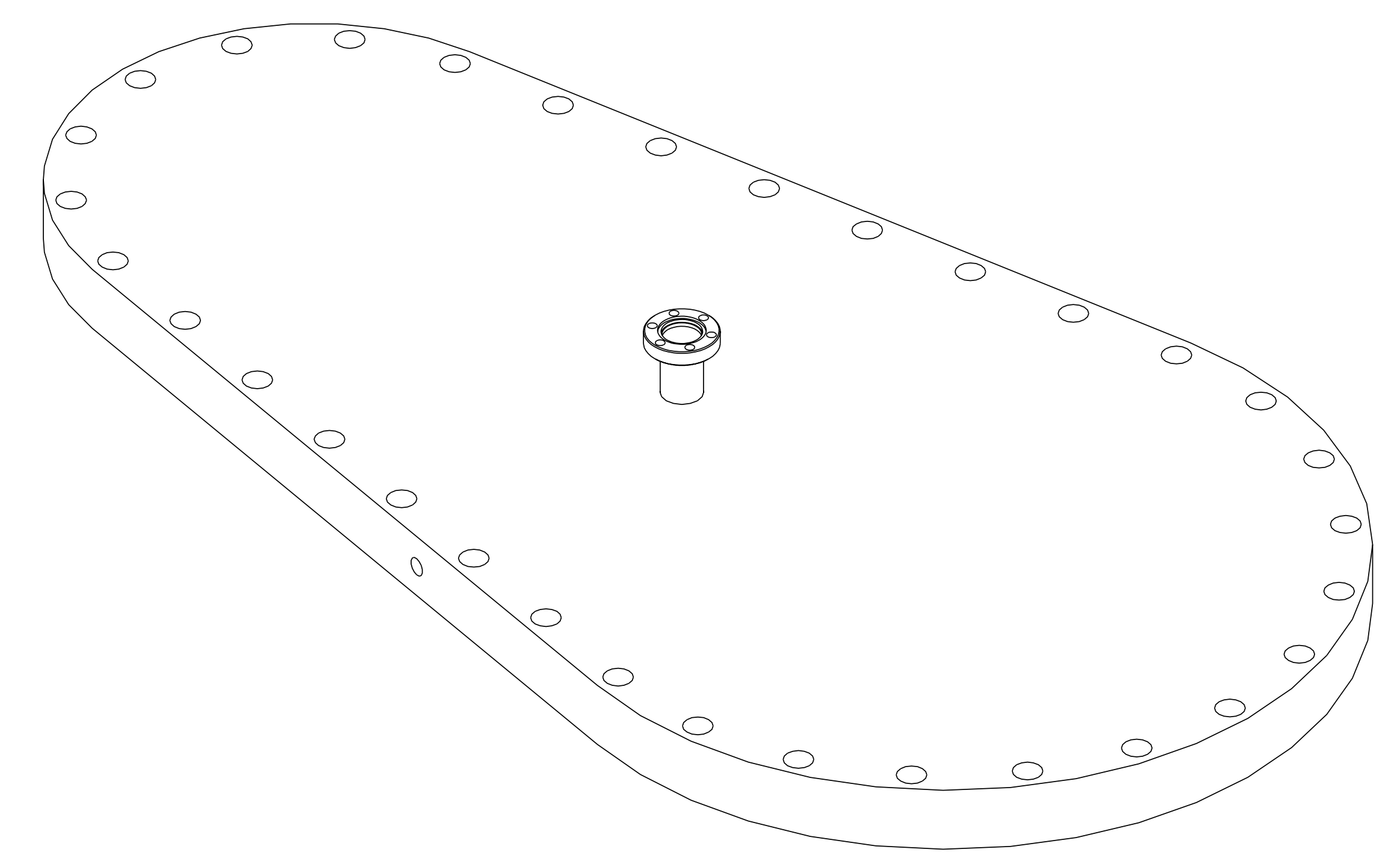
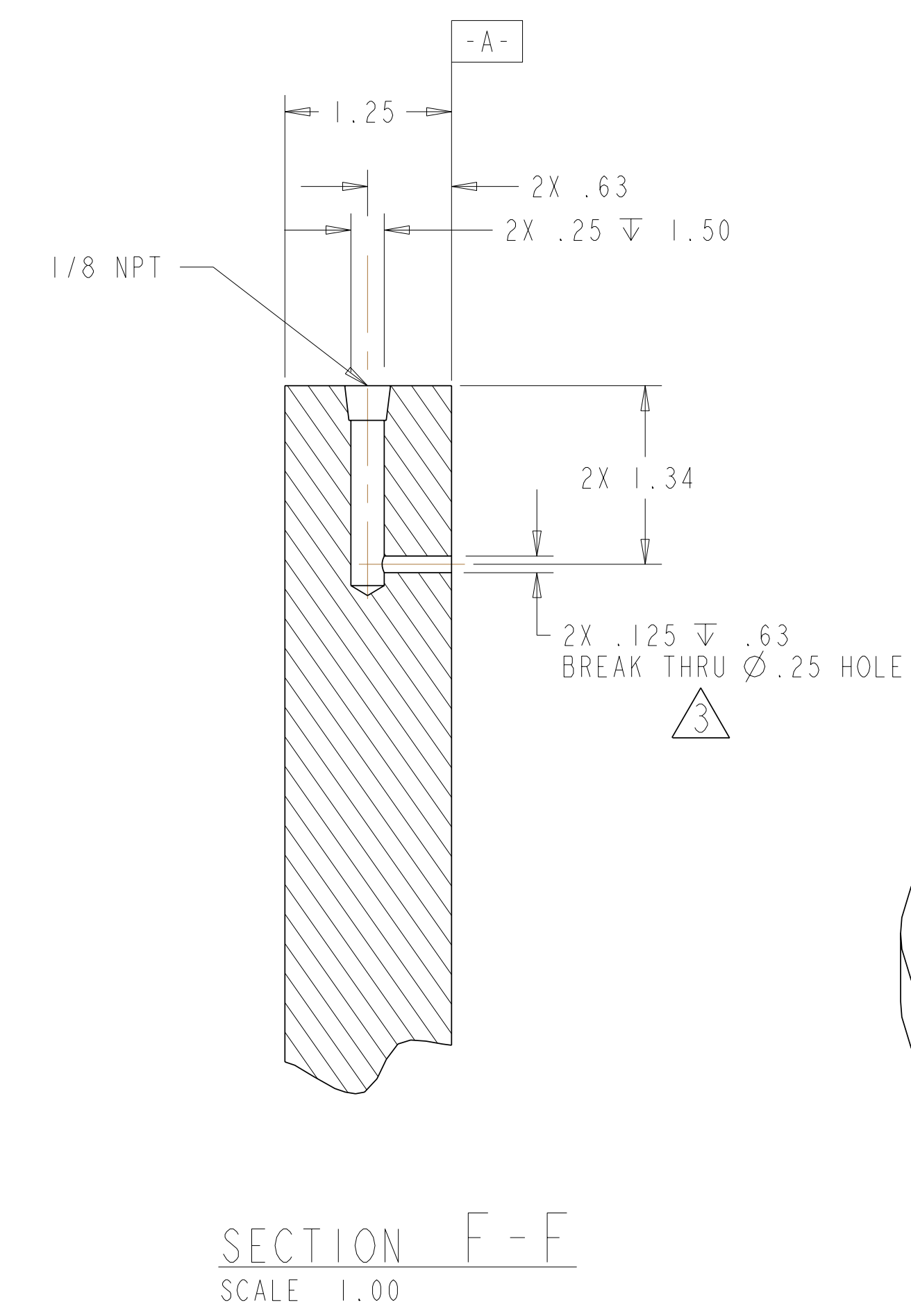
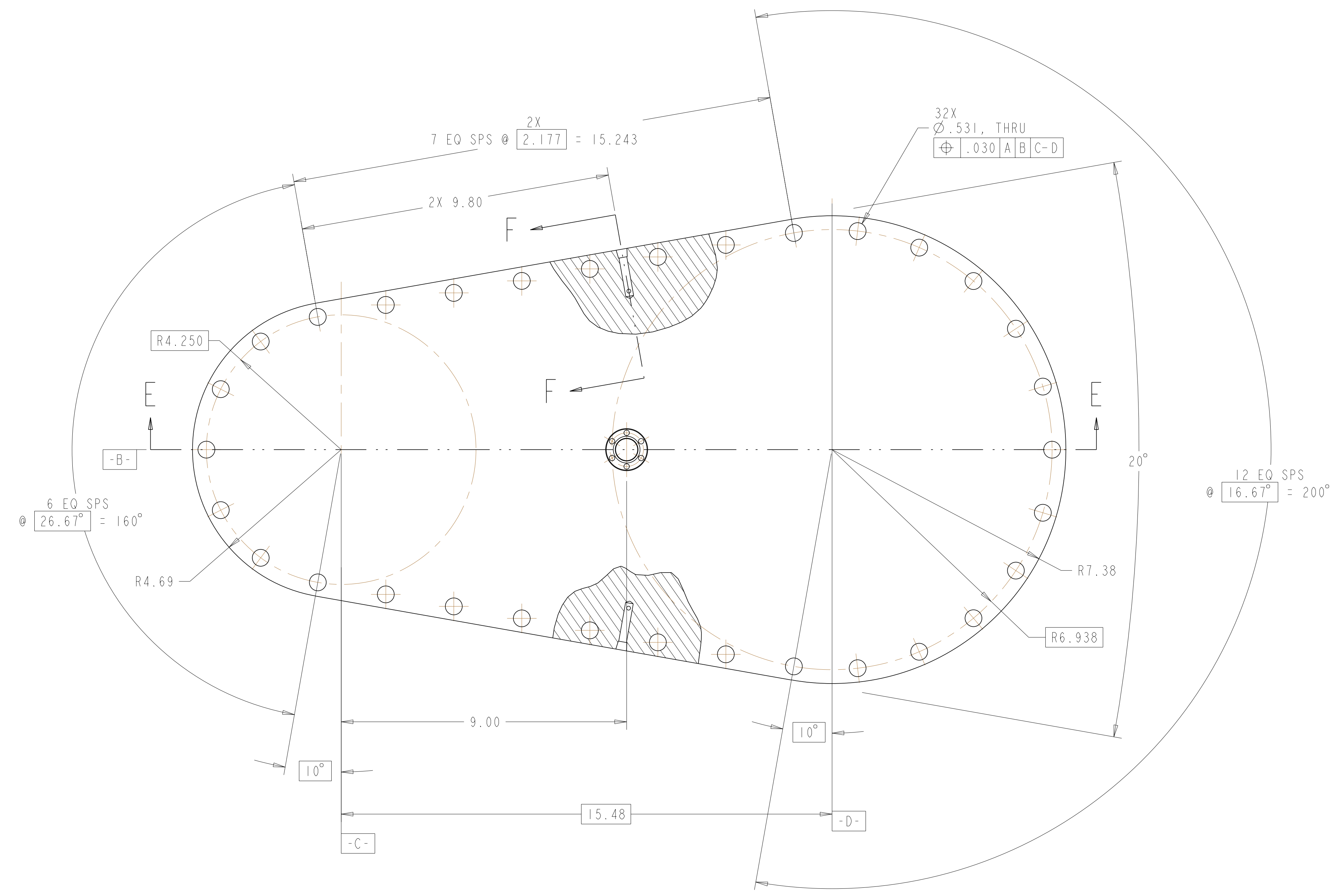
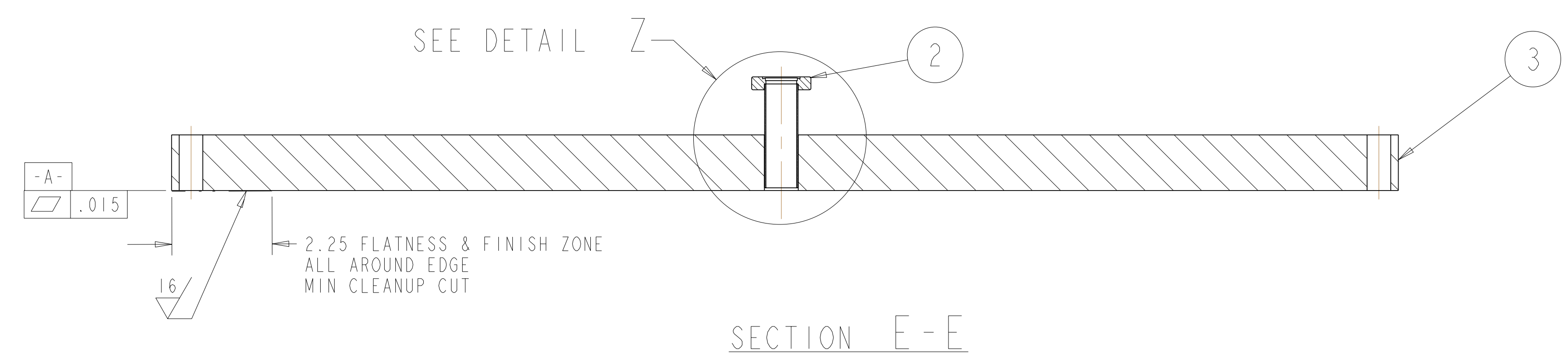


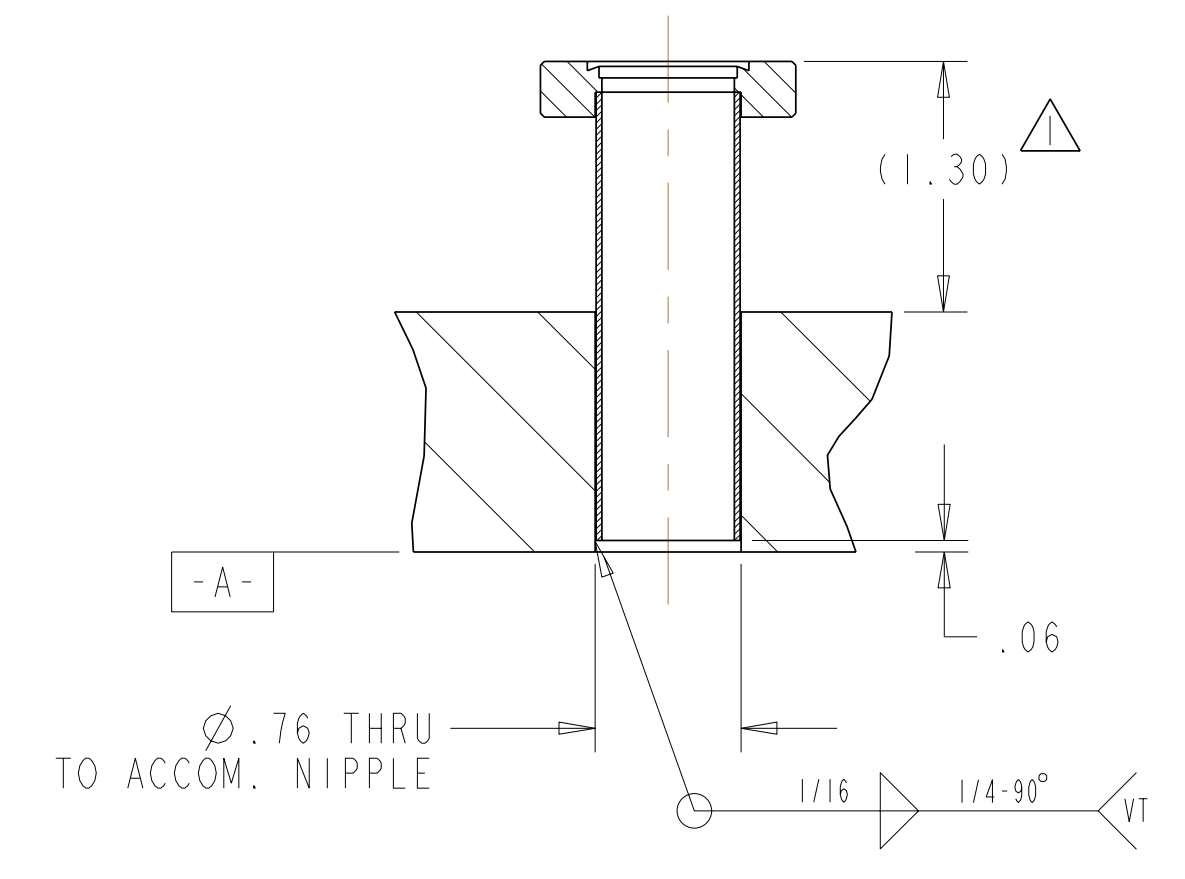
- NOTES:
1. INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M.
 2. DIMENSION ARE IN INCHES.
 3. FABRICATION, INSPECTION, AND TESTING SHALL BE PERFORMED IN ACCORDANCE WITH SPECIFICATION NCSX-CSPEC-121-02 AND STATEMENT OF WORK NCSX-SOW-121-03.
 4. LEAK CHECK ITEM -2 (HALF NIPPLE) OPTIONAL.



ISOMETRIC VIEW



SECTION E-E



DETAIL Z
SCALE 1.00

AR	CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
AR		-4	WELD, FILLER METAL			4
I		-3	PORT 12 FLANGE	316L SST		3
I		-2	HALF NIPPLE 1 1/3 DEL-SEAL CF CUSTOM LENGTH 2.50"	MDC VACUUM PRODUCTS CORP. 23842 CABBOT BOULEVARD HAYWARD, CA. 94545-1651		2
AR		-1	PORT 12 COVER TEST FLANGE WELDMENT			1
SE120-004			NEXT ASSEMBLY			

PARTS LIST

WELDING ENGINEER
 APPROVED R. PARSELLS DATE: 6/04

SCALE: .50

REV	DESCRIPTION	BY	DATE	CHK	DEPT	DATE	PE	REQ	DATE	ORNL	DOE	DATE
2	ADDED NOTE 4 MODIFIED DEPTH	MJC	02/28/05									
1	ADDED REF DIMENSION	PLG	01/02/04									

SCALE NOTED	DES. P. L. GORANSON 8/03
TOLERANCES UNLESS OTHERWISE SPECIFIED	DRW. G. H. JONES 8/03
FRACTIONS	CHK. M. J. COLE 6/04
XX DECIMALS ± .01	SECT. :
XXX DECIMALS ± .005	DEPT. :
ANGLES ± 0°15'	PE :
BREAK SHARP EDGES .06 MAX	CR :
FINISH .125 UNLESS OTHERWISE SPECIFIED	PJ :
	RED :
	PPPL DRFT J. SIEGEL 6/04
	VERSION NO. :
	PLANT X-10
	BLDG 5700
	FL 03
	SHT 1
	TYPE I
	CLASS S
	REV U
	RELEASE LEVEL WIP
	DATE

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 12 COVER TEST FLANGES WELDMENT			
VERSION NO.	PLANT	BLDG	FL
1	X-10	5700	03
SHT OF	TYPE	CLASS	REV
1	I	S	U
DRAWING APPROVALS		DATE	

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 BIDDER 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

H
G
F
E
D
C
B
A

SE122-104

A