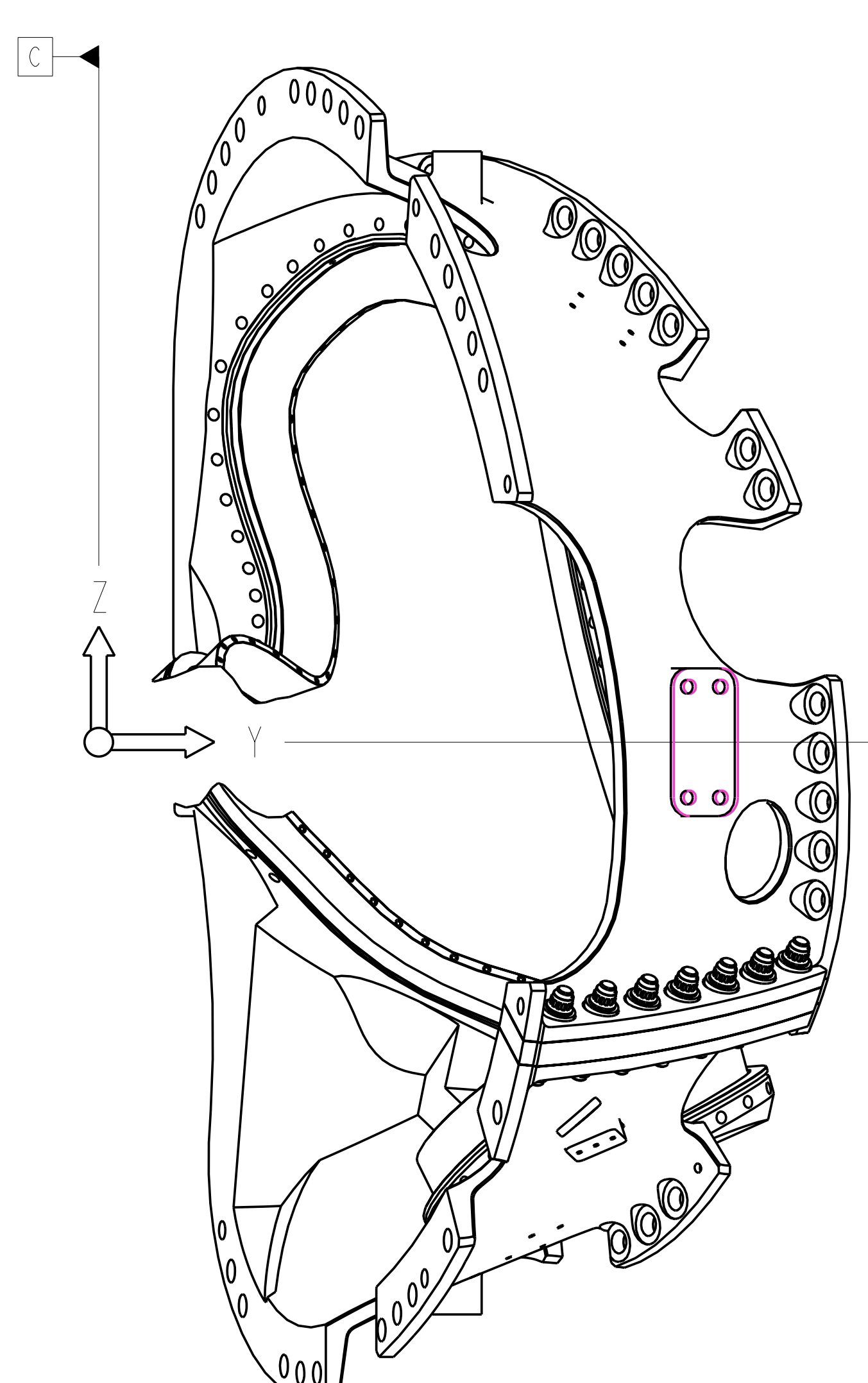
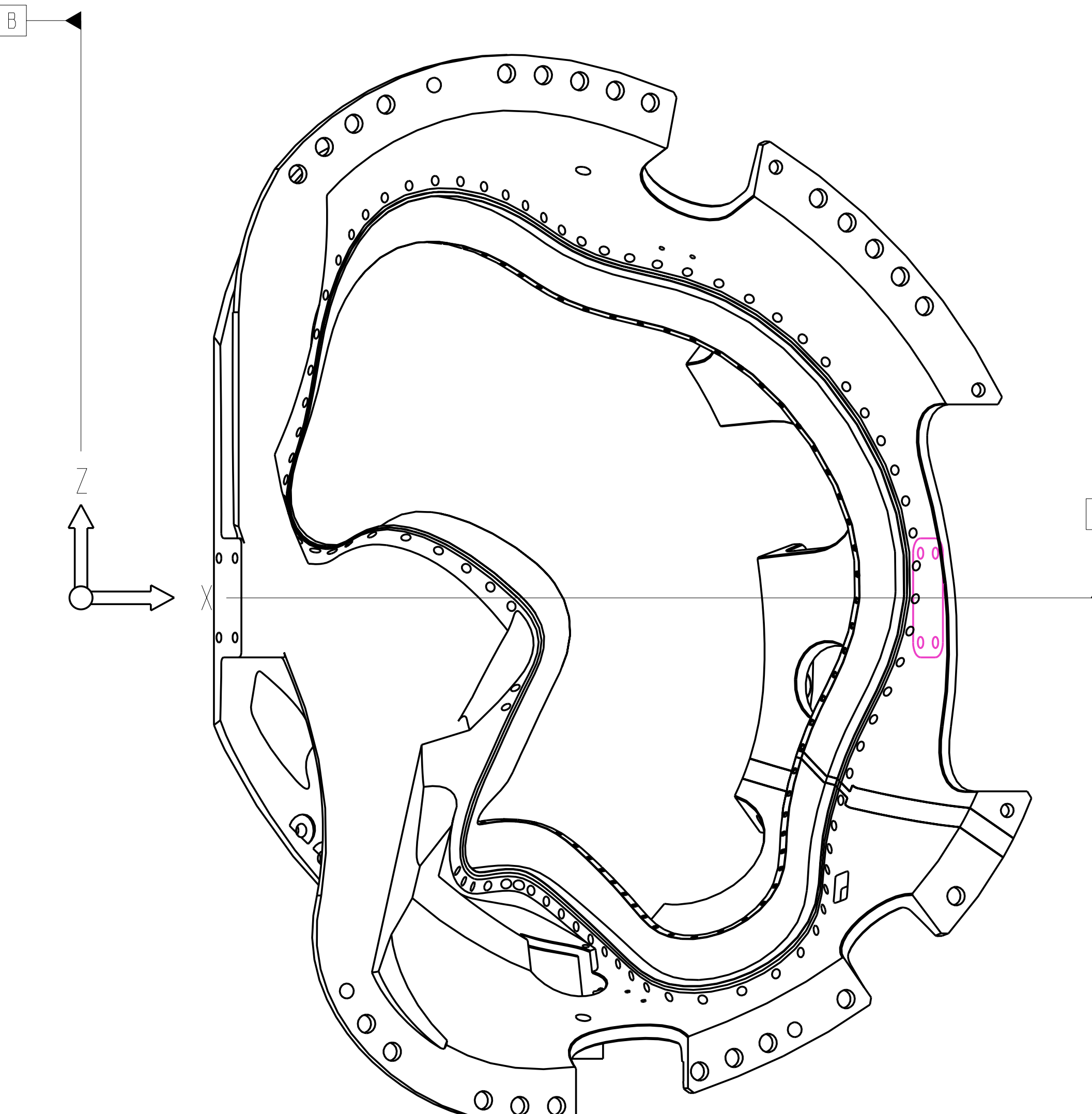
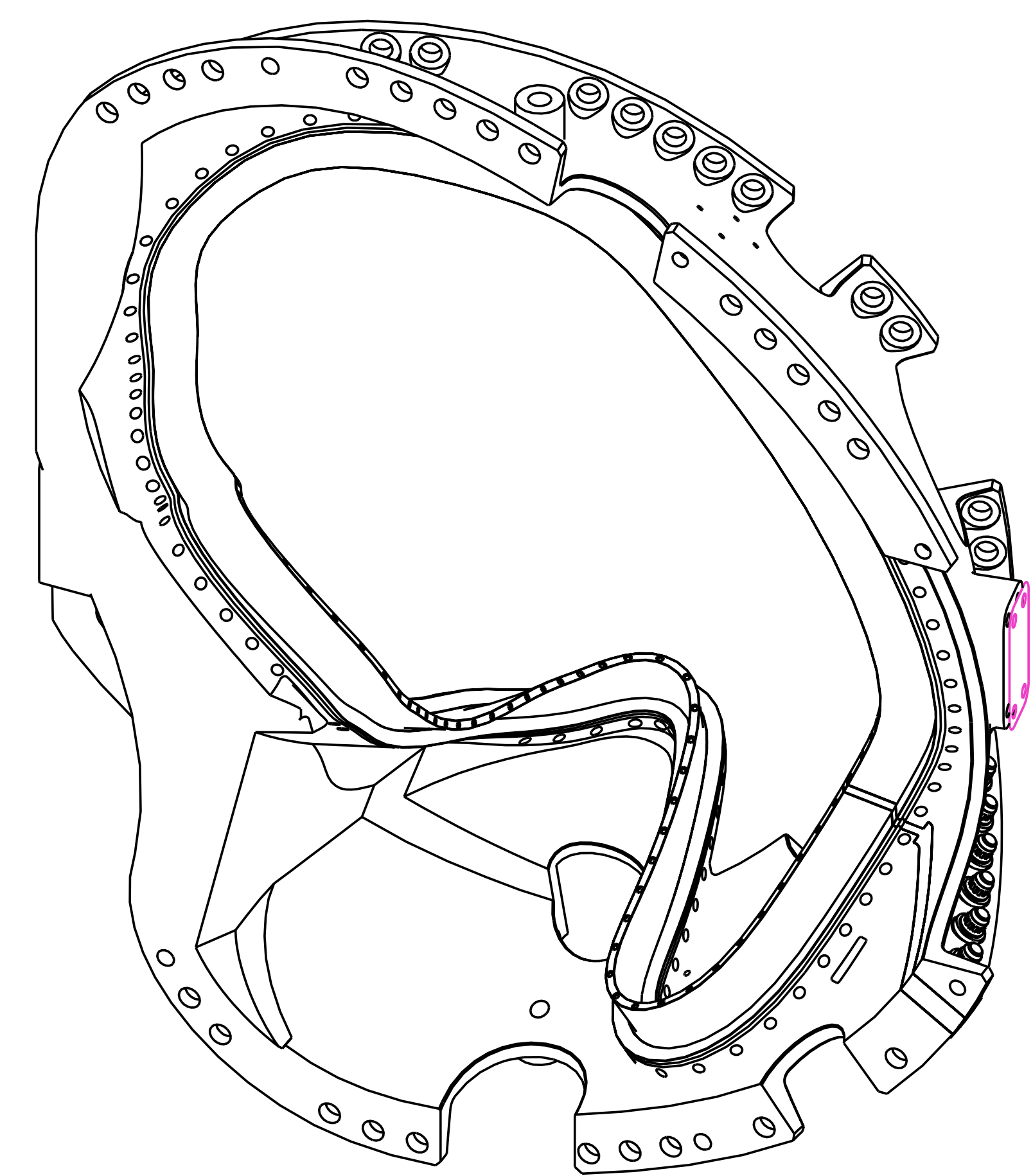
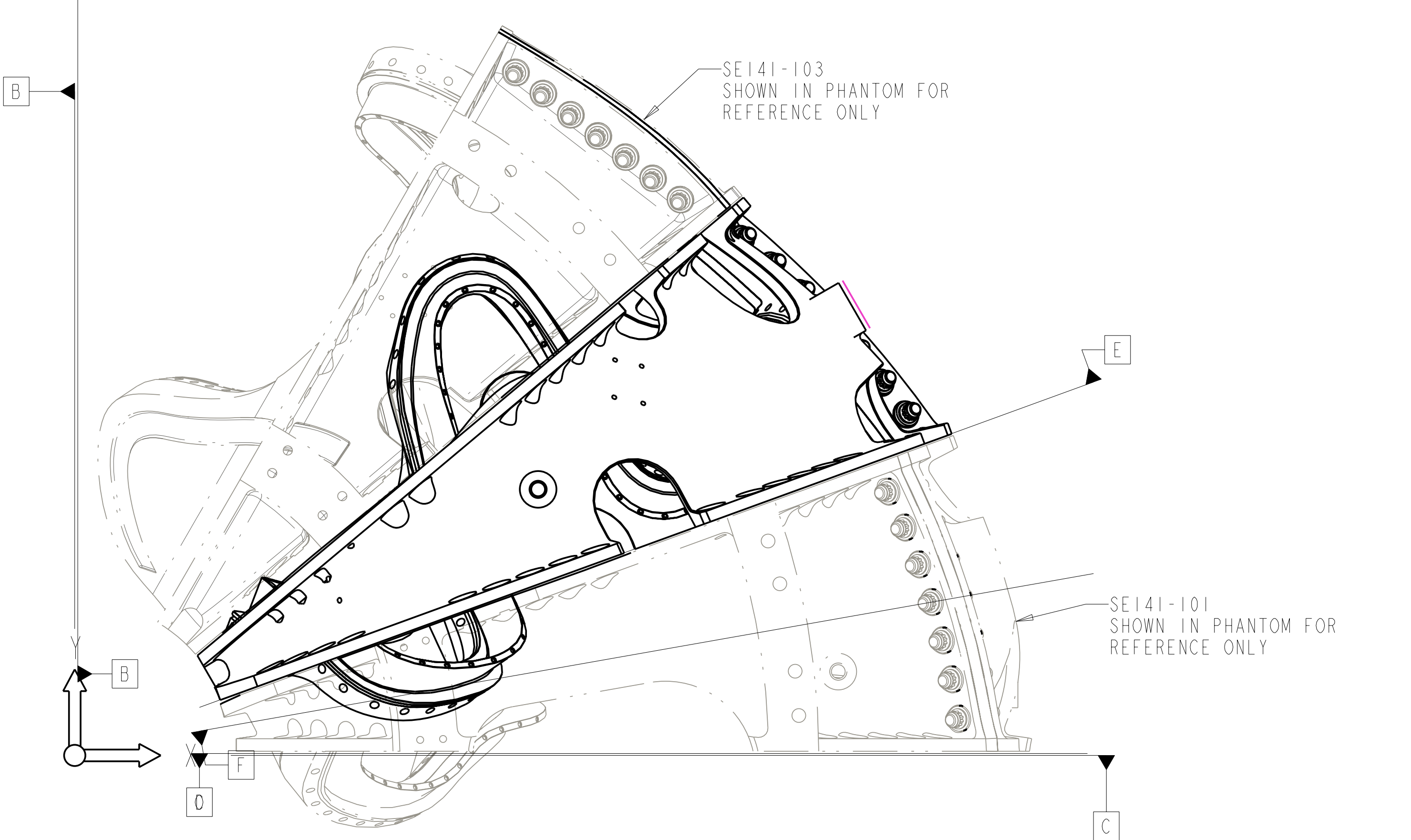


H  
G  
F  
E  
D  
C  
B  
A



1 MODULAR COIL WINDING FORM TYPE-B ASSEMBLY

- NOTES:
1. DRAWING PREPARED IN ACCORDANCE WITH ASME Y14.8M-1996
  2. INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M-1994.
  3. DIMENSIONS ARE IN INCHES
  4. DRAWING DEPICTS FINAL MACHINED STATE OF PART DEFINED BY PRO/ENGINEER FILE SE141-102.PRT.
  5. 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)
  6. DIMENSIONS APPLY AT ROOM TEMPERATURE. OPERATING TEMP 80 K
  7. APPROXIMATE MASS = 5312.442 LBS
  8. DIMENSIONS AND TOLERANCES EXCLUDE PROCESS MATERIAL ALLOWANCES WHICH MAY ADD MASS.
  9. UNLESS OTHERWISE SPECIFIED, AS-CAST SURFACE PROFILE TOLERANCE = +/- .25 - INCH, WITH EXEMPTION FOR INTERSECTING SURFACES WHERE FILLETS ARE EXPECTED. MIN FILLET AND CORNER RADII = 0.5 +/- 0.1-IN.
  10. DESIGNATED SURFACE REGIONS HAVE PROFILE TOLERANCE = +/- 0.125-IN.
  11. MIN THICKNESS PER CAD GEOMETRY, TOLERANCE = +/- 0.25-IN.
  12. PARTING LINE EDGES, FLASH, GATES, RUNNER, AND RISER EXTENSIONS 0.25-IN MAX
  13. UNLESS OTHERWISE SPECIFIED, MACHINED SURFACE PROFILE TOLERANCE = +/- 0.01-IN.
  14. SEE SPECIFICATION, NCSX-CSPEC-141-03-00, FOR ADDITIONAL REQUIREMENTS.

REV	CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
14		SE141-079	0.125 THICK FLAT WASHER	316L SS	--	10
14		SE141-060	NUT, DOUBLE HEX, SELF LOCKING, 1-3/8-6 UNC-2B	A-286, SILVER PLATED	MIL-DTL-25027, AMS 2410	9
1		SE141-055	TYPE-B POLOIDIAL BREAK UPPER INSULATOR	G11CR	--	8
1		SE141-053	TYPE-B POLOIDIAL BREAK SHIM	316L SS	--	7
1		SE141-051	TYPE-B POLOIDIAL BREAK LOWER INSULATOR	G11CR	--	6
14		SE141-038	INSULATING WASHER	G11CR	--	5
7		SE141-037	INSULATING TUBE	G11CR	--	4
7		SE141-036	STUD, 1-3/8-6 UNC-2A	316L SS	--	3
1		SE141-115	MODULAR COIL TYPE-B WINDING FORM	--	--	2
1		SE141-102	MODULAR COIL WINDING FORM TYPE-B ASSEMBLY	--	--	1

← PARTS LIST

NAME: XDW OBJECT: SE141-102\_1 DATE: 15-Jun-04 15:49:22

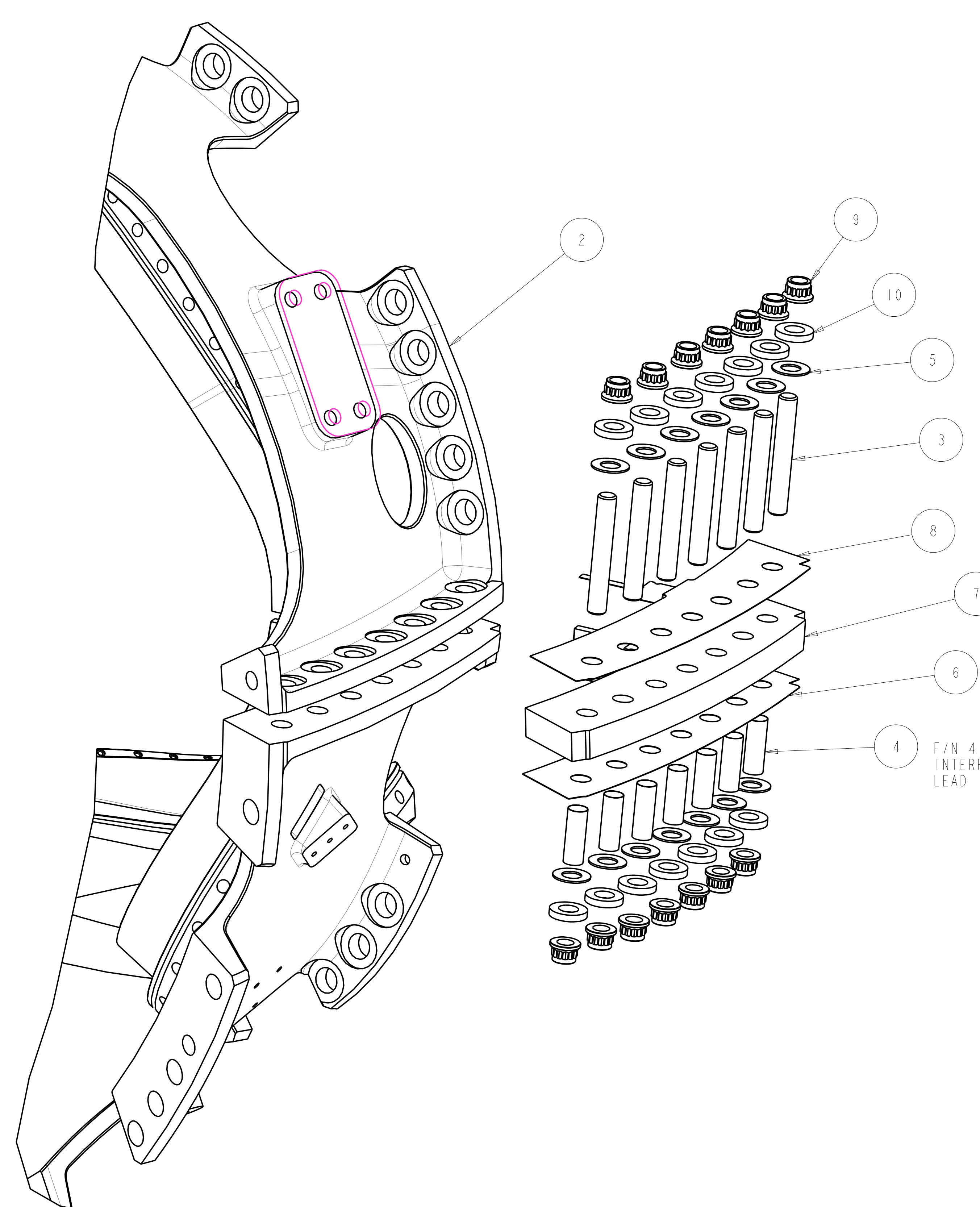
NO REPRESENTATION OR WARRANTY, EXPRESSED OR IMPLIED, IS MADE AS TO THE ACCURACY, COMPLETENESS OR USEFULNESS OF THE INFORMATION OR STATEMENTS CONTAINED IN THESE DRAWINGS, OR THAT THE USE OR DISCLOSURE OF ANY INFORMATION, APPARATUS, METHOD OR PROCESS DISCLOSED IN THESE DRAWINGS MAY NOT INFRINGE PRIVATE 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	BOE	DATE

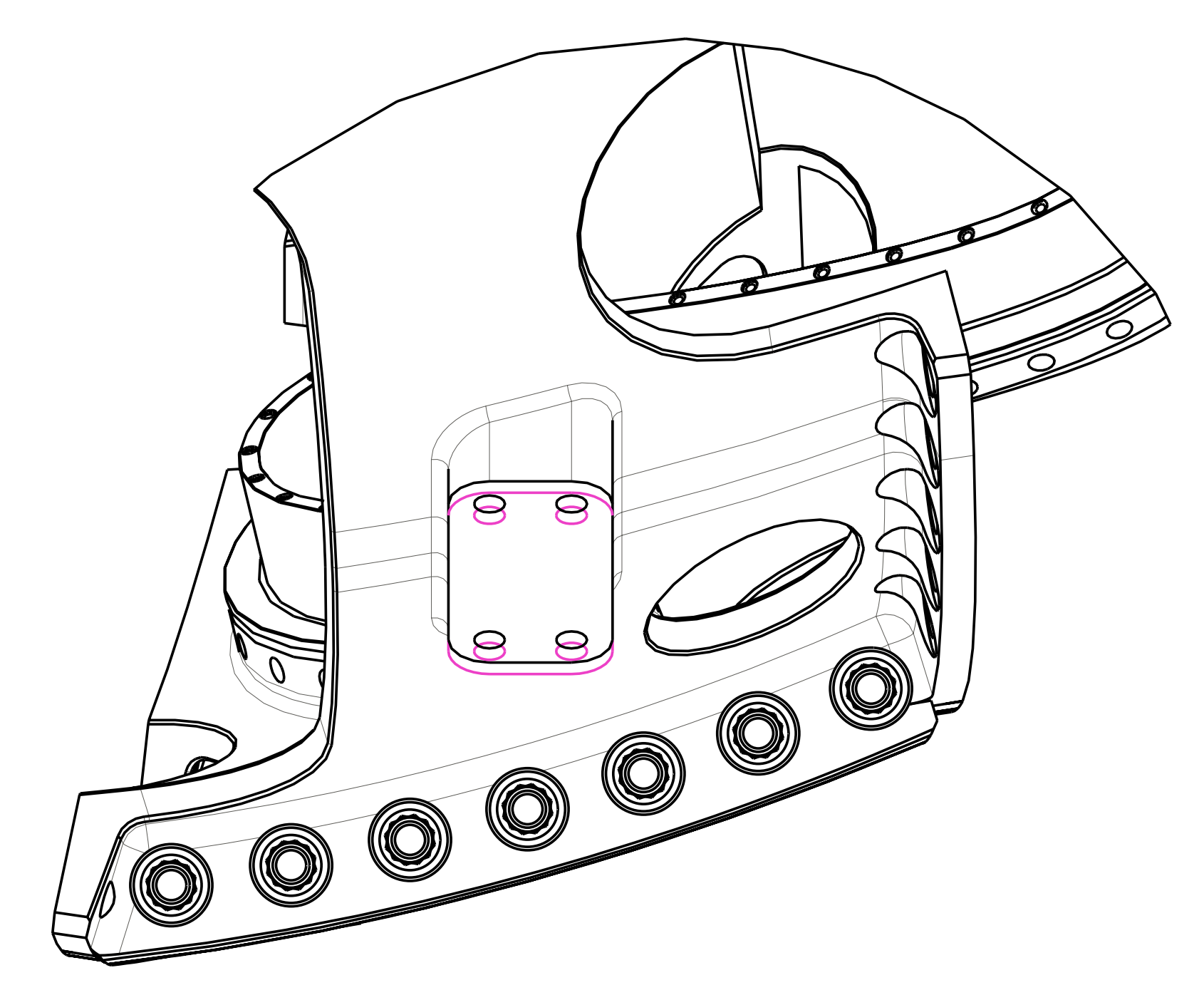
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TOLERANCES UNLESS OTHERWISE SPECIFIED		DRW	PAUL MILLER	6-7-04
FRACTIONS	±.01	CHK		
XX DECIMALS	±.005	SECT		
XXX DECIMALS	±0'15"	DEPT		
ANGLES	±0'15"	PE		
BREAK SHARP EDGES	.06 MAX	CR		
FINISH	125 UNLESS OTHERWISE SPECIFIED	PJ		
		REQ		
		PPPL DRFT		

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	
NATIONAL COMPACT STELLARATOR EXPERIMENT			
MODULAR COIL WINDING FORM TYPE-B ASSEMBLY			
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15+	ORNL	5700	3
RELEASE LEVEL			
WIP			
SEI41-102			
REV			
0			

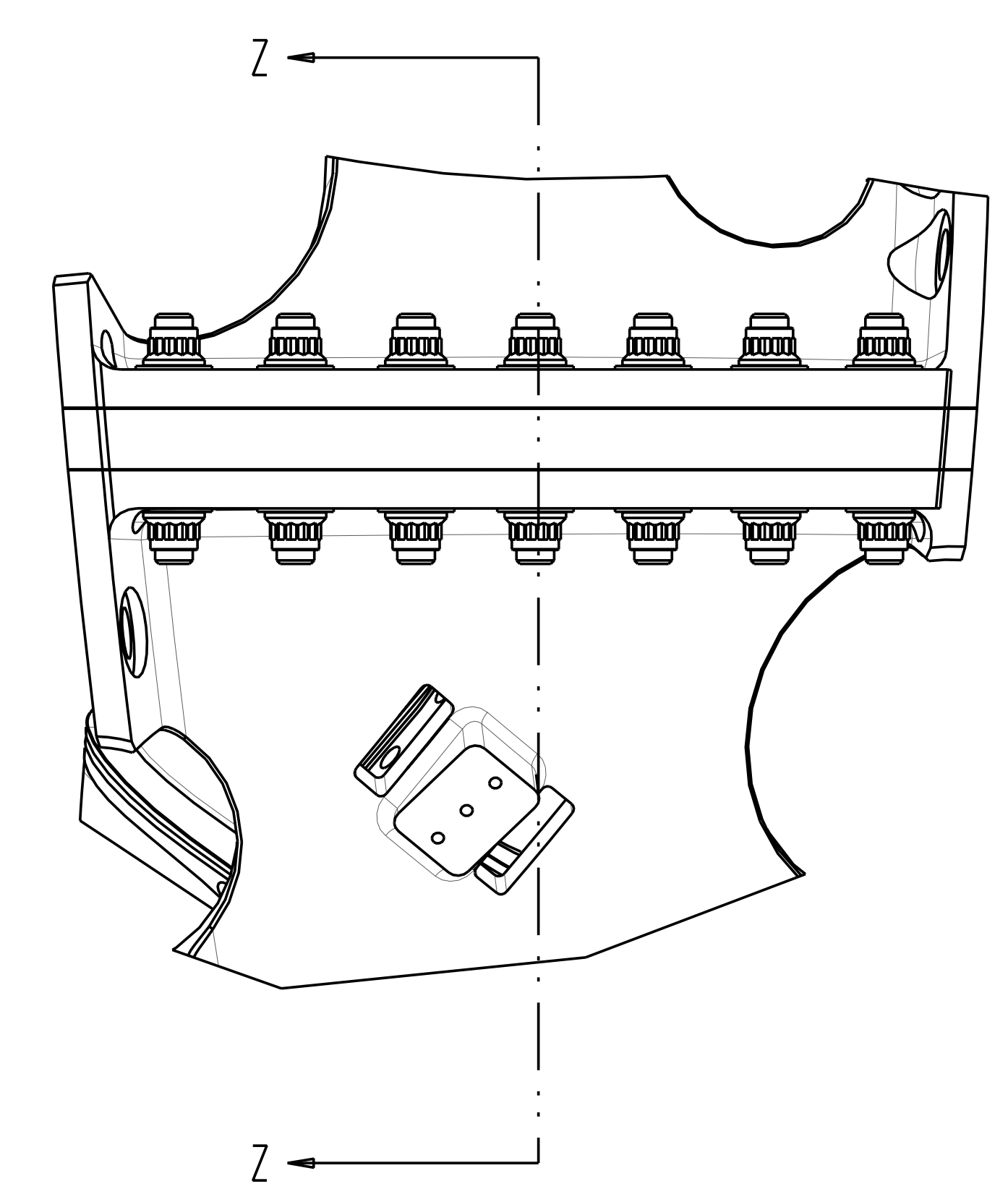


1 MODULAR COIL TYPE-B  
SCALE 0.2

F/N 4 TO HAVE +.001 TO +.002  
INTERFERENCE FIT TO HOLE IN F/N 2  
LEAD IN CHAMFER OPTIONAL

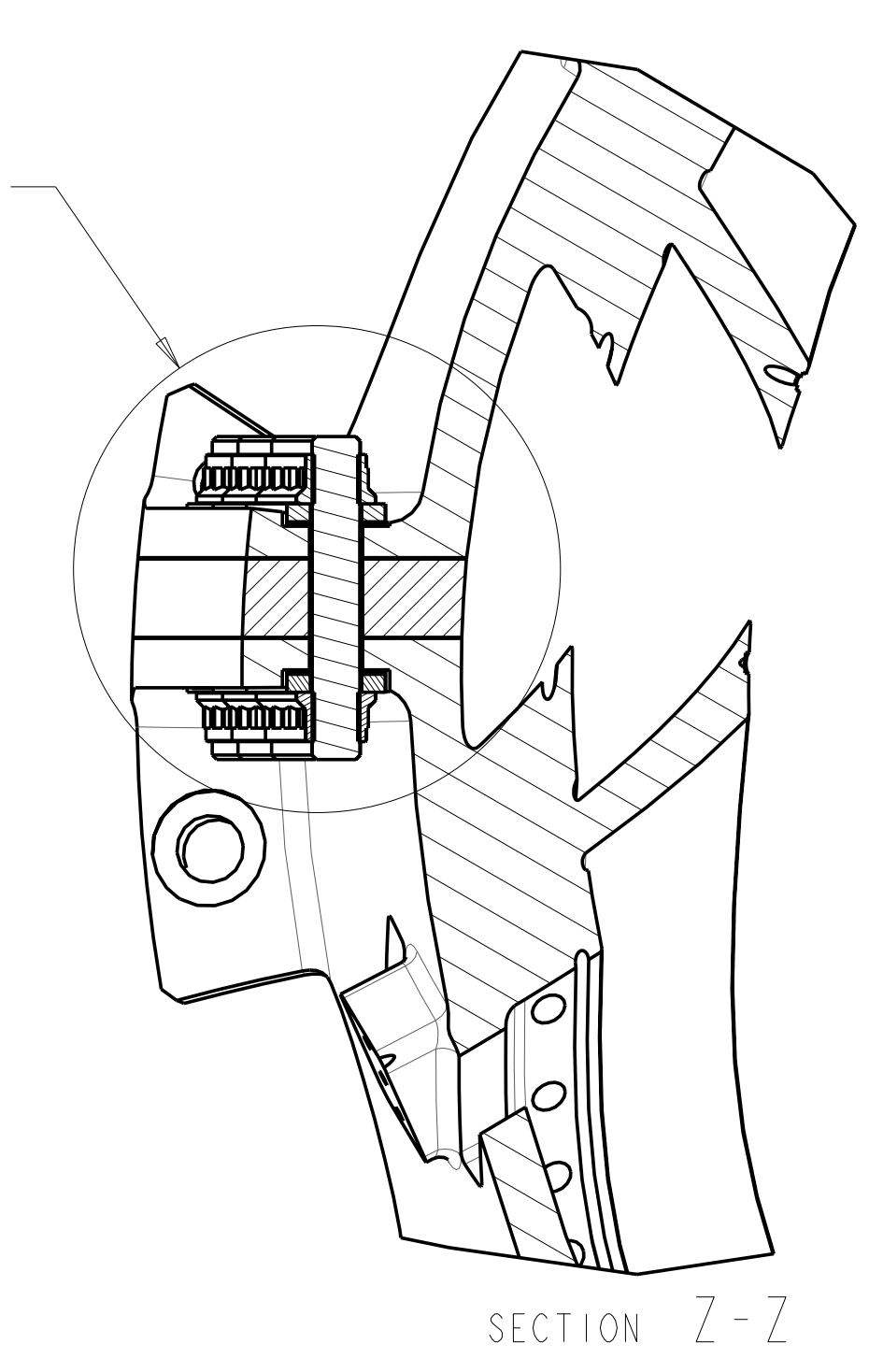


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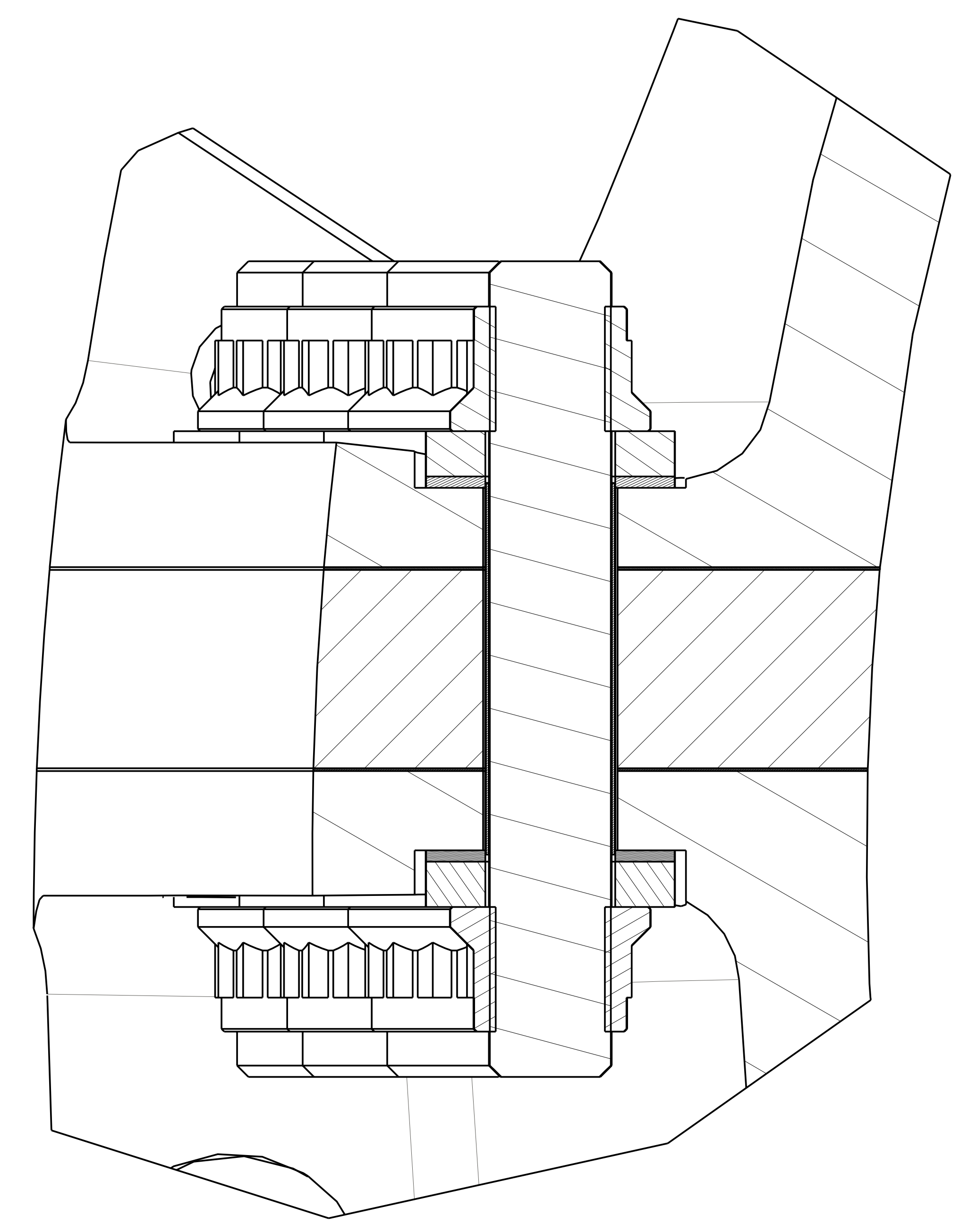


Z

SEE DETAIL B



SECTION Z-Z



DETAIL B  
SCALE 1.0

NAME: XDW OBJECT: SE141-102\_2 DATE: 15-Jun-04 15:50:48

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							
MODULAR COIL WINDING FORM TYPE-B ASSEMBLY							
VERSION NO.	PLANT	BLOG	FL	SHT	OF	TYPE	CLASS
15+	ORNL	5700	3	2	2	A	U
RELEASE LEVEL		REV					
WIP		0					