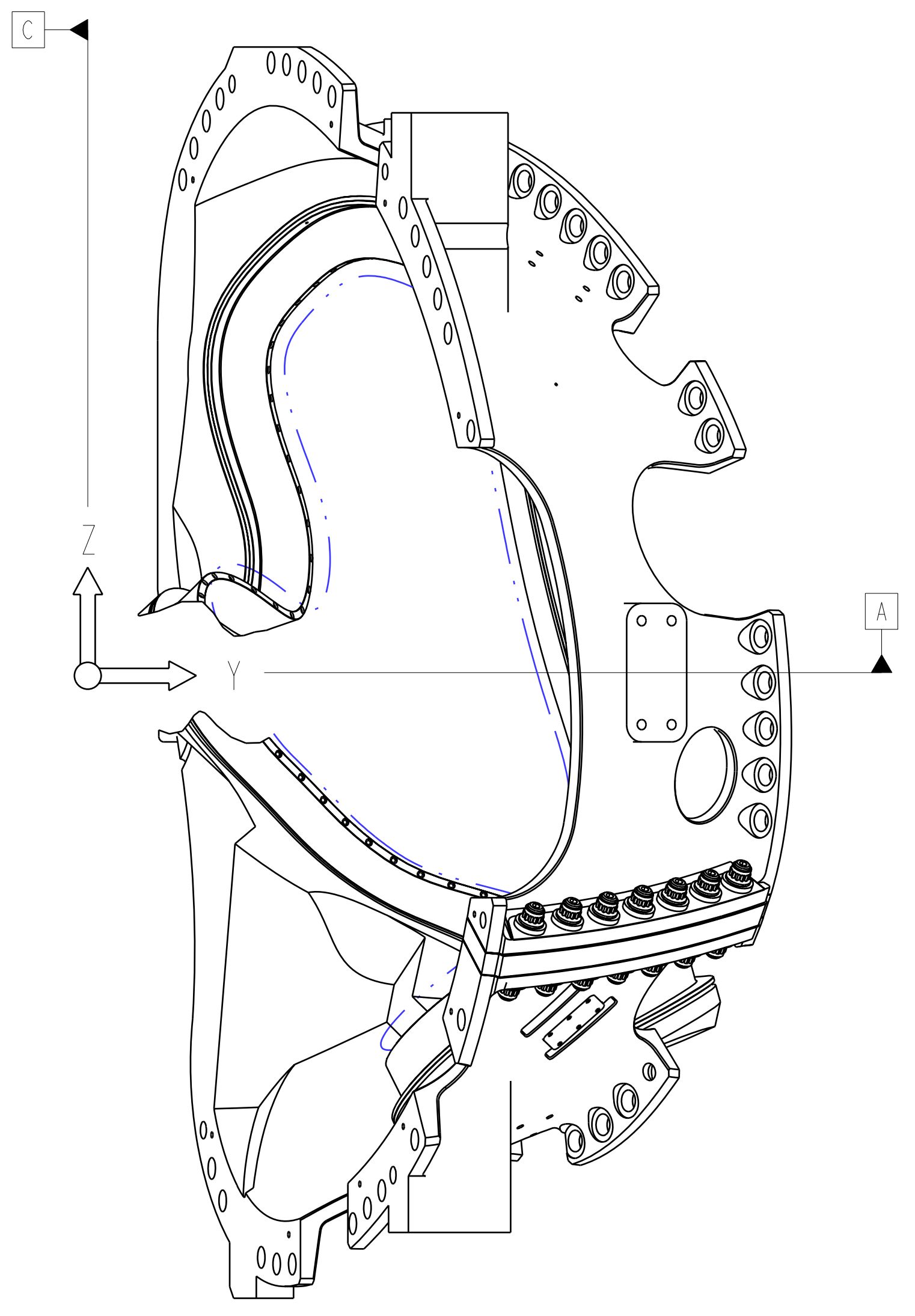
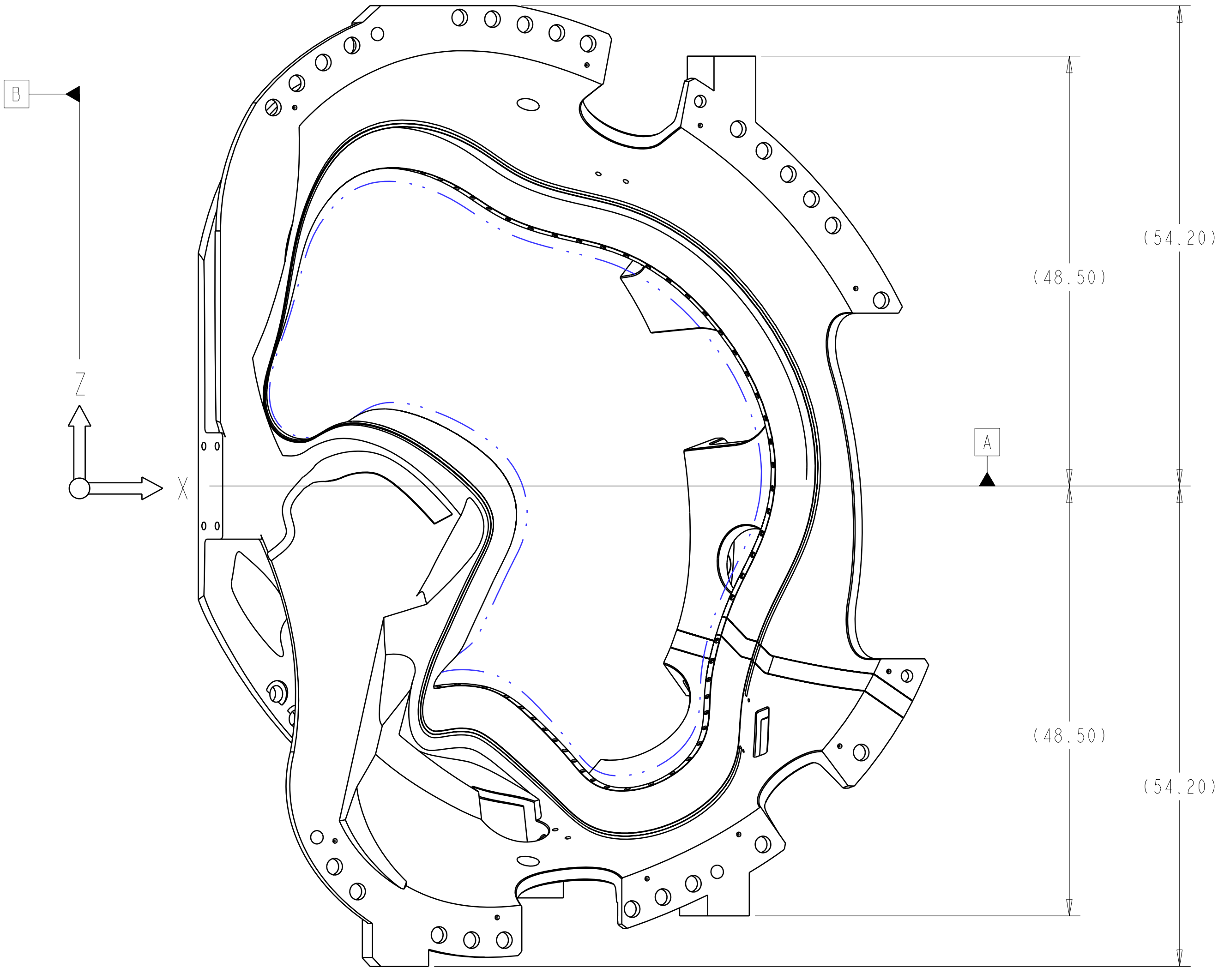


- NOTES:
- DRAWING PREPARED IN ACCORDANCE WITH ASME Y14.8M-1996
 - INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M-1994
 - DIMENSIONS ARE IN INCHES
 - DRAWING DEPICTS FINAL MACHINED STATE OF PART DEFINED BY PRO/ENGINEER FILE SE141-102.ASM
 - UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE RELATED TO DATUM 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.
 - ITEM NO. 4 HOLE DIAMETERS TO MATCH OD OF ITEM NO. 6 PLUS .001 TO .002 FOR CLEARANCE FIT.
 - 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 CLEARANCE FIT.



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 PPPL Drafting:

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, 1.630D X 1.381D X 1.7 LG NEMA GRADE G-11CR	5		
2	-4	INS SHEET, 15 X 32 X .063 THK NEMA GRADE G-11CR	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	

SCALE 0.10

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

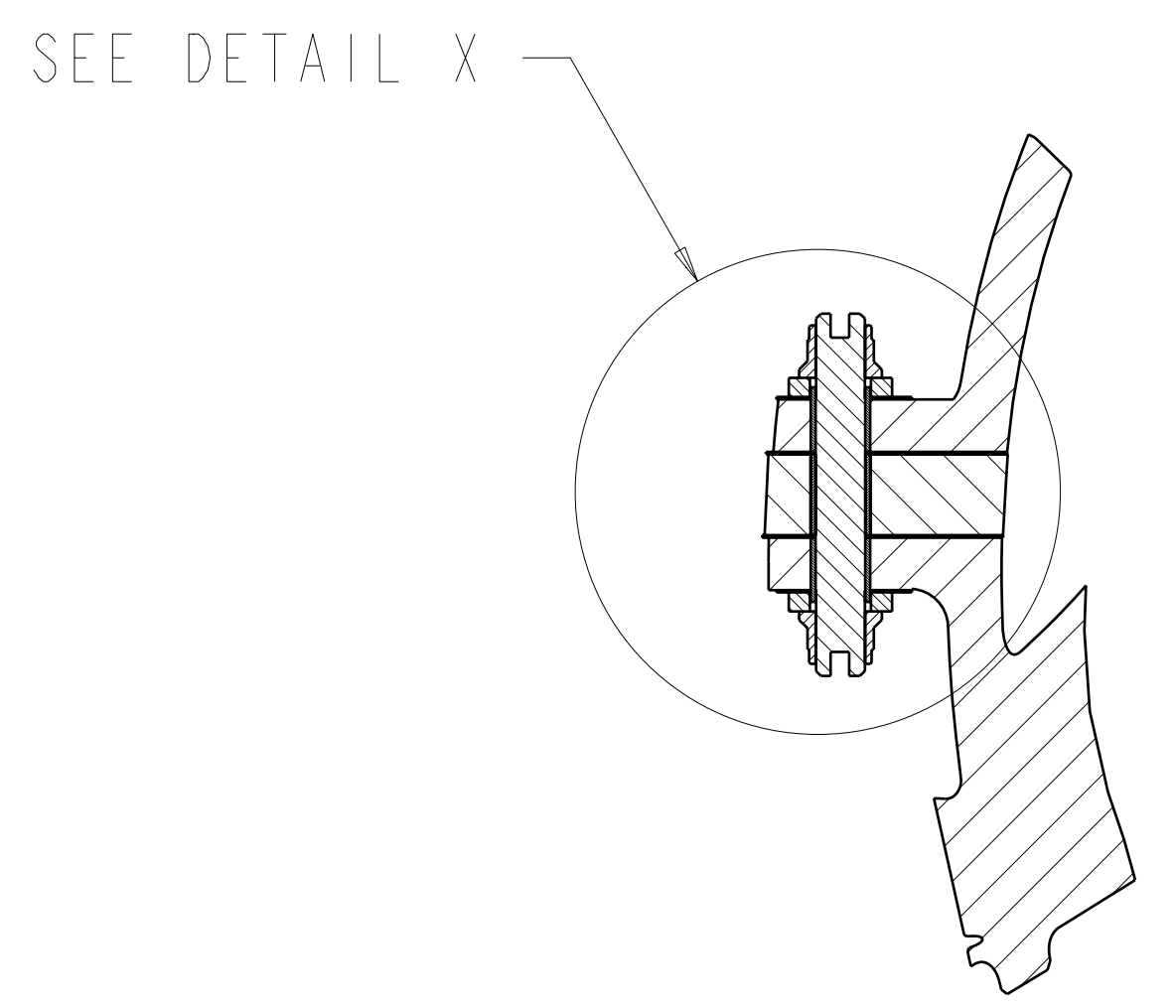
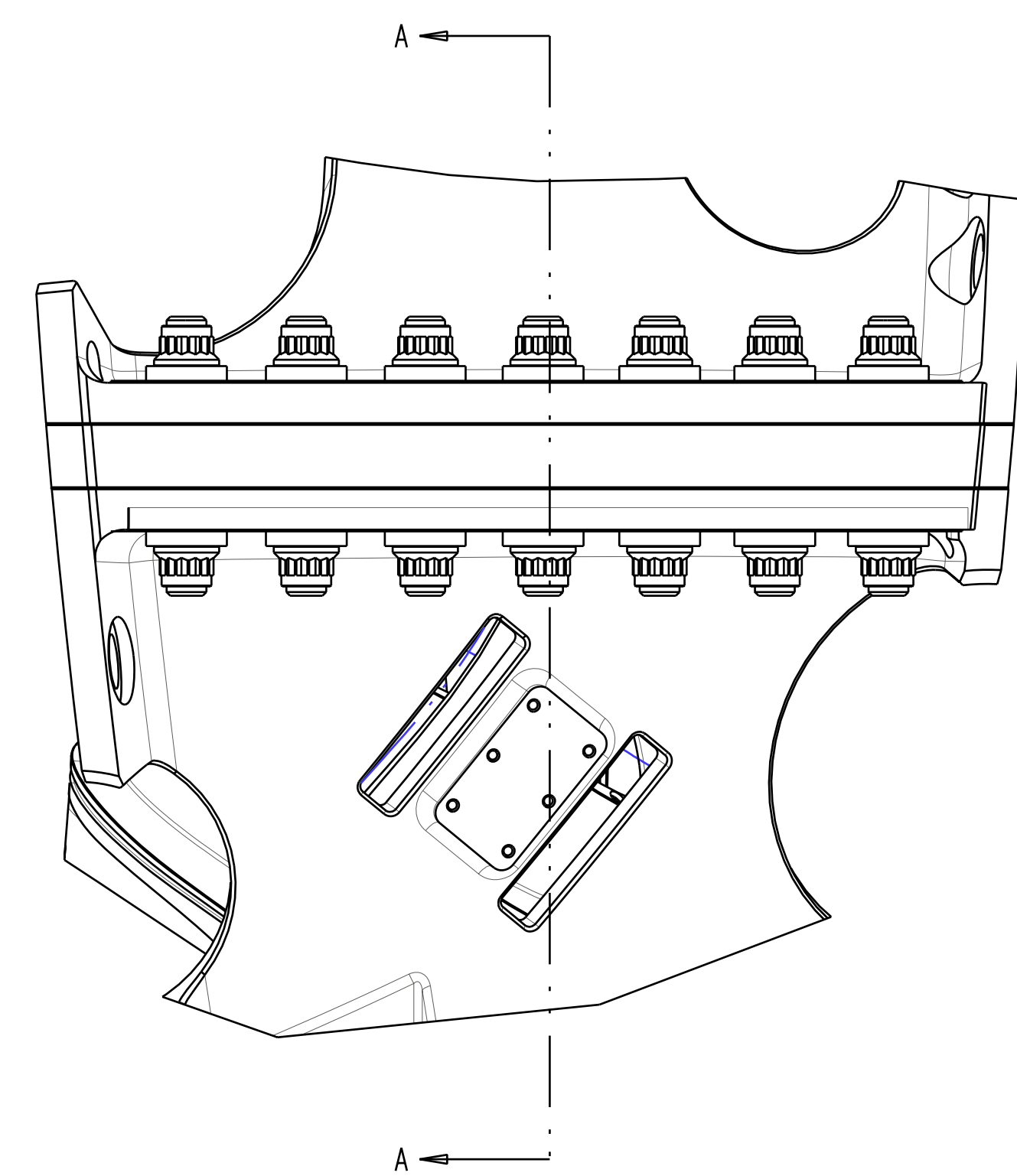
REV	DESCRIPTION	BY	DATE	CHK	DEPT	DATE	PE	REG	DATE	ORNL	DOE	DATE
2	REVISED ASSEMBLY AND DRAWING PER ECN 5009	GLL	7/05	MJC			DEW					
1	REVISED F/N 2 PER ECN-4903	DW	9/04	MJC			DEW					

SCALE	NOTED	DES	DATE
		T. BROWN	6-30-04
		PAUL MILLER	6-30-04
		M. COLE	6-30-04
		D. WILLIAMSON	6-30-04
		J. STEGEL	6-30-04

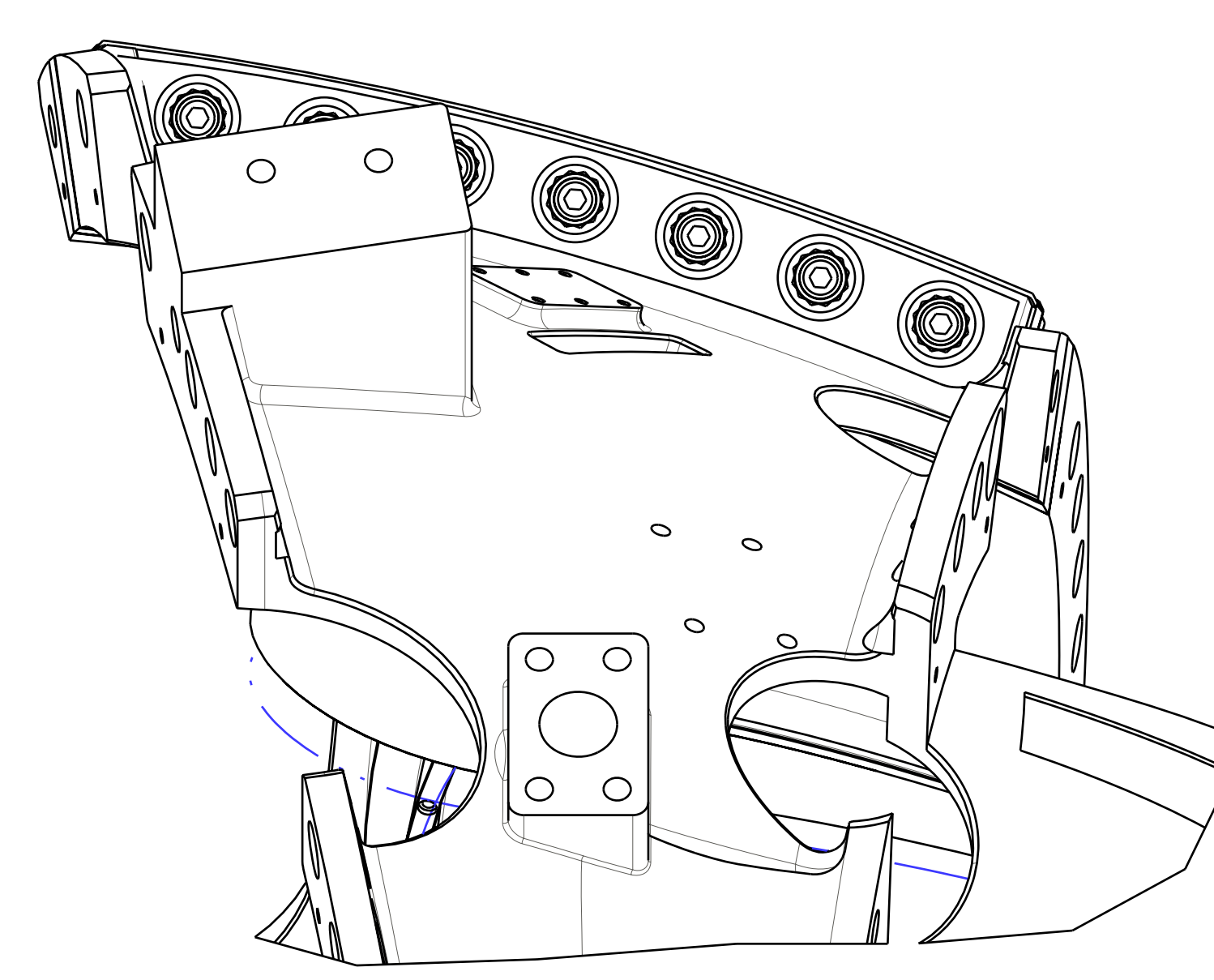
VERSION NO.	PLANT	BLDG	FL	SHT OF	TYPE	CLASS
8	X-10	5700	3	1	2	U
RELEASE LEVEL						
Fabrication						
SE141-102						
REV 2						

H
G
F
E
D
C
B
A

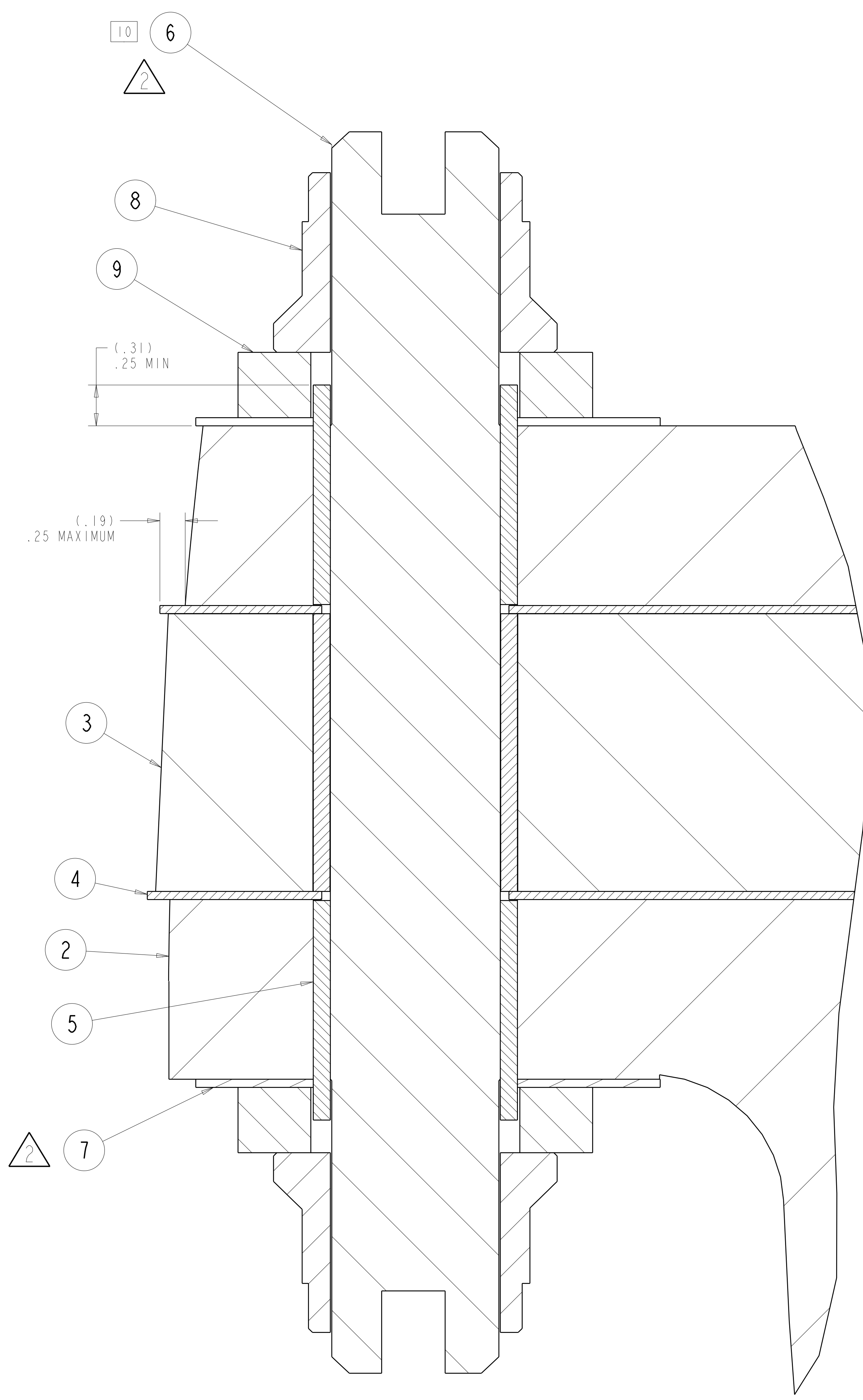
FOR NOTES AND PARTS LIST SEE SHEET 1



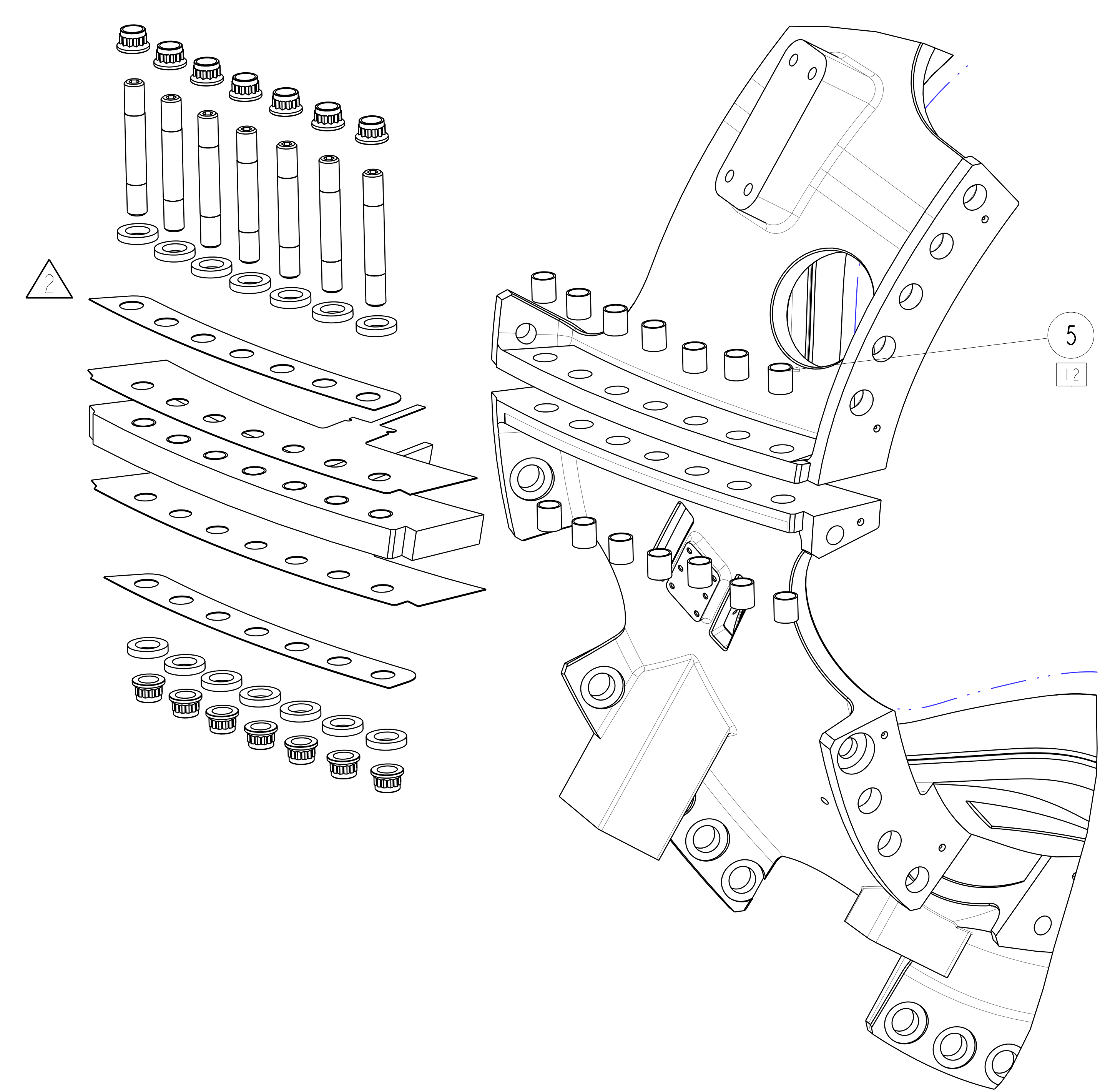
SECTION A-A
 SCALE 0.20



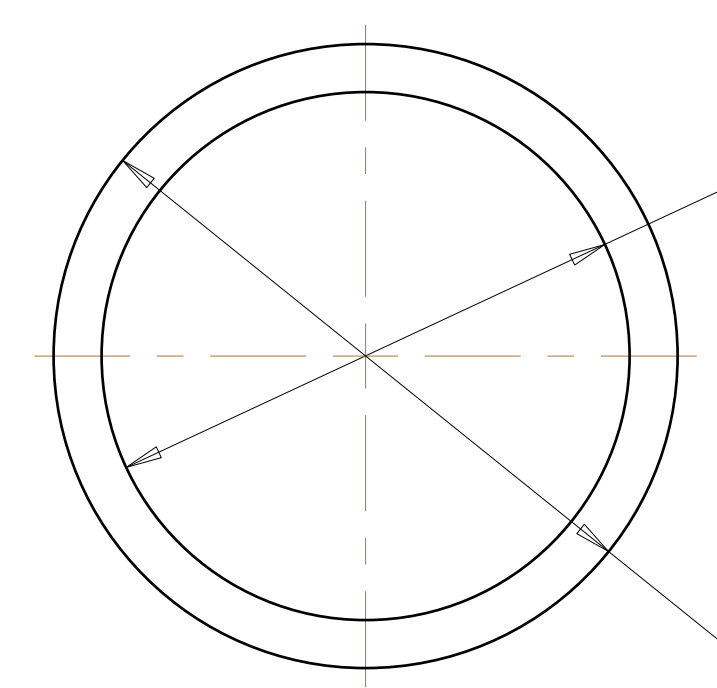
POLOIDAL BREAK DETAIL



DETAIL X
 SCALE 2.00

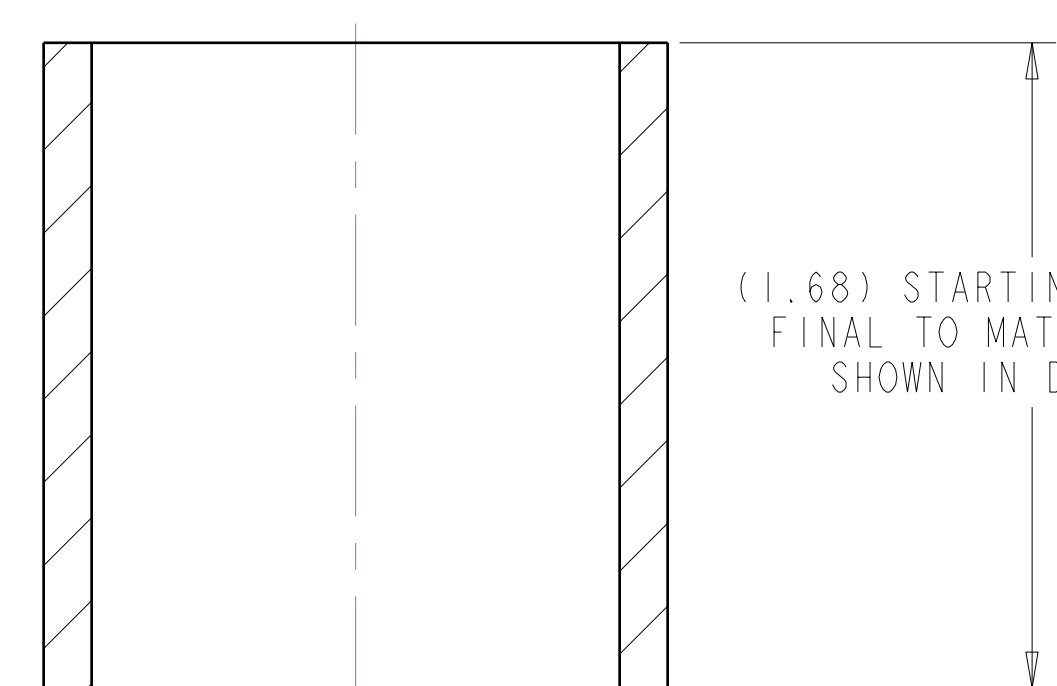
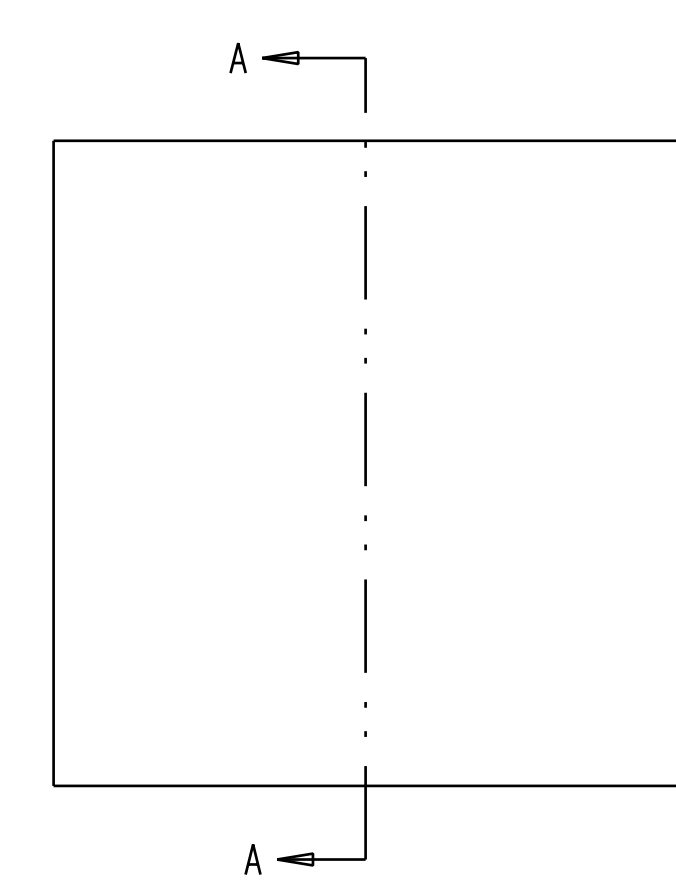


EXPLODED VIEW
 SCALE 0.20



Ø1.38 REAM AT ASSEMBLY FOR
 .001 TO .002 DIA CLEARANCE
 WITH ITEM 6

Ø1.63 OD TO MATCH HOLE
 DIA MINUS .001 TO .002 FOR
 CLEARANCE FIT



SECTION A-A
 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-B							
VERSION NO.	PLANT	BLDG	FL	SHT OF	TYPE	CLASS	
8	X-10	5700	3	2	S	U	
RELEASE LEVEL	SEI41-102						REV
Fabrication							2

SEI41-102