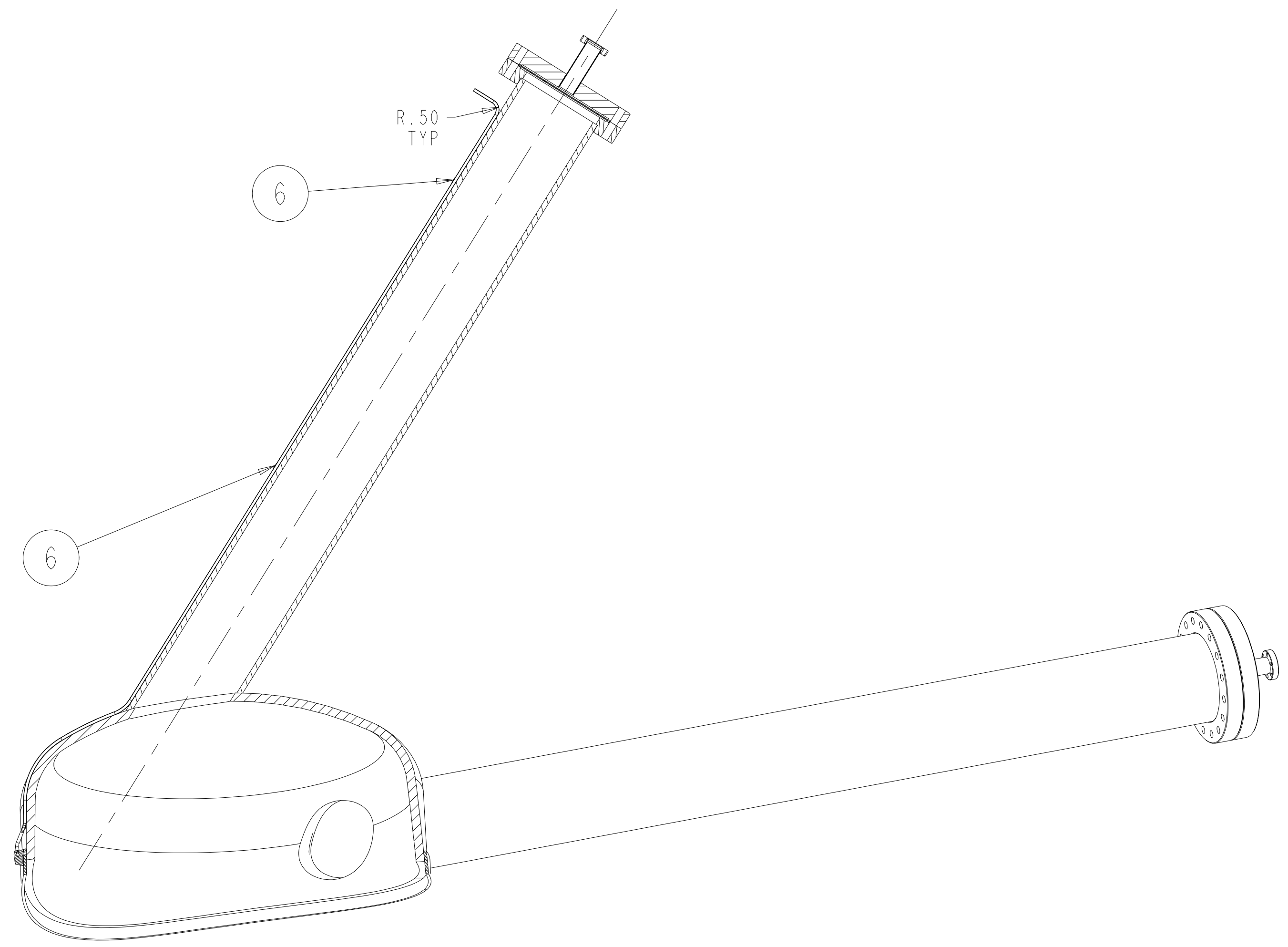
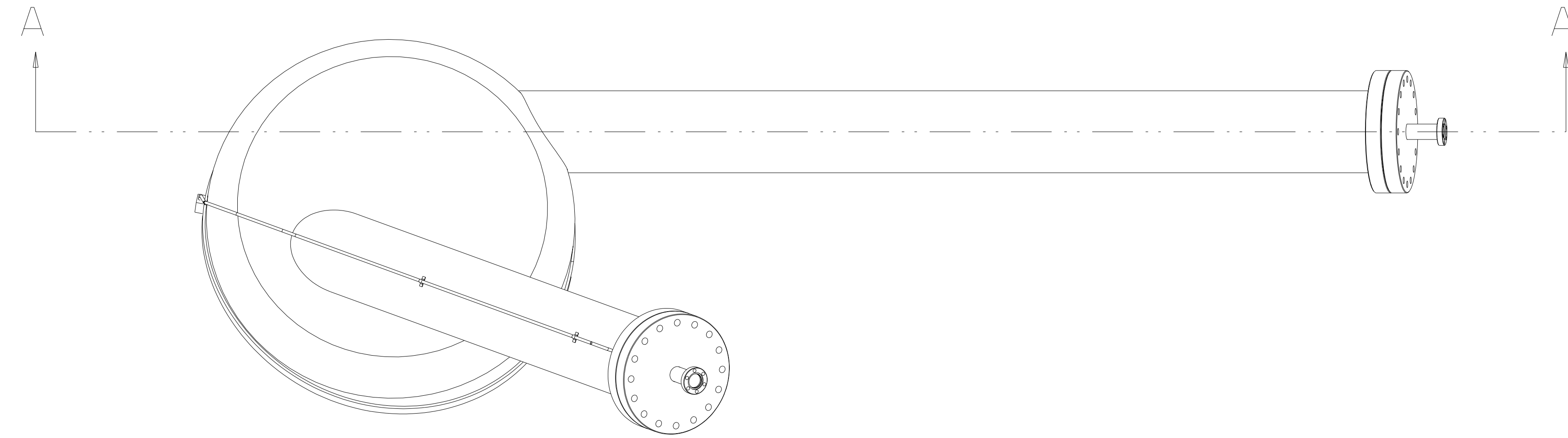
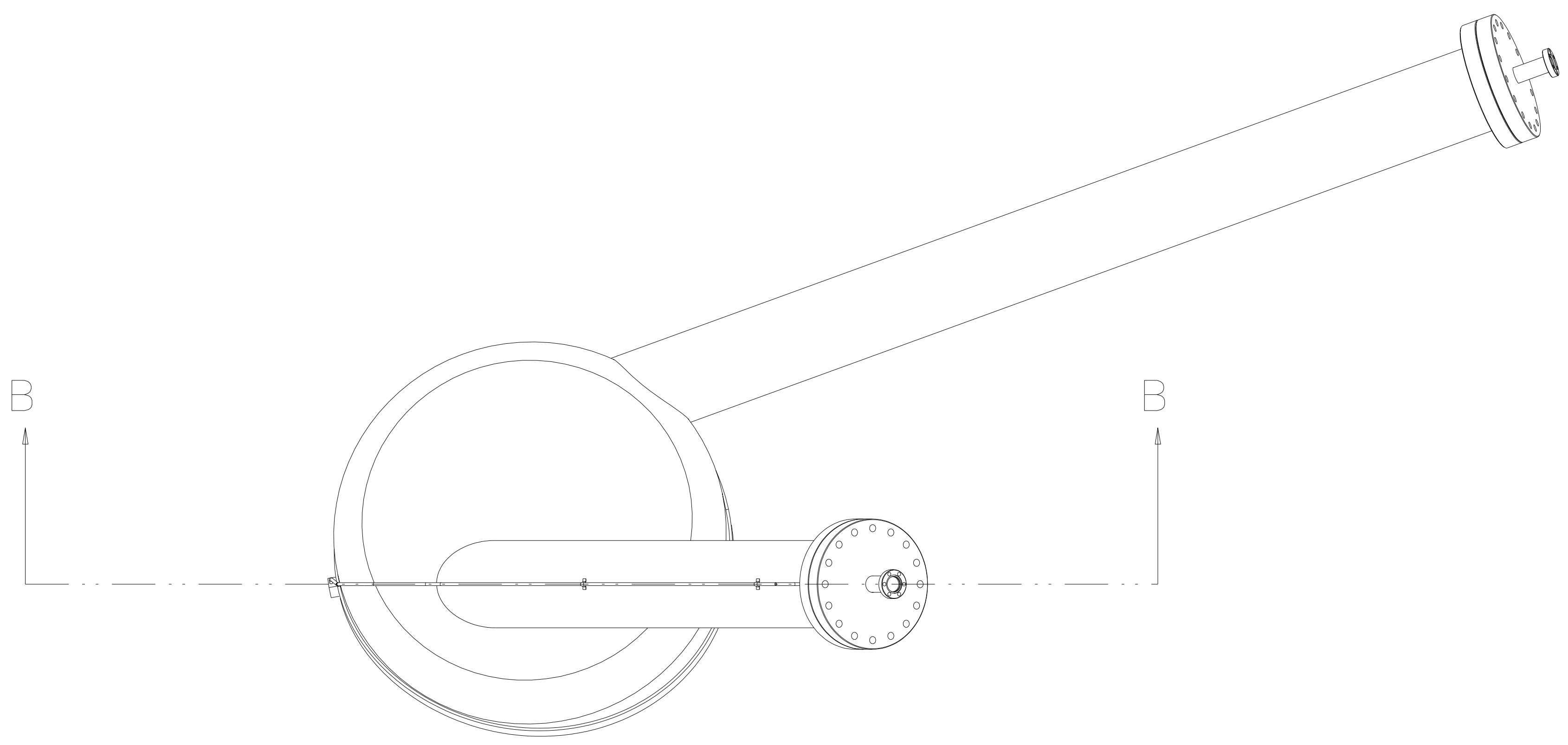
REV	DESCRIPTION	BY	DATE	CHK	DEPT	DATE	PE	REQ	DATE	ORNL	DOE	DATE
1	SCALE NOTED											
2	TOLERANCES UNLESS OTHERWISE SPECIFIED											
3	FRACTIONS											
4	XX DECIMALS ±.01											
5	XXX DECIMALS ±.005											
6	ANGLES ±0°15'											
7	BREAK SHARP EDGES .06 MAX											
8	FINISH .125 UNLESS OTHERWISE SPECIFIED											

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P THIS DRAWING PRODUCED ON PRO-ENGINEER

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									
DRW	G.H. JONES	8/03											
CHK	MIKE COLE	6/04											
DEPT													
SECT													
PROJECT NAME	NATIONAL COMPACT STELLARATOR EXPERIMENT												
PLANT	X-10	BLDG	5700	FL	3	SHT	1	OF	2	TYPE	S	CLASS	U
VERSION NO.	24	PLANT		BLDG		FL		SHT		OF		TYPE	
RELEASE LEVEL	Fabrication											REV	0
DRAWING APPROVALS		DATE											

FOR NOTES AND PARTS LIST, SEE SHEET 1.



SECTION B-B

SECTION A-A

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

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					
PROJECT NAME							
NATIONAL COMPACT STELLARATOR EXPERIMENT							
VACUUM VESSEL PORT 17 & 18 WELDMENT							
VERSION NO. 24	PLANT X-10	BLDG 5700	FL 3	SHT OF 2	TYPE S	CLASS U	REV 0
RELEASE LEVEL Fabrication		SE122-007					

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SE122-007