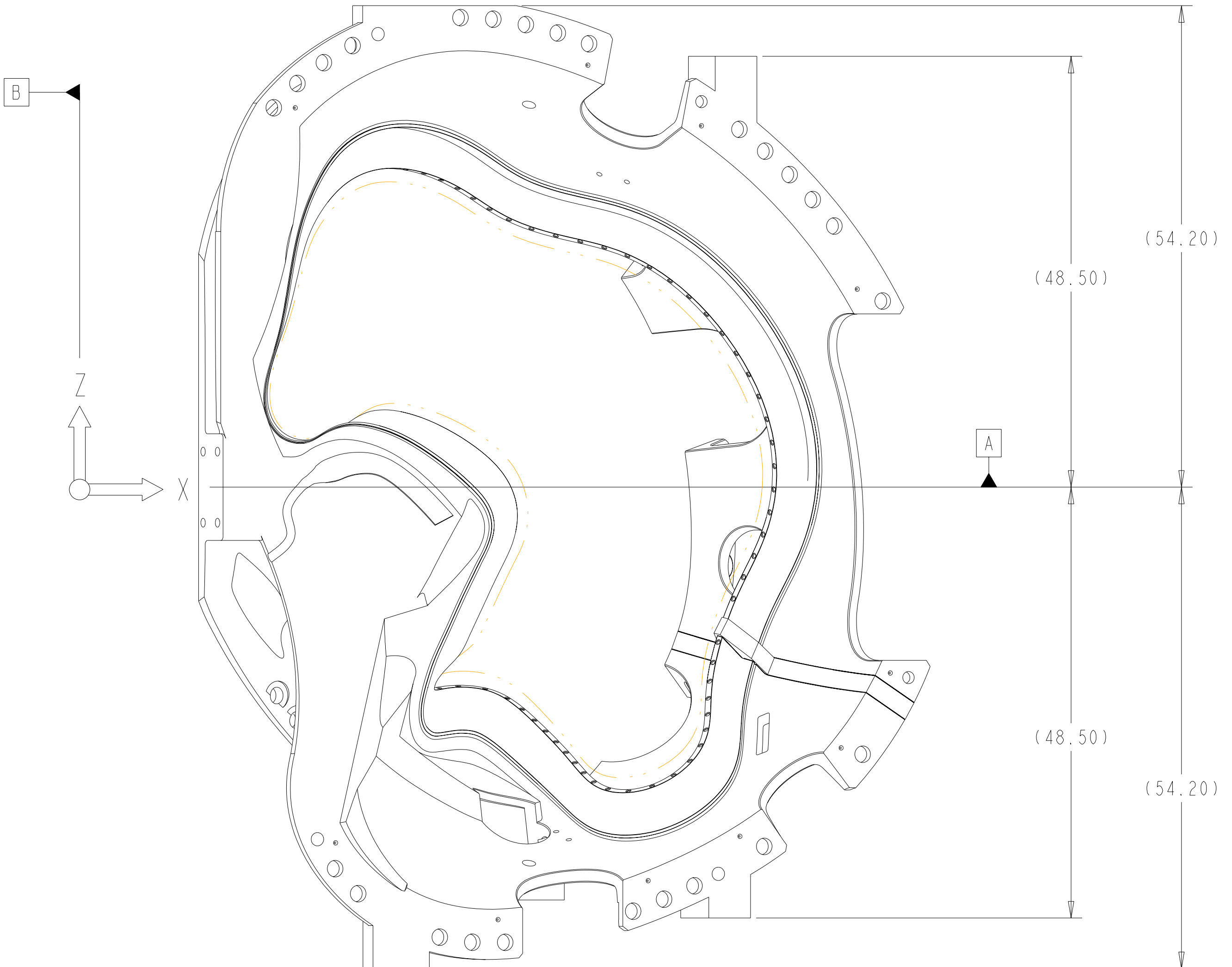
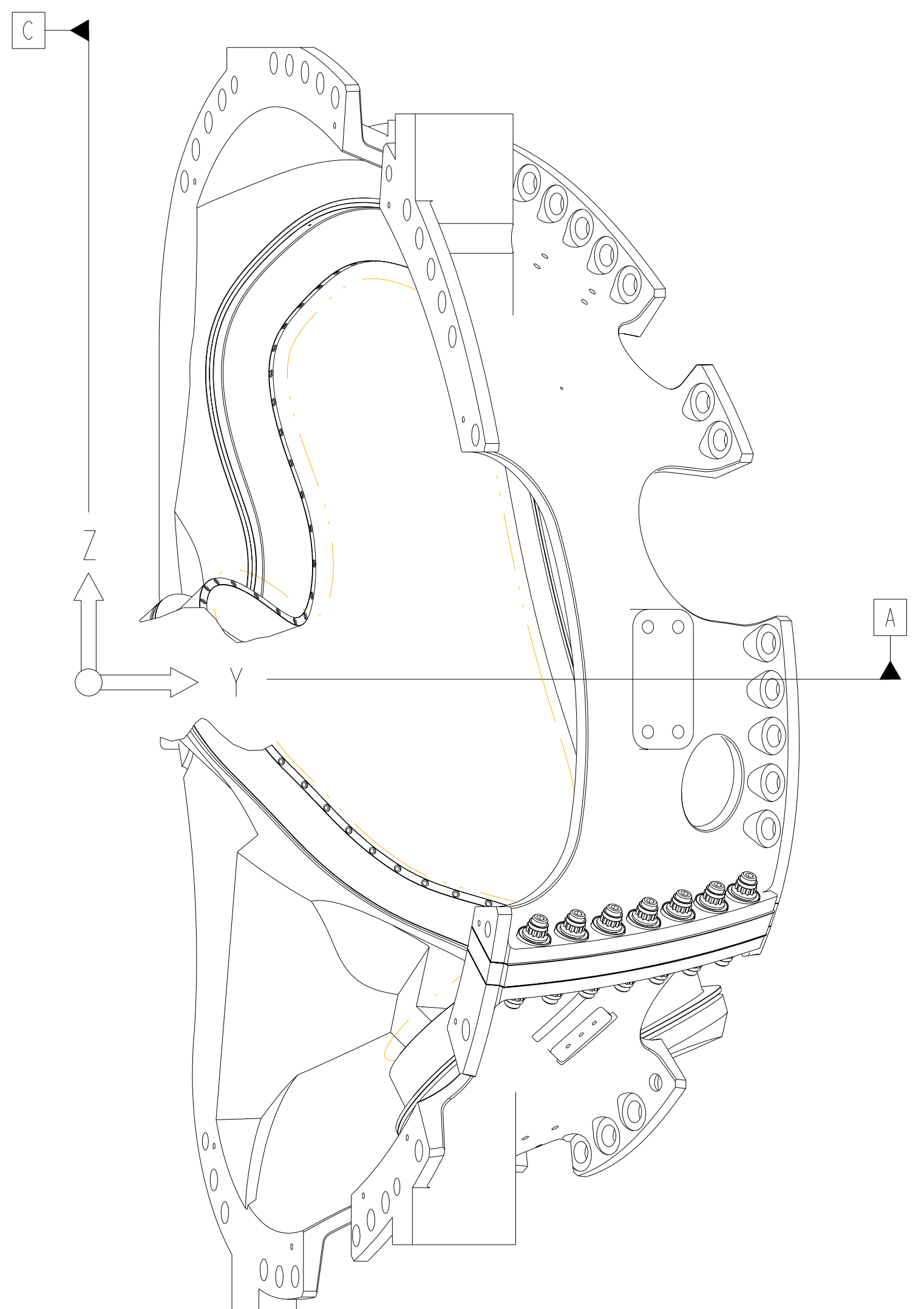


ISOMETRIC VIEW  
 SCALE 0.10

- 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



14	SE141-079	FLAT WASHER	9			
14	SE141-060	NUT, 12PT HEX 1.375-6UNC-2B	8			
14	SE141-038	INSULATING WASHER	7			
7	SE141-036	STUD, 1.375-6UNC-2A X 9 LG	6			
14	-5	MCWF INSULATING SLEEVE TYPE-B G11CR NEMA LI 1 - 1998	5			
2	-4	INSULATING SHEET TYPE-B G11CR	4			
1	SE141-058	POL BREAK SHIM ASSEMBLY TYPE-B	3			
1	SE141-115	PRODUCTION WINDING FORM TYPE-B	2			
AR	X	-1 MOD COIL WINDING FORM ASSEMBLY TYPE-B	1			
SE141-102	CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
			← NEXT ASSEMBLY			

PARTS LIST

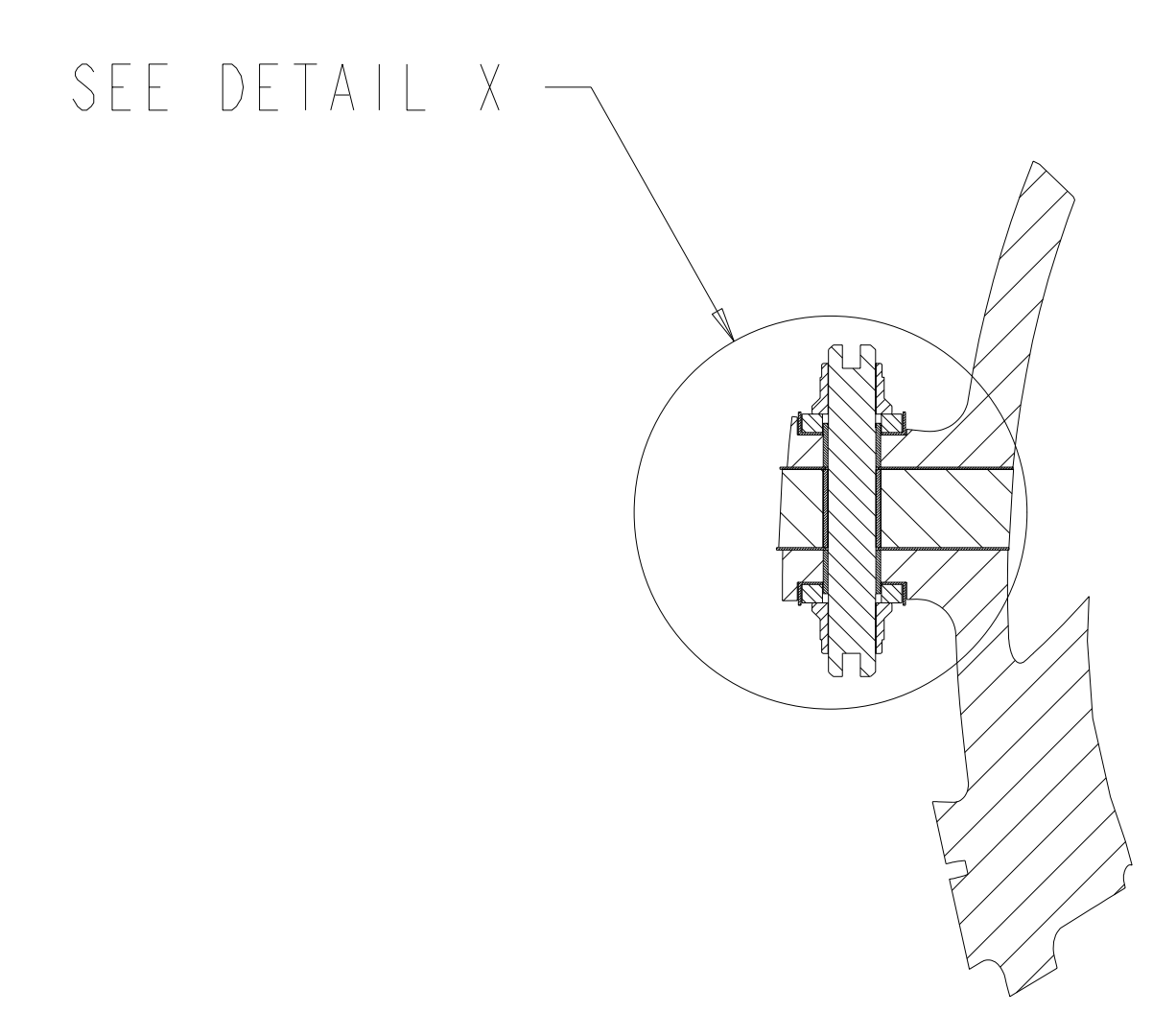
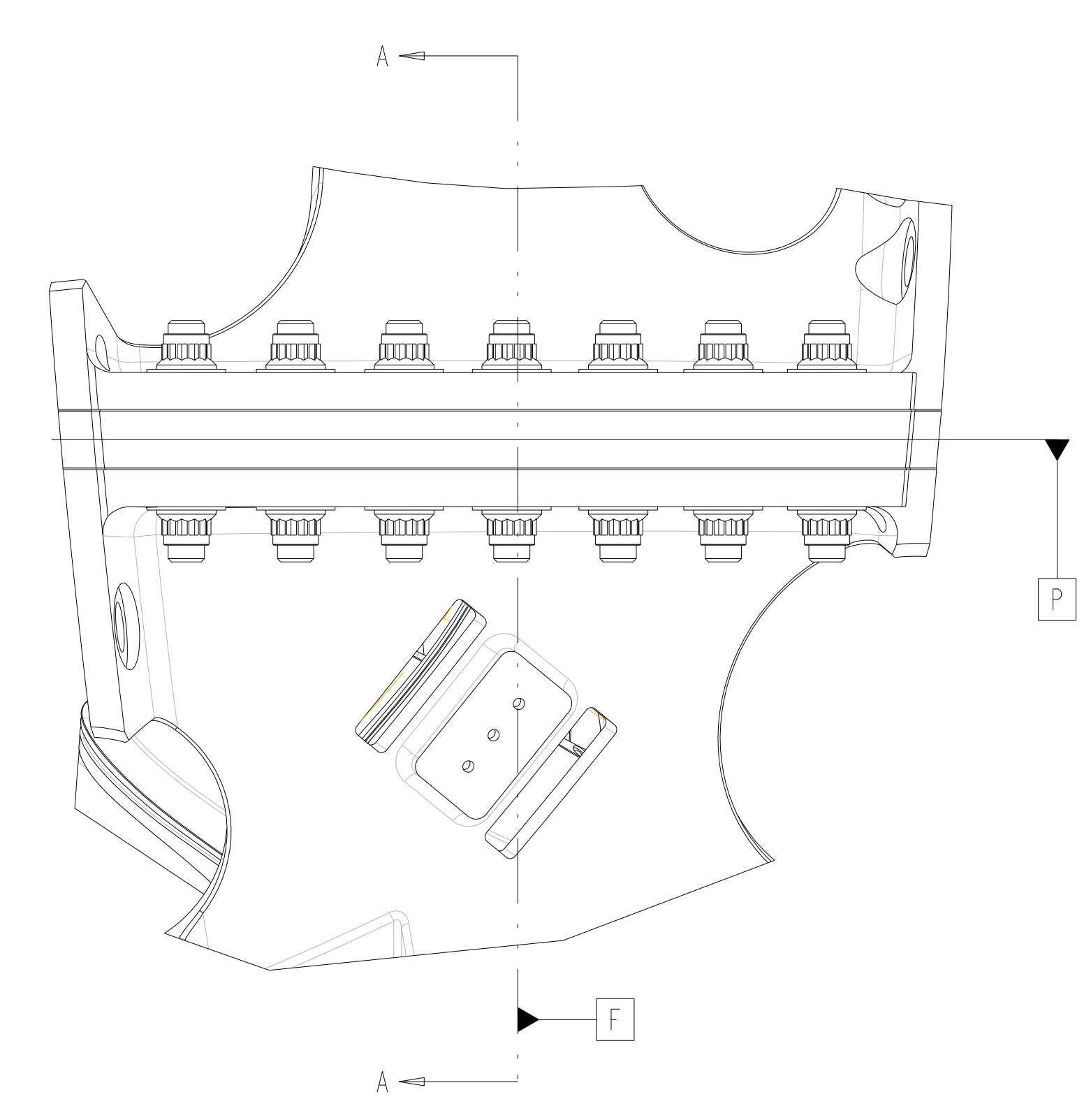
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**P** THIS DRAWING PRODUCED ON PRO-ENGINEER

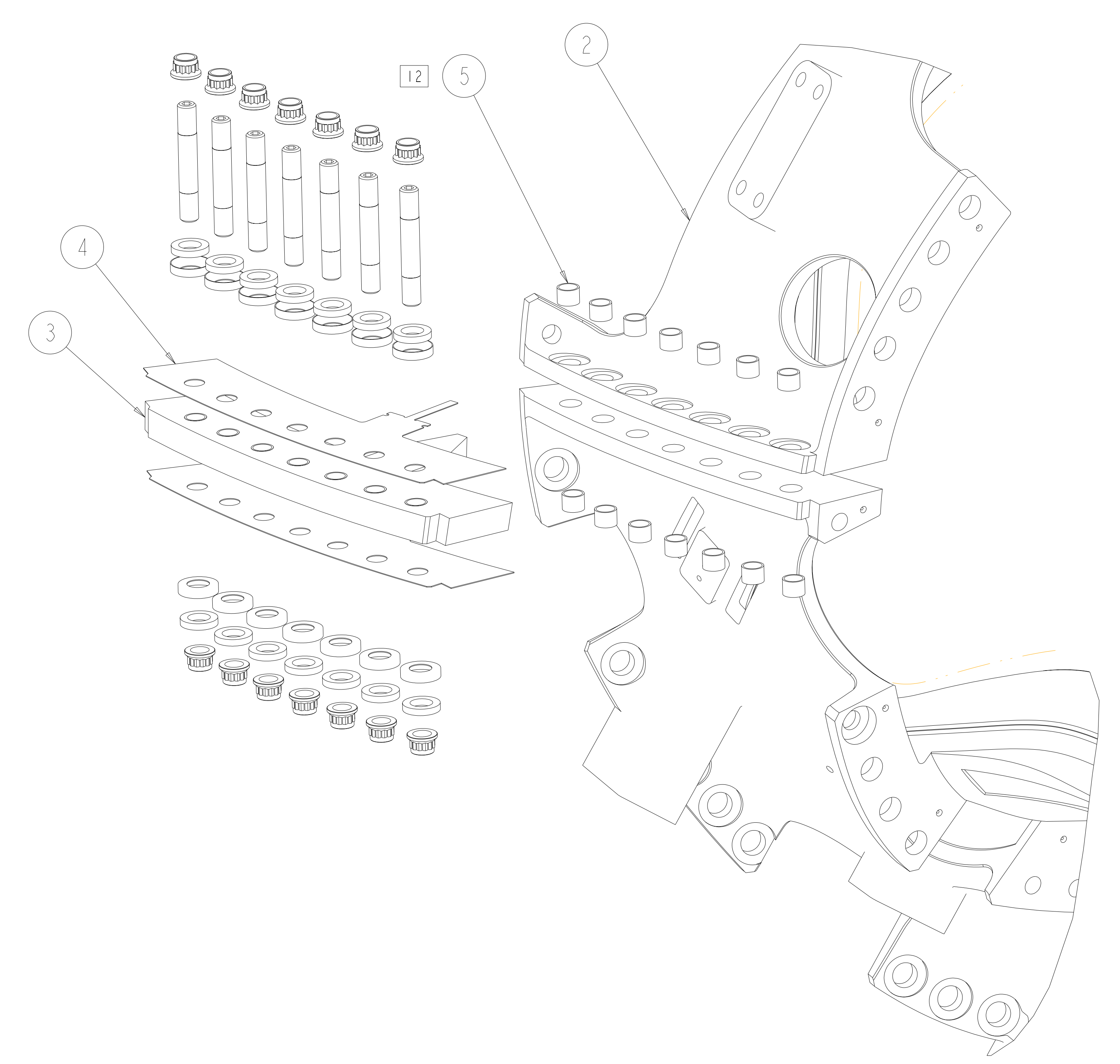
SCALE NOTED		DES. T. BROWN 6-30-04	UT-BATTELLE		Oak Ridge National Laboratory managed for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT contract DE-AC05-00OR22725 UT-BATTELLE, LLC, Oak Ridge, Tennessee	
TOLERANCES UNLESS OTHERWISE SPECIFIED		DRW. PAUL MILLER 6-30-04	NATIONAL COMPACT STELLARATOR EXPERIMENT		PROJECT NAME	
FRACTIONS : DEPT :		CHK. M. COLE 6-30-04	MOD COIL WINDING FORM ASSEMBLY TYPE-B		RELEASE LEVEL	
XX DECIMALS ± .01		PE. D. WILLIAMSON 6-30-04	PPPL DRFT J. STEGEL 6-30-04		Fabrication	
XXX DECIMALS ± .005		CR :	VERSION NO. 2		PLANT X-10	BLDG 5700
ANGLES ± 0°15'		PJ :	FL 3		SHT OF 1	TYPE 2
BREAK SHARP EDGES .06 MAX		REQ :	REV U		CLASS	
FINISH :25 UNLESS OTHERWISE SPECIFIED		DATE	DATE		DATE	
REV 1		DESCRIPTION	REVISION OR ISSUE PURPOSE		REVISION APPROVAL	
BY	DATE	CHK	DEPT	DATE	PE	REQ
DW	9/04	MJC			DEW	

H  
G  
F  
E  
D  
C  
B  
A

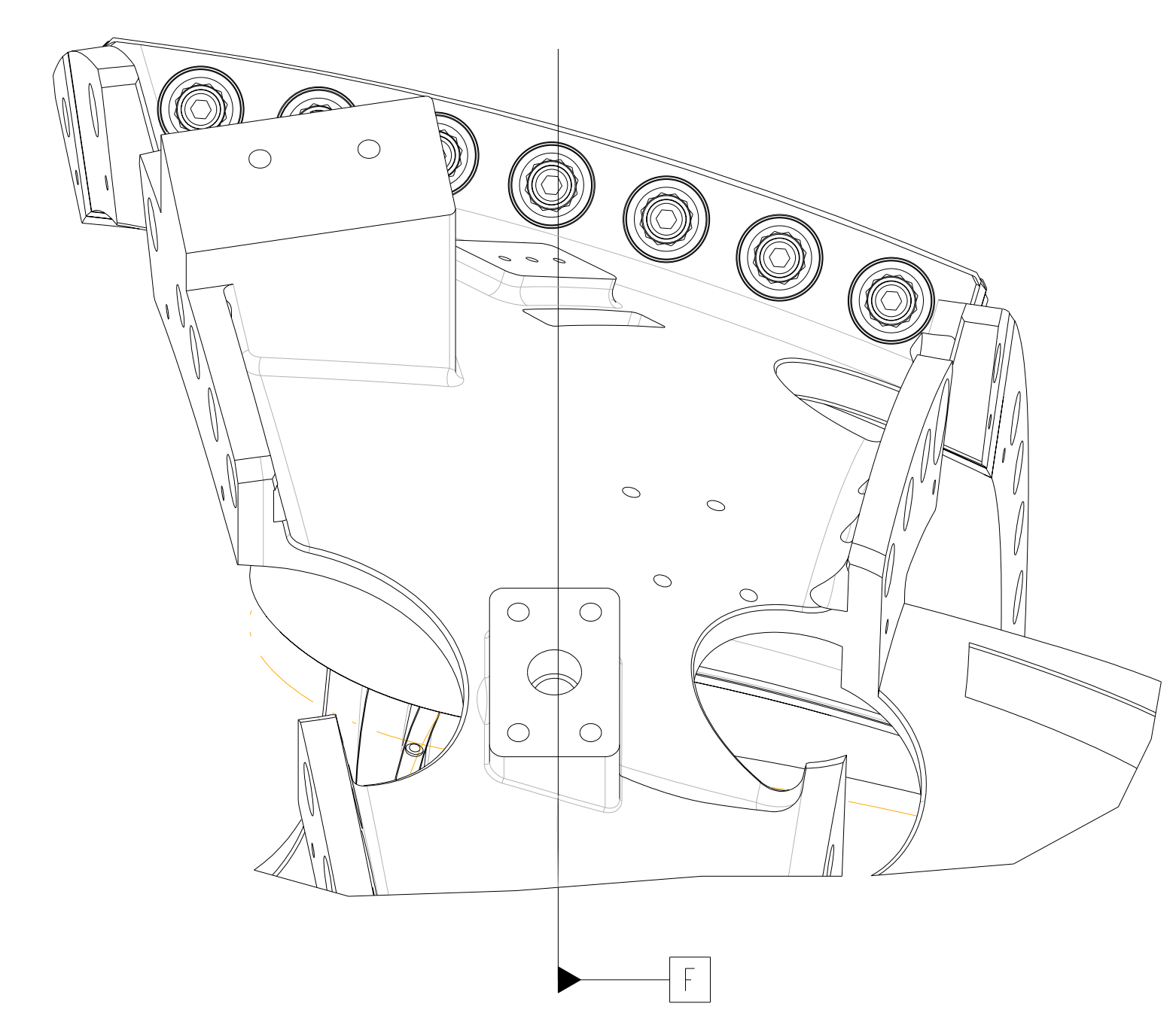
FOR NOTES AND PARTS LIST SEE SHEET 1



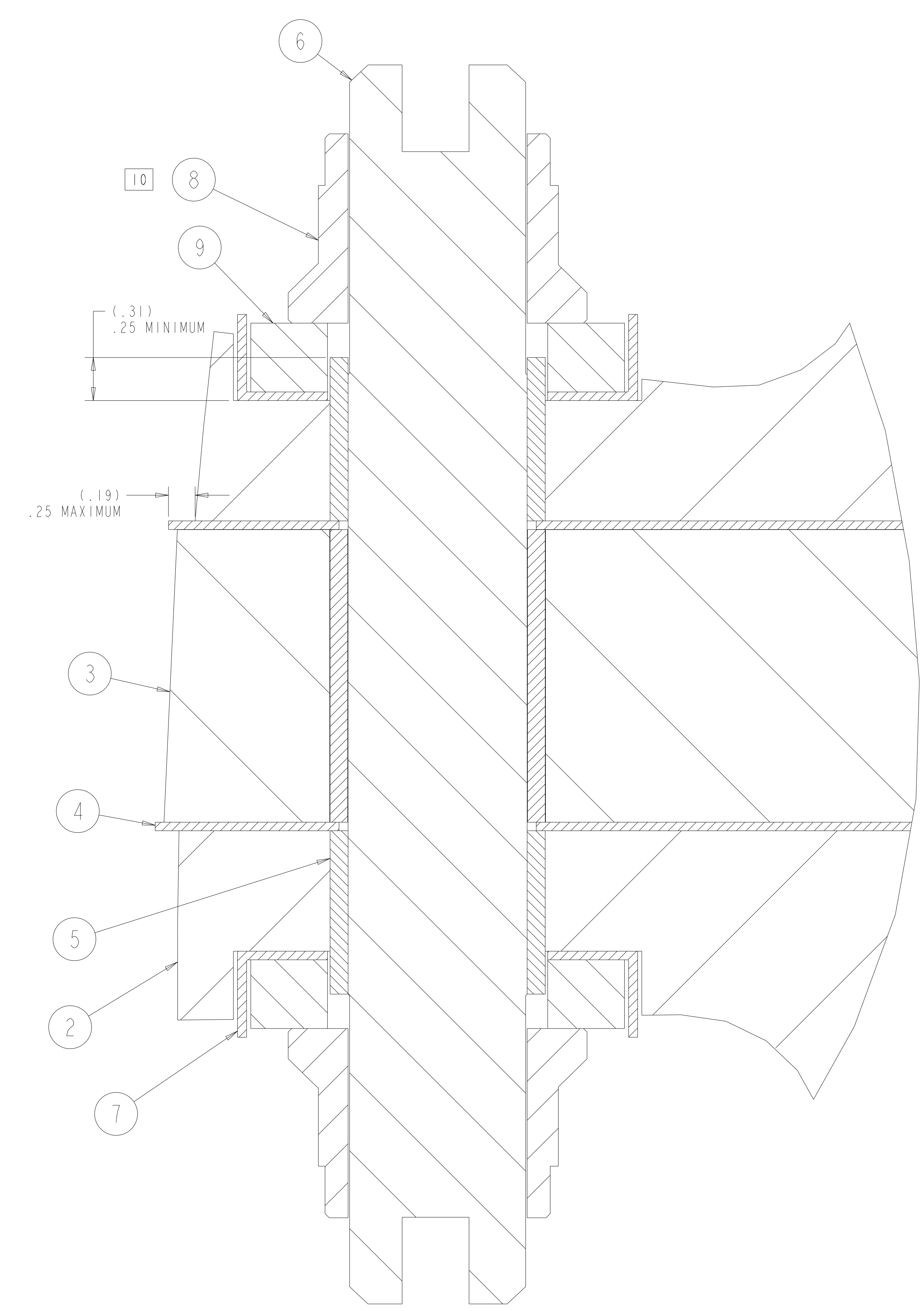
SECTION A-A  
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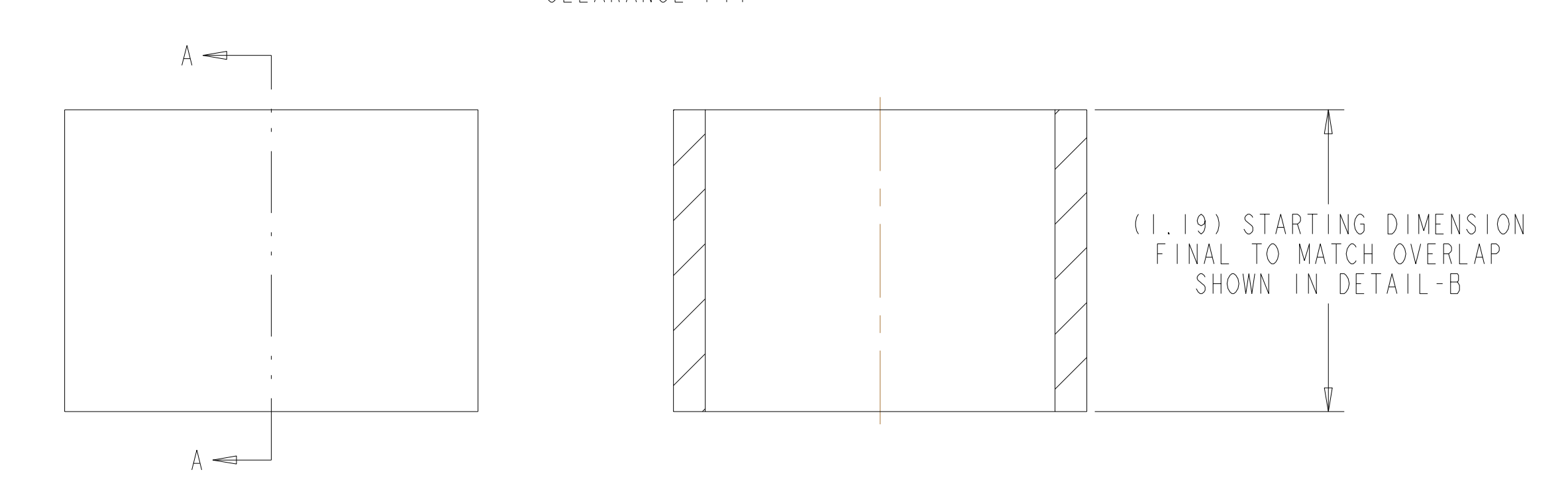
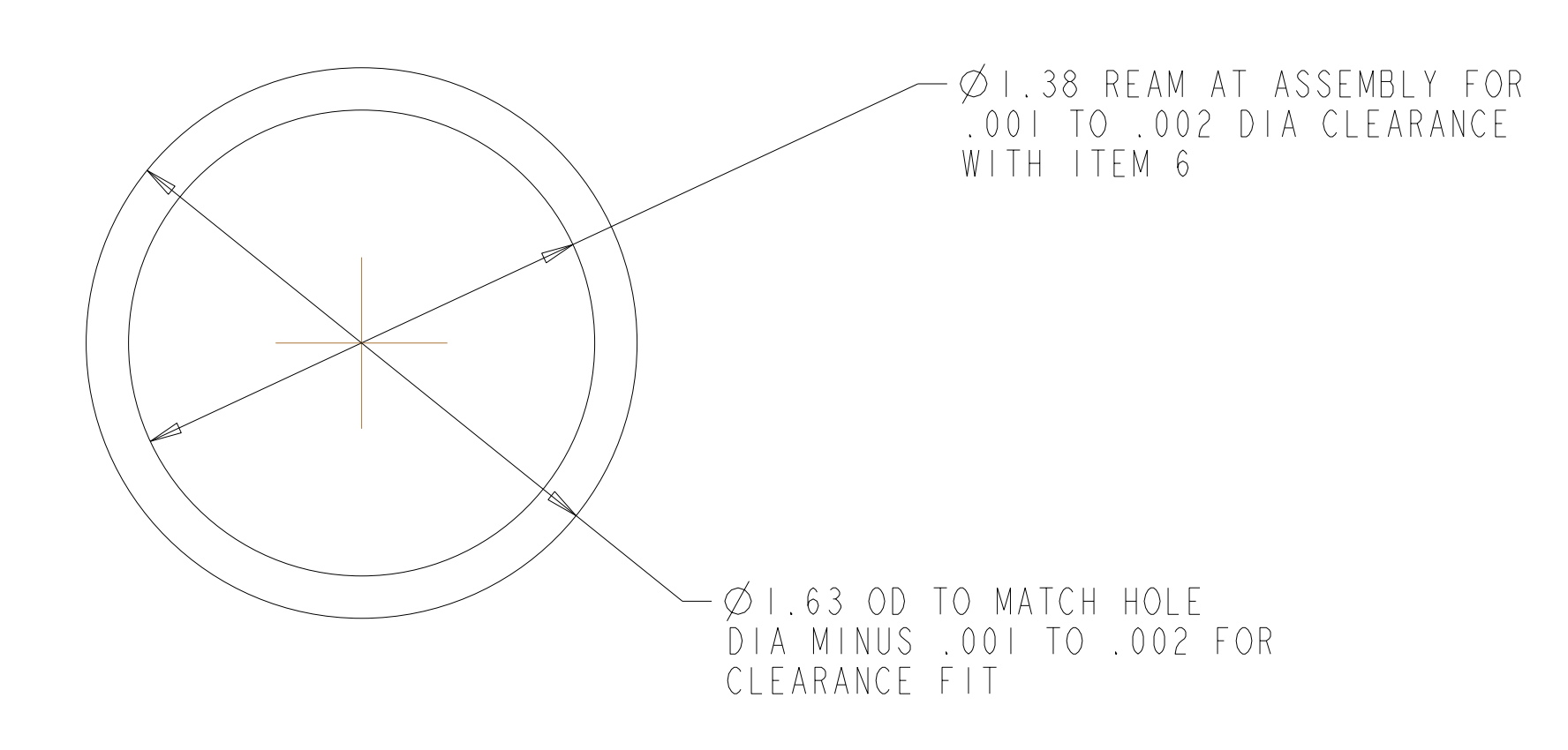
1 EXPLODED VIEW  
 SCALE 0.20



POLOIDAL BREAK DETAIL



DETAIL X  
 SCALE 2.00



5 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 PROJECT NAME						
NATIONAL COMPACT STELLARATOR EXPERIMENT						
MOD COIL WINDING FORM ASSEMBLY TYPE-B						
VERSION NO.	PLANT	BLDG	FL	SHT OF	TYPE	CLASS
2	X-10	5700	3	2	S	U
RELEASE LEVEL	SEI41-102					
Fabrication						

H  
G  
F  
E  
D  
C  
B  
A

SEI41-102