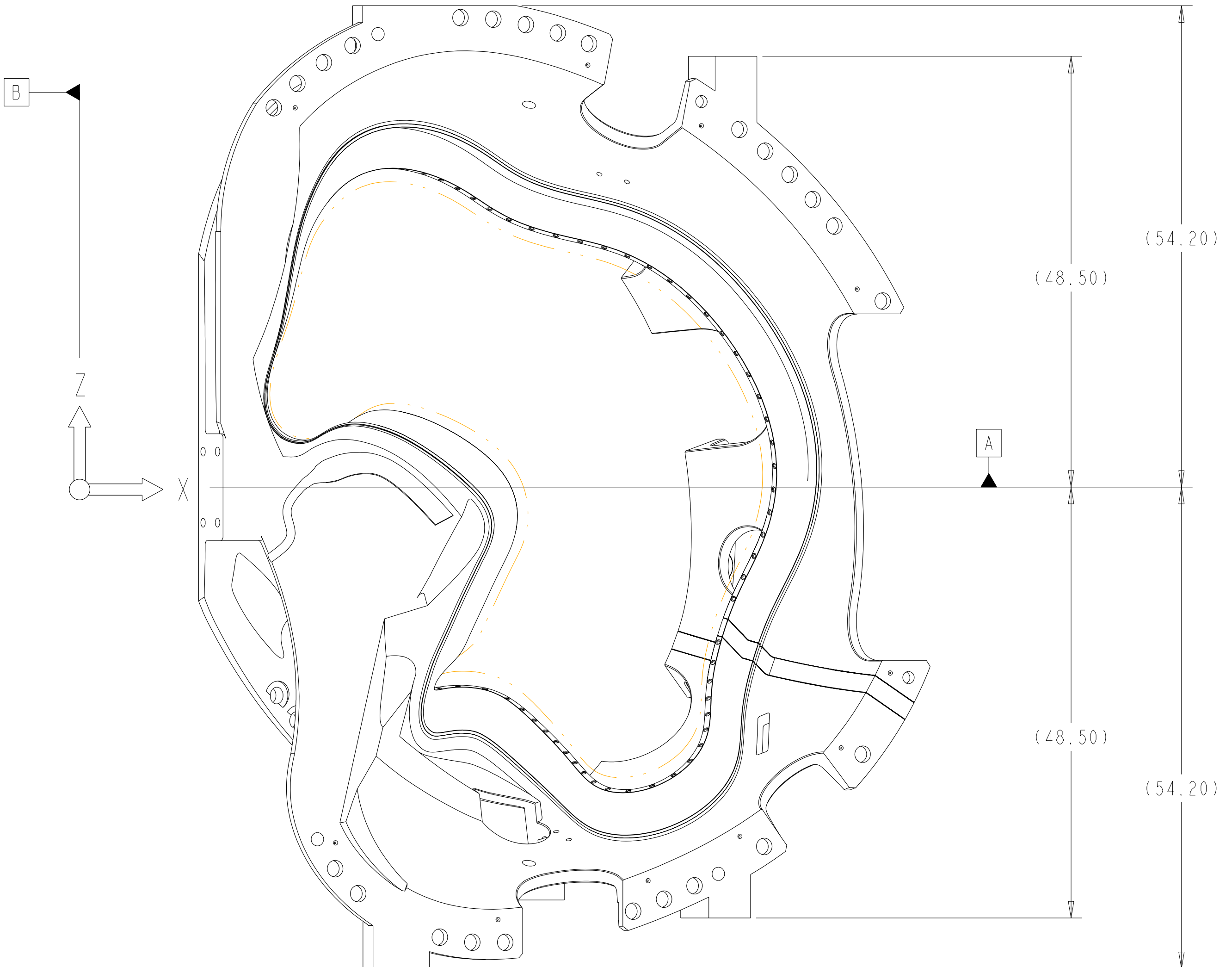
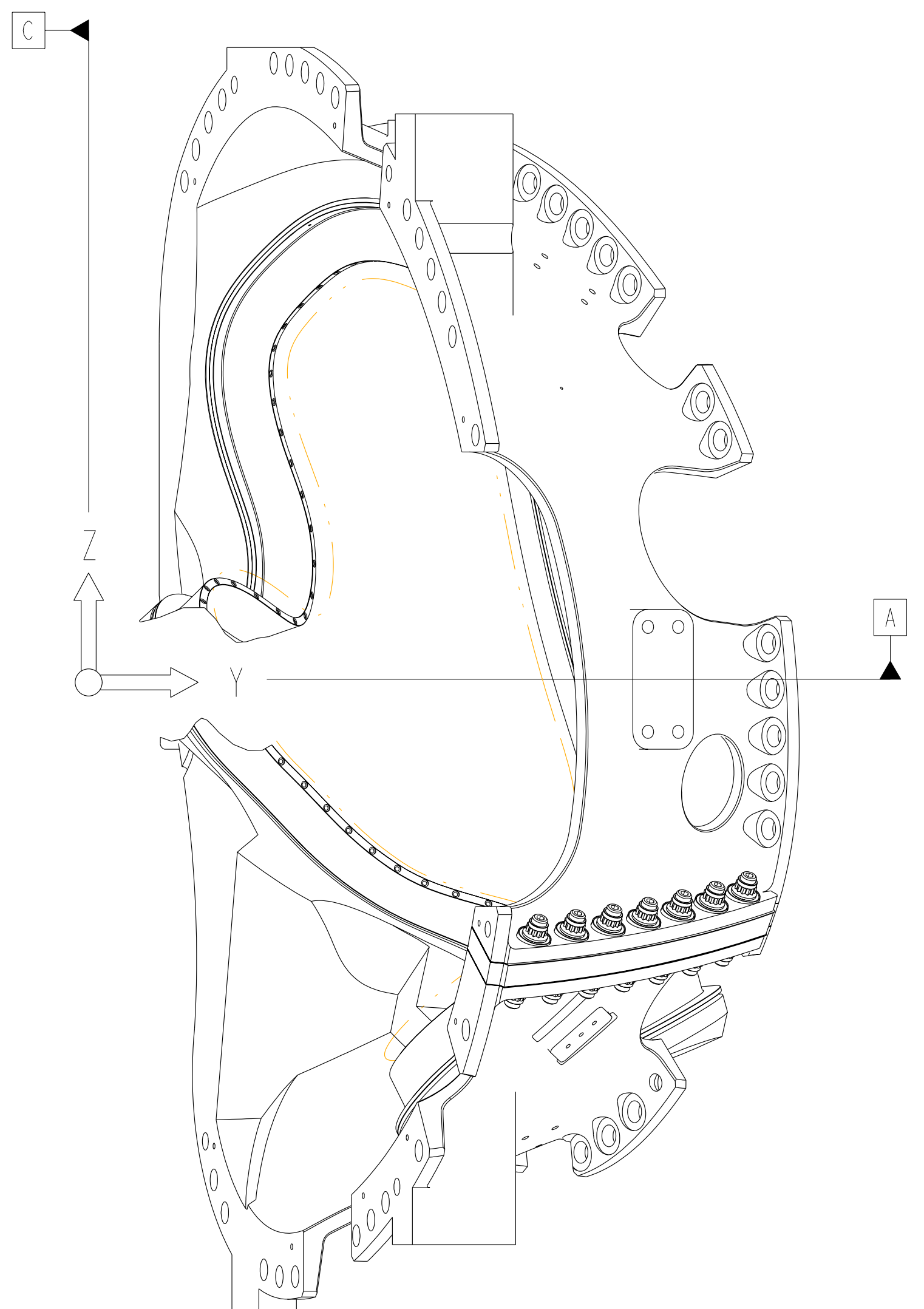


- NOTES:
- DRAWING PREPARED IN ACCORDANCE WITH ASME Y14.8M-1996
  - INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M-1994
  - DIMENSIONS ARE IN INCHES
  - DRAWING DEPICTS FINAL MACHINED STATE OF PART DEFINED BY PRO/ENGINEER FILE SE141-102.ASM
  - UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE RELATED TO DATUM A- (PRIMARY X-Y PLANE, TOP) DATUM B- (SECONDARY Y-Z PLANE, SIDE) DATUM C- (TERTIARY X-Z PLANE, FRONT)
  - DIMENSIONS APPLY AT TEMPERATURE OF 20-30°C (68-86°F)
  - DIMENSIONS AND TOLERANCES EXCLUDE PROCESS MATERIAL ALLOWANCES WHICH MAY ADD MASS
  - APPROXIMATE WEIGHT = 4950-LBS
  - MATCH DRILL OR REAM AS REQUIRED TO ACHIEVE RUNNING FIT BETWEEN PARTS AT ASSEMBLY
  - LUBRICATE THREADED SURFACES WITH MOLYCOTE 321R PER MANUFACTURER'S INSTRUCTIONS
  - SEE LATEST REVISION OF SPECIFICATION NCSX-CSPEC-141-03 FOR ADDITIONAL REQUIREMENTS
  - BOND INSULATING SLEEVE (F/N 5) INTO WINDING FORM (F/N 2) USING LOCTITE 411 PER MANUFACTURER'S INSTRUCTIONS

ISOMETRIC VIEW  
 SCALE 0.10



SCALE 0.10



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

14	DS141-079	FLAT WASHER		9		
14	DS141-060	NUT, 12PT HEX 1.375-6UNC-2B		8		
14	DS141-038	INSULATING WASHER		7		
7	DS141-036	STUD, 1.375-6UNC-2A X 9 LG		6		
14	-5	MCWF INSULATING SLEEVE TYPE-B	G11CR NEMA LI 1 - 1998	5		
2	-4	INSULATING SHEET TYPE-B	G11CR --	4		
1	SE141-058	POL BREAK SHIM ASSEMBLY TYPE-B		3		
1	SE141-115	PRODUCTION WINDING FORM TYPE-B		2		
AR	X	-1	MOD COIL WINDING FORM ASSEMBLY TYPE-B	1		
SE141-102	CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
		NEXT ASSEMBLY	PARTS LIST			

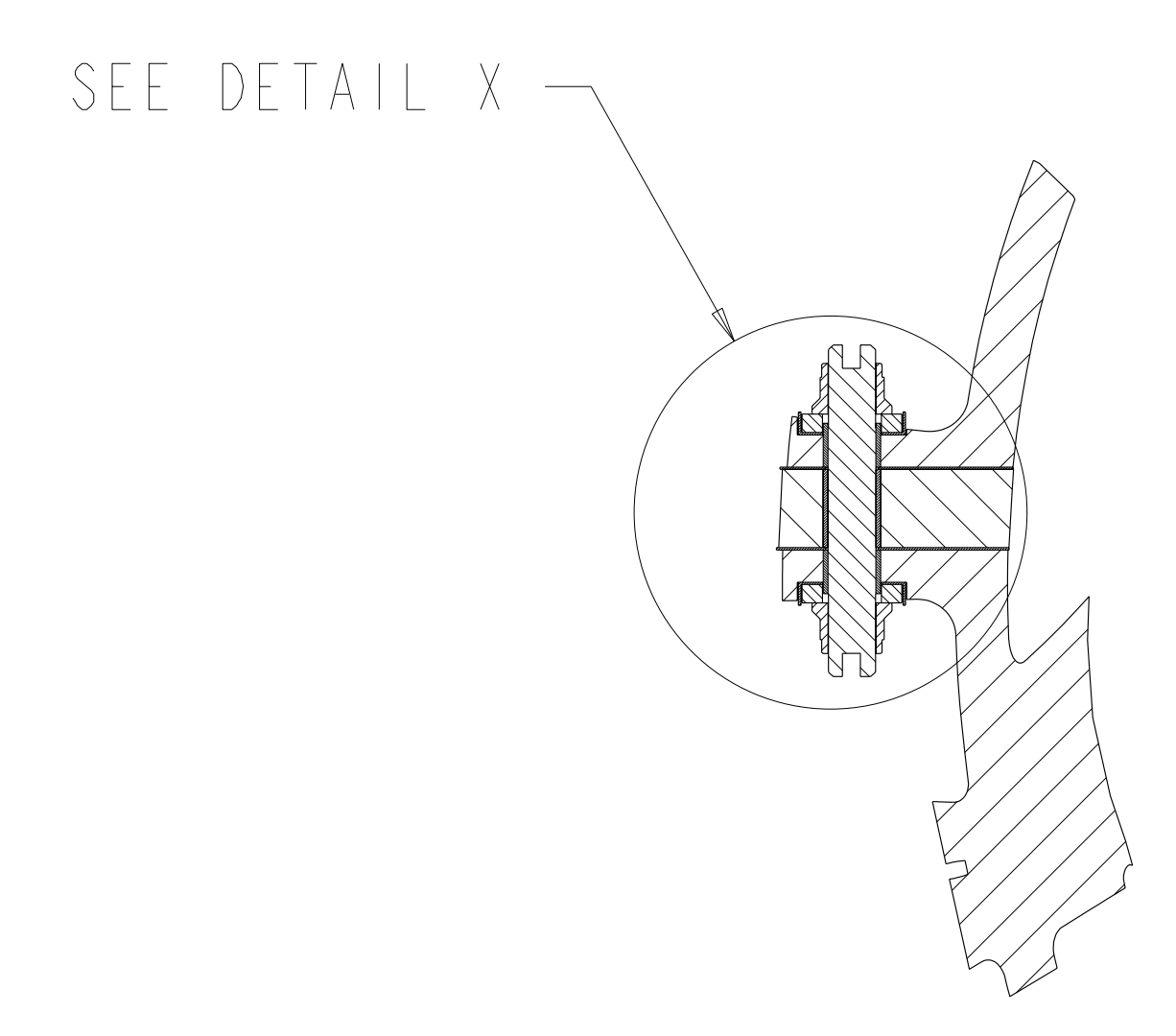
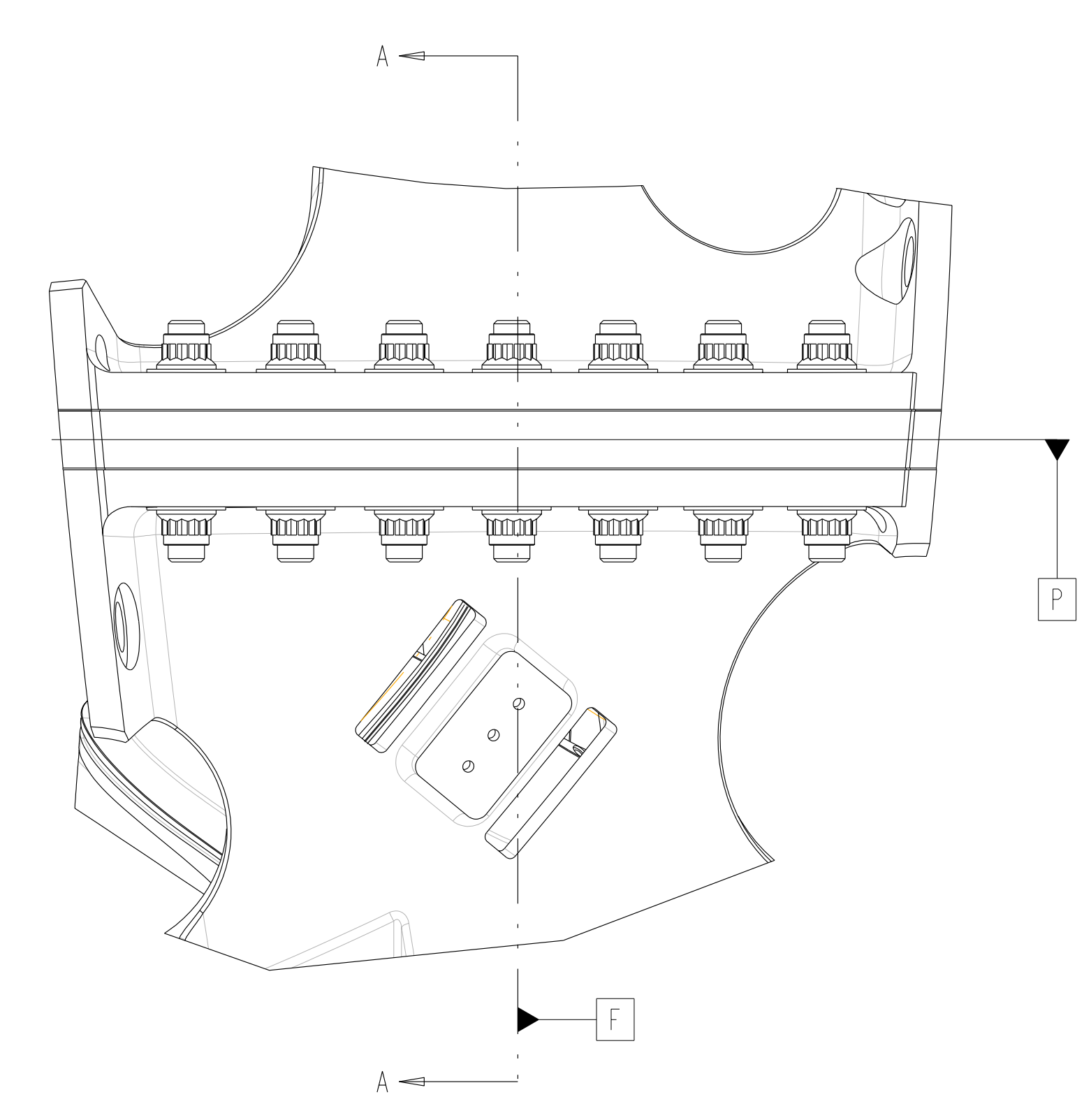
REV	DESCRIPTION	BY	DATE	CHK	DEPT	DATE	PE	REQ	DATE	ORNL	DOE	DATE																																													
1	REVISED F/N 2 PER ECN-4903	DW	9/04	MJC			DEW																																																		
<table border="0" style="width: 100%;"> <tr> <td style="width: 20%;">SCALE NOTED</td> <td style="width: 20%;">DES T. BROWN 6-30-04</td> <td style="width: 20%;">DRW PAUL MILLER 6-30-04</td> <td style="width: 20%;">UT-BATTELLE</td> <td style="width: 20%;">Oak Ridge National Laboratory managed for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT contract DE-AC05-00OR22725 UT-BATTELLE, LLC, Oak Ridge, Tennessee</td> </tr> <tr> <td>TOLERANCES UNLESS OTHERWISE SPECIFIED</td> <td>CHK M. COLE 6-30-04</td> <td>SECT :</td> <td colspan="2">NATIONAL COMPACT STELLARATOR EXPERIMENT</td> </tr> <tr> <td>FRACTIONS :</td> <td>DEPT :</td> <td colspan="3">MOD COIL WINDING FORM ASSEMBLY TYPE-B</td> </tr> <tr> <td>XX DECIMALS ± .01</td> <td>PE D. WILLIAMSON 6-30-04</td> <td>CR :</td> <td>VERSION NO. 5</td> <td>PLANT X-10</td> </tr> <tr> <td>XXX DECIMALS ± .005</td> <td>REO :</td> <td>FINISH :25 UNLESS OTHERWISE SPECIFIED</td> <td>BLDG 5700</td> <td>FL 3</td> </tr> <tr> <td>ANGLES ± 0°15'</td> <td>PPPL DRFT J. STEGEL 6-30-04</td> <td>PPPL DRFT J. STEGEL 6-30-04</td> <td>SHT OF 1</td> <td>TYPE 2</td> </tr> <tr> <td>BREAK SHARP EDGES .06 MAX</td> <td>PPPL DRFT J. STEGEL 6-30-04</td> <td>PPPL DRFT J. STEGEL 6-30-04</td> <td>REV U</td> <td>CLASS</td> </tr> <tr> <td></td> <td>PPPL DRFT J. STEGEL 6-30-04</td> <td>PPPL DRFT J. STEGEL 6-30-04</td> <td>RELEASE LEVEL Fabrication</td> <td>SE141-102</td> </tr> <tr> <td></td> <td>PPPL DRFT J. STEGEL 6-30-04</td> <td>PPPL DRFT J. STEGEL 6-30-04</td> <td>DRAWING APPROVALS</td> <td>DATE</td> </tr> </table>													SCALE NOTED	DES T. BROWN 6-30-04	DRW PAUL MILLER 6-30-04	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	CHK M. COLE 6-30-04	SECT :	NATIONAL COMPACT STELLARATOR EXPERIMENT		FRACTIONS :	DEPT :	MOD COIL WINDING FORM ASSEMBLY TYPE-B			XX DECIMALS ± .01	PE D. WILLIAMSON 6-30-04	CR :	VERSION NO. 5	PLANT X-10	XXX DECIMALS ± .005	REO :	FINISH :25 UNLESS OTHERWISE SPECIFIED	BLDG 5700	FL 3	ANGLES ± 0°15'	PPPL DRFT J. STEGEL 6-30-04	PPPL DRFT J. STEGEL 6-30-04	SHT OF 1	TYPE 2	BREAK SHARP EDGES .06 MAX	PPPL DRFT J. STEGEL 6-30-04	PPPL DRFT J. STEGEL 6-30-04	REV U	CLASS		PPPL DRFT J. STEGEL 6-30-04	PPPL DRFT J. STEGEL 6-30-04	RELEASE LEVEL Fabrication	SE141-102		PPPL DRFT J. STEGEL 6-30-04	PPPL DRFT J. STEGEL 6-30-04	DRAWING APPROVALS	DATE
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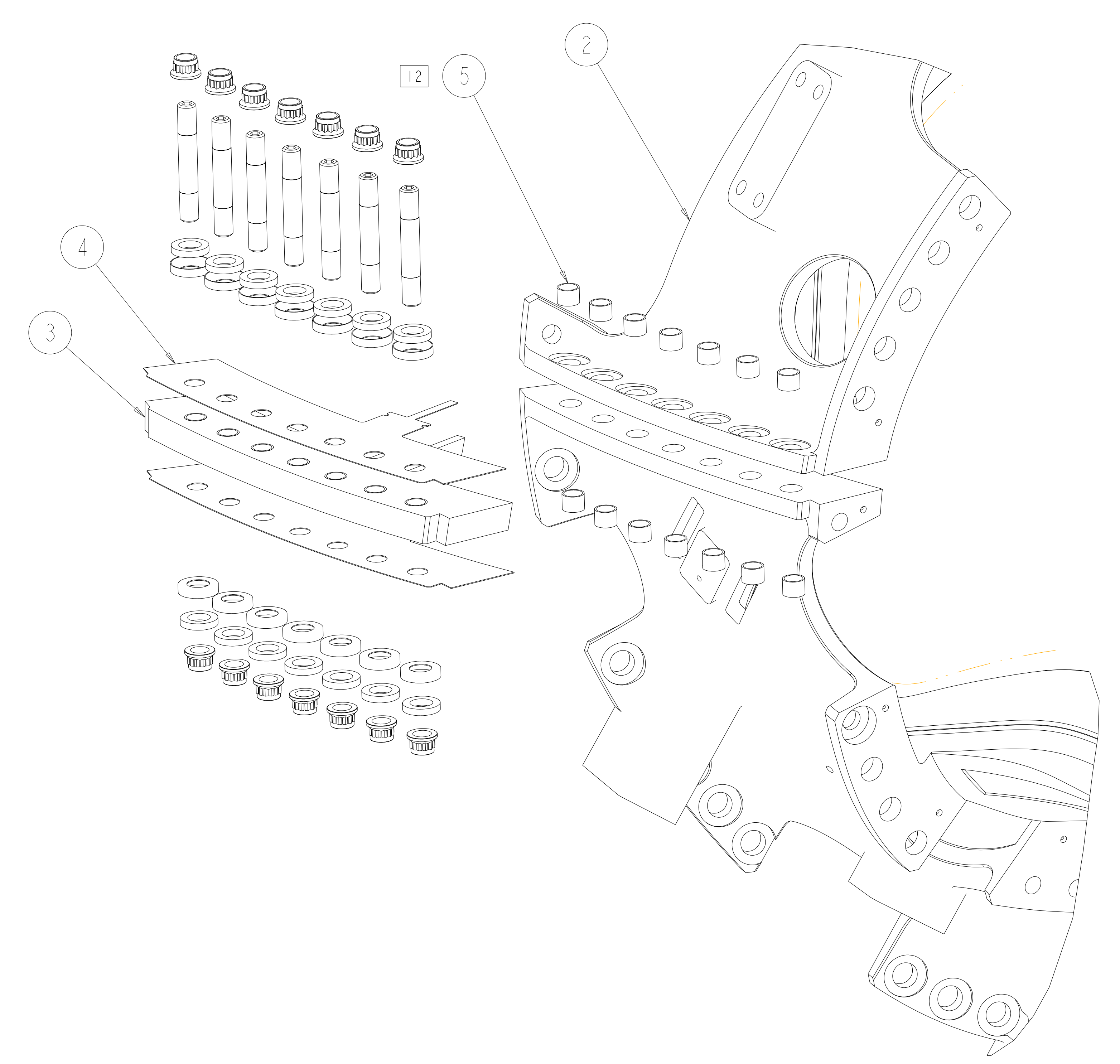
**P** THIS DRAWING PRODUCED ON PRO-ENGINEER

H  
G  
F  
E  
D  
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B  
A

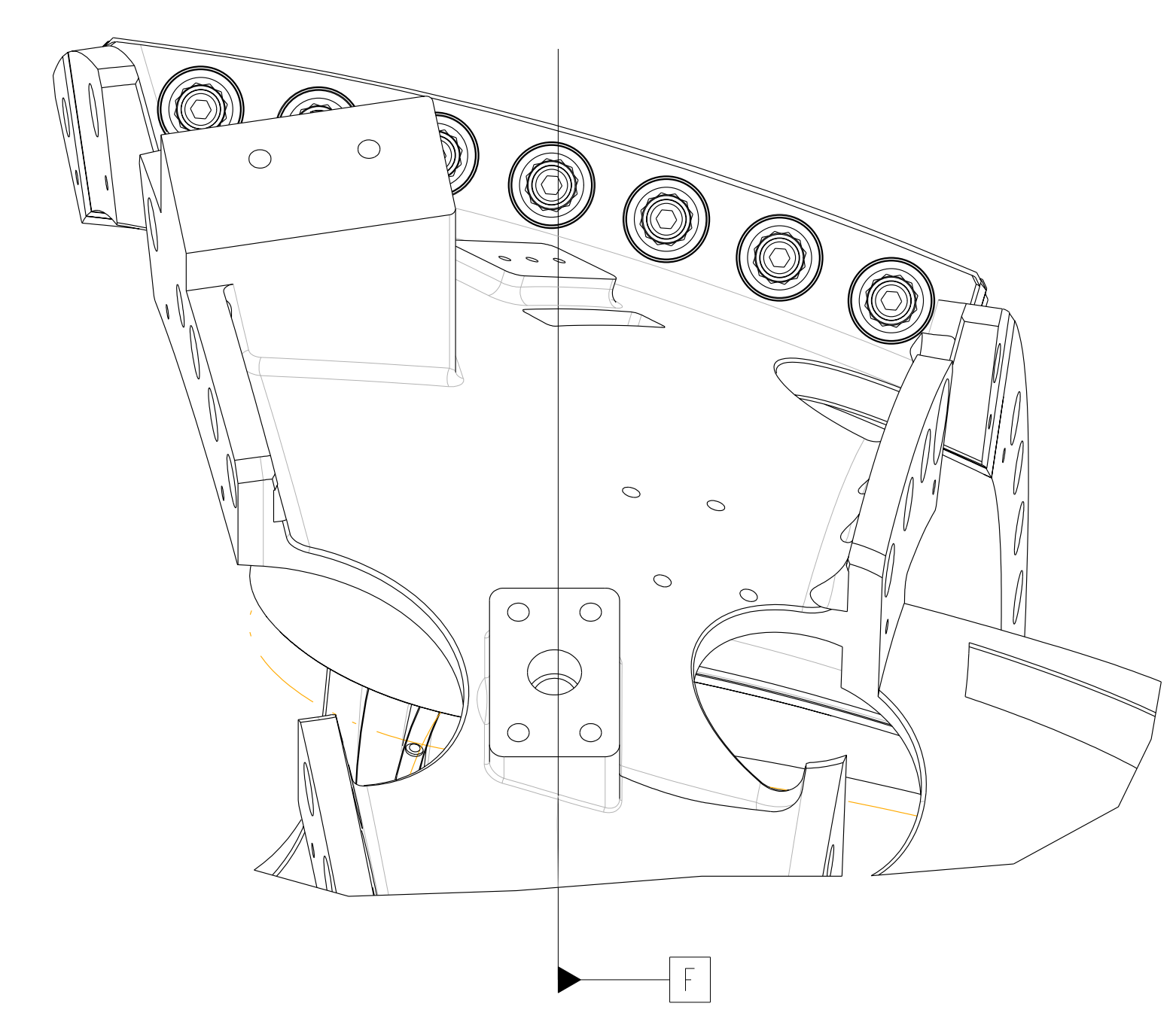
FOR NOTES AND PARTS LIST SEE SHEET 1



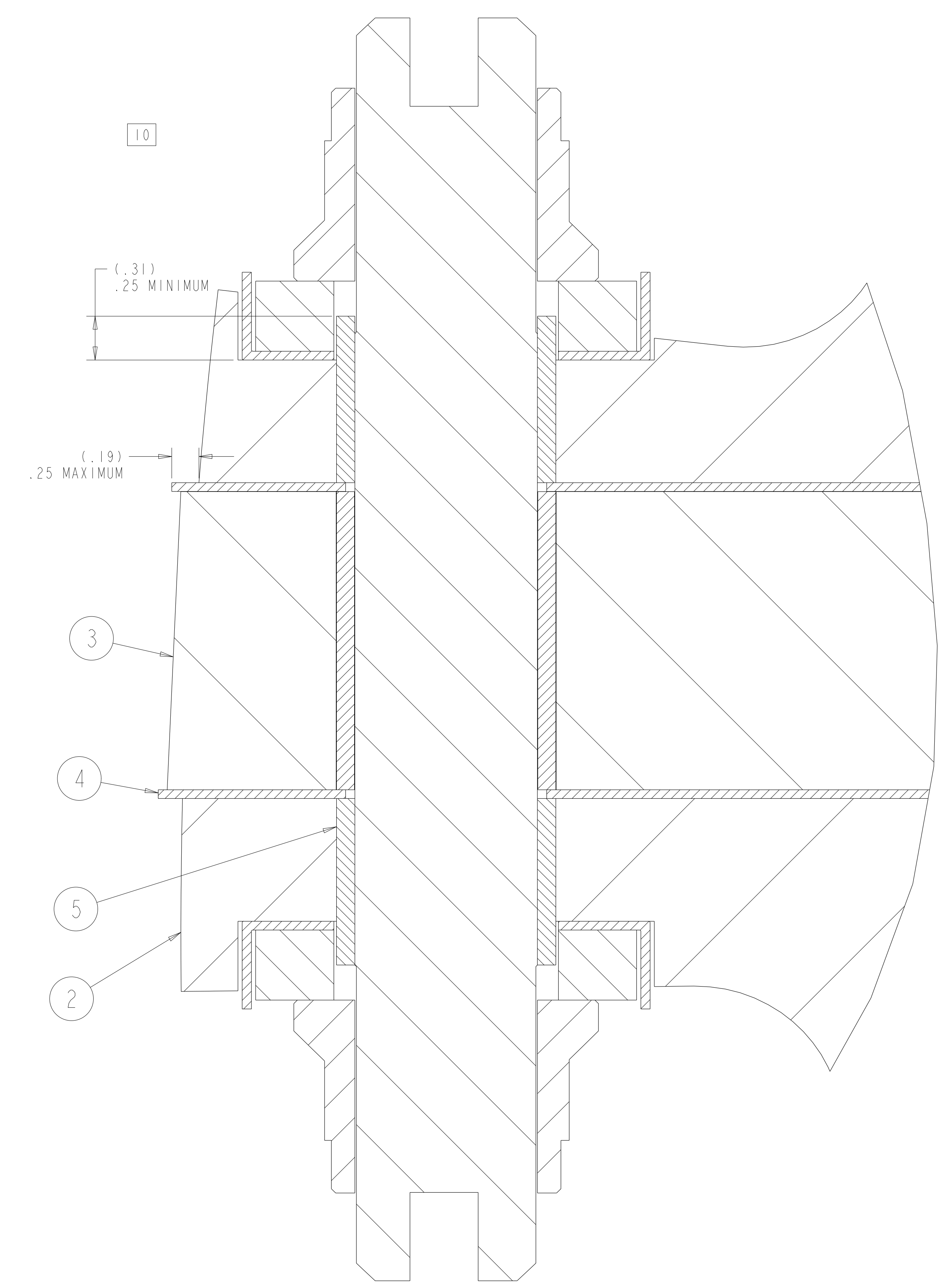
SECTION A-A  
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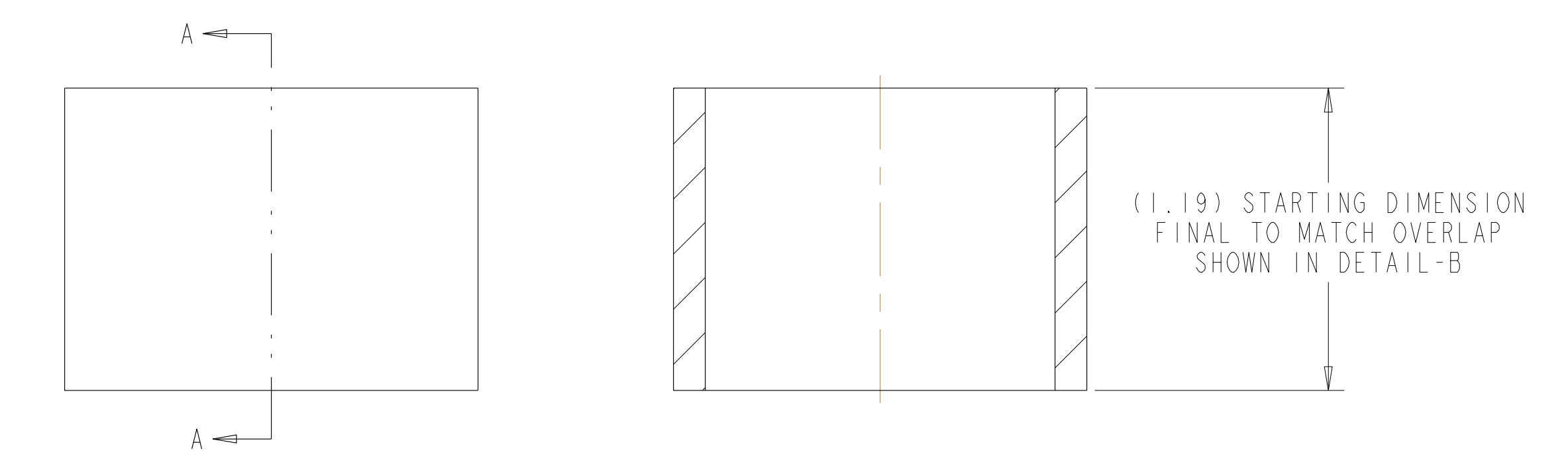
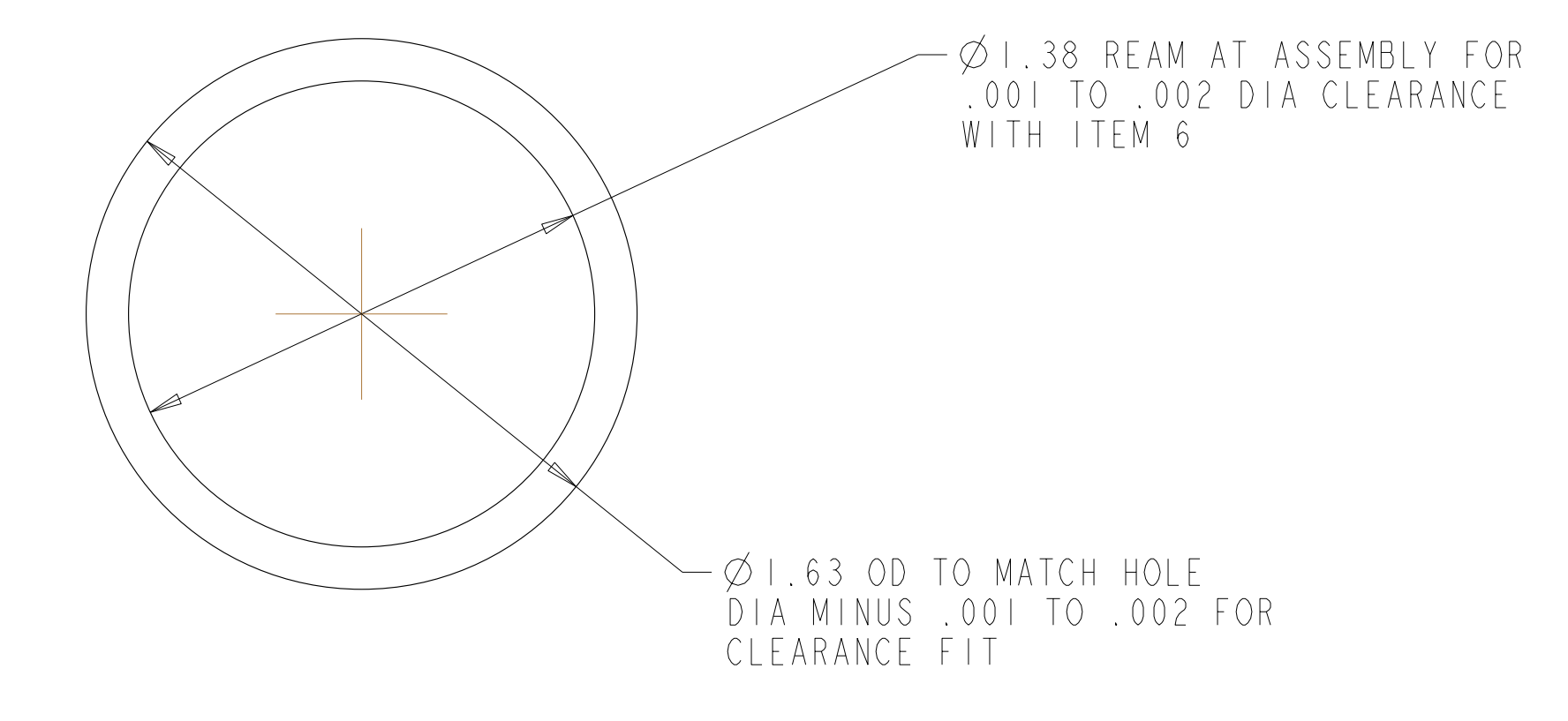
1 EXPLODED VIEW  
 SCALE 0.20



POLOIDAL BREAK DETAIL



DETAIL X  
 SCALE 2.00



5 SECTION A-A  
 SCALE 2.00

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 PPPL Drafting:

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							
<b>UT-BATTELLE</b> NATIONAL COMPACT STELLARATOR EXPERIMENT							
MOD COIL WINDING FORM ASSEMBLY TYPE-B							
VERSION NO.	PLANT	BLDG	FL	SHT OF	TYPE	CLASS	
5	X-10	5700	3	2	2	S	U
RELEASE LEVEL	SEI41-102						
Fabrication							

H  
G  
F  
E  
D  
C  
B  
A