

- NOTES:**
1. INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M.
  2. DIMENSIONS 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.

**NCSX-RFD-12-002-r1**

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

REV	AR	CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FINISH	QTY	FIND NO
			-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 4.01 ID, PKG 10 REF 6.00 FLG						7
	I	190058	BOLT SET 4.63 OD & 6.00 FLG 1/2 PT BOLT, SILVER PLTG, PKG 25	MDC VACUUM 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
	2		-3	SPACER FLANGE	UNS N06625				3
	4		1	SPACER					2
			-1	SPACER WELDMENT					1
next assy	SE121-020								

← NEXT ASSEMBLY

**WELDING ENGINEER**  
APPROVED R. PARSELLS DATE: 6/04

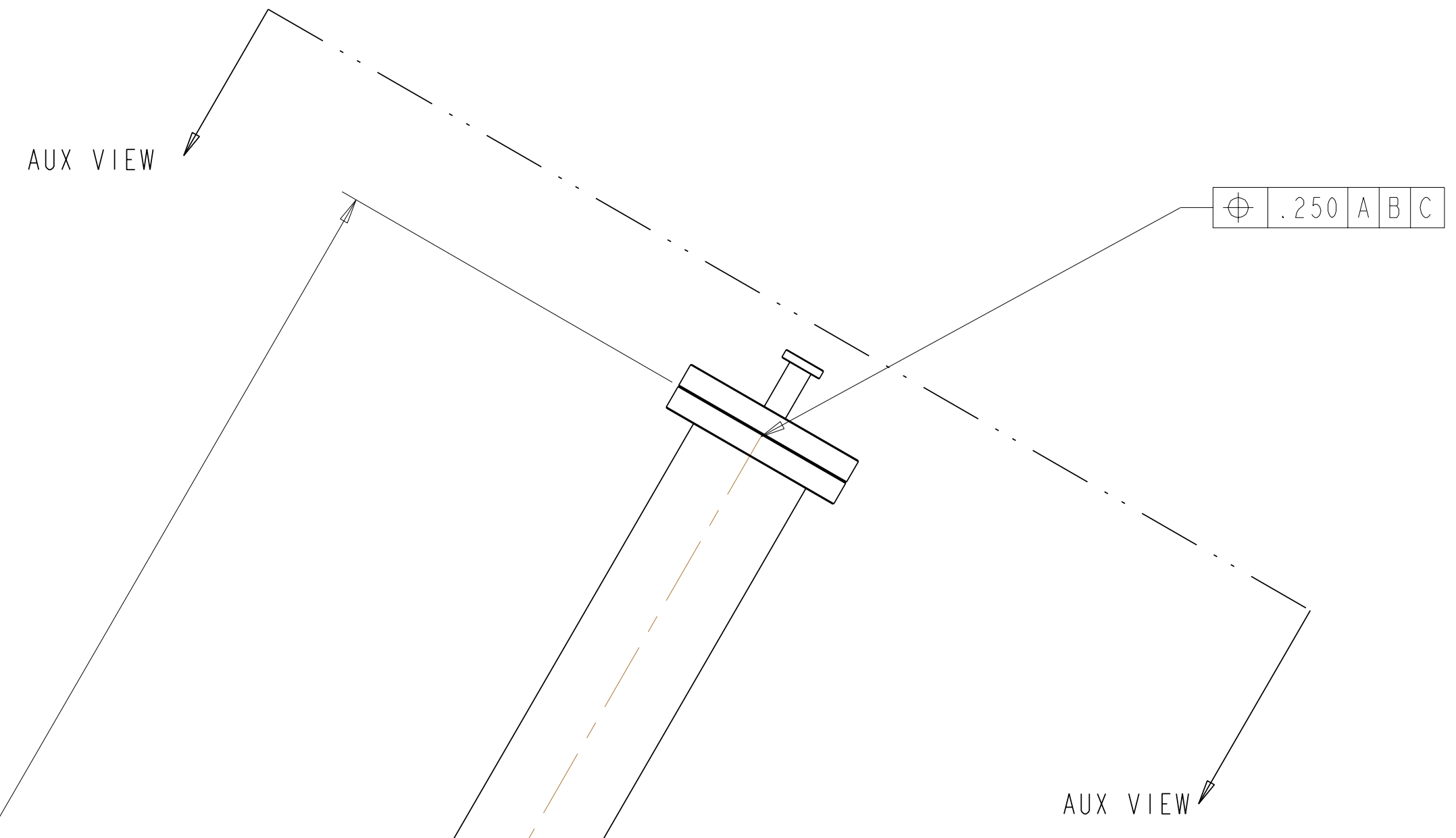
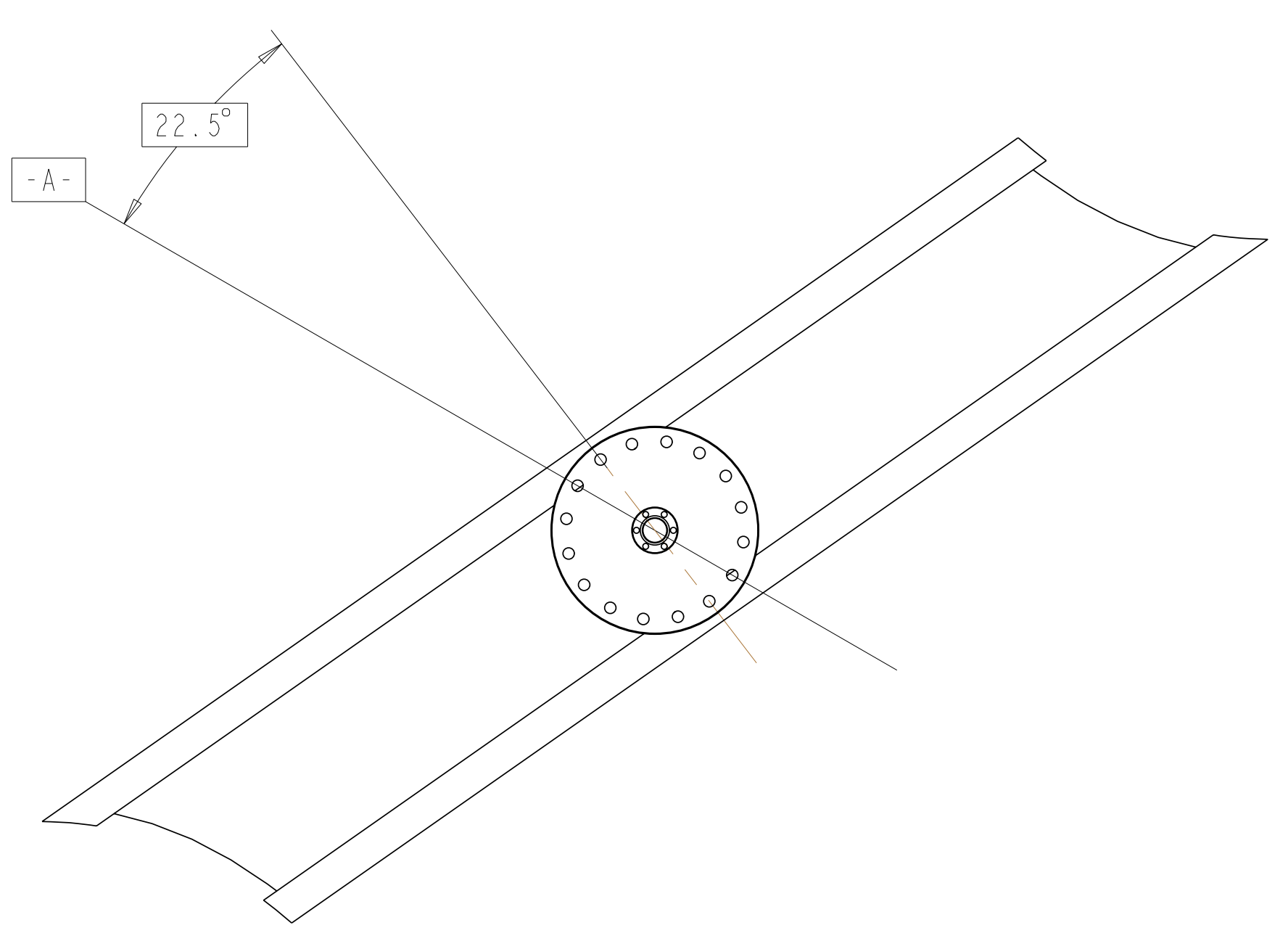
REVISED PER ECN-4945		G.H.J. 2/28/05 M.J.C.		SCALE NOTED		DES: PL. GORANSON 08/03		UT-BATTELLE				Oak Ridge National Laboratory managed for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT contract DE-AC05-00OR22725 UT-BATTELLE, LLC, Oak Ridge, Tennessee			
ADD NOTE 5				TOLERANCES UNLESS OTHERWISE SPECIFIED		DRW: G.H. JONES 08/03		NATIONAL COMPACT STELLARATOR EXPERIMENT				VACUUM VESSEL SPACER WELDMENT			
				FRACTIONS		CHK: M.J. COLE 6/04		PPPL DRFT J. SIEGEL 6/04				VERSION NO. PLANT BLDG FL SHT OF TYPE CLASS			
				XX DECIMALS ±.01		DEPT:		X-10 5700 3 1 2 S U				RELEASE LEVEL Fabrication			
				XXX DECIMALS ±.005		PE:		SE121-014							
				ANGLES ±0°15'		CR:									
				BREAK SHARP EDGES .06 MAX		PJ:									
				FINISH .125 UNLESS OTHERWISE SPECIFIED		RD:									
						REG:									
						ORNL DOE DATE									

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

H  
G  
F  
E  
D  
C  
B  
A

FOR NOTES AND PARTS LIST SEE SHEET 1



99.36

⊕ .250 A B C

⌒ .375 A B C

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

(60°)

SCALE 0.250

-B-

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

SEI21-014

A