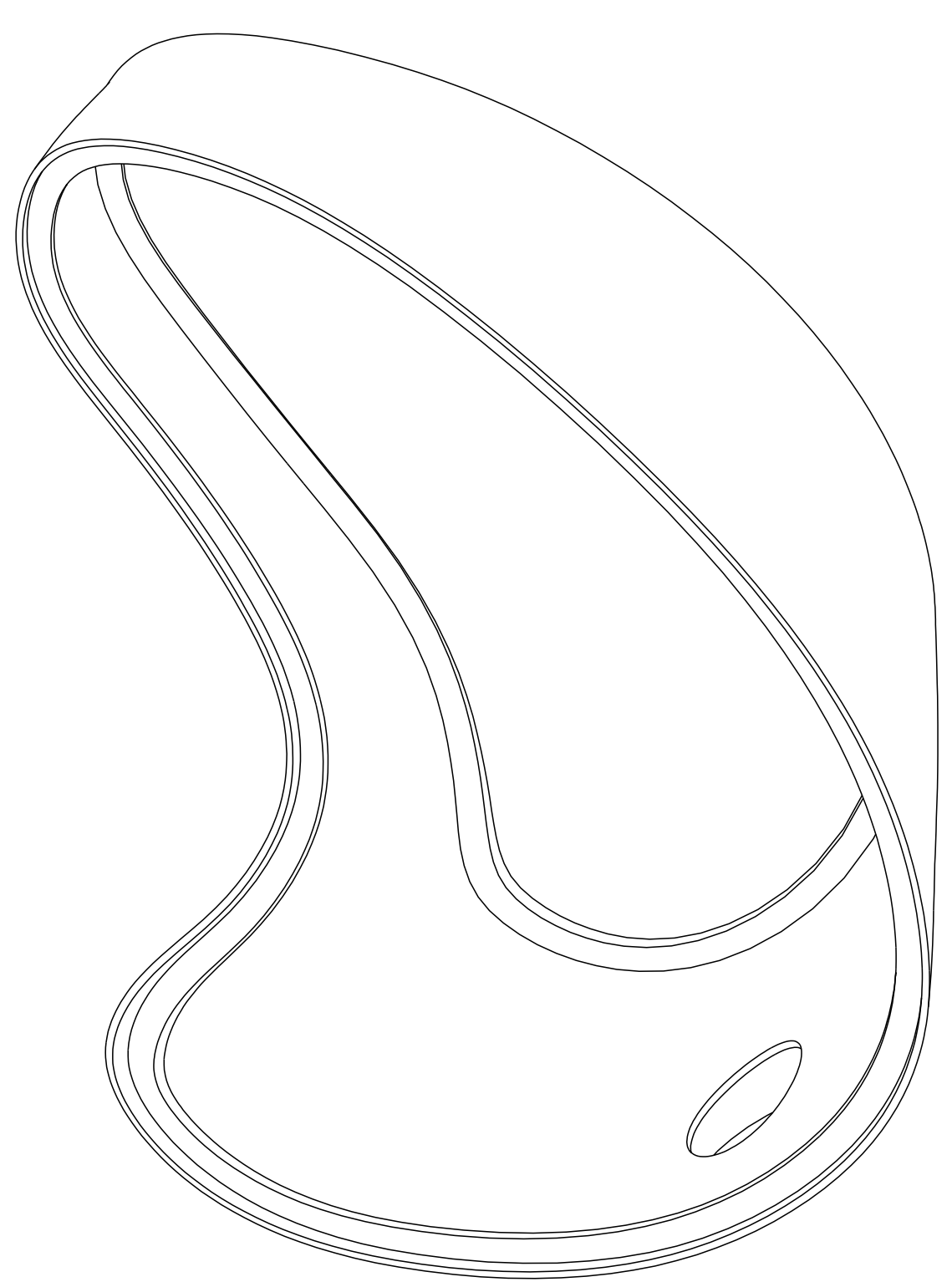
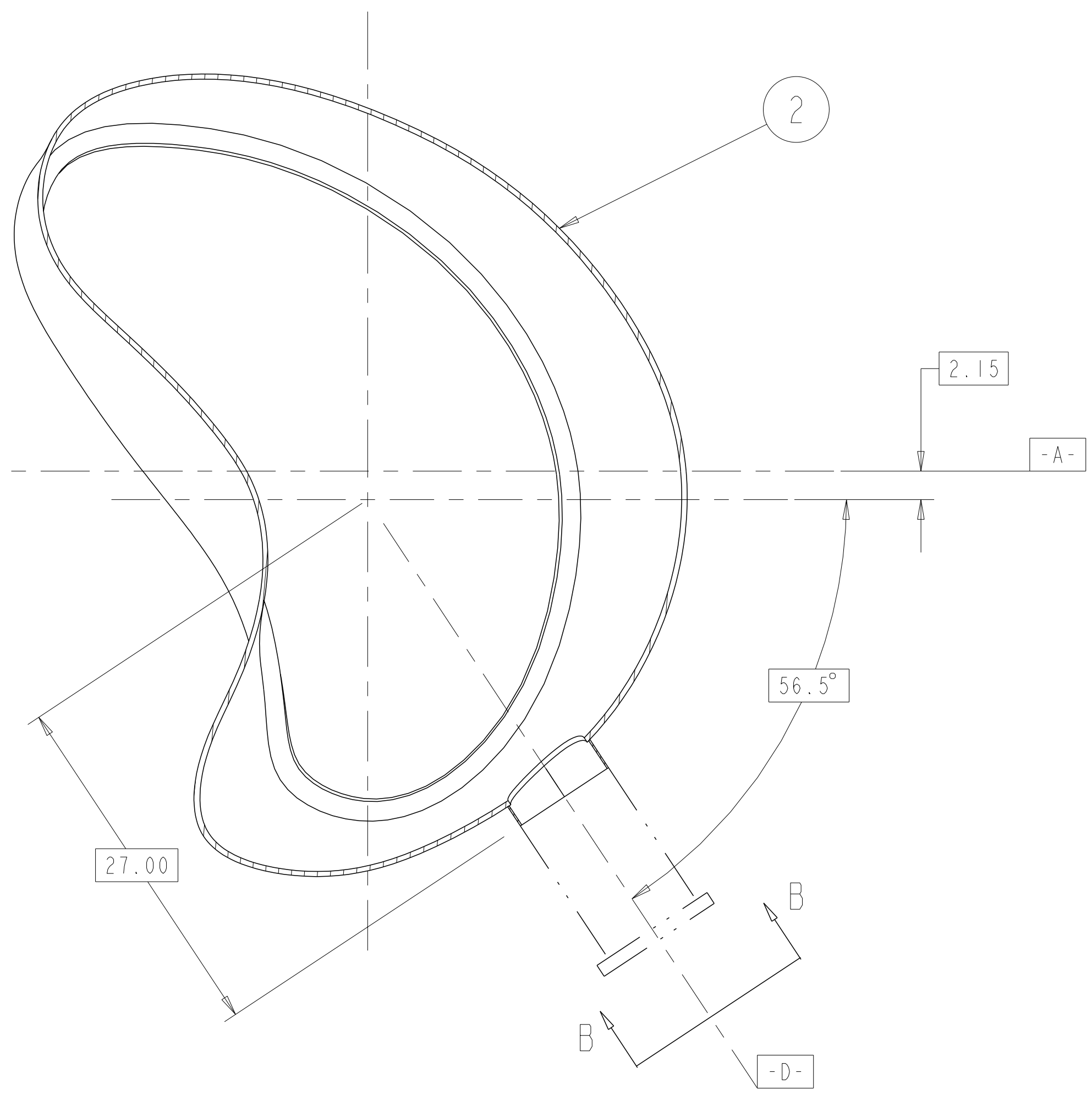
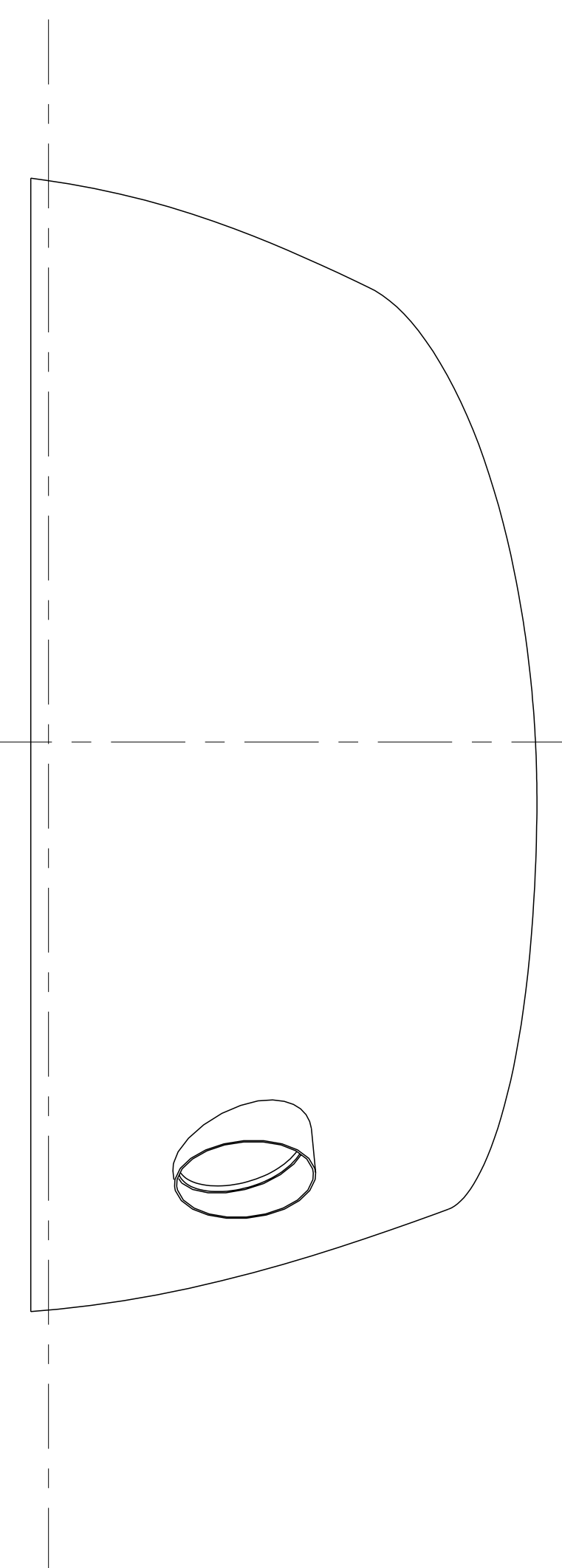
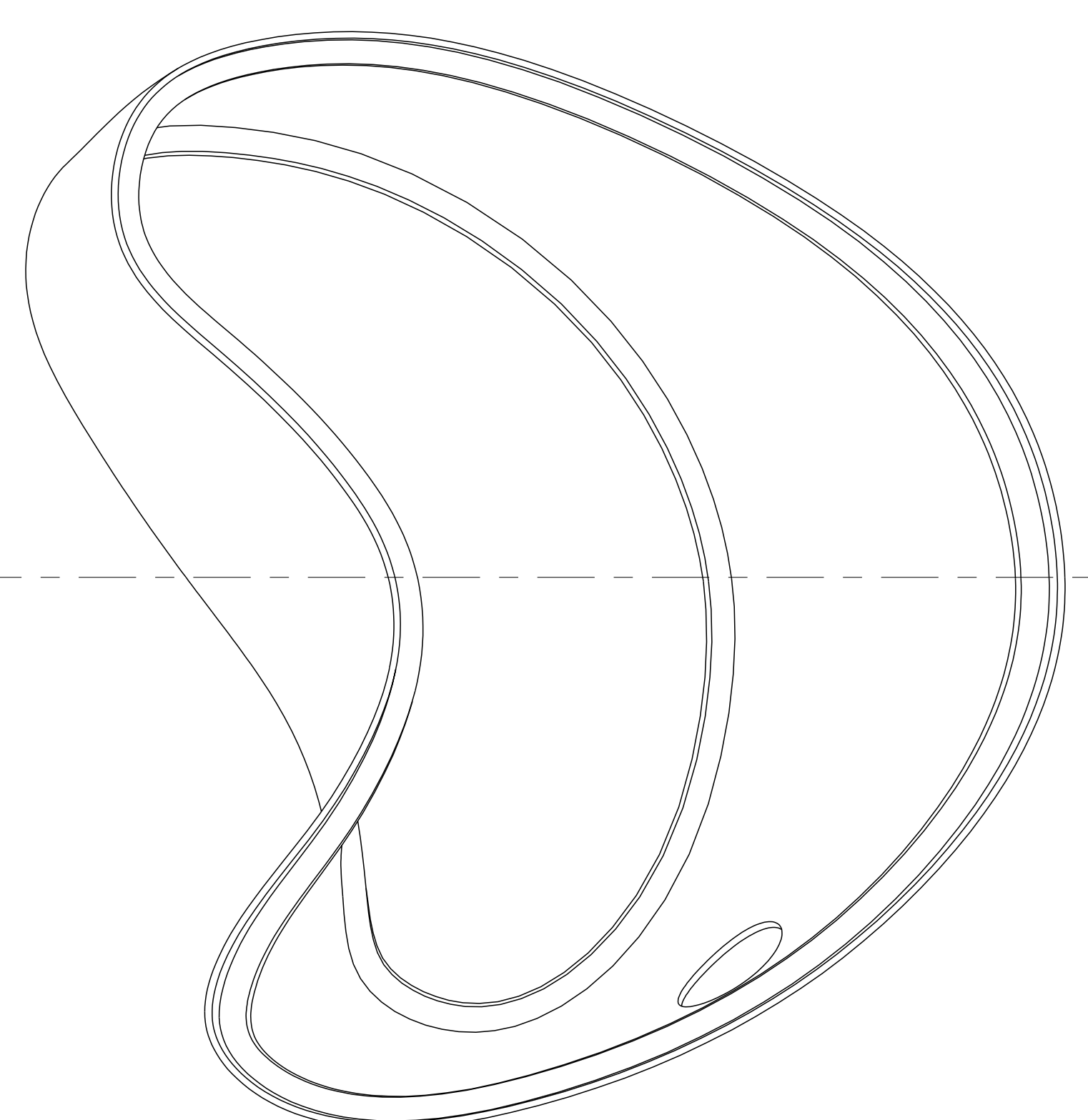
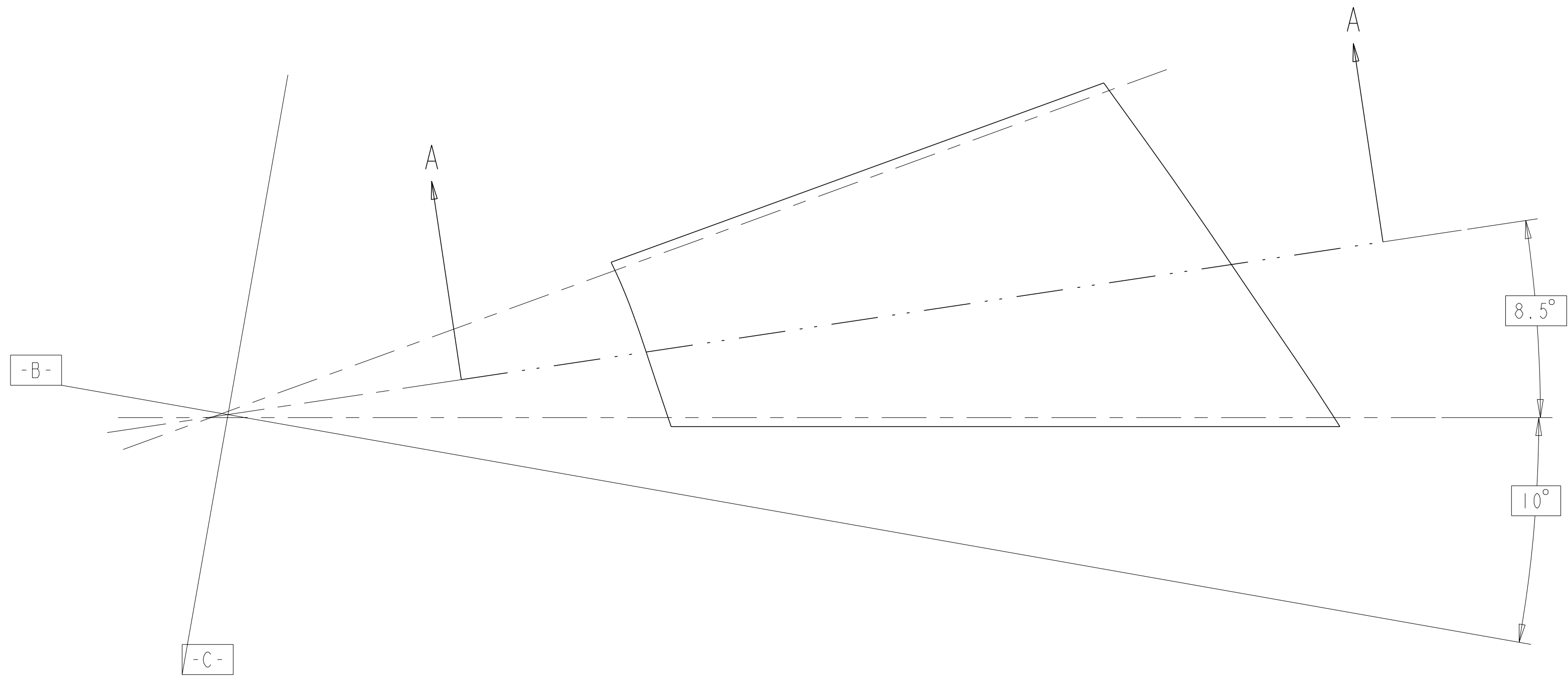


PRELIMINARY

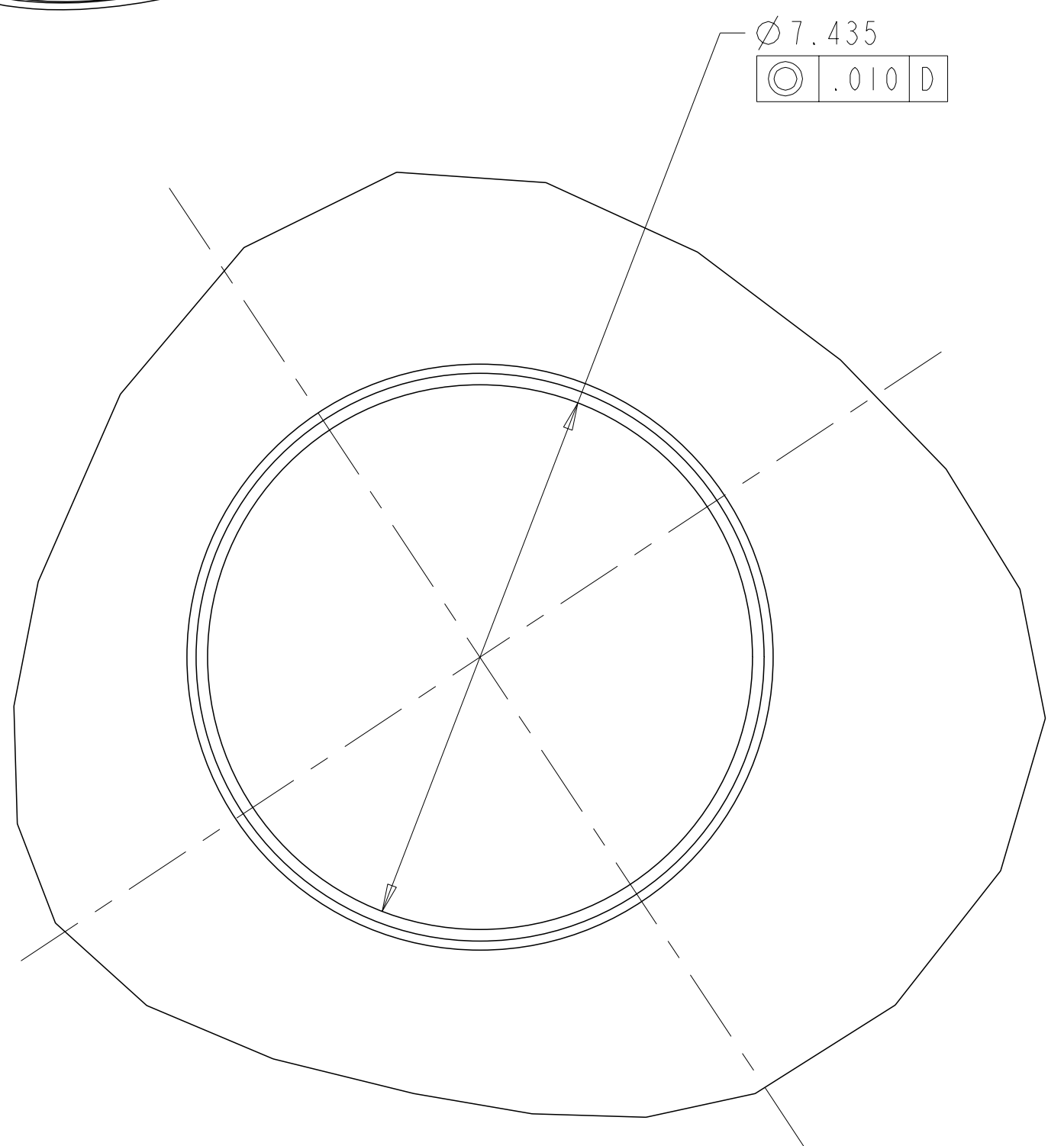
- NOTES:**
1. INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M.
 2. DIMENSION ARE IN INCHES.
 3. REQUIREMENTS FOR FABRICATING THE VACUUM VESSEL PROTOTYPE ARE DEFINED IN THE DRAWINGS, MODELS, AND SPECIFICATION.
 4. GEOMETRY OF VACUUM VESSEL PROTOTYPE IS DEFINED IN CAD MODELS/FILES SE121-001P.ASM, SE121-002P.ASM, AND SE121-003P.ASM.
 5. SURFACE FINISH REQUIREMENTS ARE DEFINED IN SPECIFICATION NCSX-CSPEC-120-01-00 SECTION 3.2.1.2.
 6. MATERIAL REQUIREMENTS ARE DEFINED IN SPECIFICATION NCSX-CSPEC-120-01-00 SECTION 3.3.2.1
 7. CLEANING REQUIREMENTS ARE DEFINED IN SPECIFICATION NCSX-CSPEC-120-01-00 SECTION 3.3.2.4



ISOMETRIC VIEW



SECTION A-A



VIEW B-B
SCALE 0.50

SCALE: .125

AR	CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
1	-1	-2	PORT AND RIB WELDMENT			2
			PORT MODIFICATION DETAILS			1
			PARTS LIST			

QUALITY VERIFICATION
MECHANICAL AND STRUCTURAL
REFERENCE ORNL QA-605

QV CLAUSE	DOCUMENTS REQUIRED	APPLICABLE TO PART NO *
303	MATERIAL MILL TEST REPORT	
325	MATERIAL SELLER CERT	X
326	SPECIAL MATERIAL INSPECTION REPORT	
205	MANUFACTURING INSPECTION AND TEST PLAN	
312	FIELD INSPECTION AND TEST PLAN	
321	WELD AND BRAZE INSPECTION REPORT	
322	HEAT TREAT REPORT (MCHMT)	
310	LEAK TEST REPORT	
315	CLEANING CERT	X
318	DEVIATION REQUEST	X
319	NONCONFORMANCE REPORT	X
323	DIMENSIONAL REPORT	X
330	FUNCTIONAL TEST REPORT	

100 DOCUMENTATION X
 * SYMBOL X INDICATES APPLICABLE TO ALL PARTS OR ITEMS

PRELIMINARY

SCALE NOTED

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

DES: P.L.GORANSON 11/26/02
 DRW: G.H.JONES 11/26/02

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NATIONAL COMPACT STELLERATOR EXPERIMENT
 PROTOTYPE VACUUM VESSEL SEGMENT
 PORT MODIFICATIONS
 DETAILS

VERSION NO. PLANT BLDG FL SHT OF TYPE CLASS
 *** Y-12 9201-2 2 1 1 A U
 RELEASE LEVEL
 *** SE121-002P REV 0

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P THIS DRAWING PRODUCED ON PRO-ENGINEER

REV	DESCRIPTION	A-E	BY	CHK	SECT	DEPT	DATE	PE	REQ. DATE	ORNL DATE	DOE DATE	QA	CV	EC	EE	EM	IE	M	PD	SE	ST	XAD	PES

DRAWING APPROVALS DATE