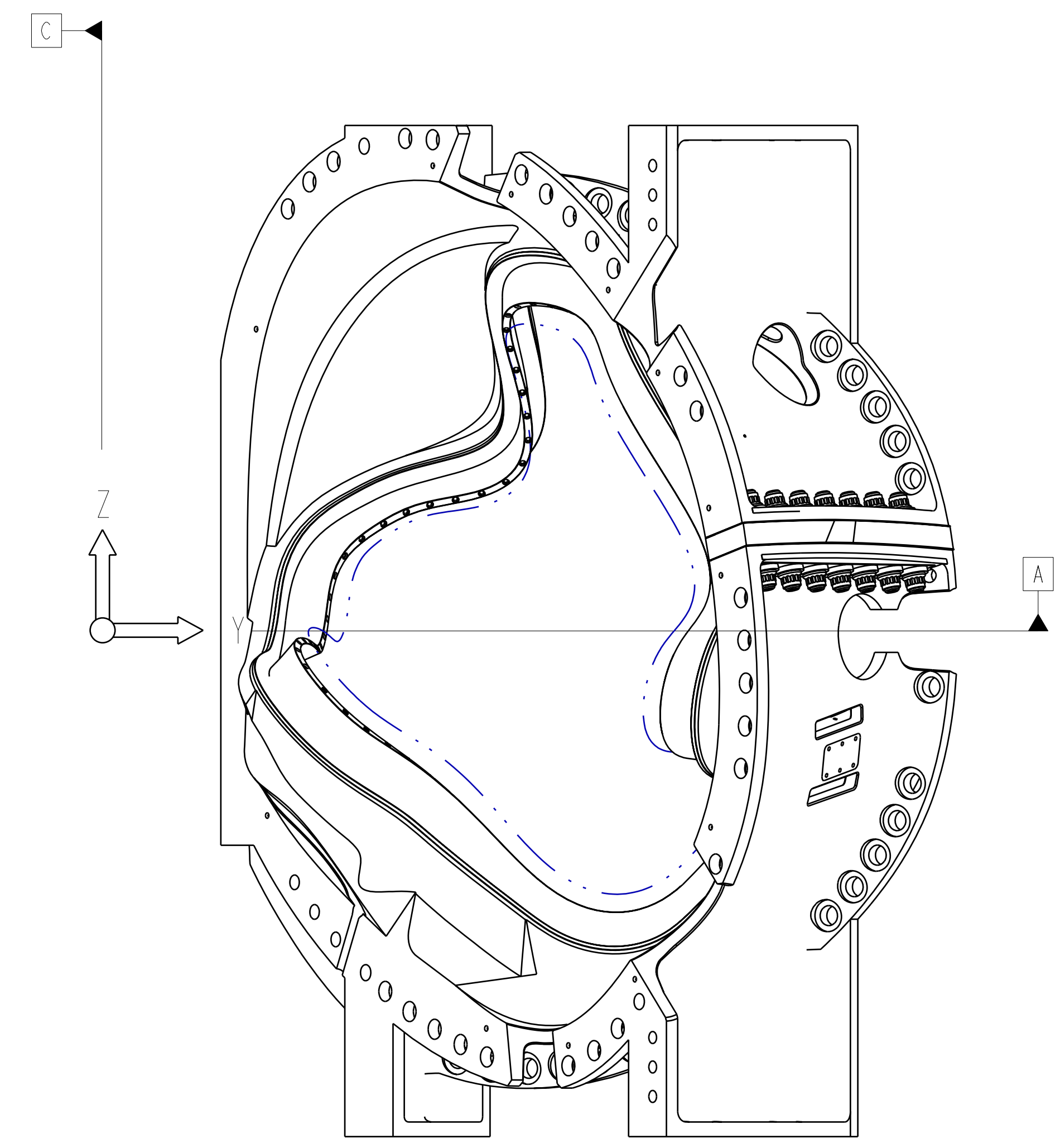
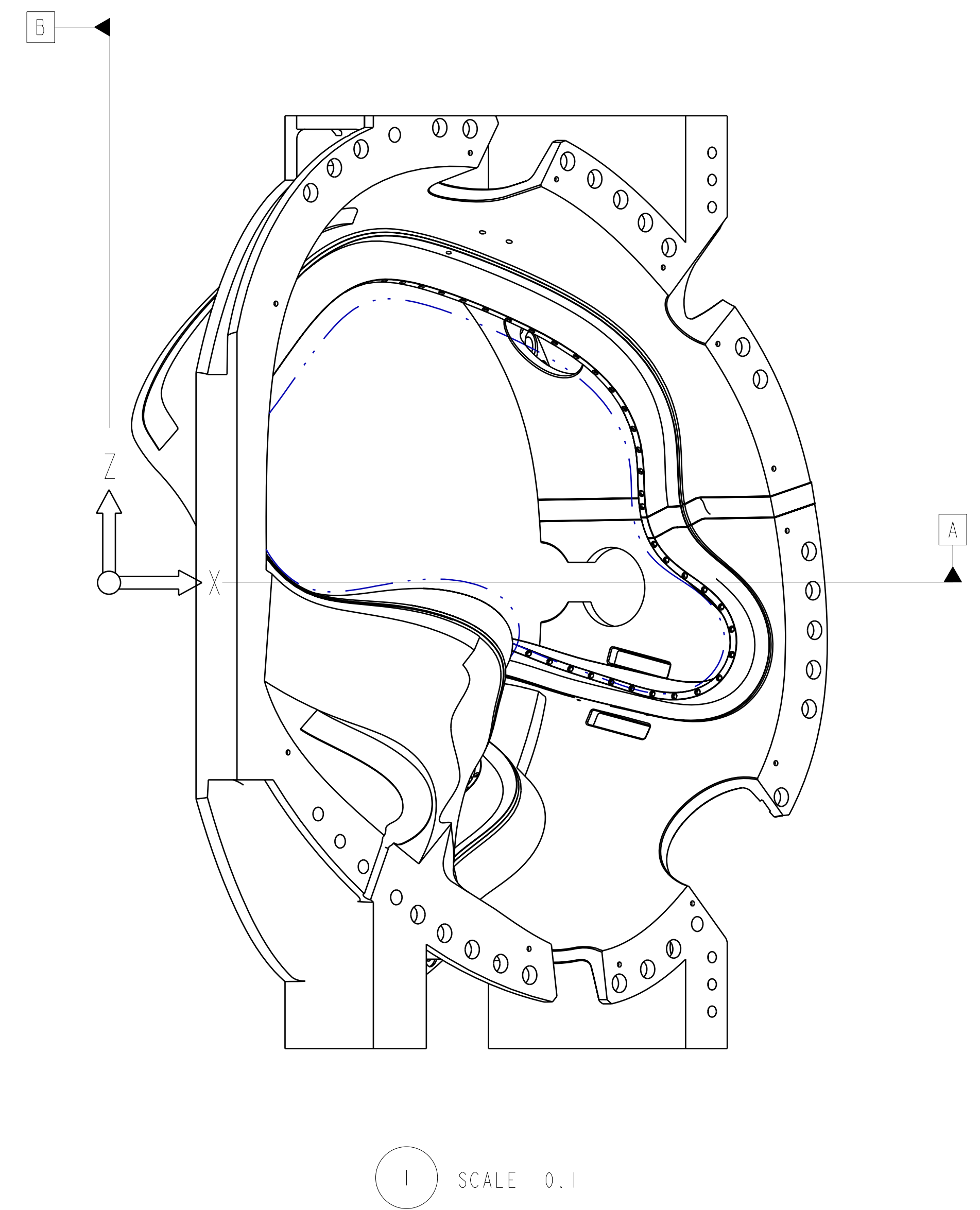
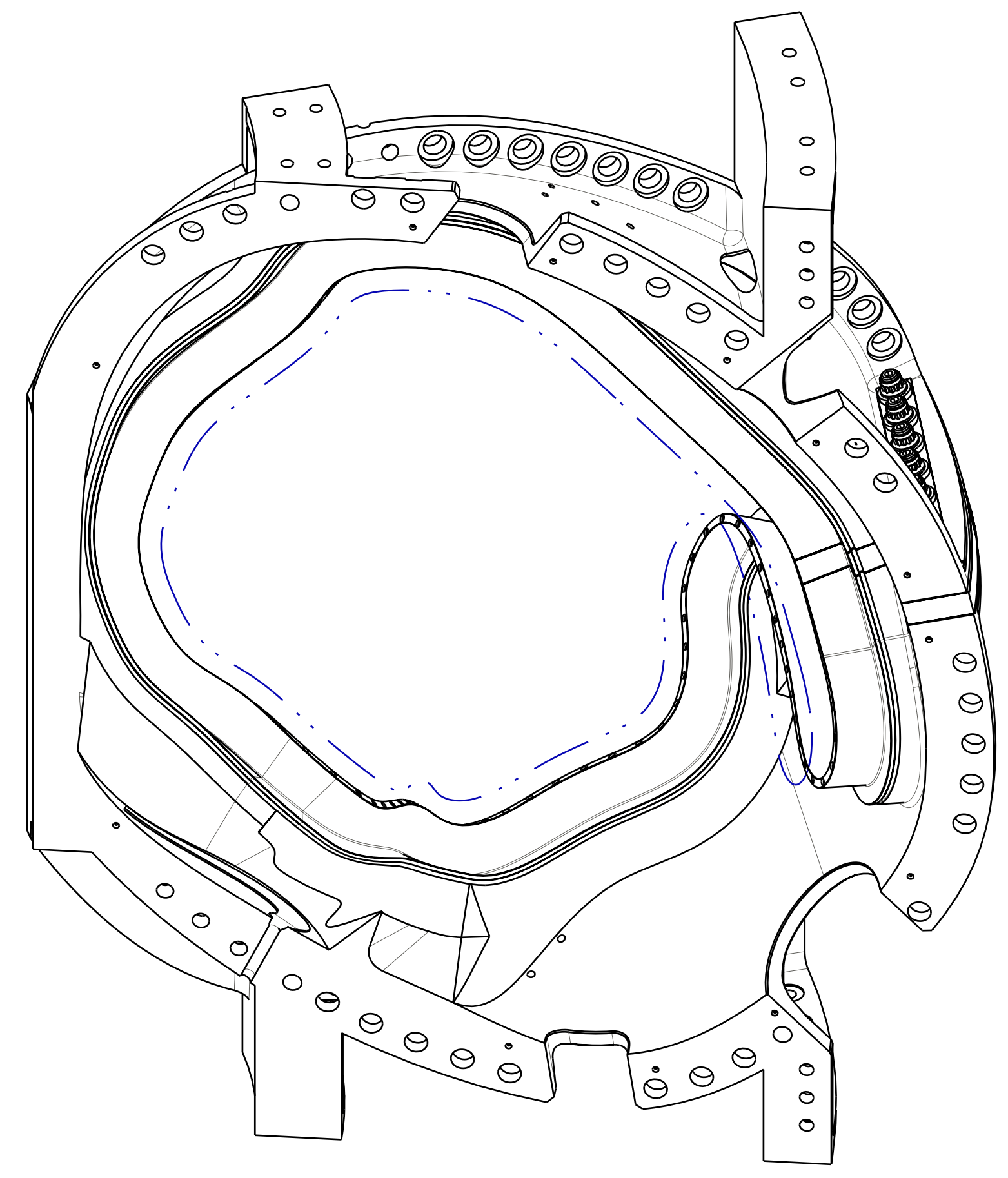
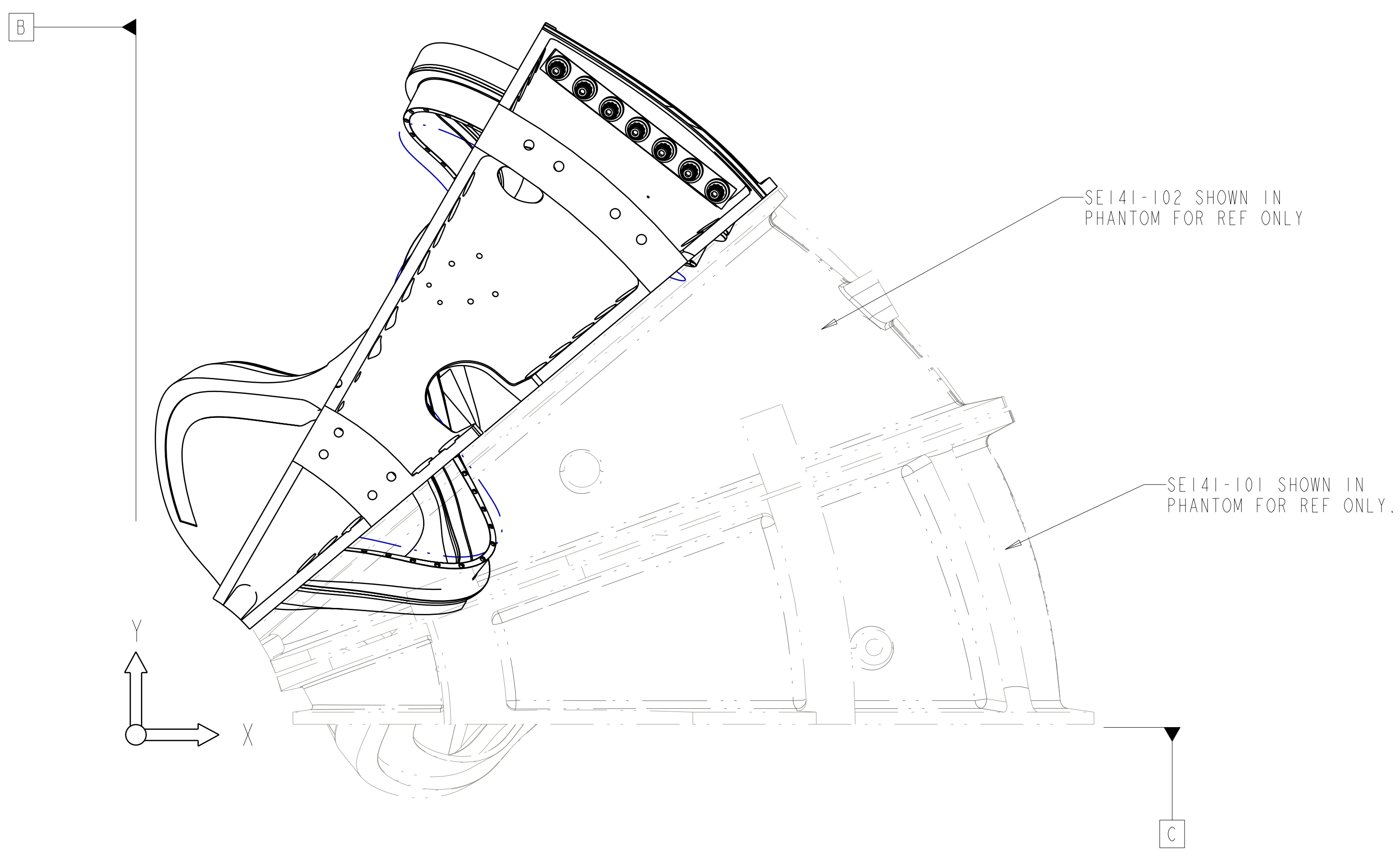


- NOTES:
- DRAWING PREPARED IN ACCORDANCE WITH ASME Y14.8M-1996.
 - INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M-1994.
 - DIMENSIONS ARE IN INCHES.
 - DRAWING DEPICTS FINAL MACHINED STATE OF ASSEMBLY DEFINED BY PRO/ENGINEER FILE SE141-103.ASM.
 - UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE RELATED 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 = 5080 LBS.
 - MATCH DRILL OR REAM TO ACHIEVE RUNNING FIT BETWEEN PARTS AND 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) TO 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 FOR 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, 1.63 OD X 1.38 ID X 1.68 LG NEMA GRADE G-11CR	5		
2	-4	INS SHEET, 15 X 32 X .063 THK NEMA GRADE G-11CR	4		
1	SE141-078	POL BREAK SHIM ASSEMBLY TYPE-C	3		
1	SE141-116	PRODUCTION WINDING FORM TYPE-C	2		
AR	X	-1 MOD COIL WINDING FORM ASSEMBLY TYPE-C	1		
SE141-103	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
2	REVISED ASSEMBLY AND DRAWING PER ECN 5009	GLL	7/05/04	MJC			DEW					
1	REVISED F/N 2 PER ECN-4903	DW	9/04/04	MJC			DEW					

SCALE	NOTED	DES	DATE	DRW	DATE	CHK	DATE	SECT	DATE	DEPT	DATE	PE	DATE	REG	DATE	ORNL	DOE	DATE
		T BROWN	6-30-04	G LOVETT	6-30-04	M COLE	6-30-04											
		D WILLIAMSON	6-30-04															

VERSION NO.	PLANT	BLDG	FL	SHT OF	TYPE	CLASS
11	X-10	5700	3	1	2	U

RELEASE LEVEL	PROJECT NAME
Fabrication	NATIONAL COMPACT STELLARATOR EXPERIMENT
	MOD COIL WINDING FORM ASSEMBLY TYPE-C

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.

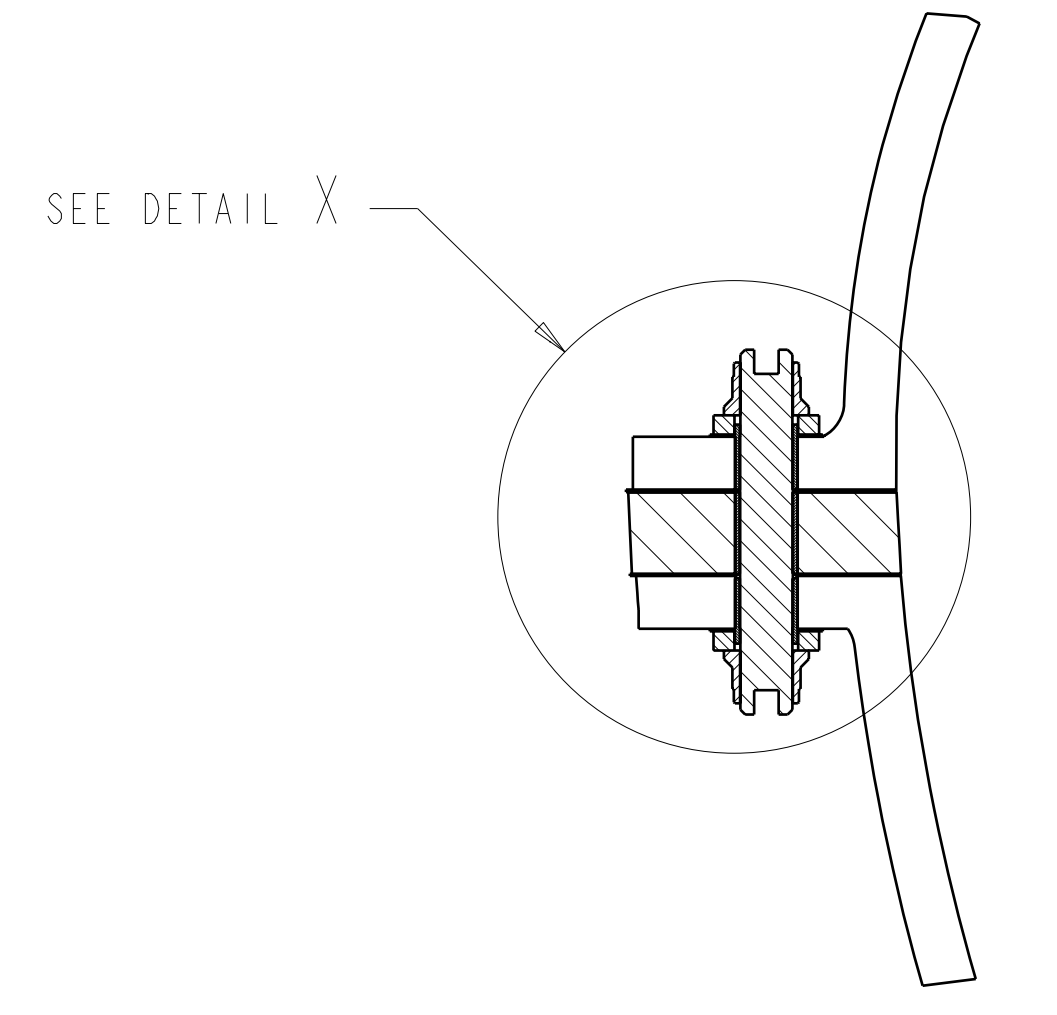
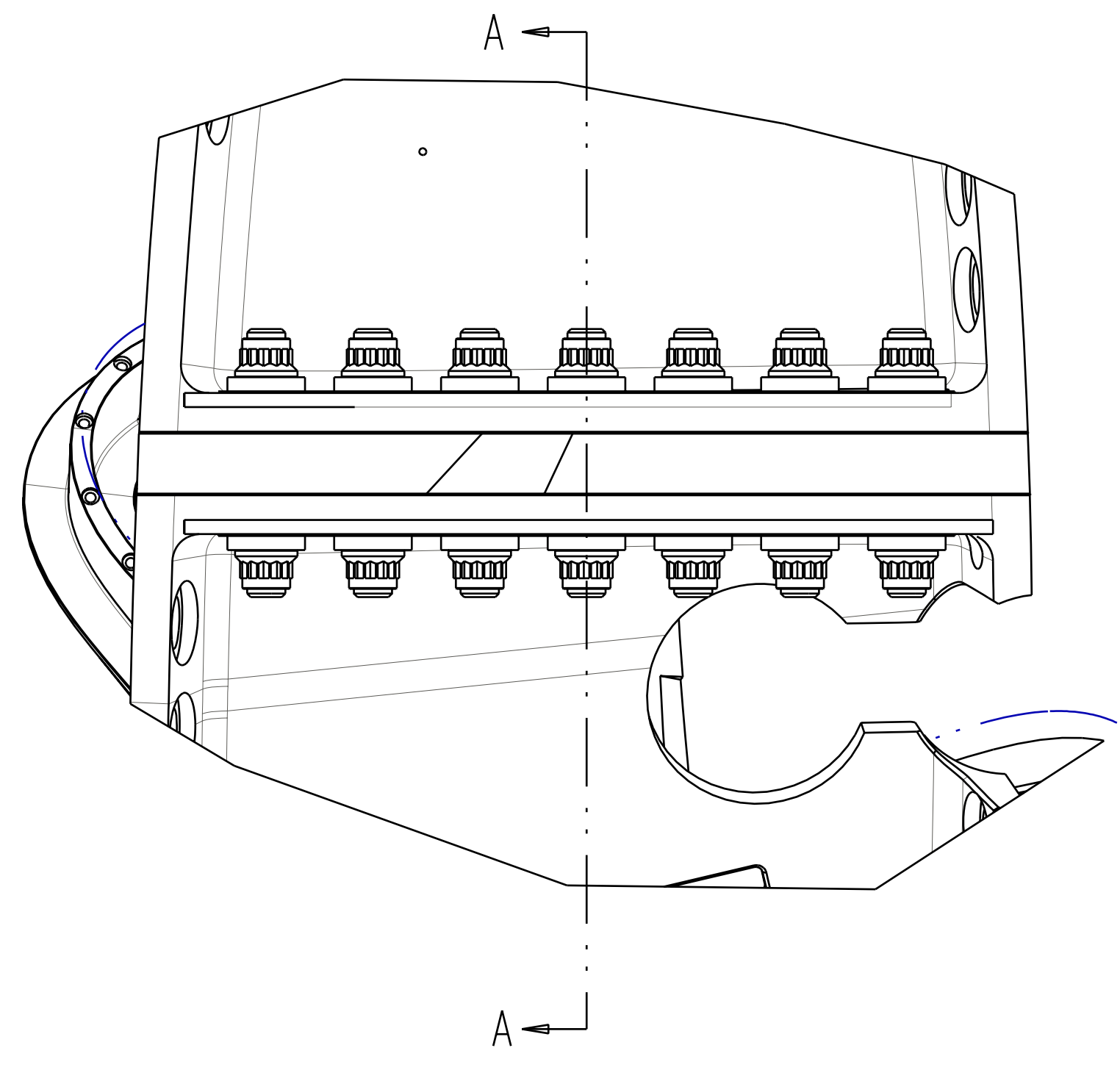
P THIS DRAWING PRODUCED ON PRO-ENGINEER

H
G
F
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B
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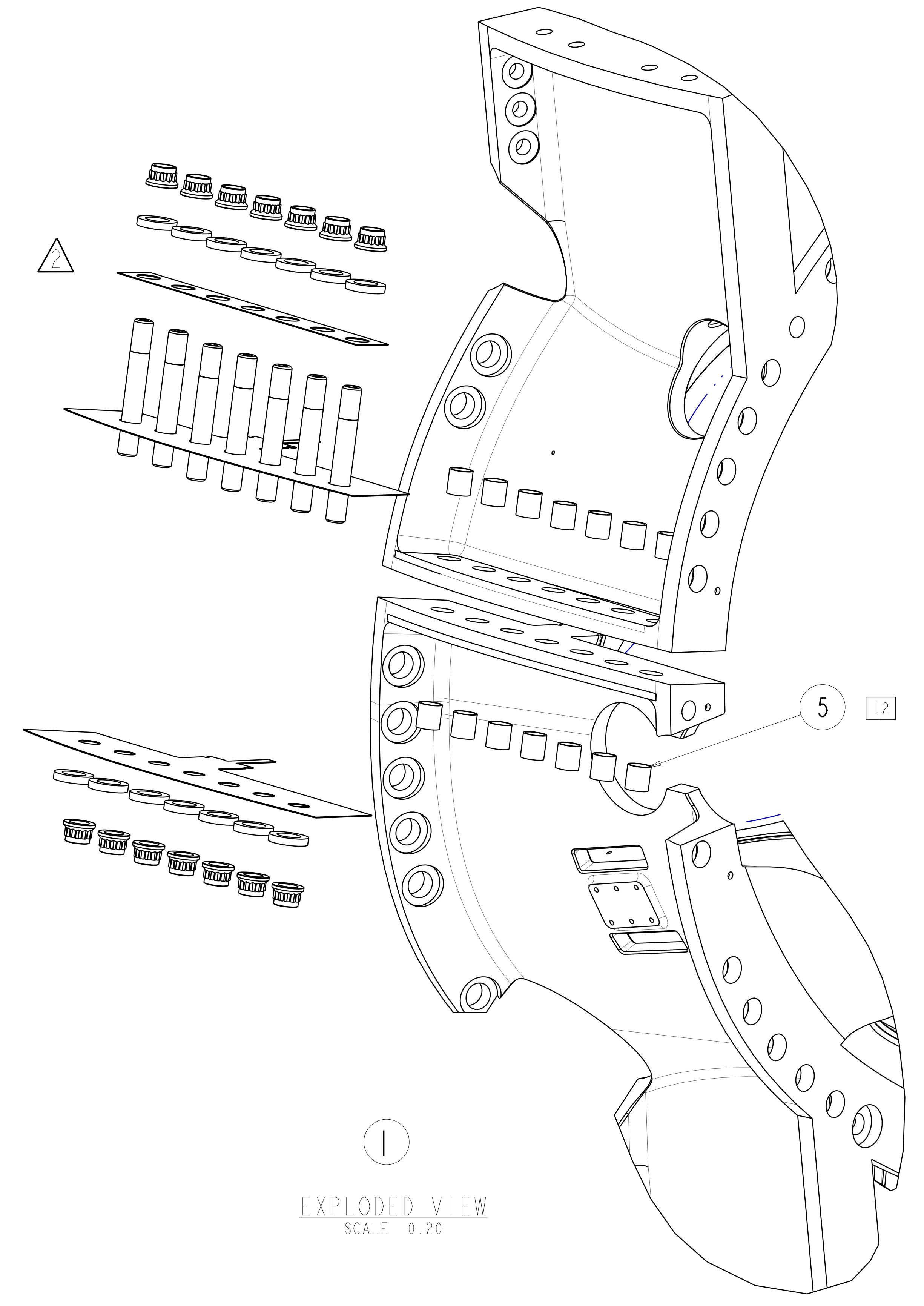
SE141-103

A

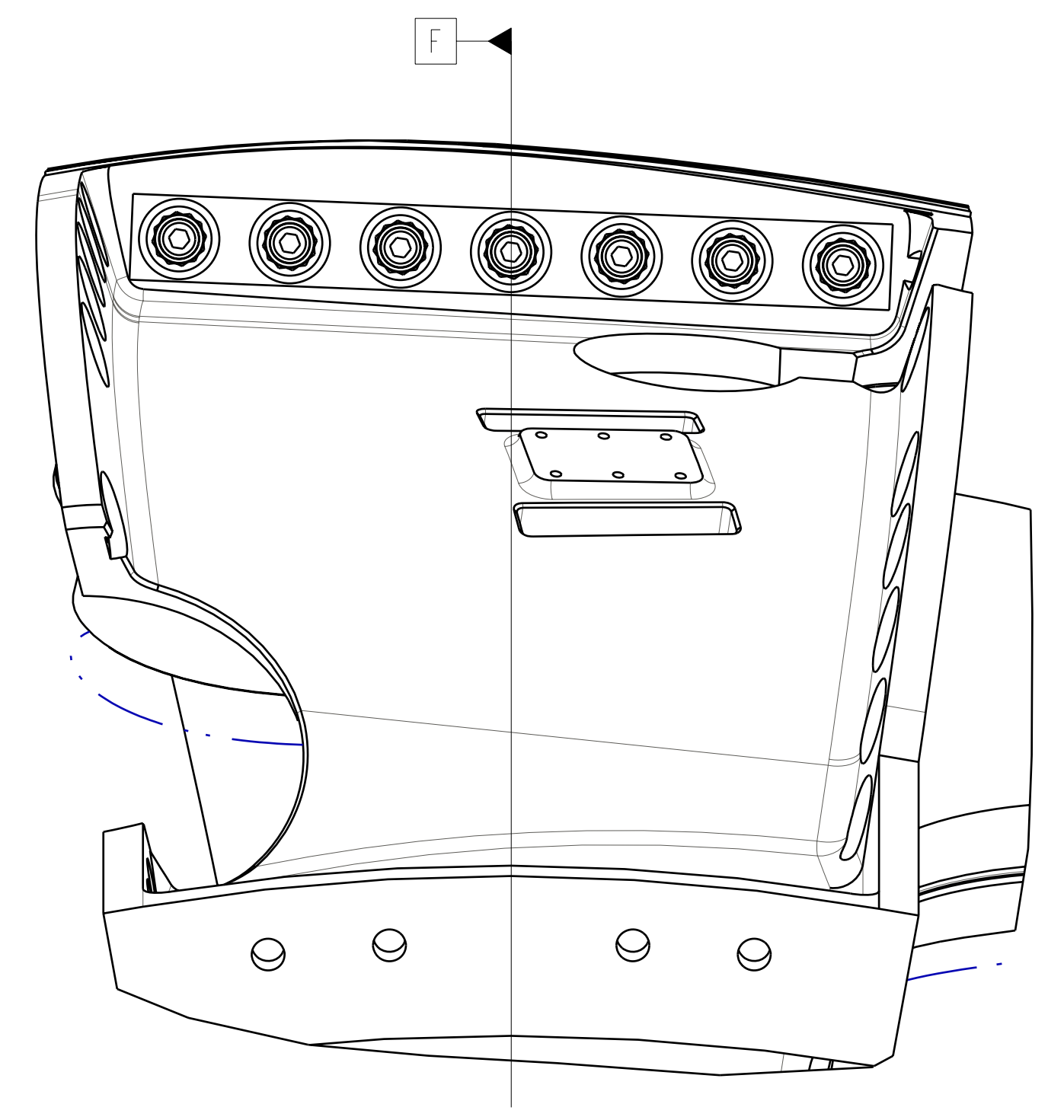
FOR NOTES AND PARTS LIST SEE SHEET 1



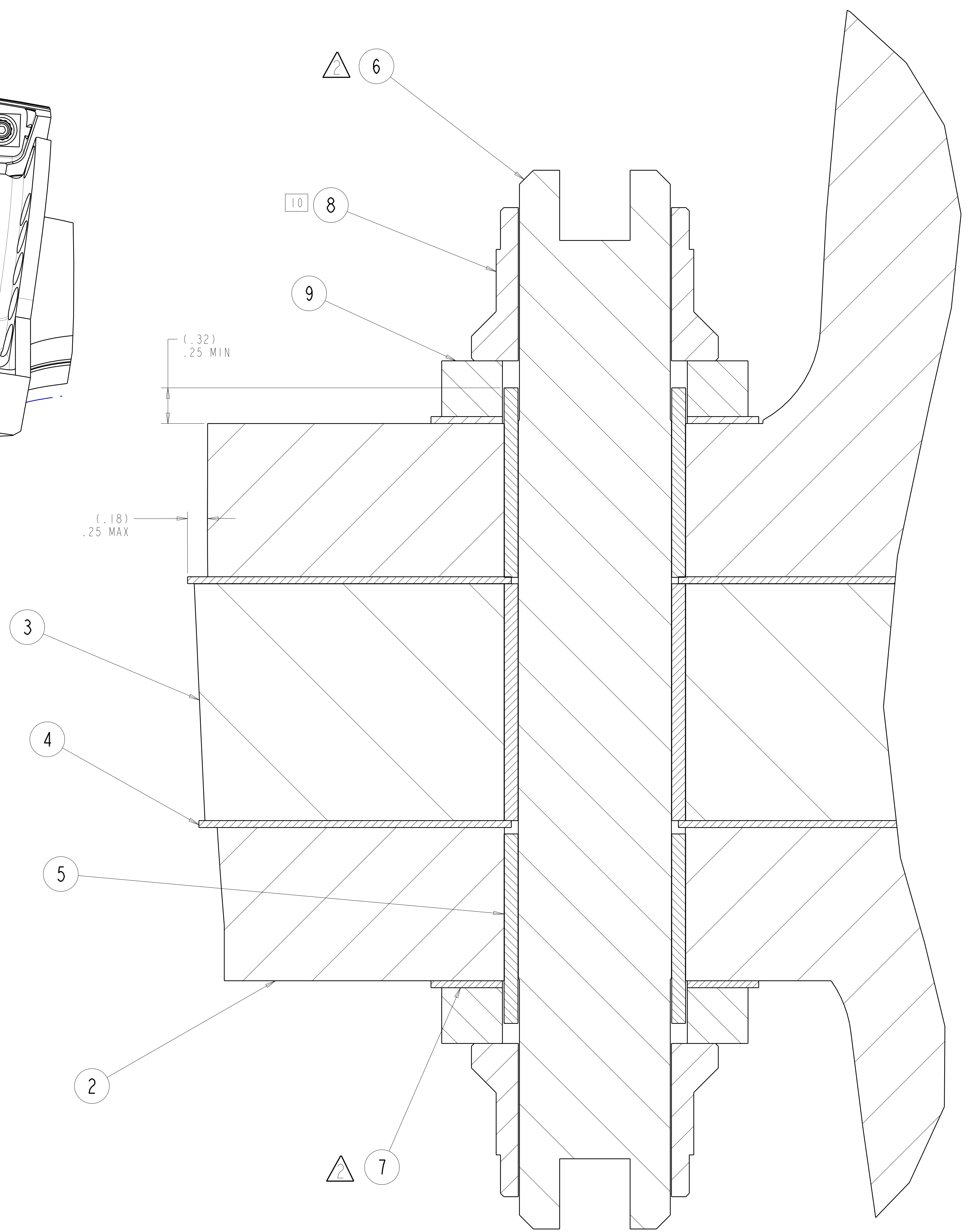
SECTION A-A
 SCALE 0.20



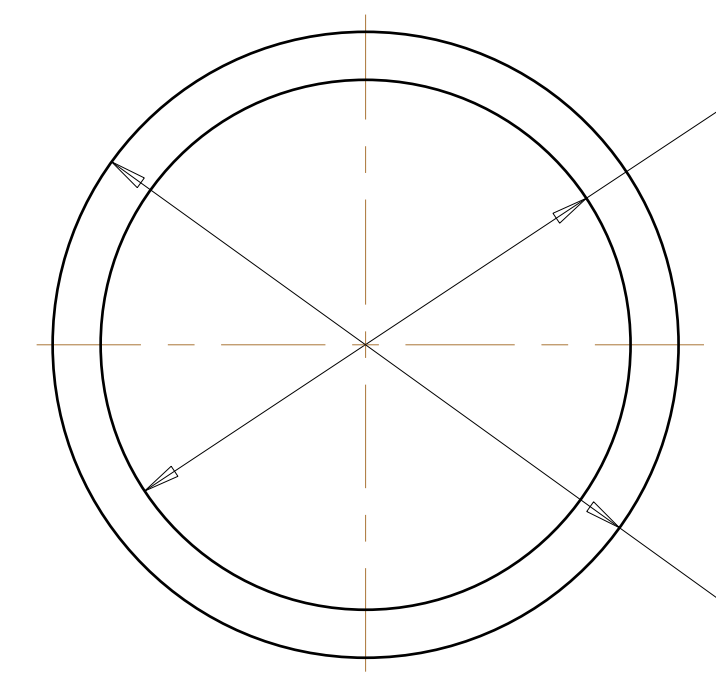
EXPLODED VIEW
 SCALE 0.20



POLOIDAL BREAK DETAIL

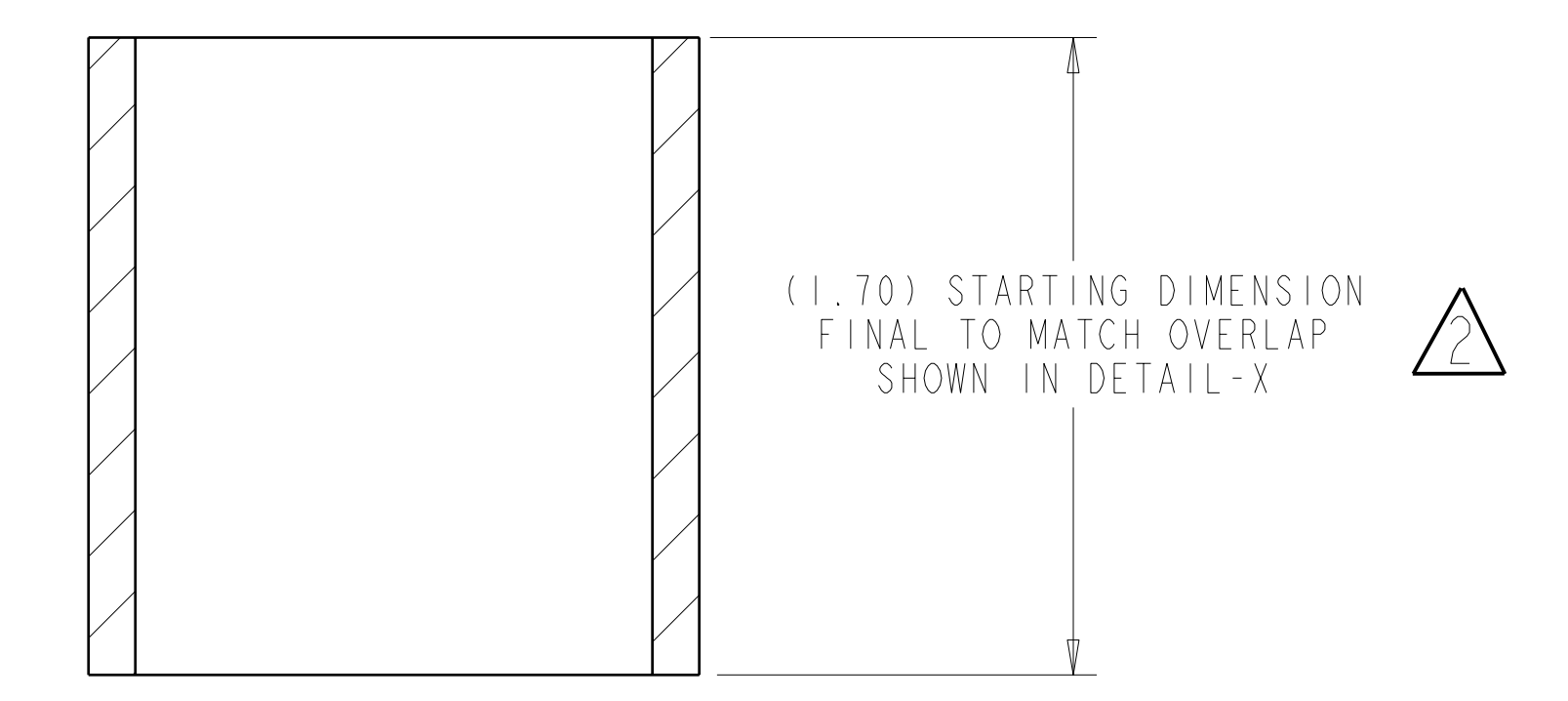
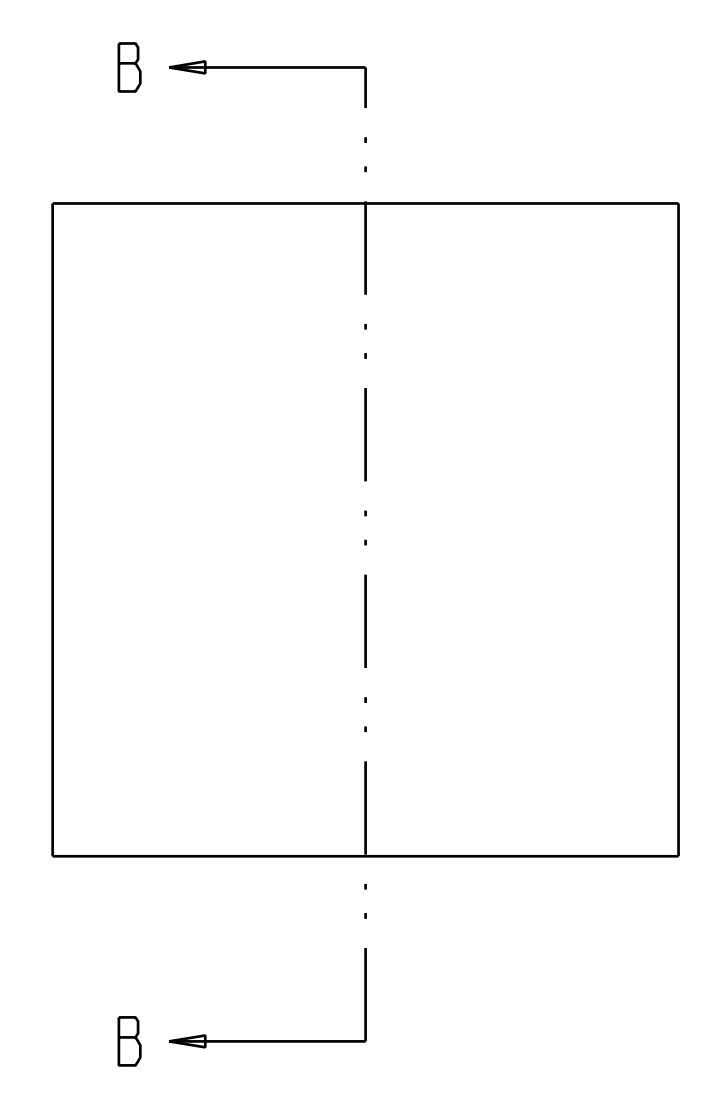


DETAIL X
 SCALE 2.00



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

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



(1.70) STARTING DIMENSION
 FINAL TO MATCH OVERLAP
 SHOWN IN DETAIL-X

SECTION B-B
 SCALE 2.00

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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	
NATIONAL COMPACT STELLARATOR EXPERIMENT			
MOD COIL WINDING FORM ASSEMBLY TYPE-C			
VERSION NO. 11	PLANT X-10	BLDG 5700	FL 3
RELEASE LEVEL Fabrication		SHT OF 2	TYPE S
SEI41-103		CLASS U	REV 2

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