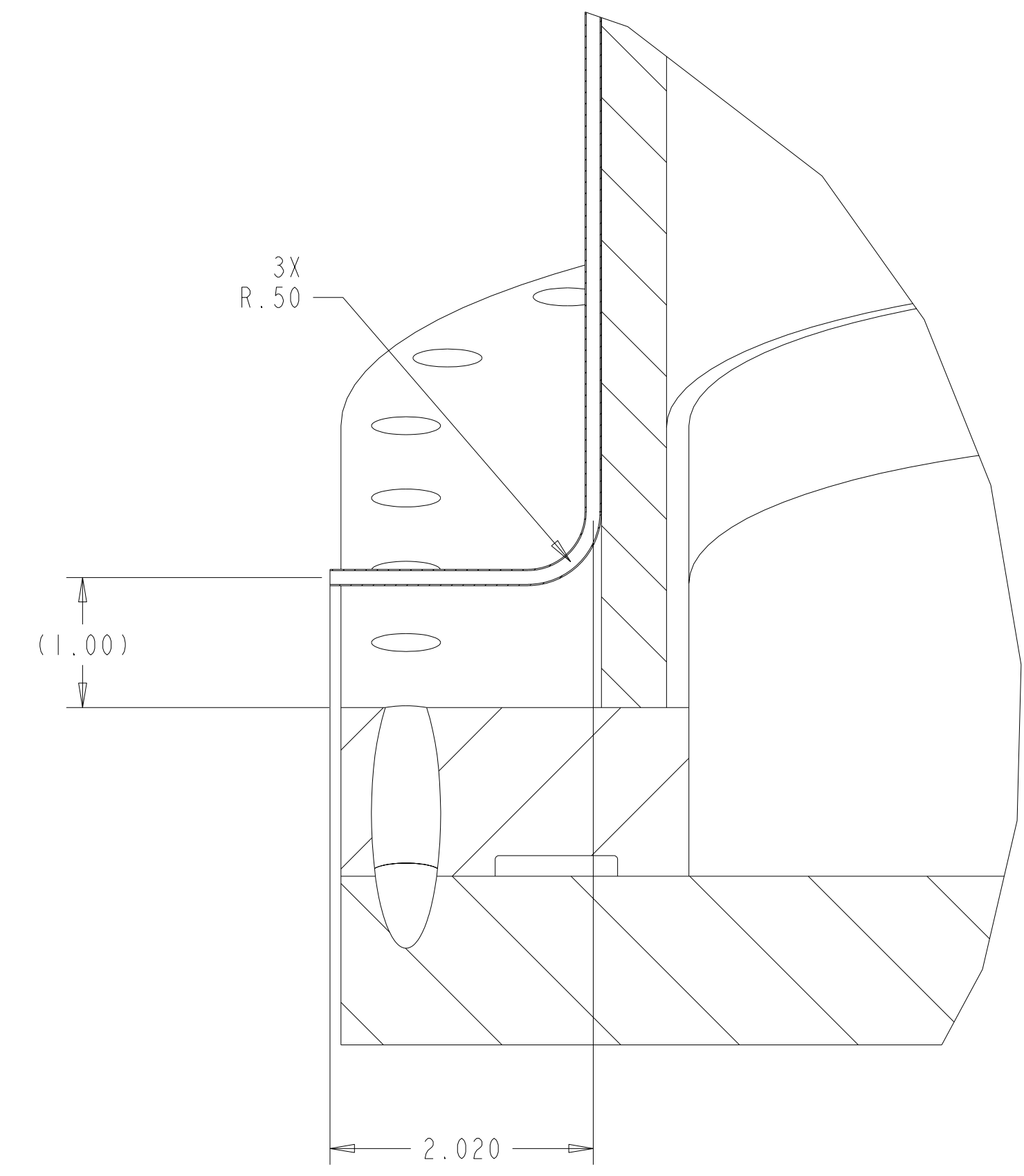
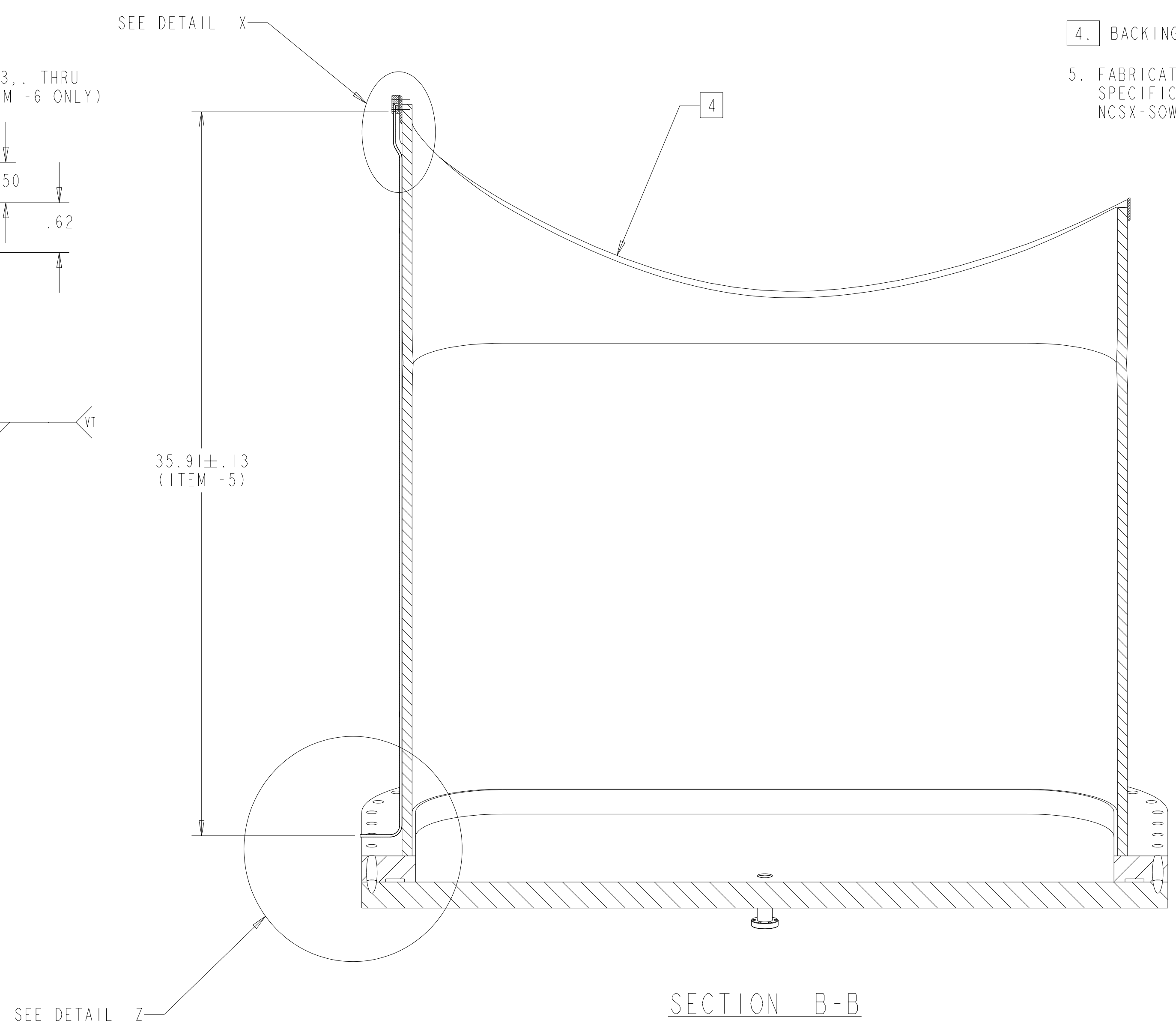
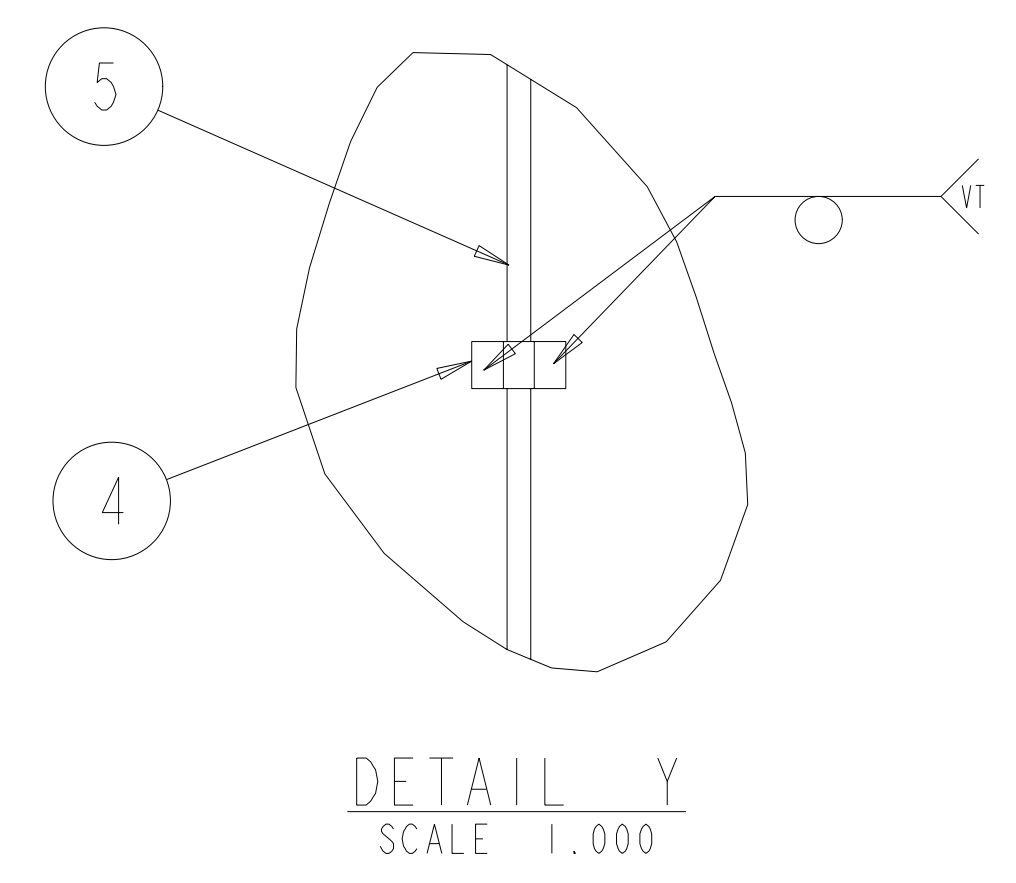
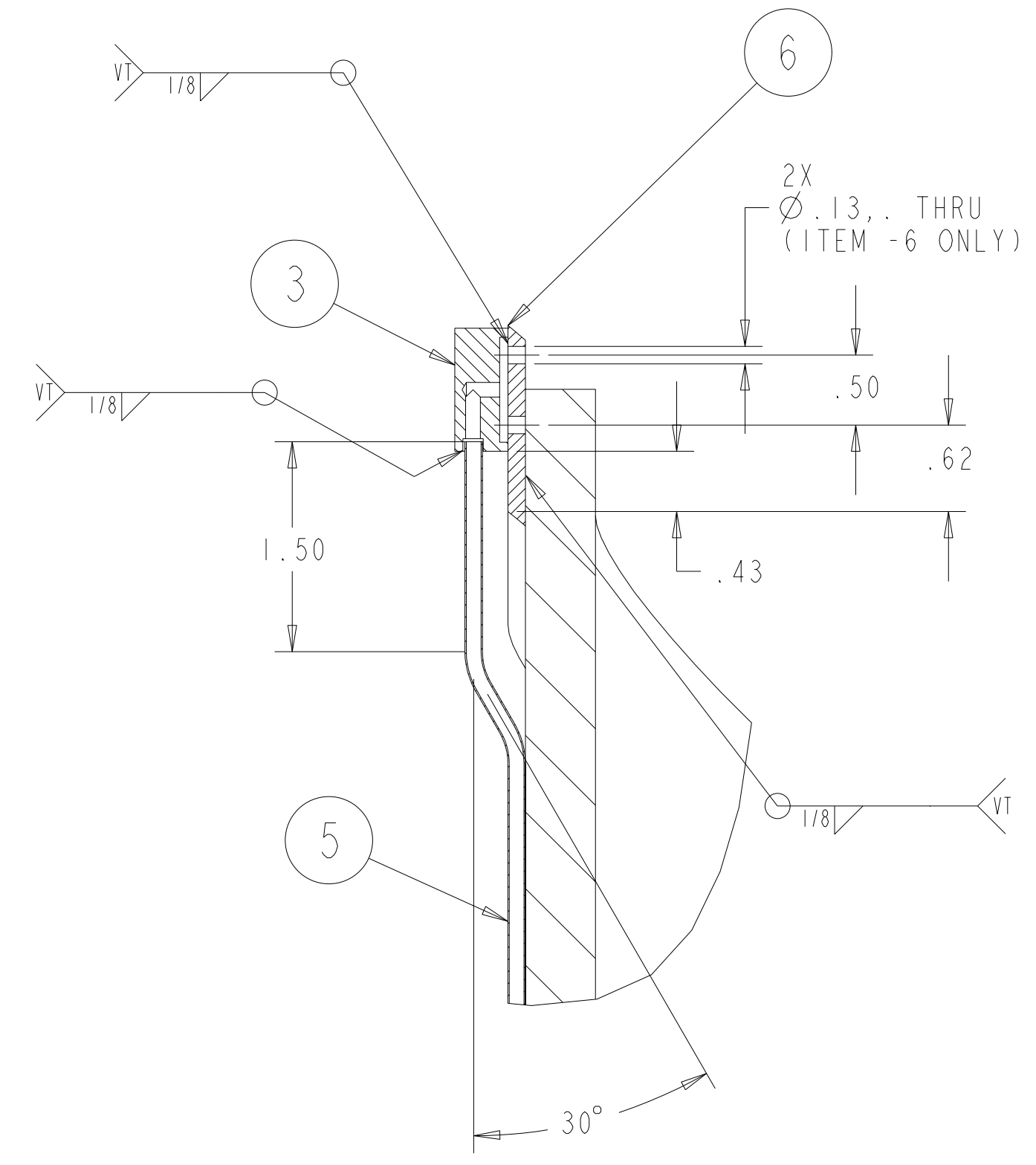
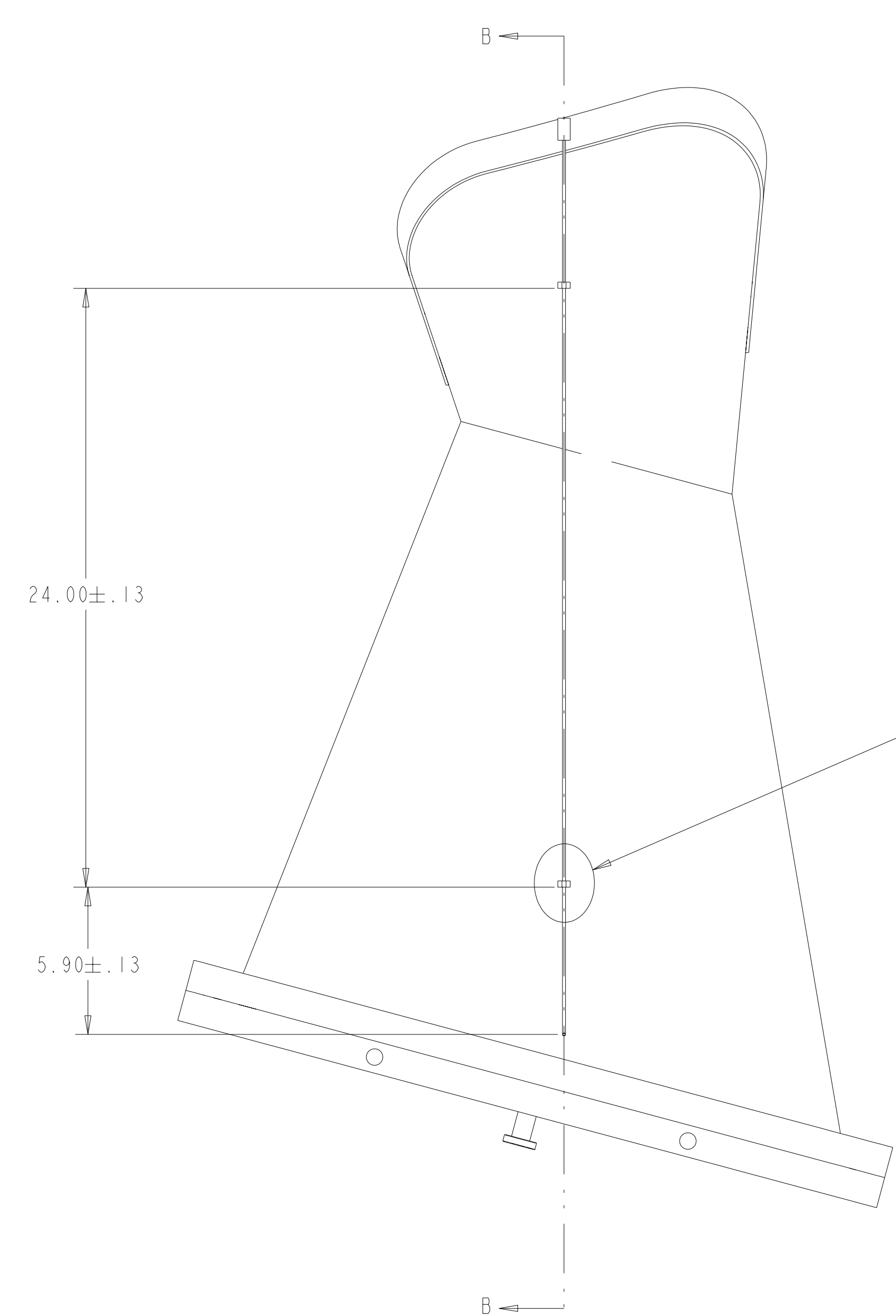


NCSX-RFD-12-004

- 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

WELDING ENGINEER
APPROVED R PARSELLS DATE: 6/04

RELEASED FOR FABRICATION / INSTALLATION
PPPL Drafting:

REV	AR	DESCRIPTION	DATE	CHK	DEPT	DATE	PE	REQ	DATE	ORNL	DOE	DATE
3	AR	WELD, FILLER METAL	-7									
	1	PORT 4 BACKING RING	-6									
	AR	TUBEING 1/8 X.035 WALL	-5									
	2	CLIP	SE120-005-39									
	1	BLOCK	SE122-105									
3	AR	PORT 4B WELDMENT	-2									
3	AR	PORT 4A WELDMENT	-1									

REV	DESCRIPTION	BY	DATE	CHK	DEPT	DATE	PE	REQ	DATE	ORNL	DOE	DATE
1												
2												

SCALE NOTED	DES	DATE	DRW	DATE	CHK	DATE	SECT	DEPT	PE	CR	FJ	REQ	PPPL DRFT	DATE	VERSION NO.	PLANT	BLDG	FL	SHT	OF	TYPE	CLASS
	P. L. GORANSON	8/03	G. H. JONES	8/03	M. COLE								J. SIEGEL	6/04	23	X-10	5700	3	1	1	S	U

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

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 EXTENSION WELDMENT
RELEASE LEVEL: Fabrication
SE122-006
REV 0