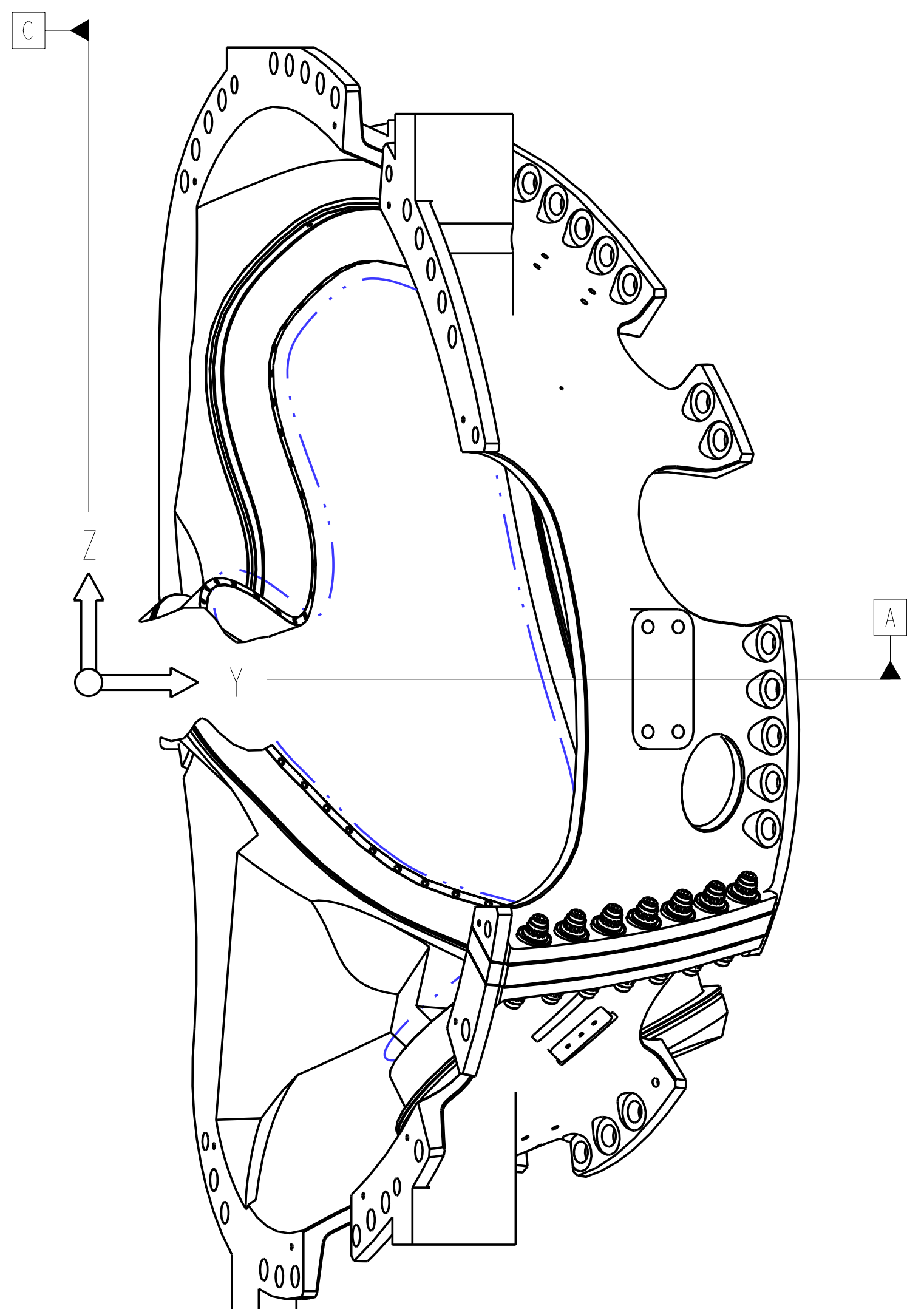
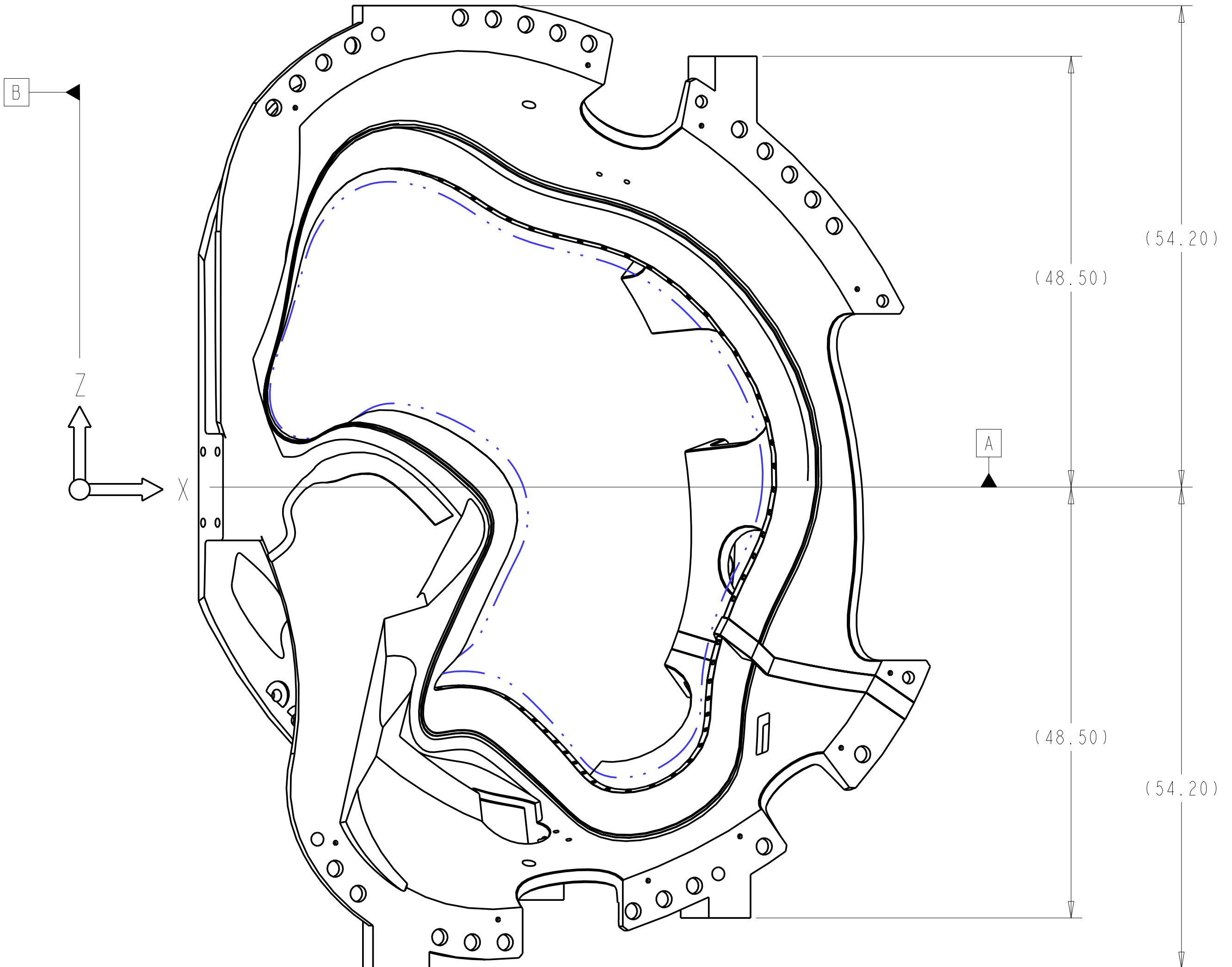


- NOTES:
- DRAWING PREPARED IN ACCORDANCE WITH ASME Y14.8M-1996
  - INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M-1994
  - DIMENSIONS ARE IN INCHES
  - DRAWING DEPICTS FINAL MACHINED STATE OF PART DEFINED BY PRO/ENGINEER FILE SE141-102.ASM
  - UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE RELATED 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



SCALE 0.10

REV	DESCRIPTION	BY	DATE	CHK	DEPT	DATE	PE	REQ	DATE	ORNL	DOE	DATE	
14	SE141-079												
14	SE141-060												
14	SE141-038												
7	SE141-036												
14	-5	MCWF INSULATING SLEEVE TYPE-B	G11CR	NEMA LI 1 - 1998									
2	-4	INSULATING SHEET TYPE-B	G11CR	--									
1	SE141-058	POL BREAK SHIM ASSEMBLY TYPE-B											
1	SE141-115	PRODUCTION WINDING FORM TYPE-B											
AR	X	-1	MOD COIL WINDING FORM ASSEMBLY TYPE-B										
SE141-102	CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO							
		← NEXT ASSEMBLY	PARTS LIST										

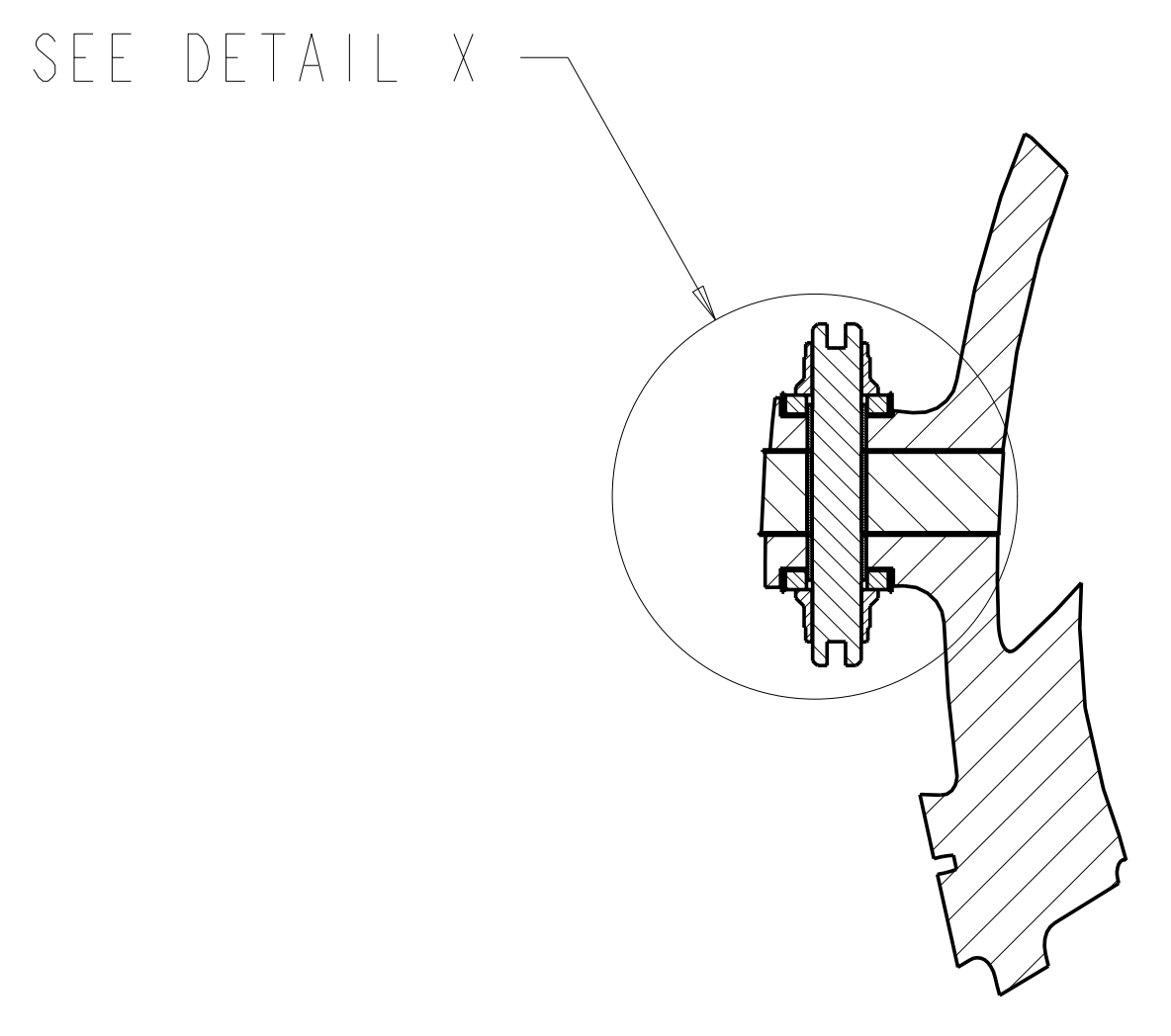
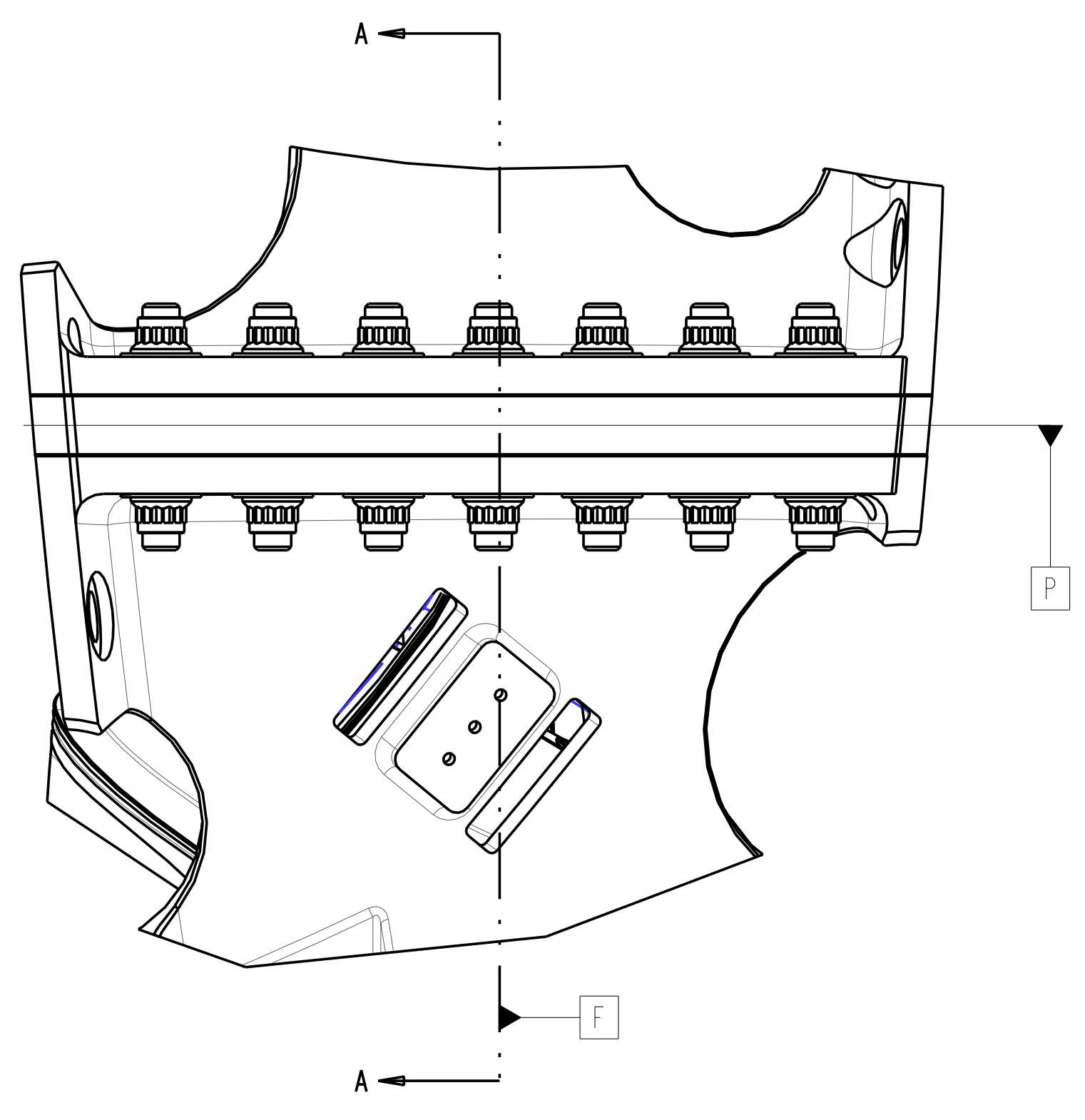
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**P** THIS DRAWING PRODUCED ON PRO-ENGINEER

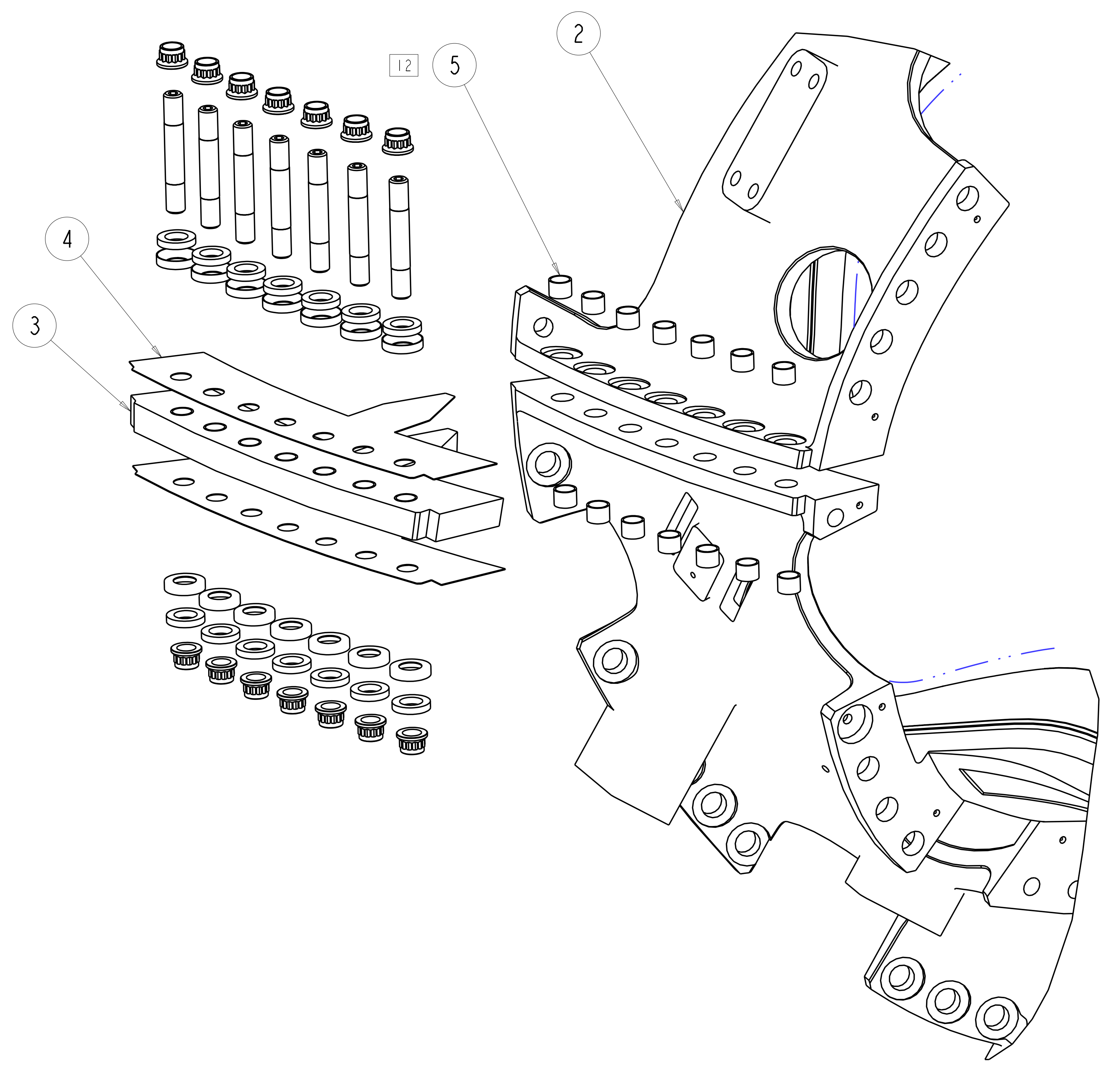
SCALE NOTED	DES T. BROWN 6-30-04	<b>UT-BATTELLE</b> Oak Ridge National Laboratory managed for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT contract DE-AC05-00OR22725 UT-BATTELLE, LLC, Oak Ridge, Tennessee PROJECT NAME <b>NATIONAL COMPACT STELLARATOR EXPERIMENT</b>																		
TOLERANCES UNLESS OTHERWISE SPECIFIED	DRW PAUL MILLER 6-30-04																			
FRACTIONS	CHK M. COLE 6-30-04																			
XX DECIMALS ±.01	PE D. WILLIAMSON 6-30-04																			
XXX DECIMALS ±.005	CR :	<b>MOD COIL WINDING FORM ASSEMBLY TYPE-B</b>																		
ANGLES ±0°15'	PJ :																			
BREAK SHARP EDGES .06 MAX	RED :																			
FINISH .125 UNLESS OTHERWISE SPECIFIED	PPPL DRFT J. STEGEL 6-30-04																			
REV	DESCRIPTION	BY	DATE	CHK	DEPT	DATE	PE	REQ	DATE	ORNL	DOE	DATE	VERSION NO.	PLANT	BLDG	FL	SHT OF	TYPE	CLASS	
	REVISION OR ISSUE PURPOSE												1	X-10	5700	3	1	2	S	U
													RELEASE LEVEL	SEI41-102						REV
													WIP							1

H  
G  
F  
E  
D  
C  
B  
A

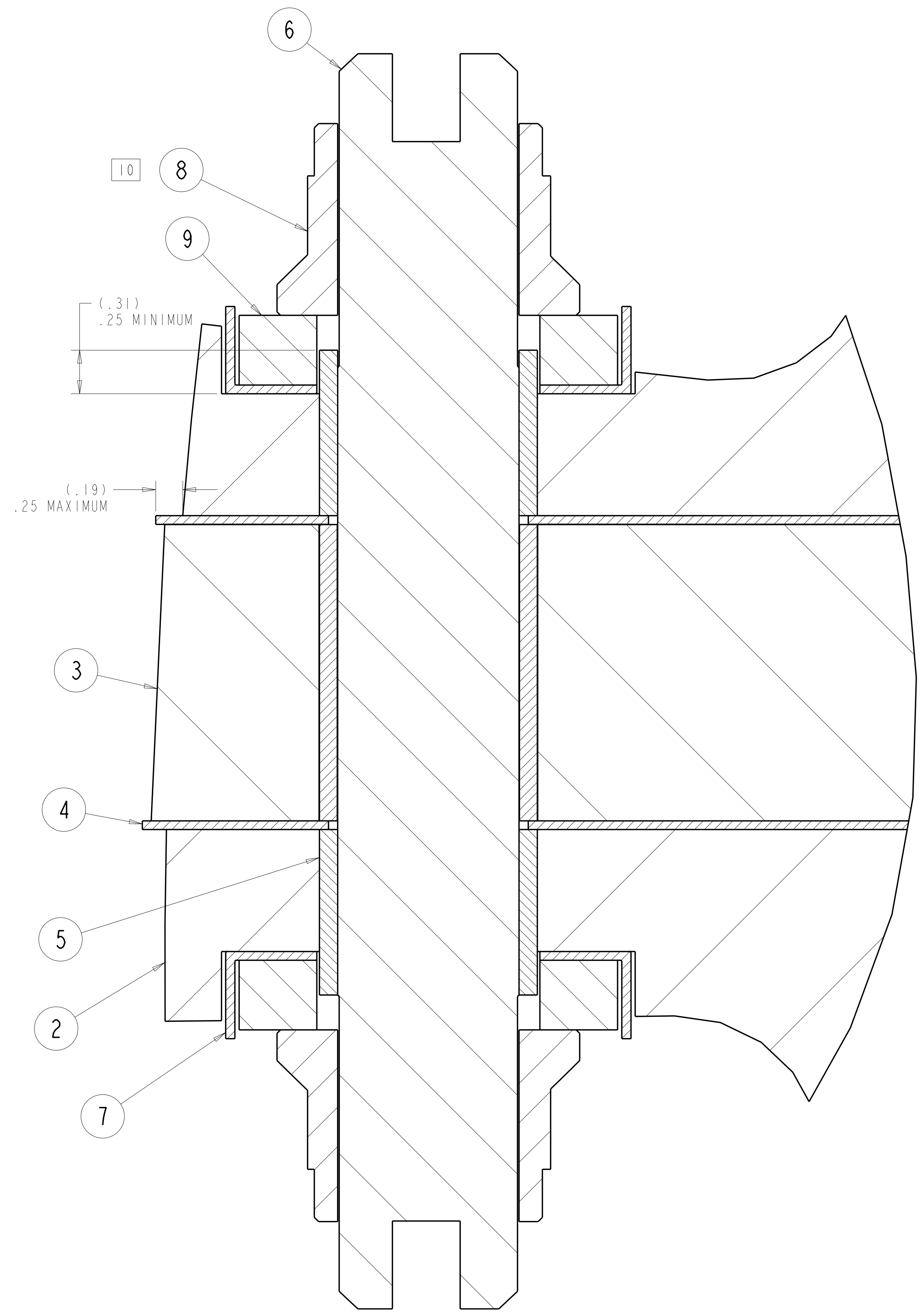
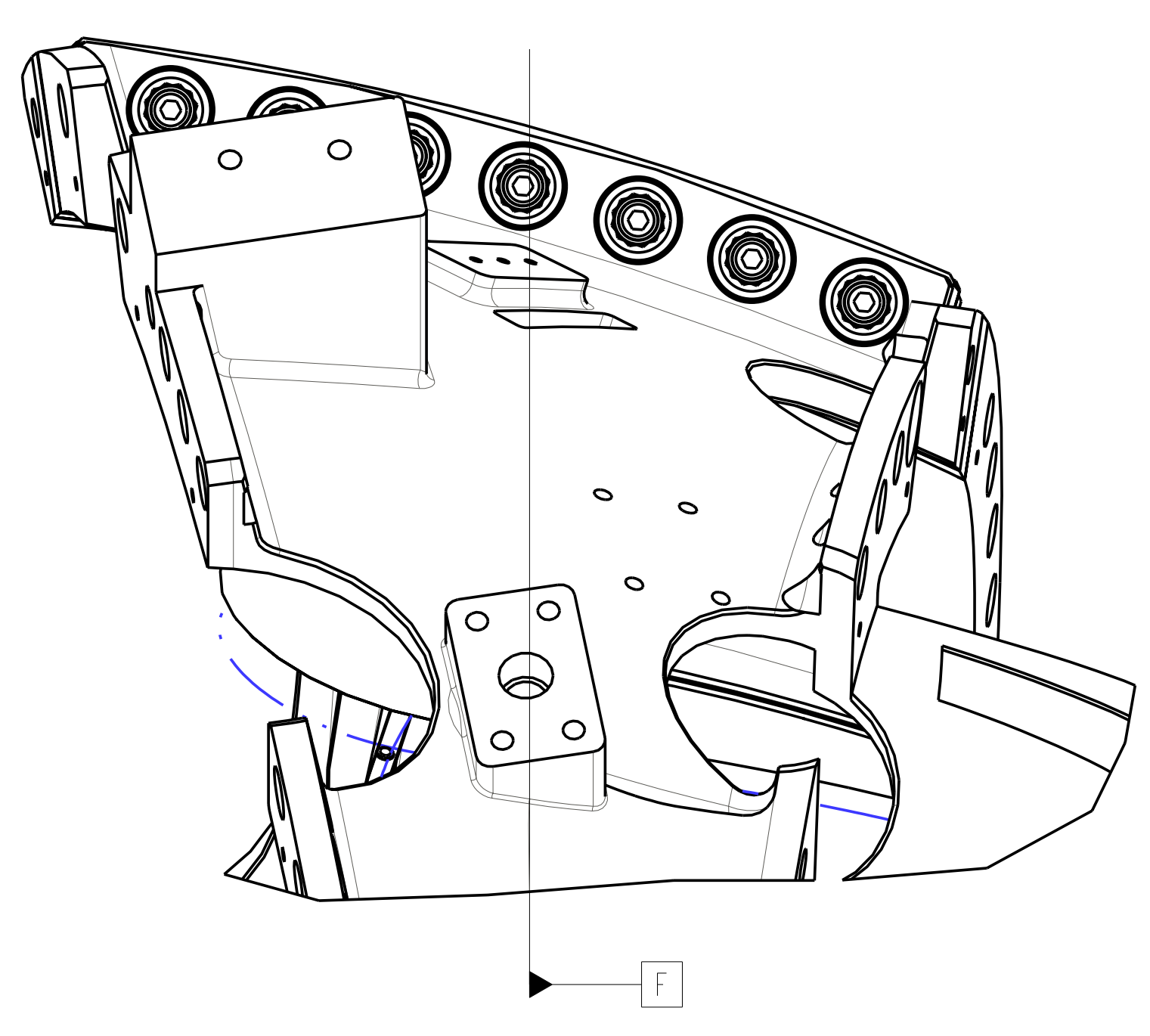
FOR NOTES AND PARTS LIST SEE SHEET I



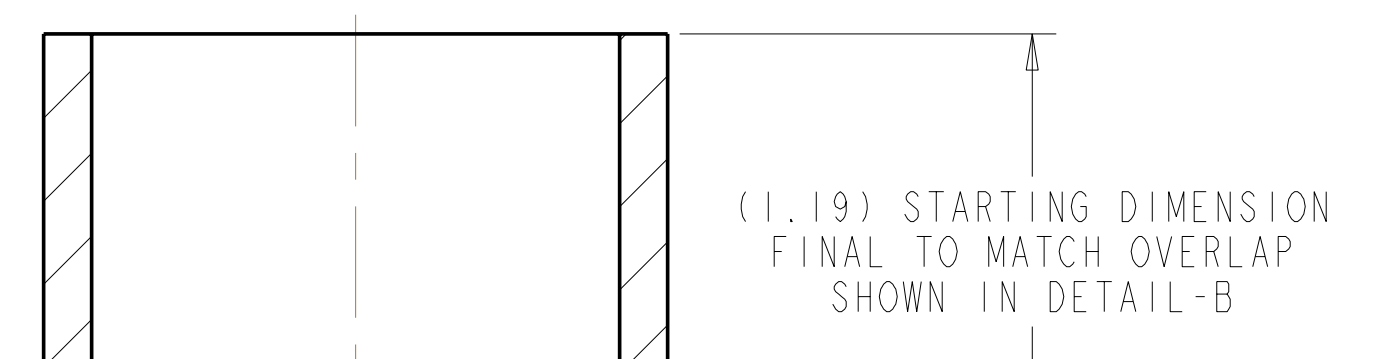
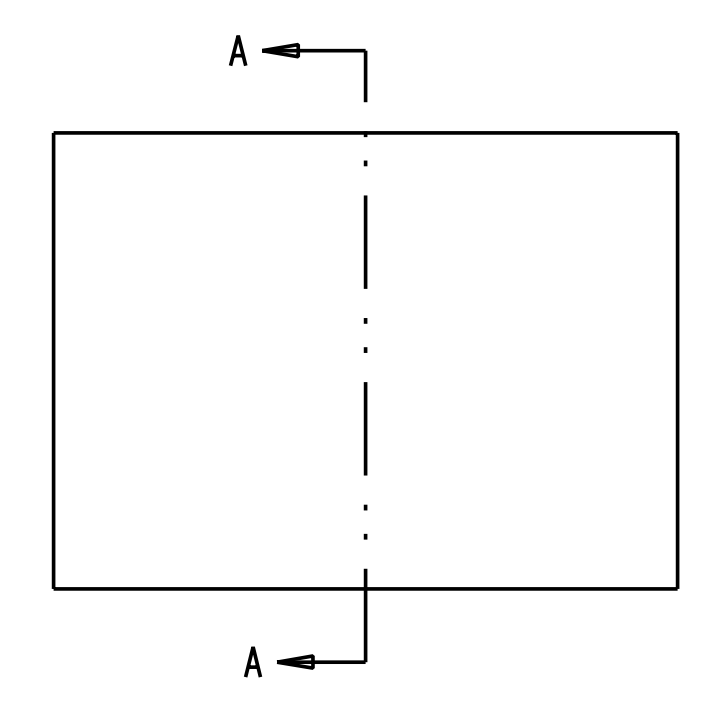
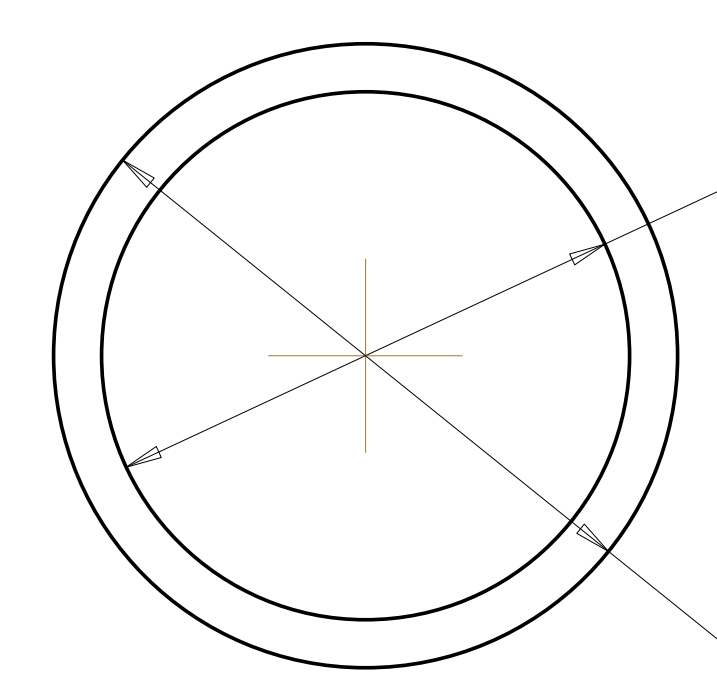
SECTION A-A  
 SCALE 0.20



EXPLODED VIEW  
 SCALE 0.20



DETAIL X  
 SCALE 2.00



SECTION A-A  
 SCALE 2.00

Oak Ridge National Laboratory managed for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT contract DE-AC05-00OR22725 UT-BATTELLE, LLC, Oak Ridge, Tennessee							
<b>UT-BATTELLE</b>							
NATIONAL COMPACT STELLARATOR EXPERIMENT							
MOD COIL WINDING FORM ASSEMBLY TYPE-B							
VERSION NO.	PLANT	BLDG	FL	SHT OF	TYPE	CLASS	
1	X-10	5700	3	2	S	U	
RELEASE LEVEL	SEI41-102						
WIP							

SEI41-102