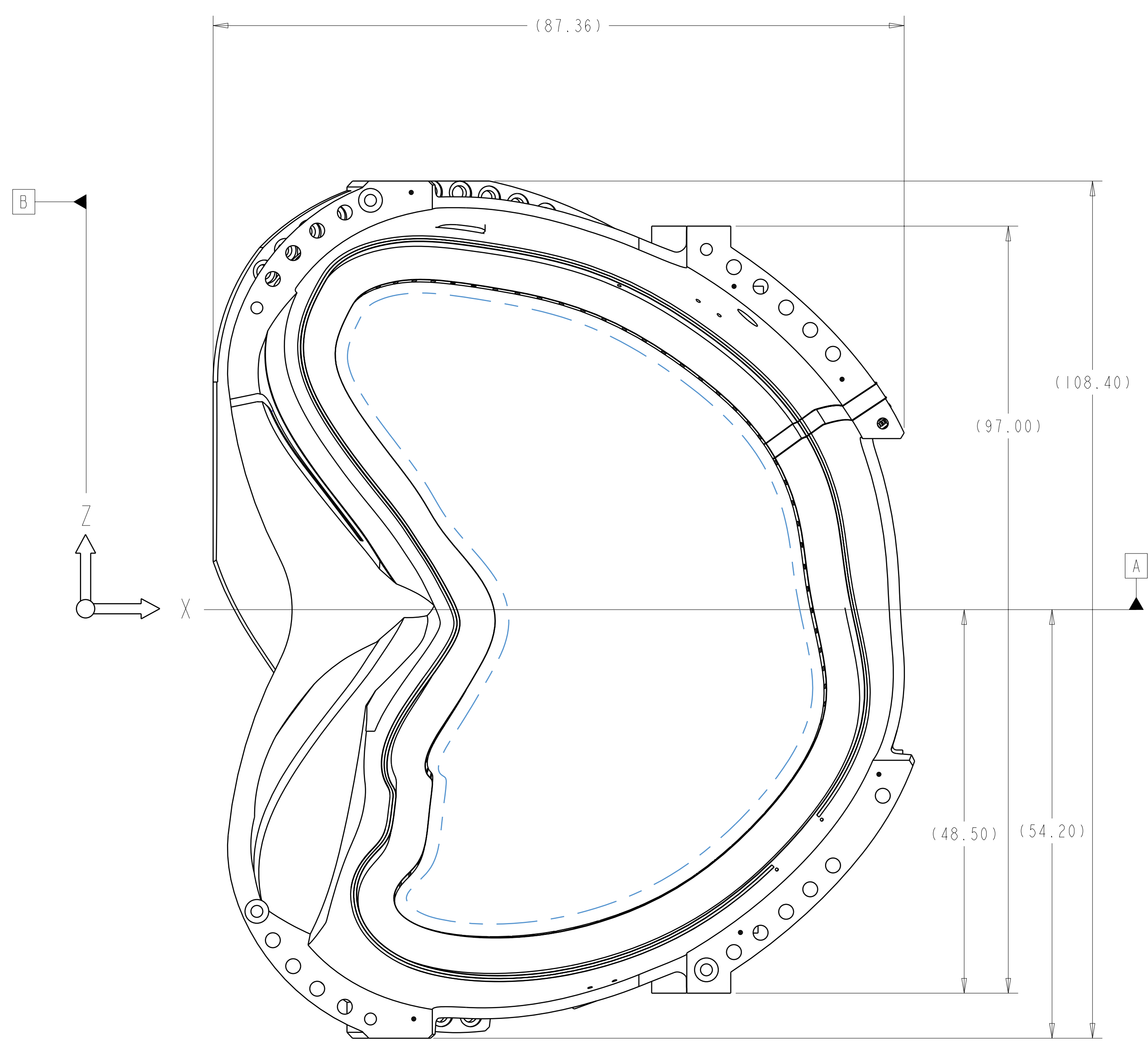
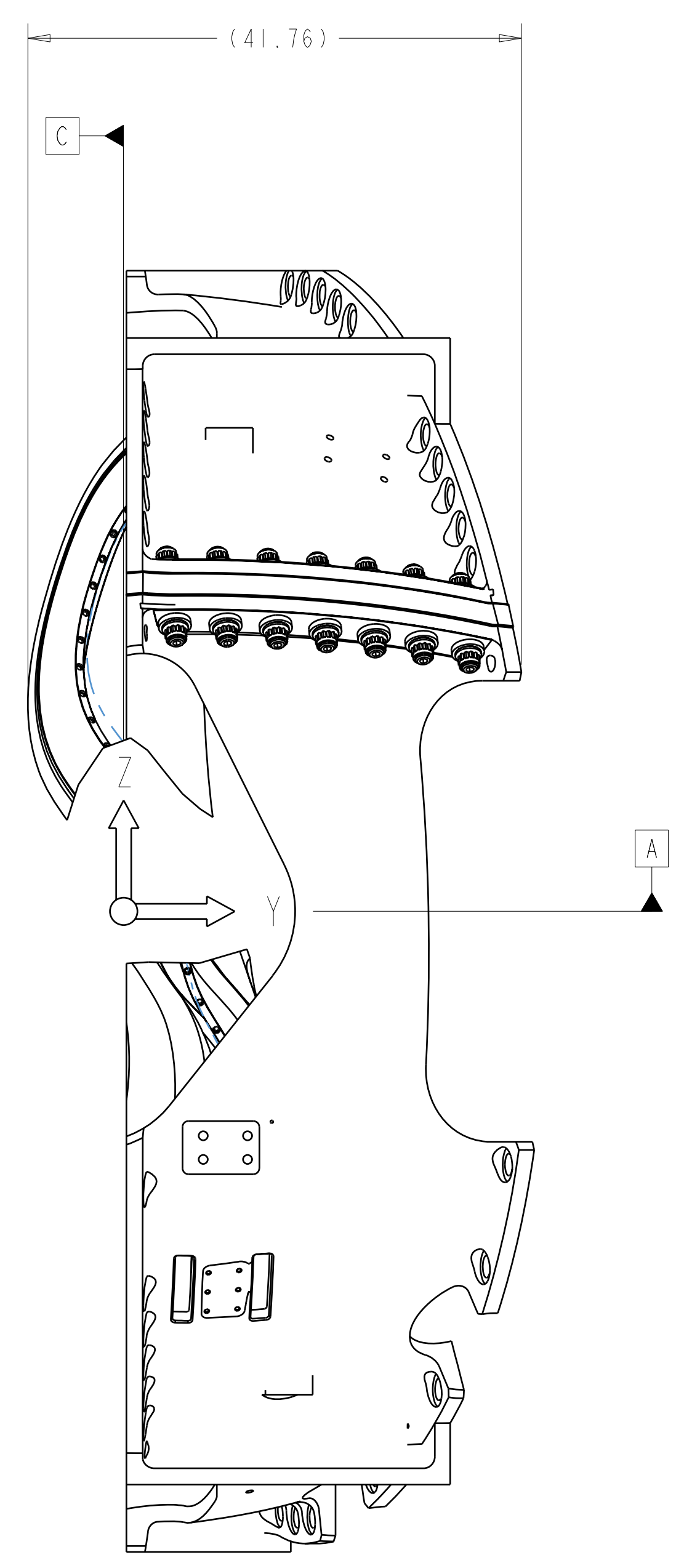


ISOMETRIC VIEW
 SCALE 0.10

- NOTES:
1. DRAWING PREPARED IN ACCORDANCE WITH ASME Y14.8M-1996.
 2. INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M-1994.
 3. DIMENSIONS ARE IN INCHES.
 4. DRAWING DEPICTS FINAL MACHINED STATE OF ASSEMBLY DEFINED BY PRO/ENGINEER FILE SEI41-101.PRT.
 5. 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)
 6. DIMENSIONS APPLY AT TEMPERATURE OF 20-30°C (68-86°F).
 7. DIMENSIONS AND TOLERANCES EXCLUDE PROCESS MATERIAL ALLOWANCES WHICH MAY ADD MASS.
 8. APPROXIMATE WEIGHT = 4983 LBS
 9. MATCH DRILL OR REAM AS REQUIRED TO ACHIEVE RUNNING FIT BETWEEN PARTS AT ASSEMBLY.
 10. LUBRICATE THREADED SURFACES WITH MOLYCOTE 321R PER MANUFACTURER'S INSTRUCTIONS.
 11. SEE LATEST REVISION OF SPECIFICATION NCSX-CSPEC-141-03 FOR ADDITIONAL REQUIREMENTS.
 12. BOND INSULATING SLEEVE (F/N 5) TO WINDING FORM (F/N 2) USING LOCTITE 411, PER MANUFACTURER'S INSTRUCTIONS.
 13. ITEM NO. 4 HOLE DIAMETERS TO MATCH OD OF ITEM NO. 6 PLUS .001 TO .002 FOR CLEARANCE FIT.
 14. ITEM NO. 7 MAY BE DIVIDED INTO TWO PARTS IF NECESSARY. HOLE DIAMETERS TO MATCH OUTER DIA OF ITEM NO. 5 PLUS .001 TO .002 FOR CLEARANCE FIT.



SCALE .10



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14	DS141-079	WASHER, 2.75 OD X 1.66 ID X 0.5 THK	9		
14	DS141-060	NUT, 12PT HEX 1.375-6UNC-2B	8		
2	-7	INS SHEET, 26 X 3 X .063 THK	NEMA GRADE G-11CR	7	
7	DS141-036	STUD, 1.375-6UNC-2A X 9.5 LG	6		
14	-5	INS BUSHING, 1.63 OD X 1.38 ID X 1.7 LG	NEMA GRADE G-11CR	5	
1	-4	INS SHEET, 15 X 32 X .063 THK	NEMA GRADE G-11CR	4	
1	SEI41-048	POL BREAK SHIM ASSEMBLY TYPE-A	3		
1	SEI41-114	PRODUCTION WINDING FORM TYPE-A	2		
AR	X	-1	MOD COIL WINDING FORM ASSEMBLY TYPE-A	1	
SEI41-101	CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPECIFICATION	FIND NO
			← NEXT ASSEMBLY	PARTS LIST	

		SCALE NOTED		DES: T BROWN	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 PROJECT NAME:
		TOLERANCES UNLESS OTHERWISE SPECIFIED		DRW: P MILLER	6-30-04	
				CHK: M COLE	6-30-04	
		FRACTIONS		SECT:		NATIONAL COMPACT STELLARATOR EXPERIMENT MOD COIL WINDING FORM ASSEMBLY TYPE-A
		XX DECIMALS ±.01		DEPT:		
		XXX DECIMALS ±.005		PE: D WILLIAMSON	6-30-04	VERSION NO. 8 PLANT X-10 BLDG 5700 FL 3 SHT OF 12 TYPE S CLASS U REV 2 RELEASE LEVEL Fabrication SEI41-101
		ANGLES ±0°15'		PJ:		
		BREAK SHARP EDGES .06 MAX		RED:		
		FINISH .125 UNLESS OTHERWISE SPECIFIED		PPPL DRFT J SIEGEL	6-30-04	
				DRAWING APPROVALS		

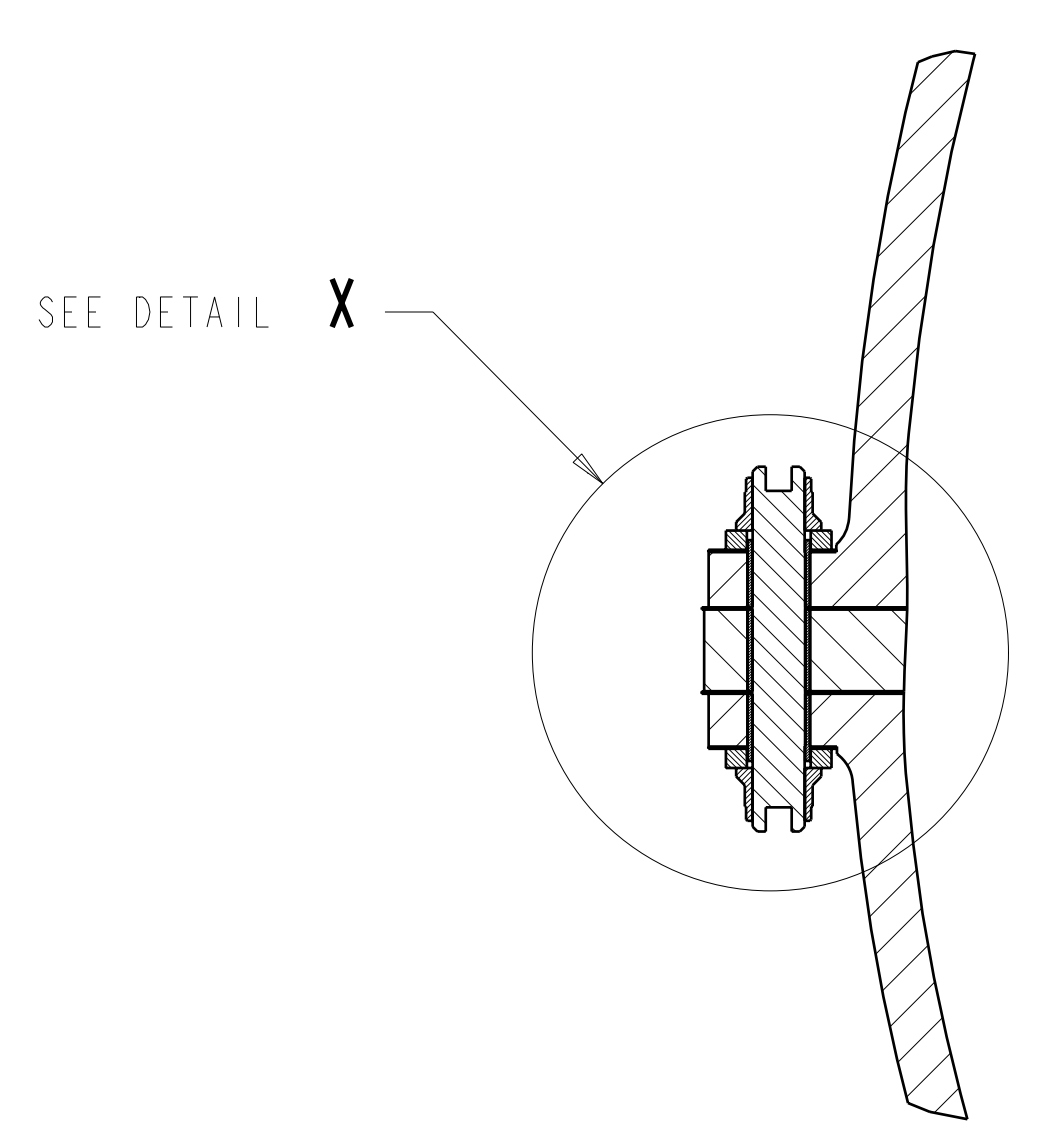
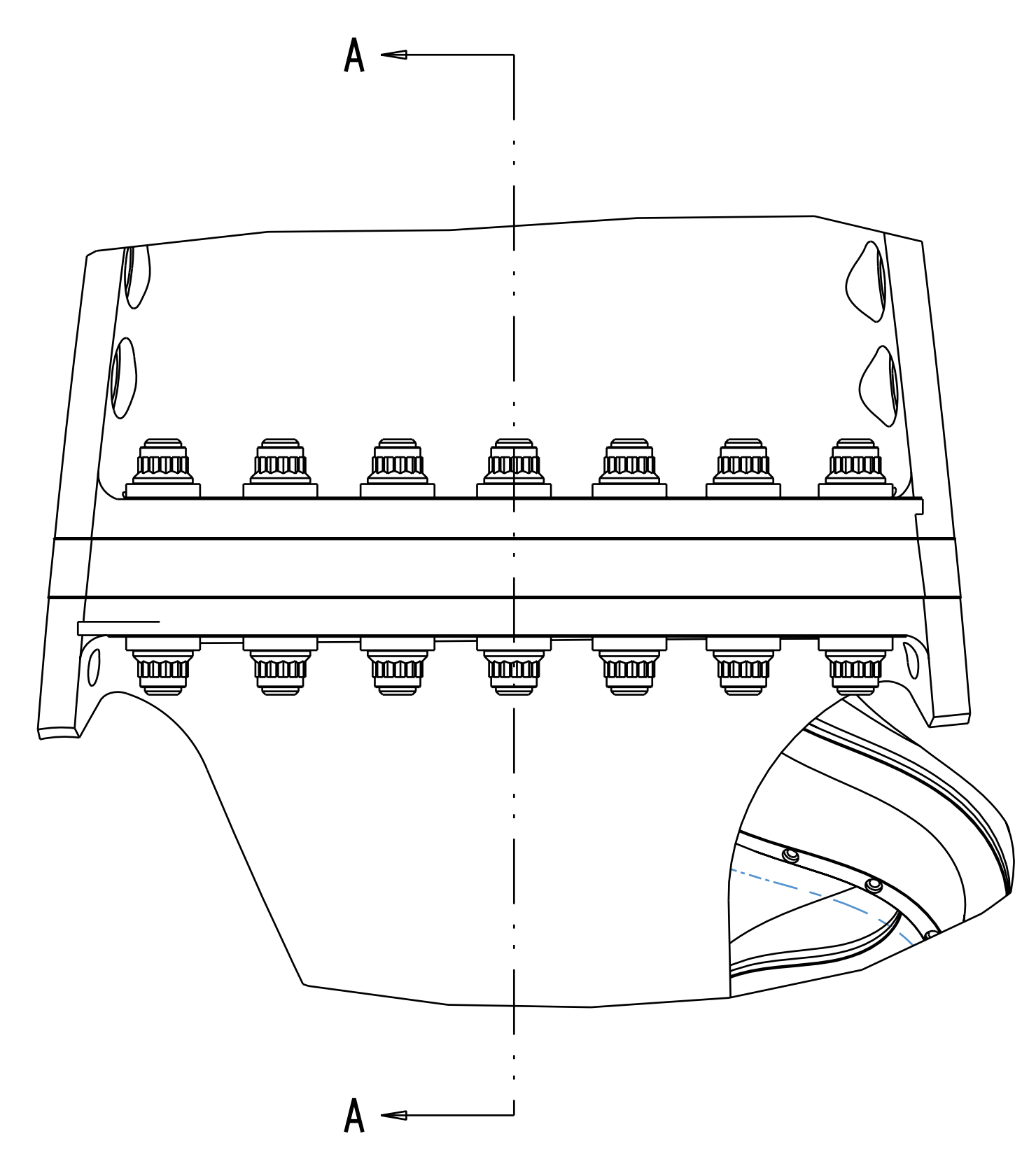
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P THIS DRAWING PRODUCED ON PRO-ENGINEER

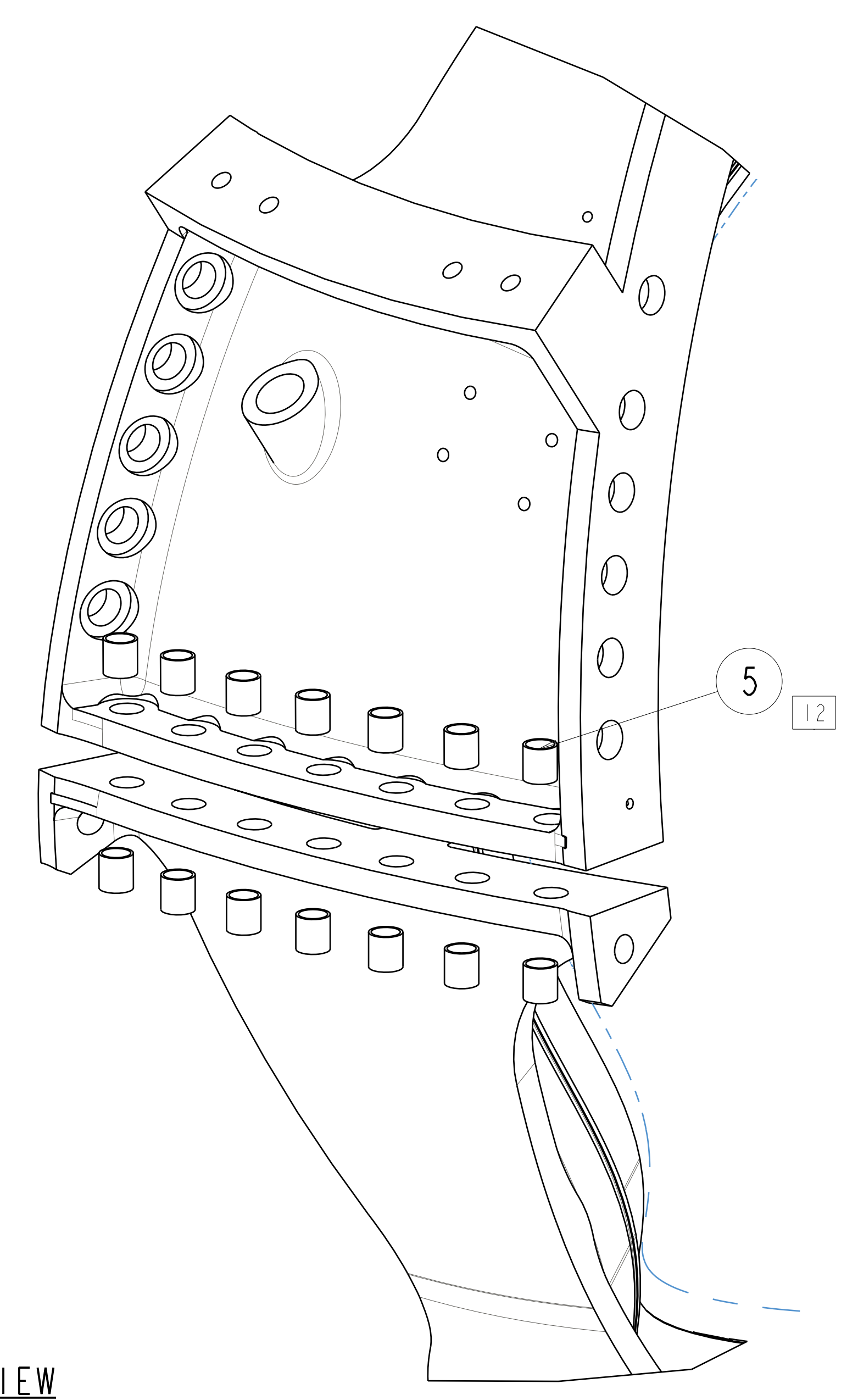
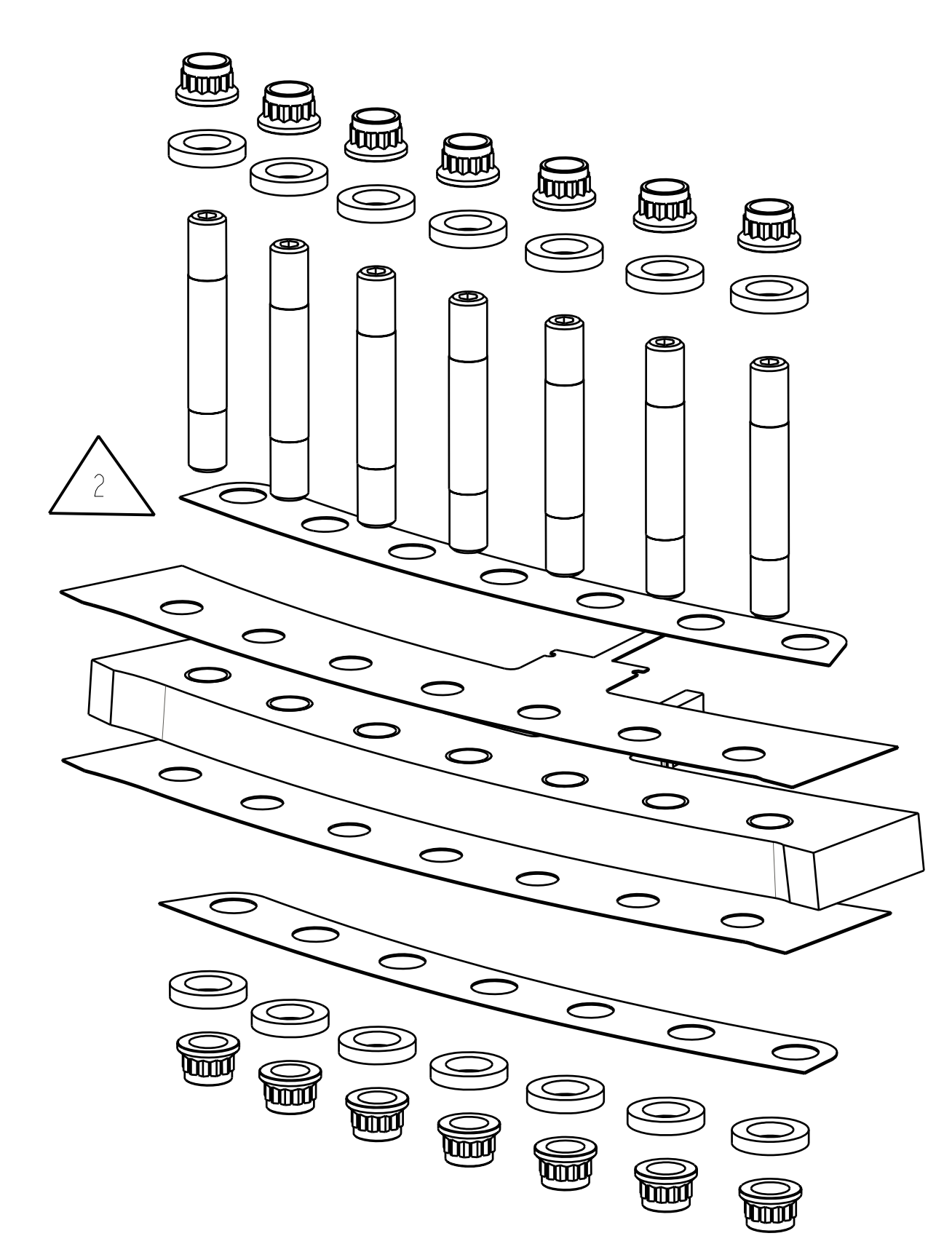
2	REVISED ASSEMBLY AND DRAWING PER ECN 5009	GLL	7-05	MJC	DEW	
1	REVISED F/N 2 PER ECN-4903	DW	9/04	MJC	DEW	
REV	DESCRIPTION	BY	DATE	CHK	DEPT	DATE
REVISION OR ISSUE PURPOSE						
REVISION APPROVAL						

H
 G
 F
 E
 D
 C
 B
 A

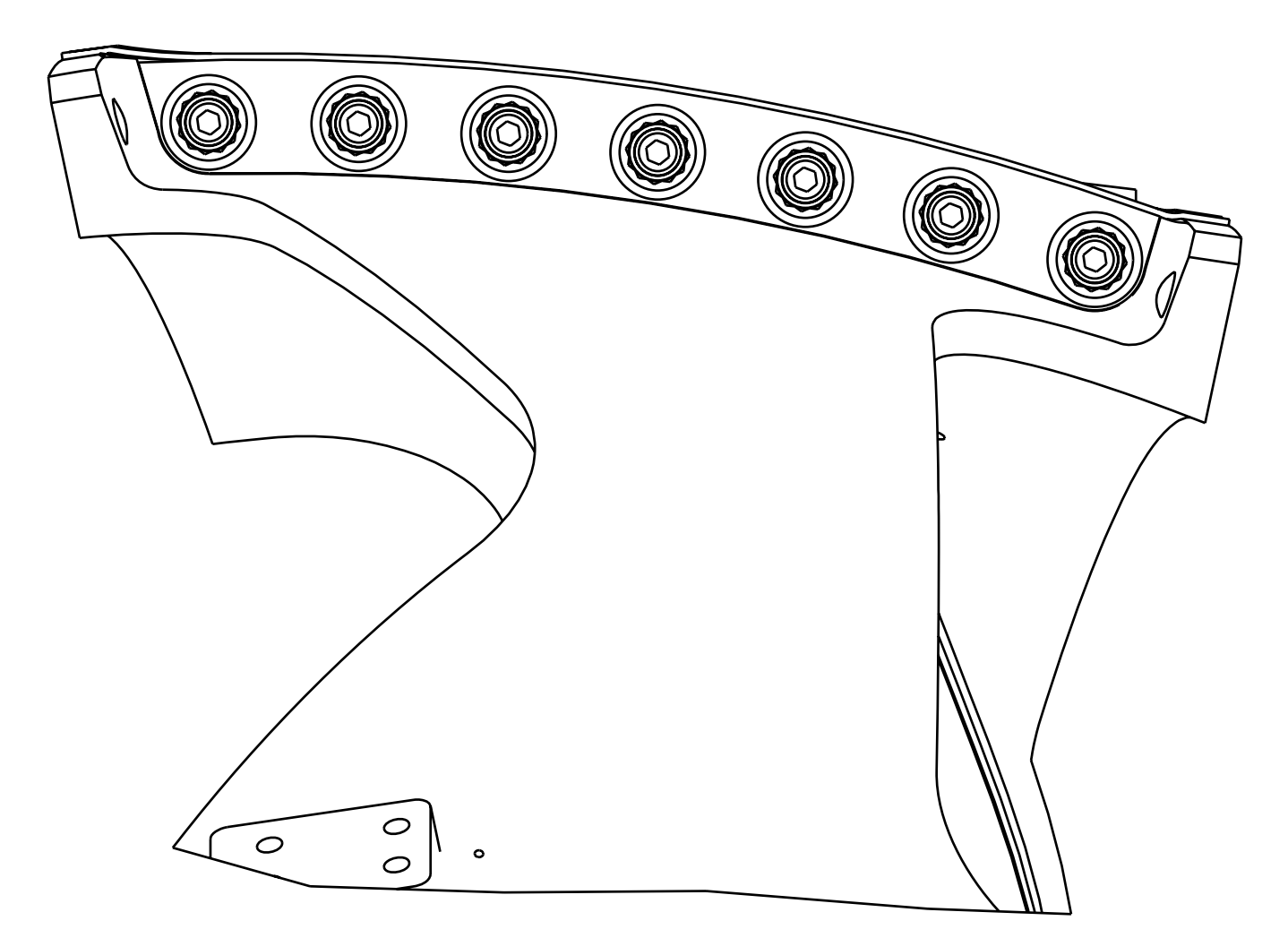
FOR NOTES AND PARTS LIST SEE SHEET 1



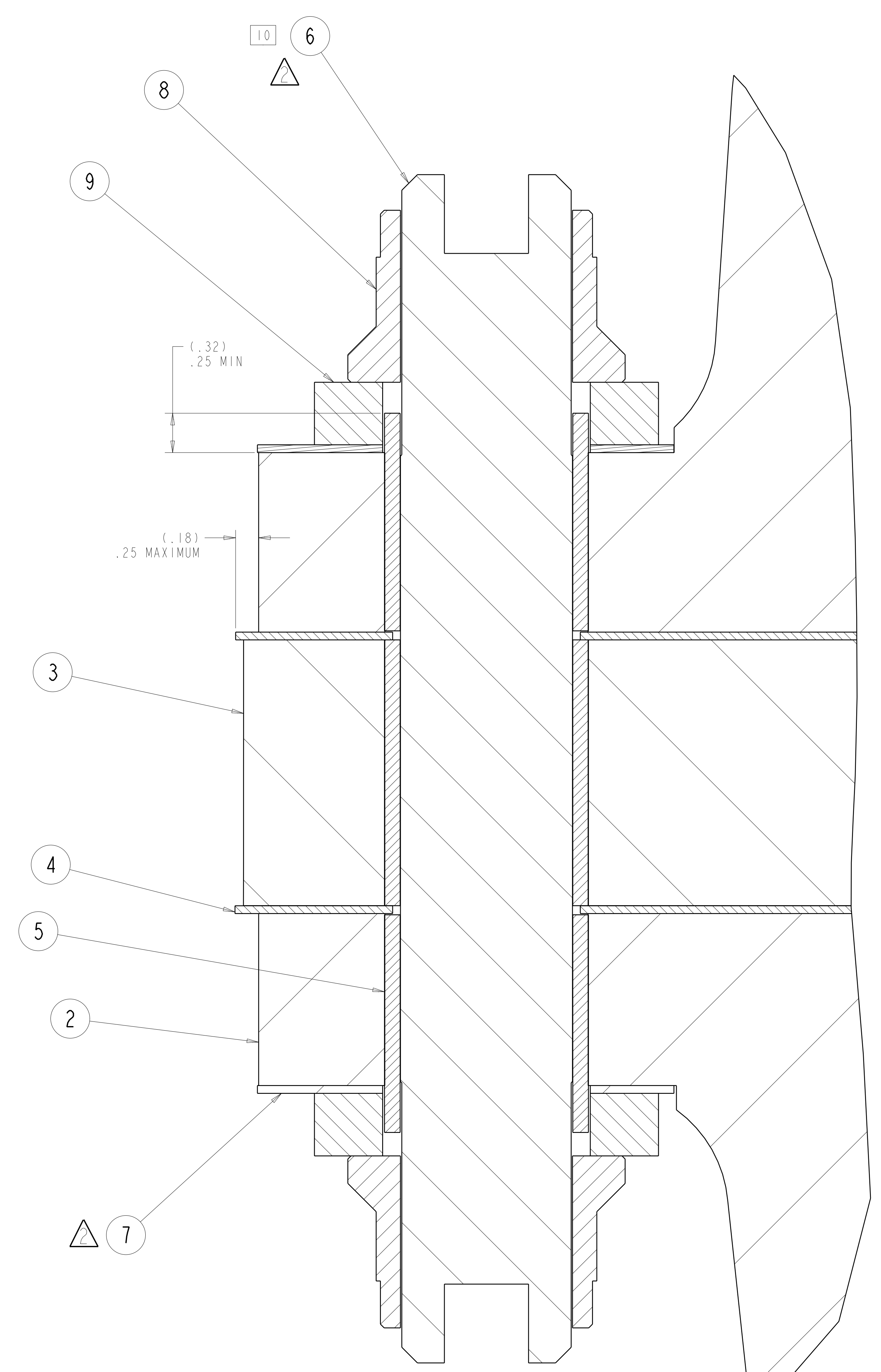
SECTION A-A
 SCALE 0.20



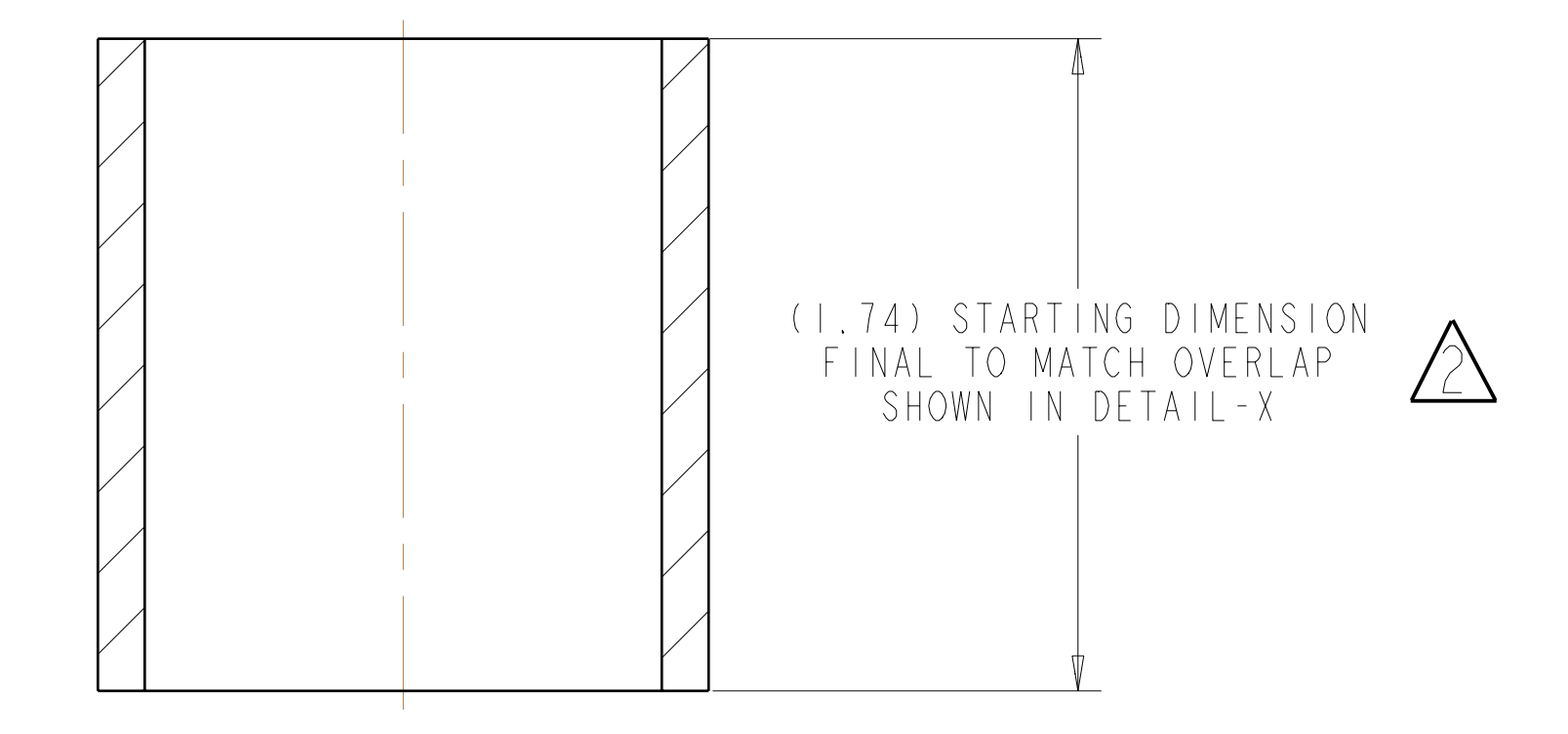
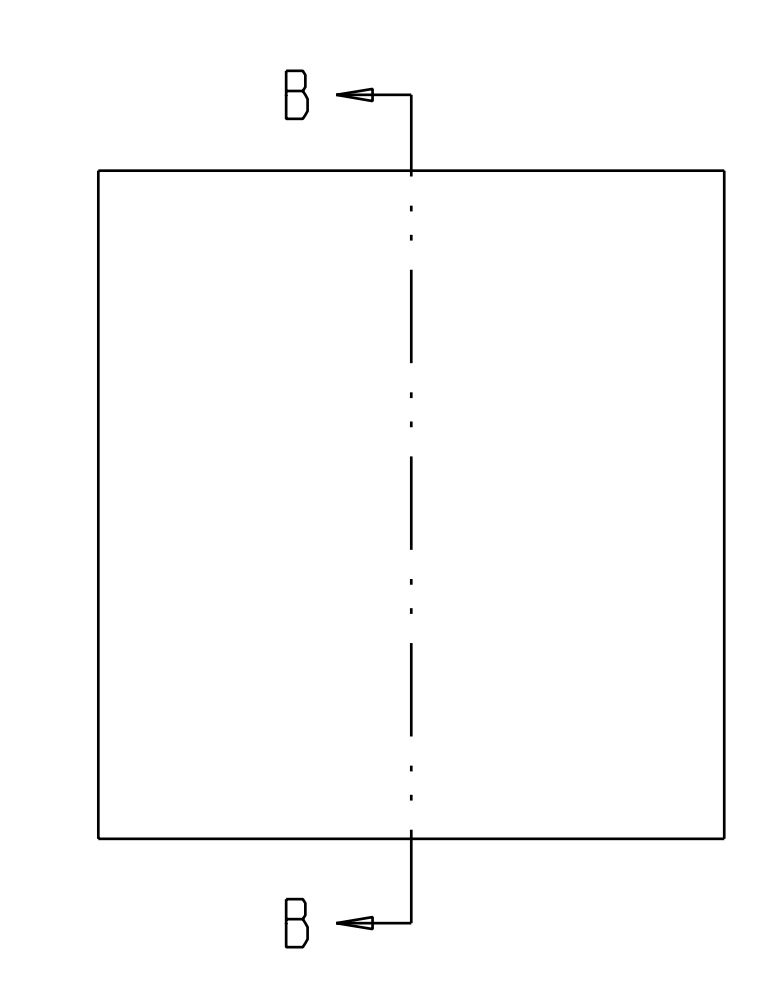
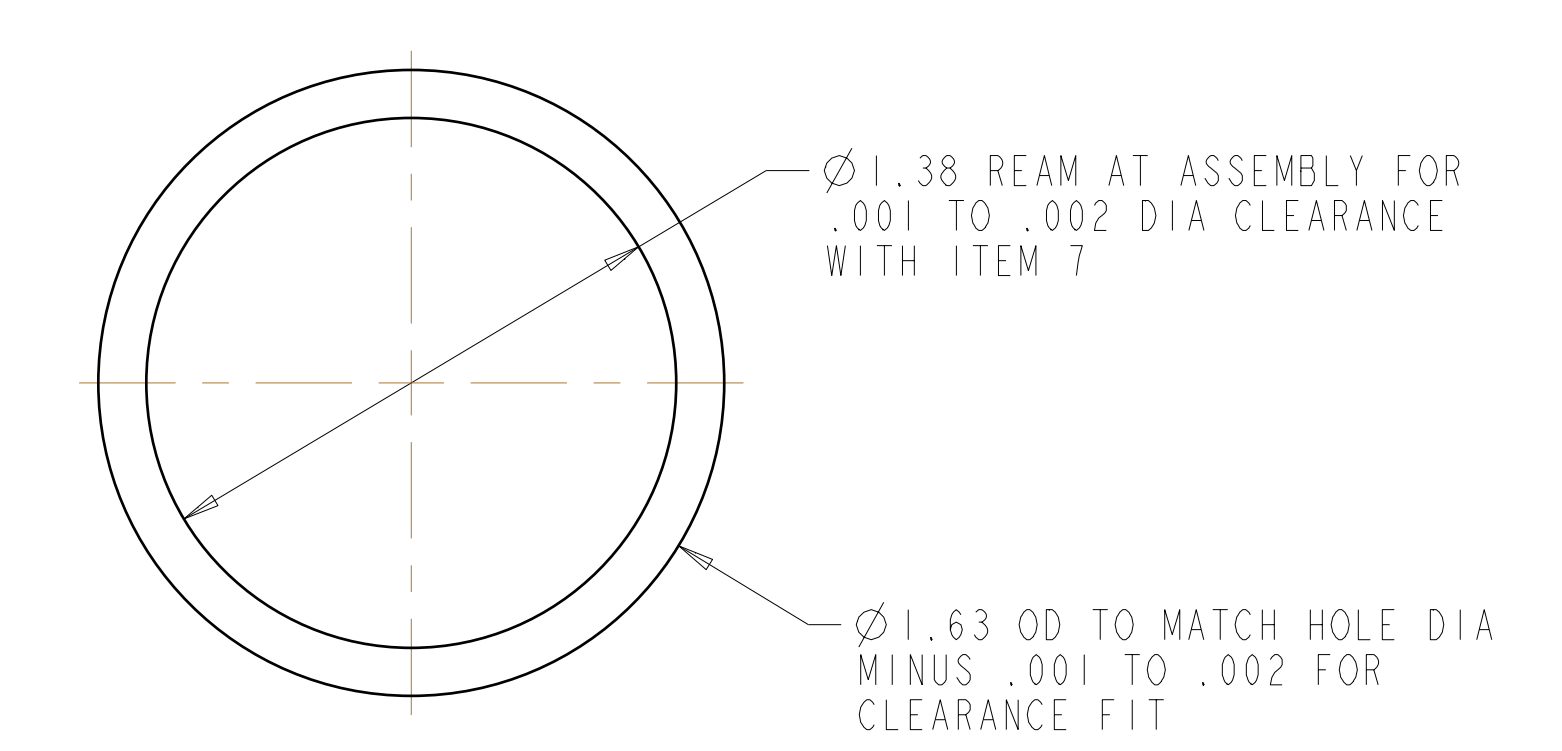
1 EXPLODED VIEW
 SCALE 0.20



POLOIDAL BREAK DETAIL



DETAIL X
 SCALE 2.00



5 SECTION B-B
 SCALE 2.00

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 FABRICATION / INSTALLATION**
 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:							
UT-BATTELLE NATIONAL COMPACT STELLARATOR EXPERIMENT							
MOD COIL WINDING FORM ASSEMBLY TYPE-A							
VERSION NO.	PLANT	BLDG	FL	SHT OF	TYPE	CLASS	
8	X-10	5700	3	2	S	U	
RELEASE LEVEL	SEI41-101						REV
Fabrication							2

SEI41-101