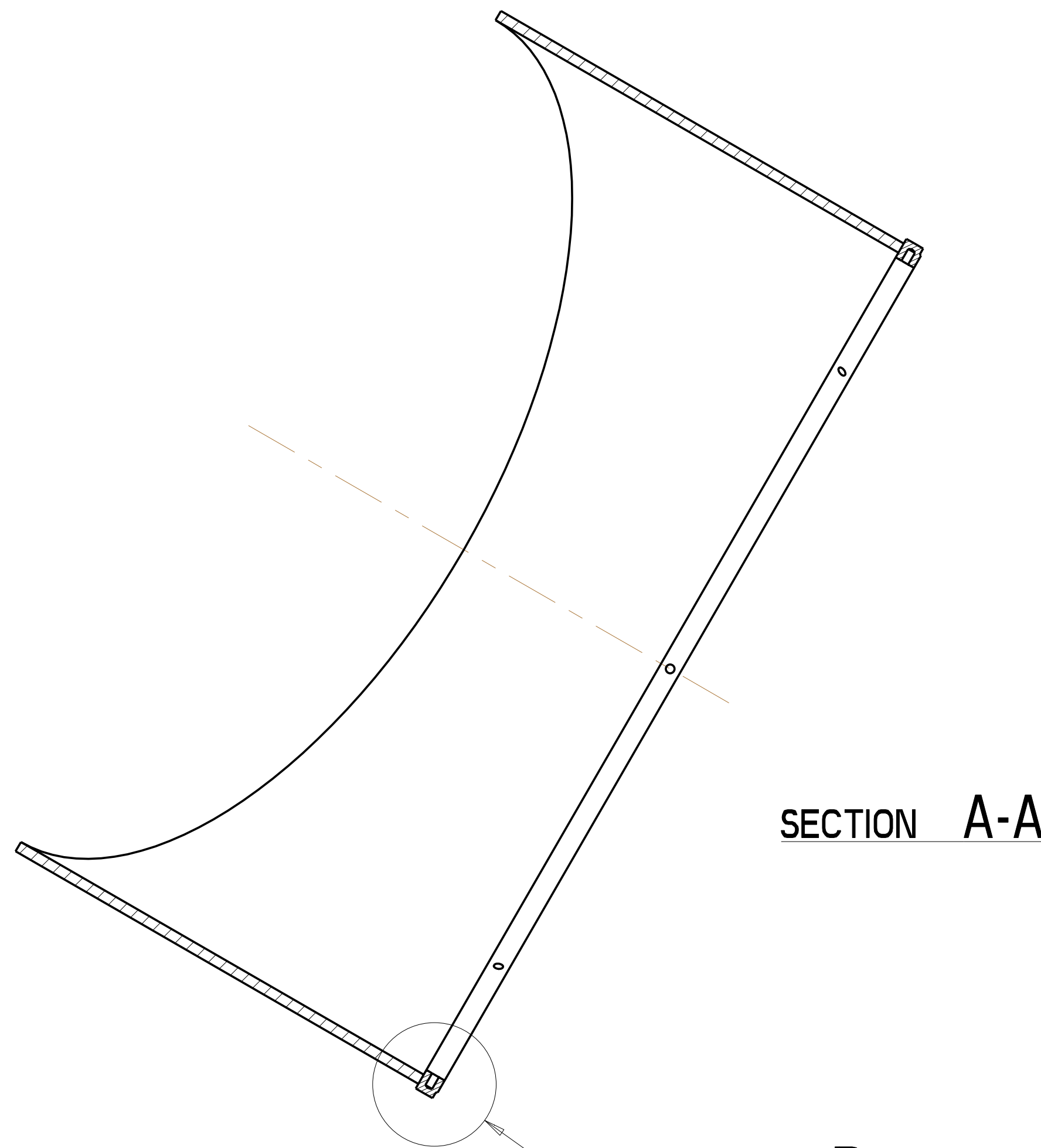
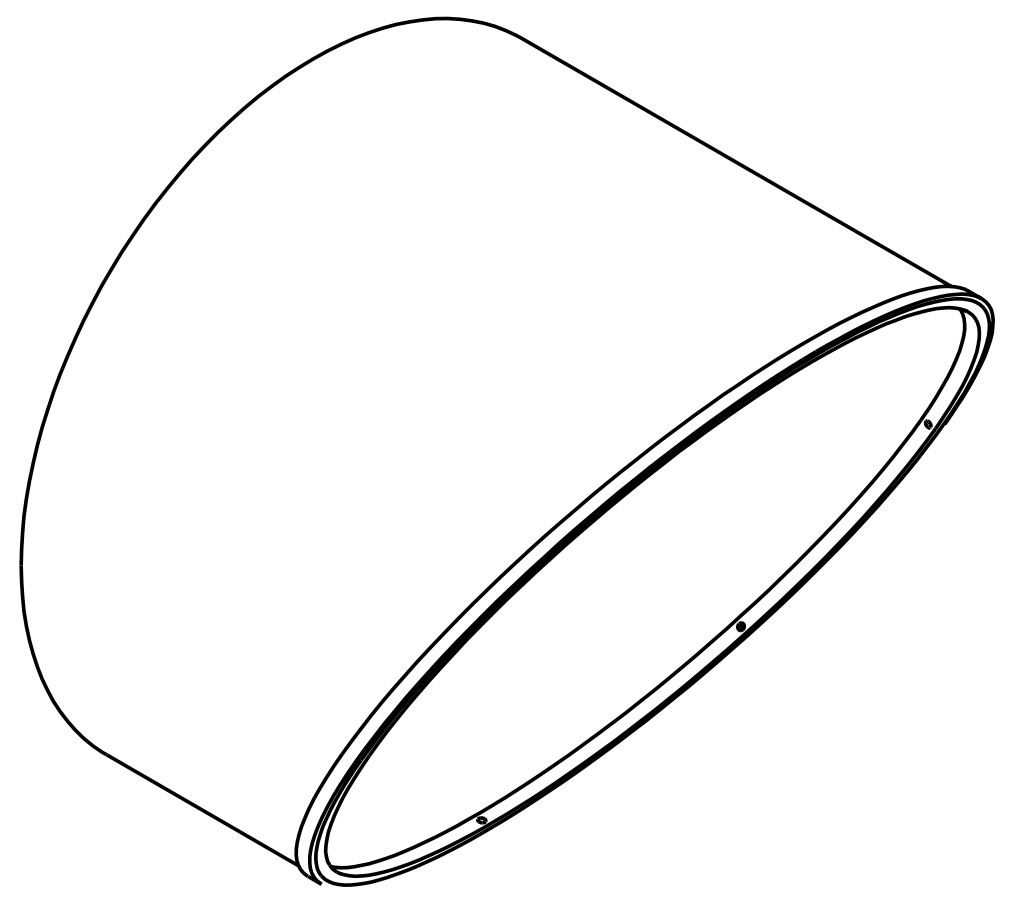


DETAIL D
SCALE 2.000

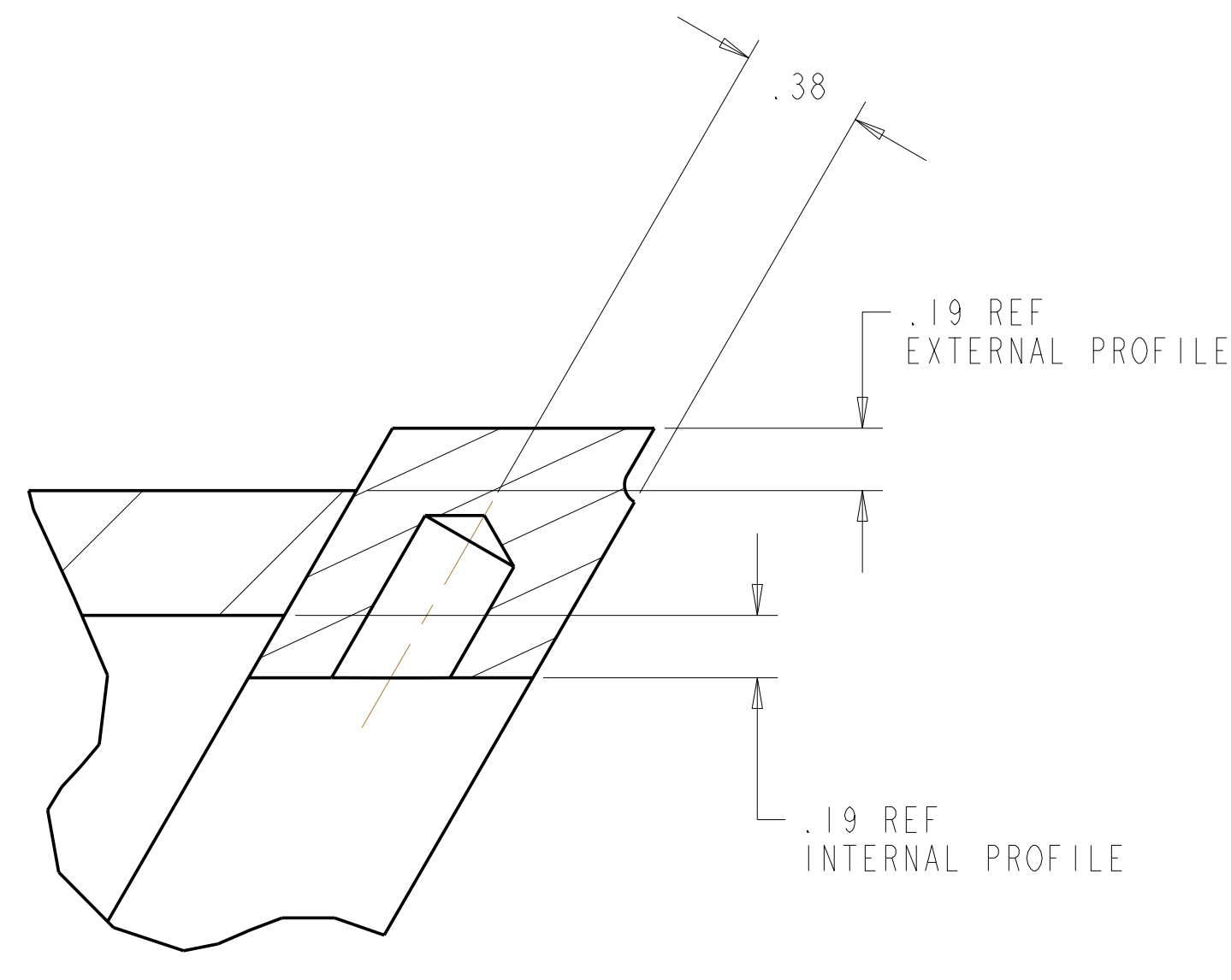


SECTION A-A

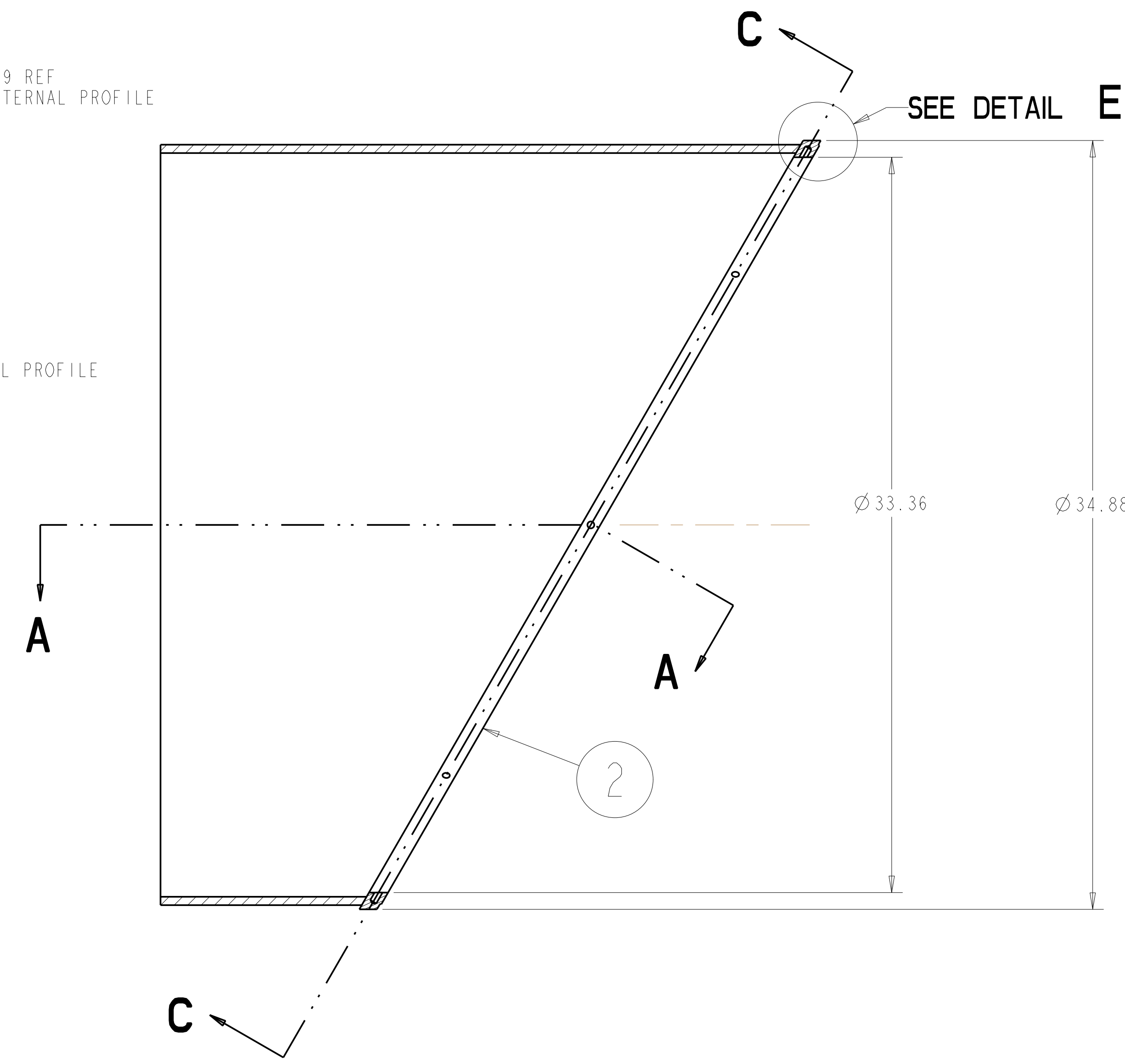
- NOTES:
1. INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M.
 2. DIMENSION ARE IN INCHES.
 3. REQUIREMENTS FOR FABRICATING THE VACUUM VESSEL END PIECE ARE DEFINED IN THE DRAWINGS, MODELS, AND NCSX-SOW-121-02-00.
 4. GEOMETRY OF VACUUM VESSEL END PIECE IS DEFINED IN CAD MODELS/FILES SEI203-003.ASM, SEI203-005.ASM, SEI203-012 AND SEI203-015.PRT.



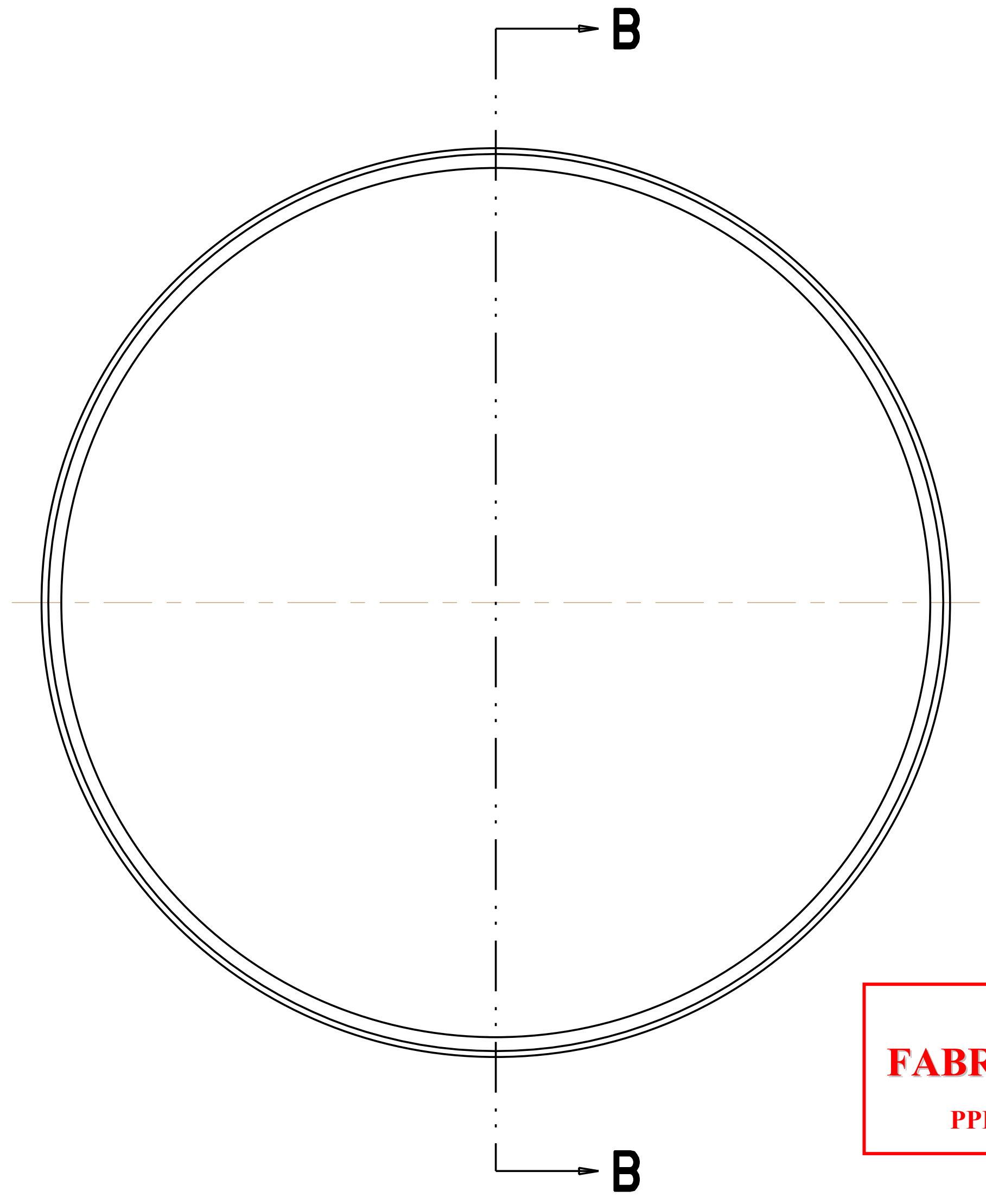
REFERENCE VIEW
SCALE 0.125



DETAIL E
SCALE 2.000



SECTION B-B



SCALE 0.250

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

| | | | | | | |
|-----------|---------------|------------------------|-----------------------------|----------|---------------|------------|
| next assy | I | SEI203-005 | VVFWJ END PIECE STOCK | INCONEL | UNS N06625 | 2 |
| | I | SEI203-003 | VVFWJ END PIECE MACHINING | INCONEL | UNS N06625 | 1 |
| | CAGE CODE | PART OR IDENTIFYING NO | NOMENCLATURE OR DESCRIPTION | MATERIAL | SPECIFICATION | FIND NO |
| | NEXT ASSEMBLY | | | | | PARTS LIST |

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 | REQ | DATE | ORNL | DOE | DATE |
|---------------------------|-------------|----|------|-----|------|------|----|-----|------|------|-----|------|
| REVISION OR ISSUE PURPOSE | | | | | | | | | | | | |
| REVISION APPROVAL | | | | | | | | | | | | |

SCALE AS NOTED
TOLERANCES UNLESS OTHERWISE SPECIFIED
FRACTIONS XX DECIMALS ± .01
XXX DECIMALS ± .005
ANGLES ± 0°15'
BREAK SHARP EDGES .06 MAX
FINISH .125 UNLESS OTHERWISE SPECIFIED

DES: P. GORANSON
DRW: G. FORTIER
CHK: G. LOVETT
SECT: :
DEPT: :
PE: :
CR: :
PJ: :
REQ: :
PPPL DRFT :
PPPL WELD ENGR - R. Parsells 4/6/04
DRAWING APPROVALS : DATE :

27MARD04
28MARD04
6APR04

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 TITLE
NATIONAL COMPACT STELLARATOR EXPERIMENT
VACUUM VESSEL END MACHINING
VERSION NO. :
PLANT ORNL
BLDG 5700
FL 3
SHT 1
OF 2
TYPE D
CLASS U
RELEASE LEVEL :
Fabrication
SEI203-003
REV 0

8

7

6

5

4

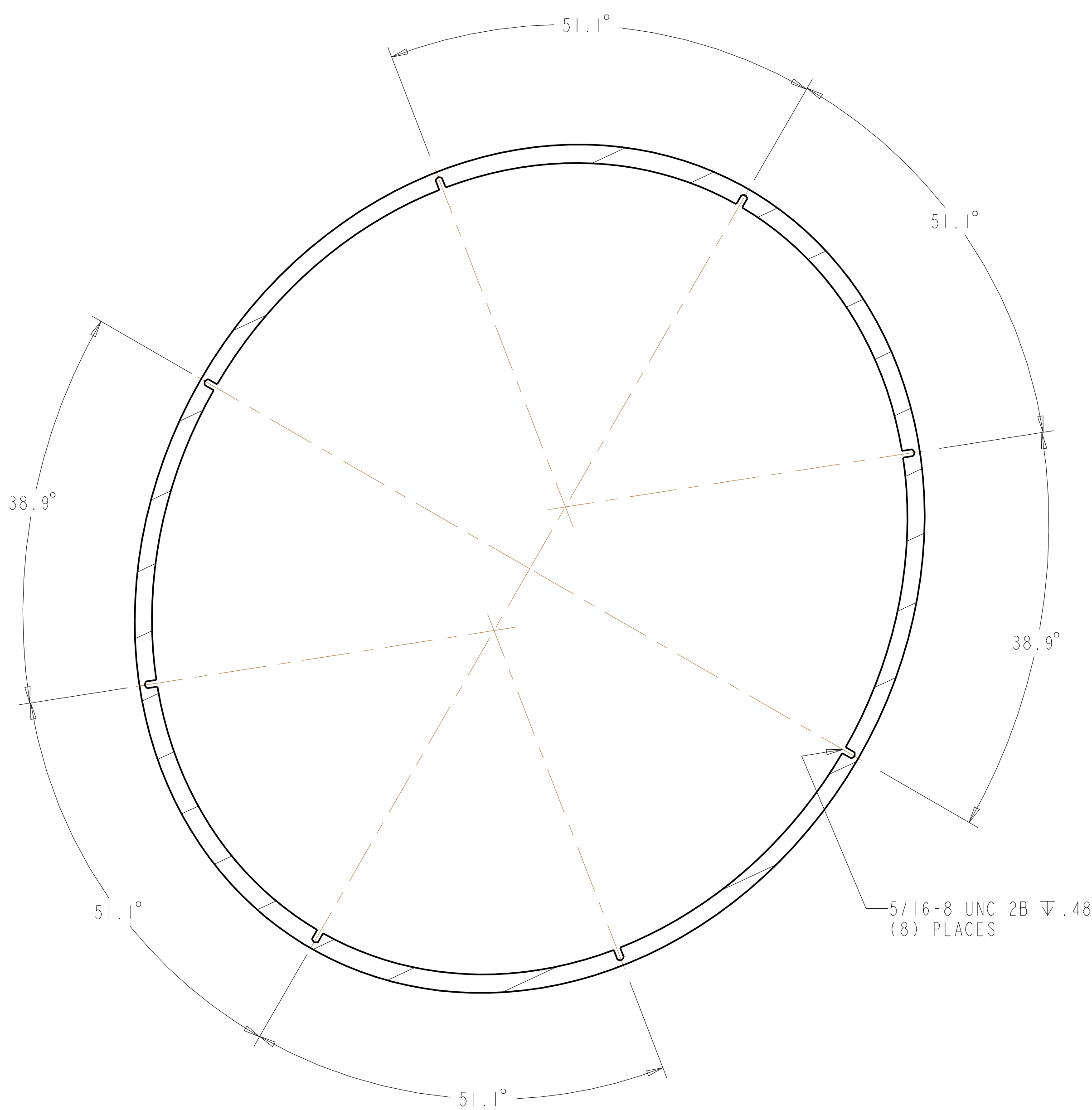
3

2

1

NEXT ASS'Y:

FINAL ASS'Y:



SECTION C-C
SEE DETAIL E
SHT. 1 OF 2 - ZONE D8

**RELEASED FOR
FABRICATION / INSTALLATION**

PPPL Drafting:

| | | | | | | | |
|--|---------------|---|---------|----------|---------|-----------|------------|
| <u>UT-BATTELLE</u> | | 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 END MACHINING | | | | | | | |
| VERSION NO. | PLANT ORNL | BLDG 5700 | FL 3 | SHT 2 | OF 2 | TYPE D | CLASS U |
| RELEASE LEVEL Fabrication | | SE1203-003 | | | | | REV 0 |