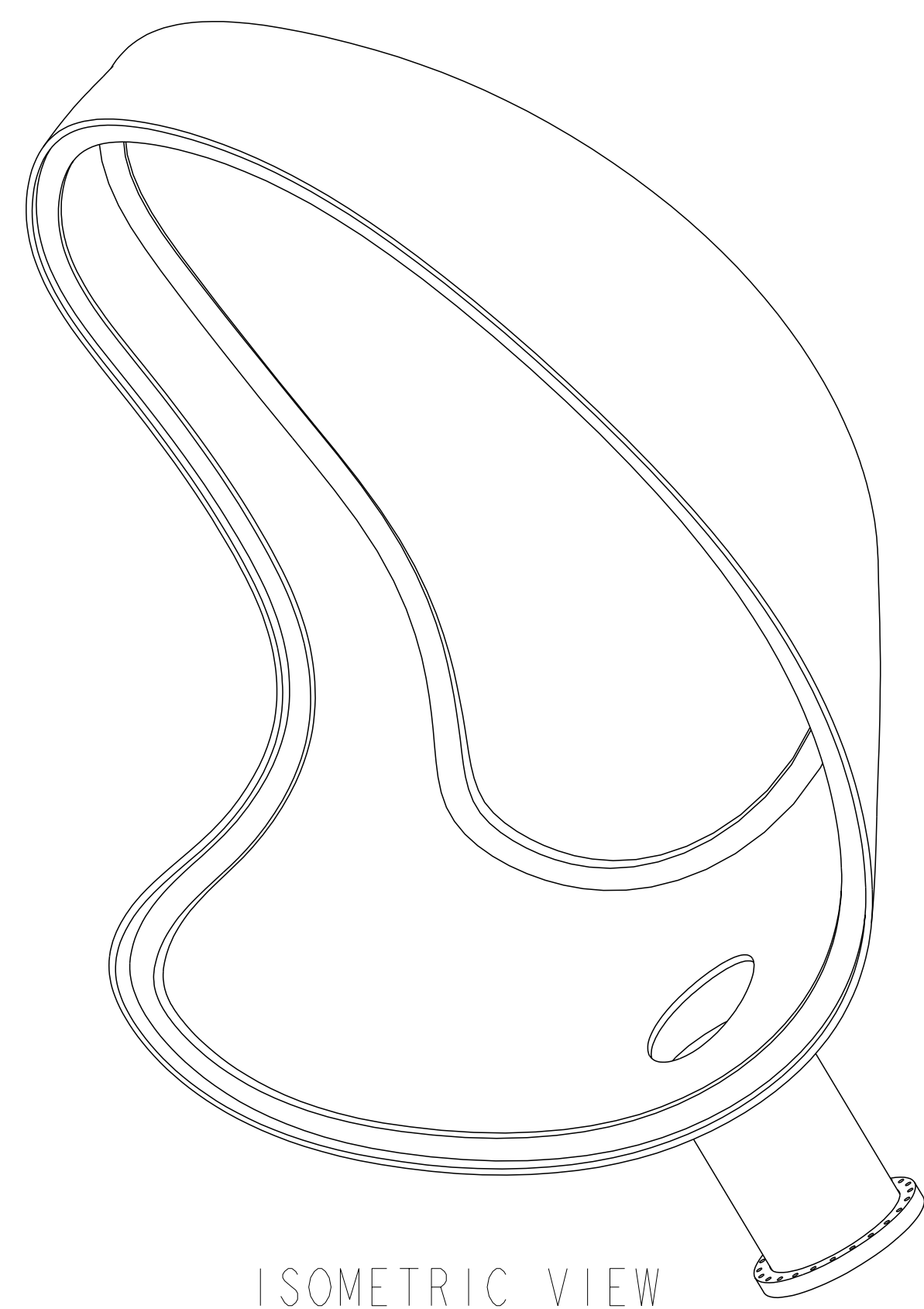
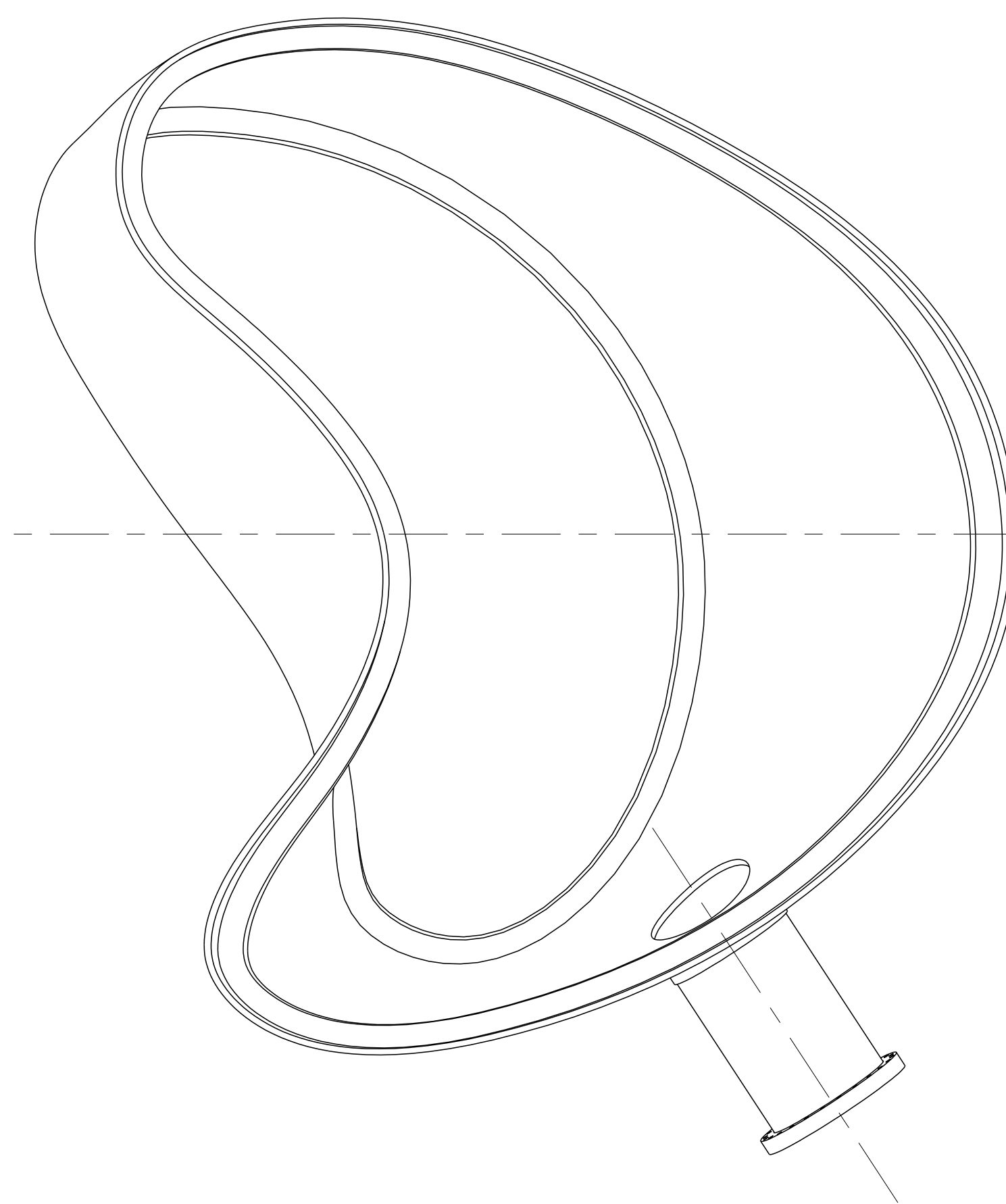
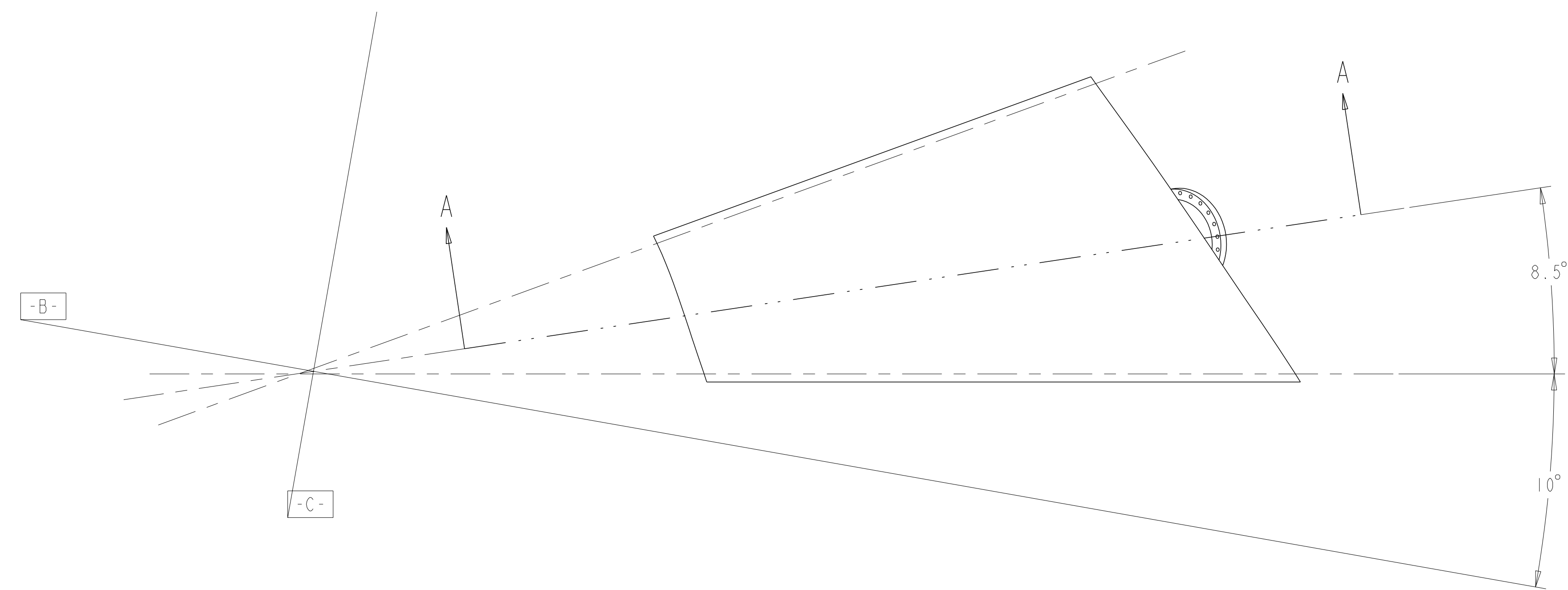


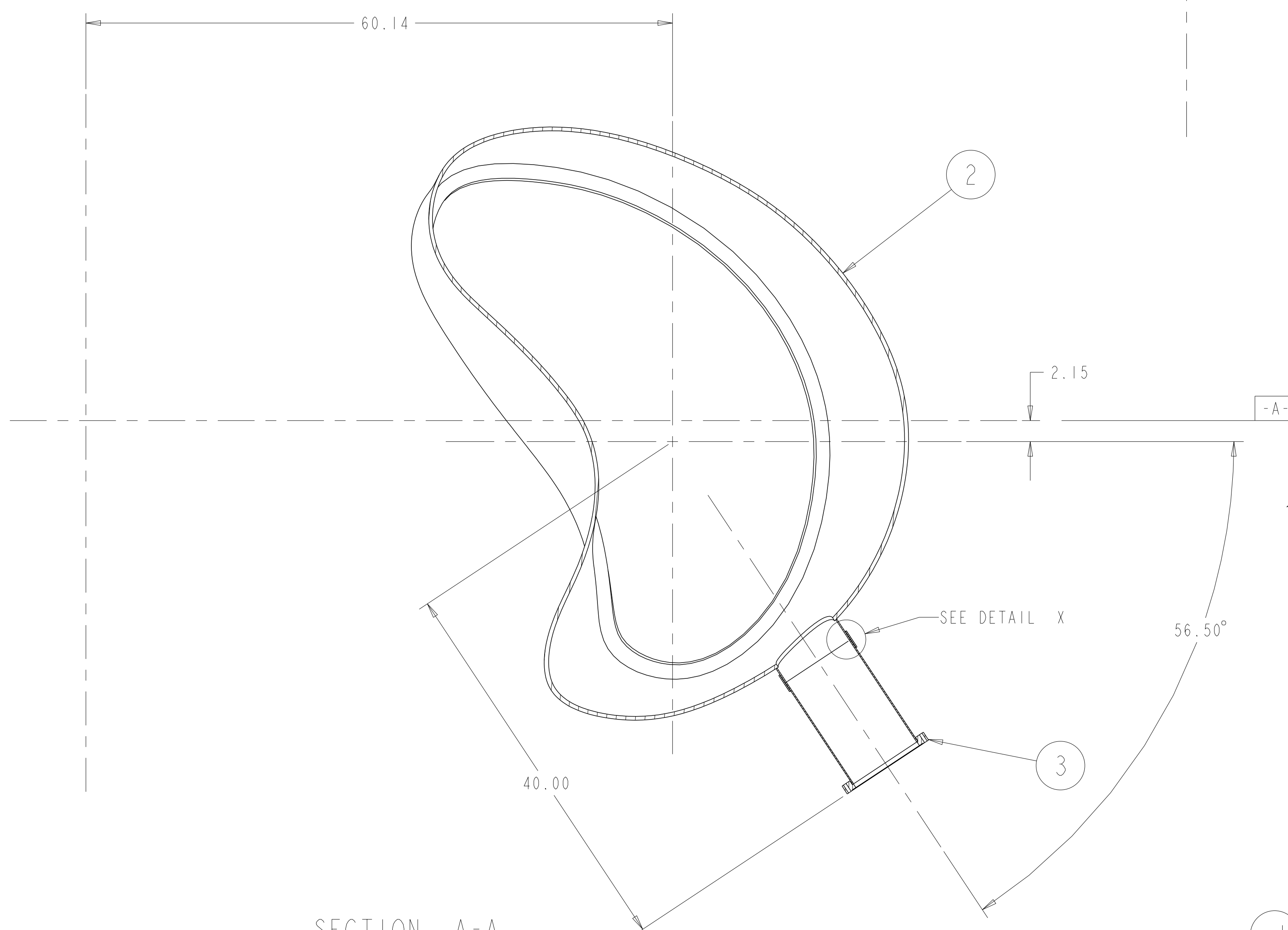
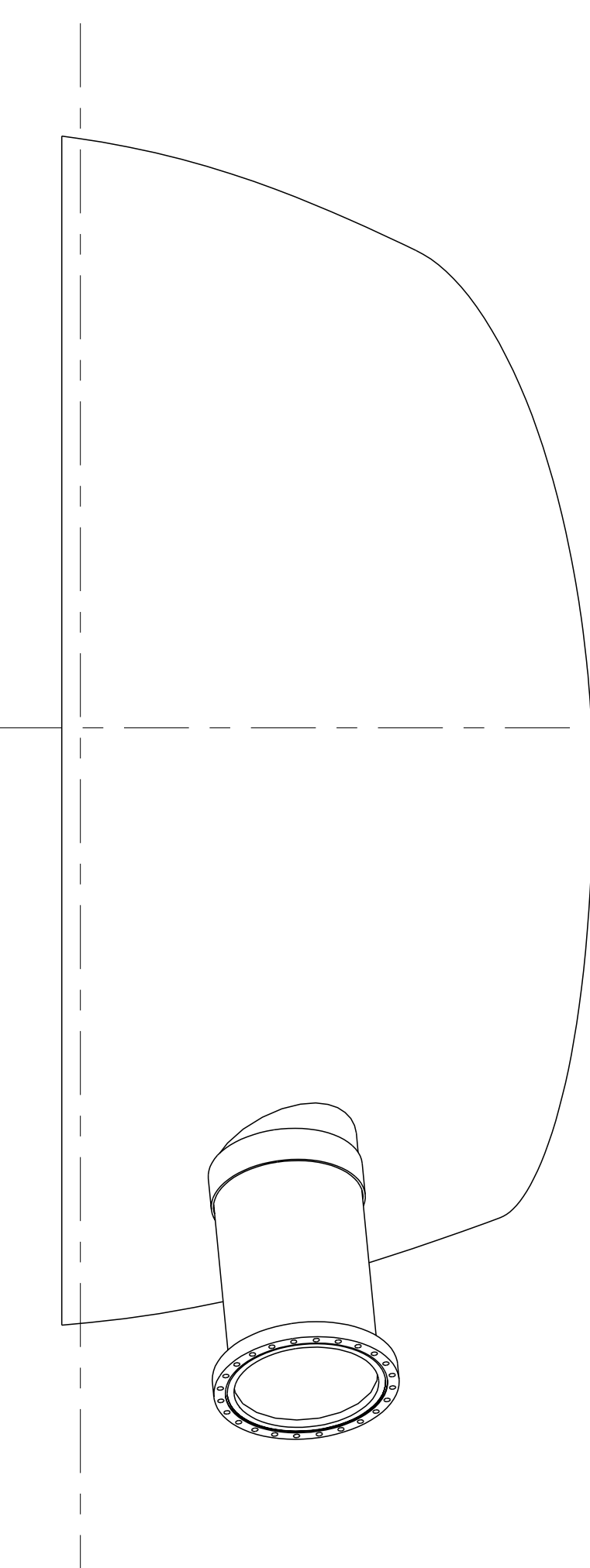
PRELIMINARY



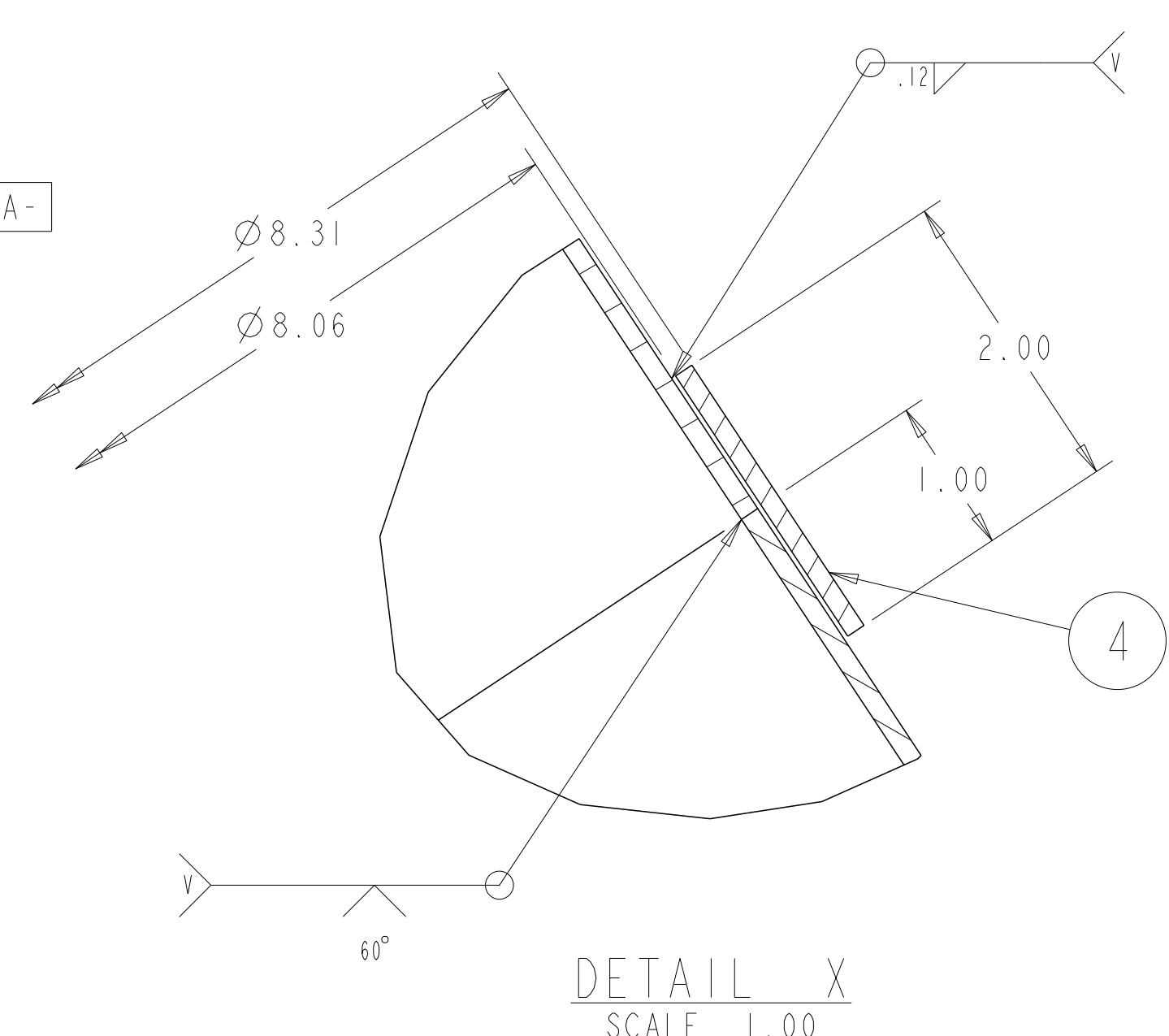
ISOMETRIC VIEW



- 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
- 8 ITEMS -5 AND -6 FROM DRAWING SE121-001P.



SECTION A-A



DETAIL X SCALE: 1.00

SCALE: .125

CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
-5		WELD FILLER METAL			5
-4		WELD BACKING RING	INCONEL 625		4
-3		PORT EXTENSION			3
-2		PORT MODIFICATION DETAILS			2
-1		PORT MODIFICATION WELDMENT			1

← NEXT ASSEMBLY

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		
326	SPECIAL MATERIAL INSPECTION REPORT		
305	MANUFACTURING, INSPECTION, AND TEST PLAN		
312	FIELD INSPECTION AND TEST PLAN		
321	WELD AND BRAZE INSPECTION REPORT		
322	HEAT TREAT REPORT (WHEN APPLICABLE)		
310	LEAK TEST REPORT	X	
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

DES	P.L. GORANSON	11/26/02	DATE	
DRW	G.H. JONES	11/26/02		
CHK				
SECT				
DEPT				
PE				
CR				
PJ				
REQ				

SCALE NOTED: TOLERANCES UNLESS OTHERWISE SPECIFIED

FRACTIONS: .125 UNLESS OTHERWISE SPECIFIED

XX DECIMALS ± .01

XXX DECIMALS ± .005

ANGLES ± 0°15'

BREAK SHARP EDGES .06 MAX

FINISH: .125 UNLESS OTHERWISE SPECIFIED

UT-BATTELLE  
NATIONAL COMPACT STELLERATOR EXPERIMENT  
PROTOTYPE VACUUM VESSEL SUPPORT PORT MODIFICATIONS WELDMENT

VERSION NO. Y-12  
PLANT 9201-2  
BLDG 2  
FL 1  
SHT 1  
TYPE A  
CLASS U  
REV 0

RELEASE LEVEL \*\*\*  
DRAWING APPROVALS DATE  
SE121-003P

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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	DOC DATE	QA	CV	EC	EE	EM	IE	M	PD	SE	ST	XAD	PES

SE121-003P

A