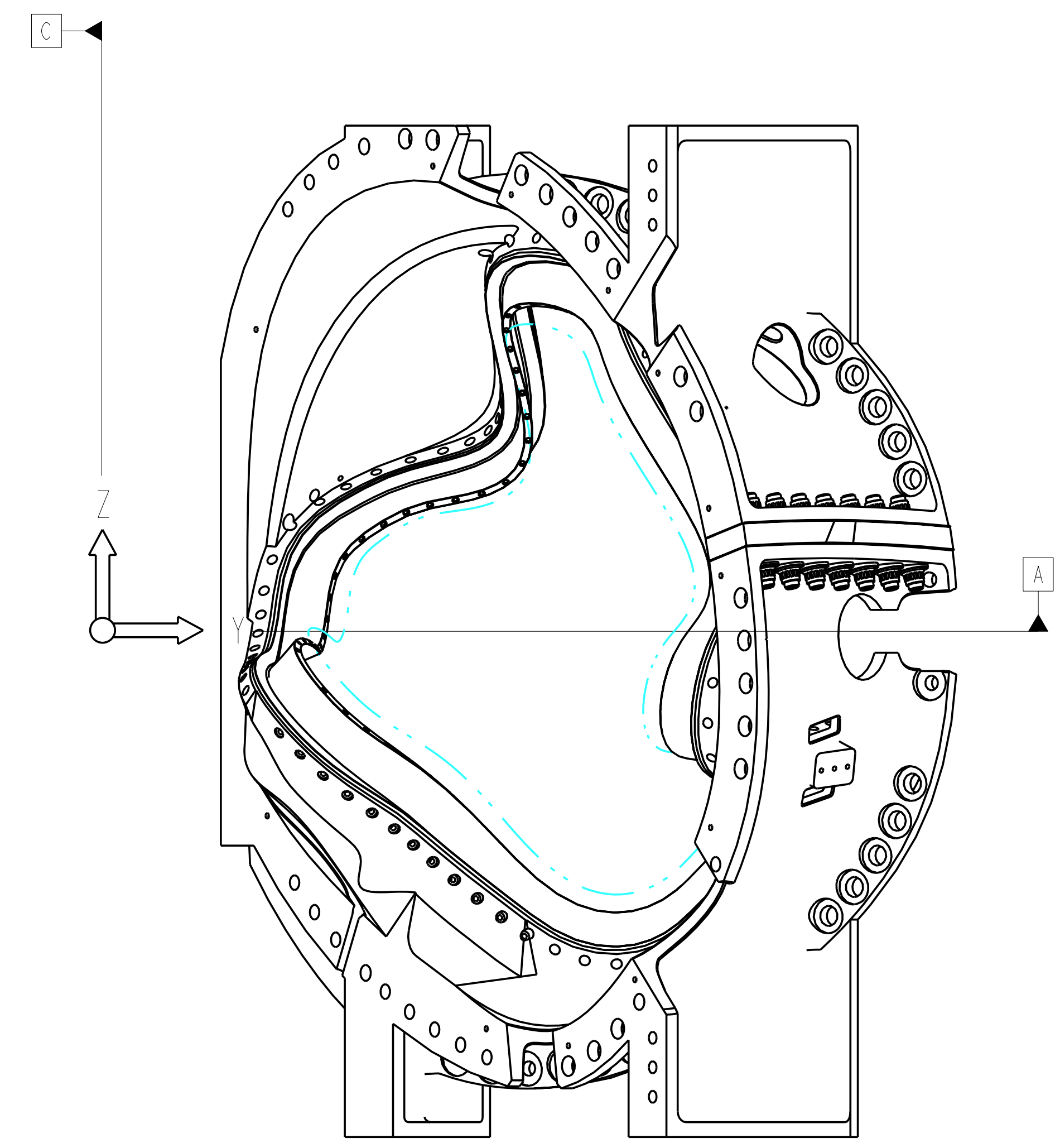
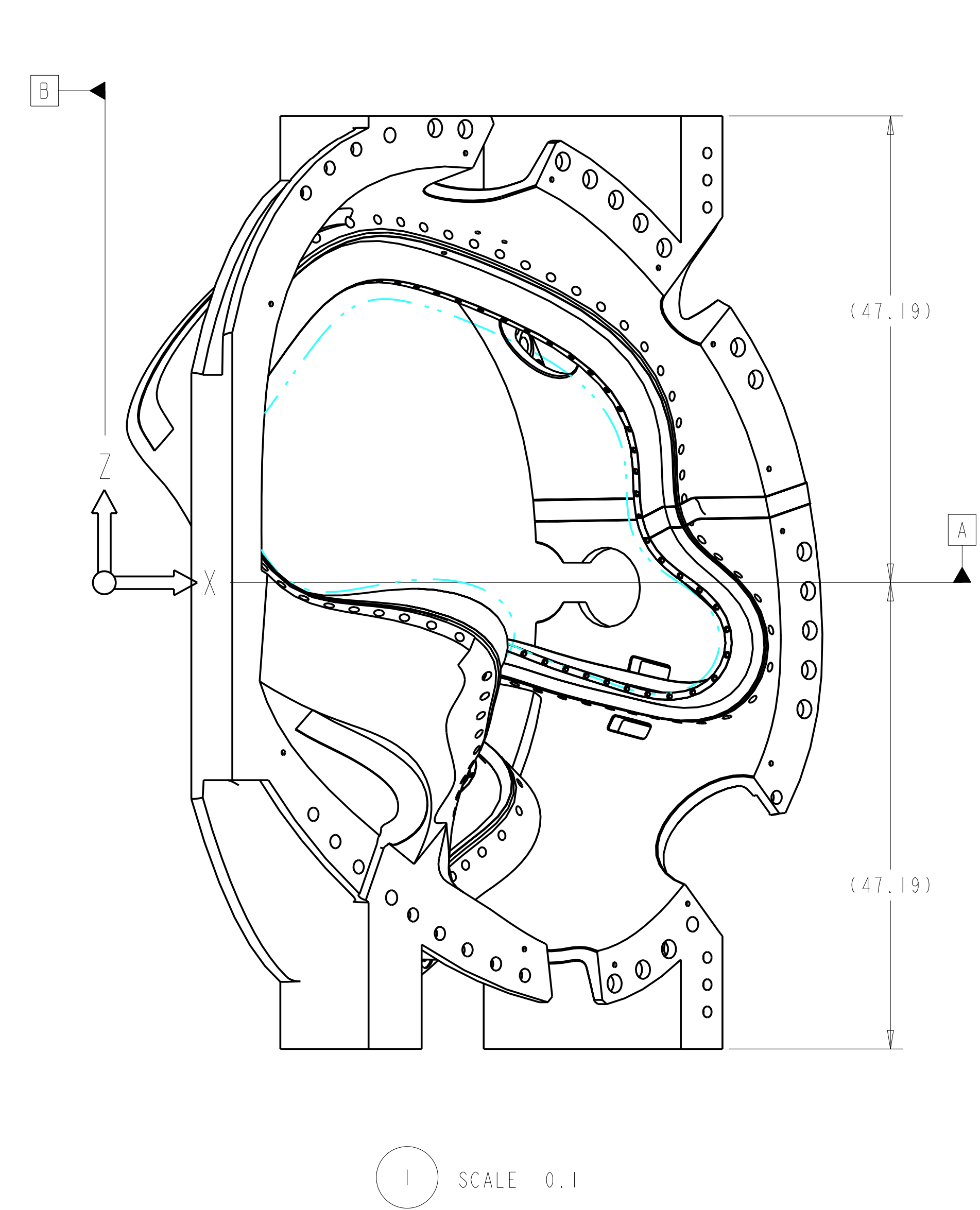


ISOMETRIC VIEW
 SCALE 0.1

- 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 ASSEMBLY DEFINED BY PRO/ENGINEER FILE SE141-103.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 = 5080 LBS.
 - MATCH DRILL OR REAM TO ACHIEVE RUNNING FIT BETWEEN PARTS AND 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) TO WINDING FORM (F/N 2) USING LOCTITE 411 PER MANUFACTURER'S INSTRUCTIONS.



REV	CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
14	DS141-079		FLAT WASHER			9
14	DS141-060		NUT, 12PT HEX 1.375-6UNC-2B			8
14	DS141-038		INSULATING WASHER			7
7	DS141-036		STUD, 1.375-6UNC-2A X 9 LG			6
14	-5	MCWF INSULATING SLEEVE TYPE-C	G11CR	NEMA LI 1 - 1998		5
2	-4	INSULATING SHEET TYPE-C	G11CR	NEMA LI 1 - 1998		4
1	SE141-078		POL BREAK SHIM ASSEMBLY TYPE-C			3
1	SE141-116		PRODUCTION WINDING FORM TYPE-C			2
AR	X	-1	MOD COIL WINDING FORM ASSEMBLY TYPE-C			1
SE141-103						

← NEXT ASSEMBLY

PARTS LIST

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

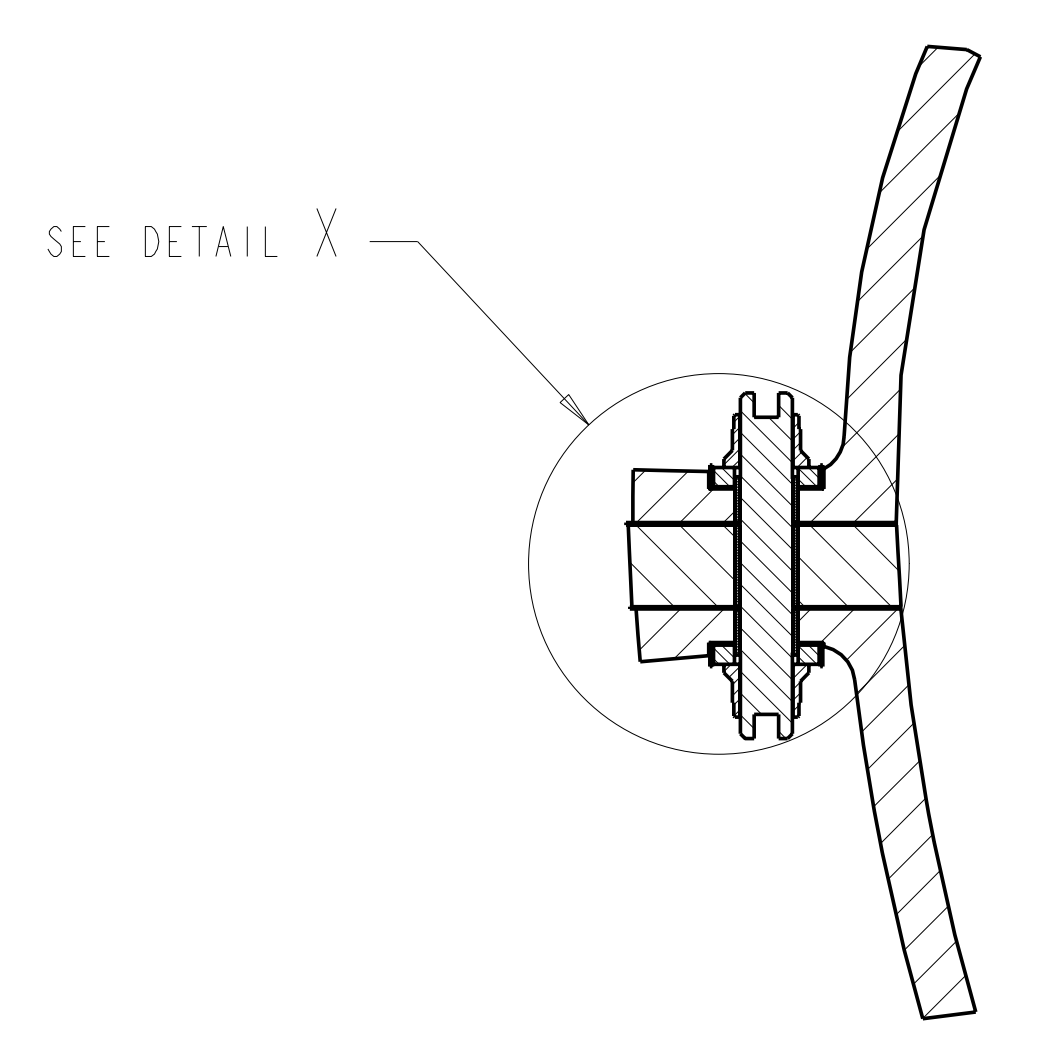
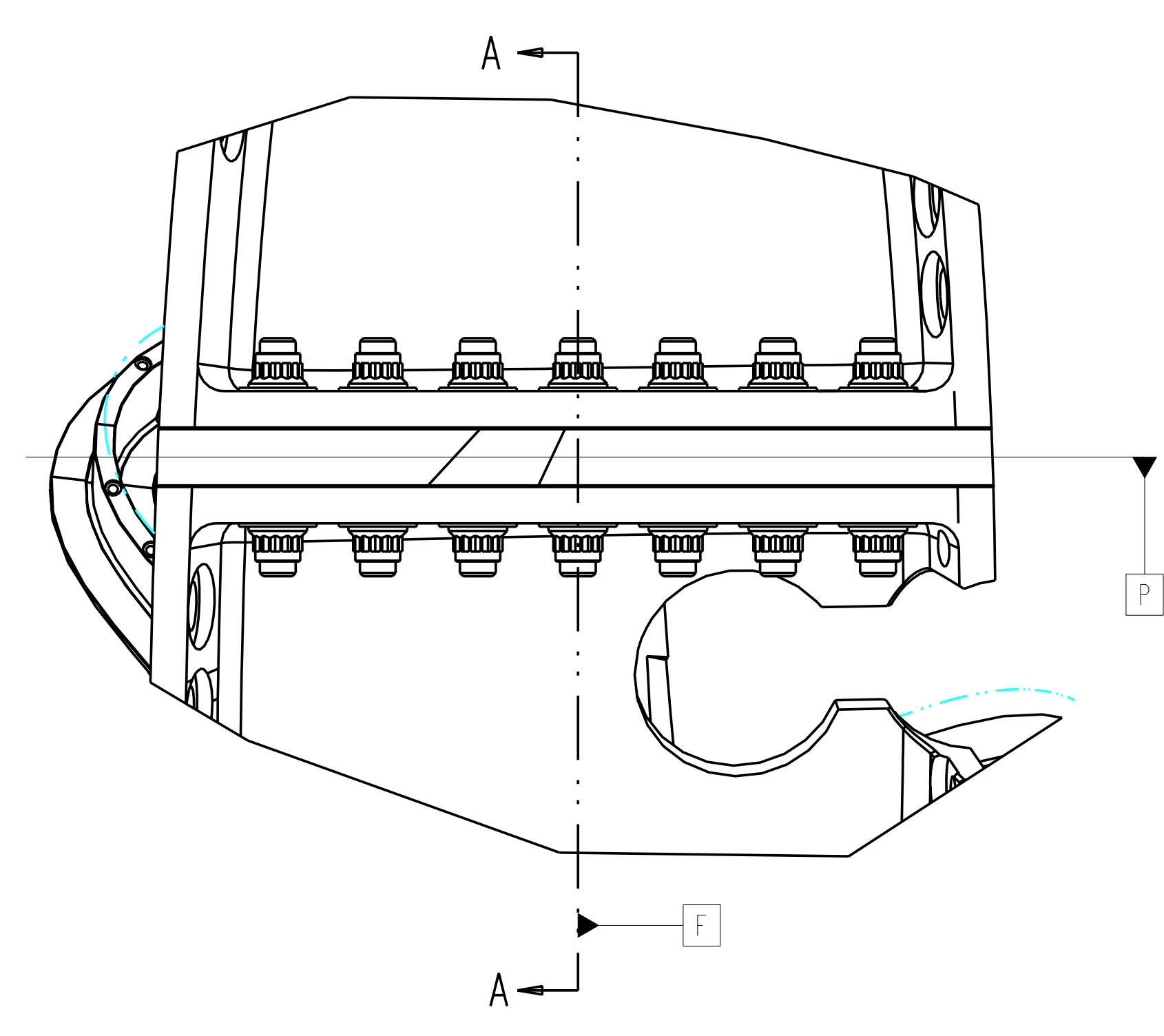
REV	DESCRIPTION	BY	DATE	CHK	DEPT	DATE	PE	REQ	DATE	ORNL	DOE	DATE

SCALE NOTED	DES T BROWN	6-30-04
TOLERANCES UNLESS OTHERWISE SPECIFIED	DRW P MILLER	6-30-04
FRACTIONS	CHK M COLE	6-30-04
XX DECIMALS ± .01	SECT :	
XXX DECIMALS ± .005	DEPT :	
ANGLES ± 0°15'	PE D WILLIAMSON	6-30-04
BREAK SHARP EDGES .06 MAX	CR :	
FINISH .125 UNLESS OTHERWISE SPECIFIED	PJ :	
	RED :	
	PPPL DRFT J SIEGEL	6-30-04

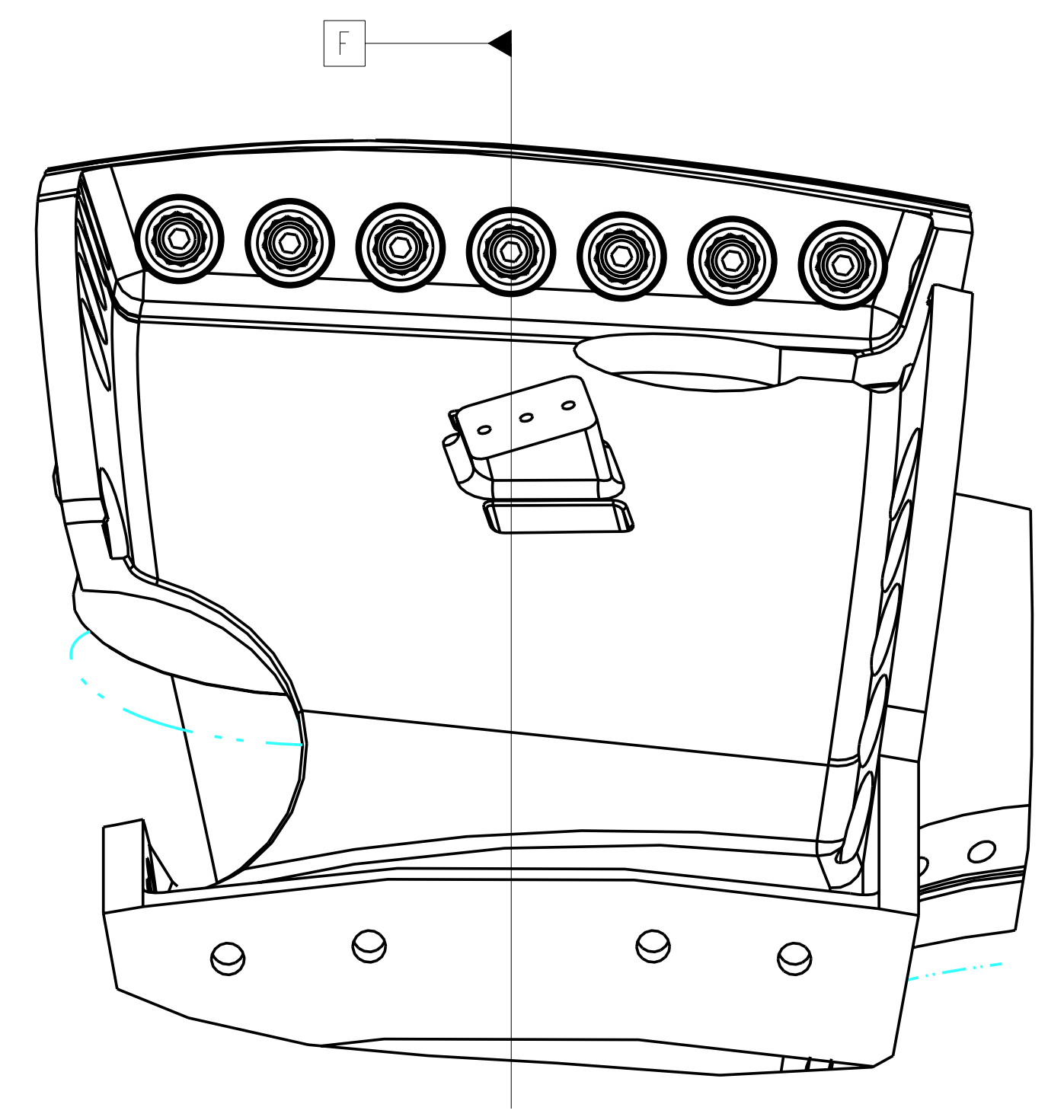
UT-BATTELLE		Oak Ridge National Laboratory managed for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT contract DE-AC05-00OR22725 UT-BATTELLE, LLC. Oak Ridge, Tennessee	
PROJECT NAME			
NATIONAL COMPACT STELLARATOR EXPERIMENT			
MOD COIL WINDING FORM ASSEMBLY TYPE-C			
VERSION NO.	PLANT	BLDG	FL
28+	X-10	5700	3
RELEASE LEVEL	WIP		
SEI41-103			
REV	U		
0			

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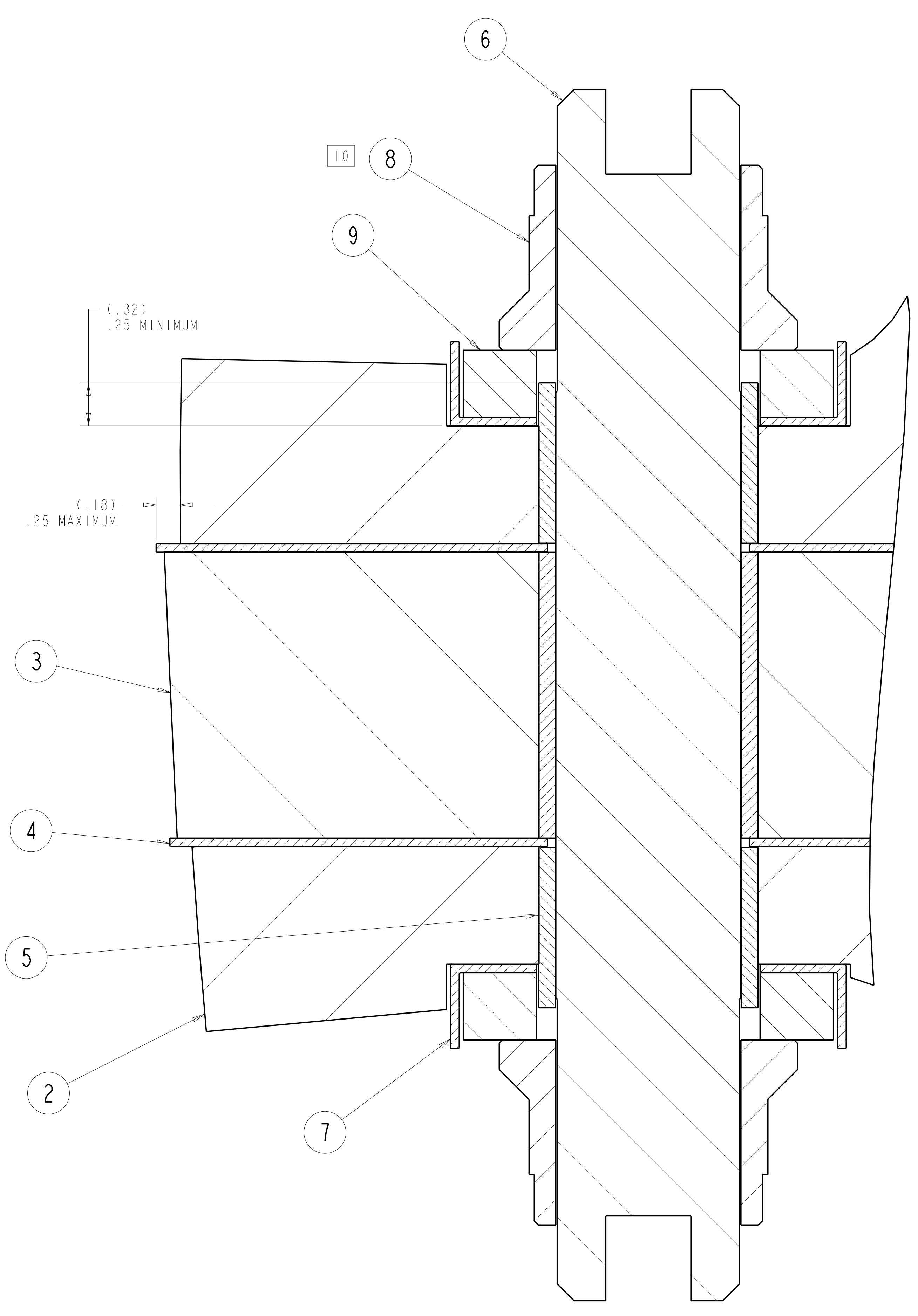
FOR NOTES AND PARTS LIST SEE SHEET 1



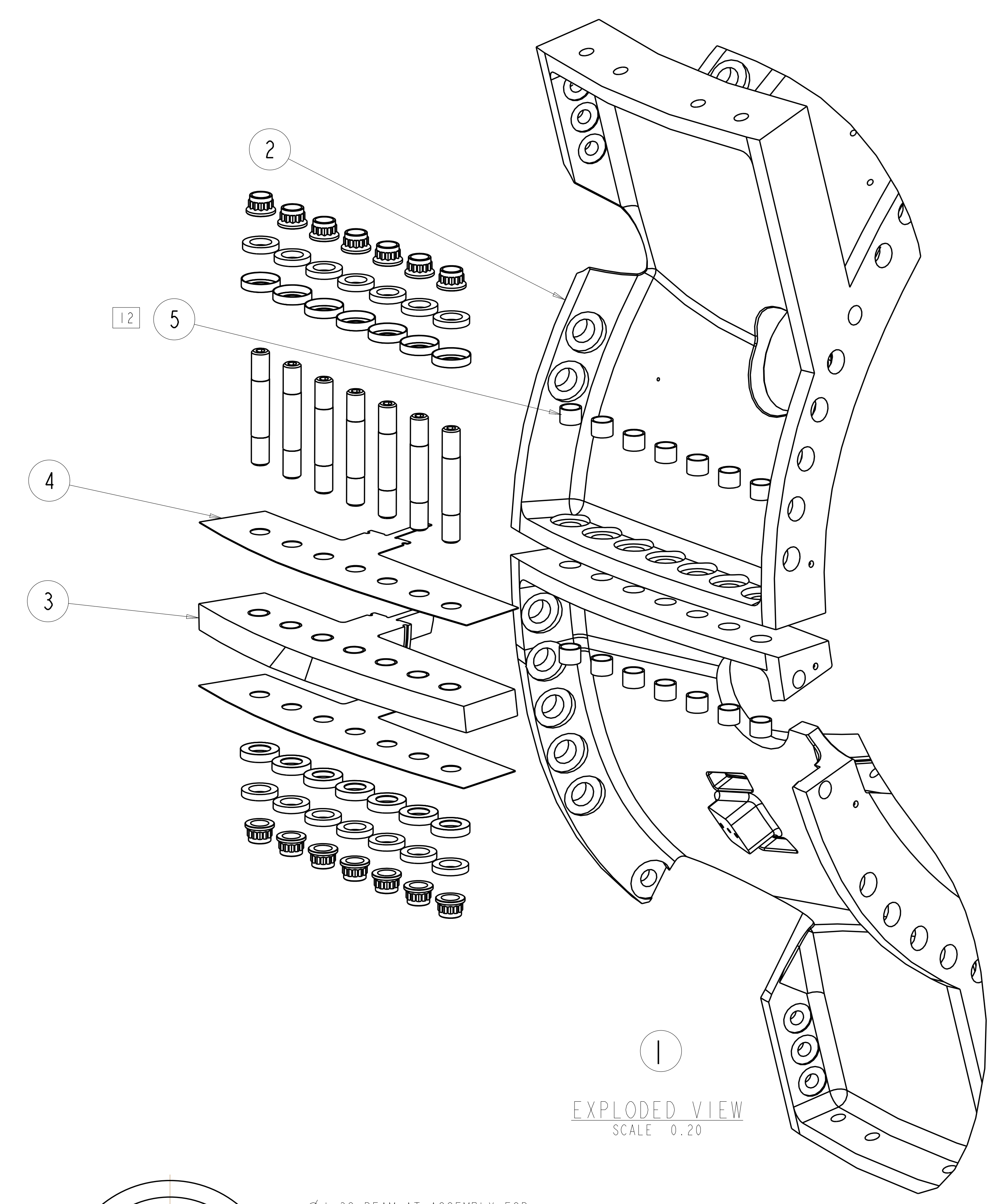
SECTION A-A
SCALE 0.20



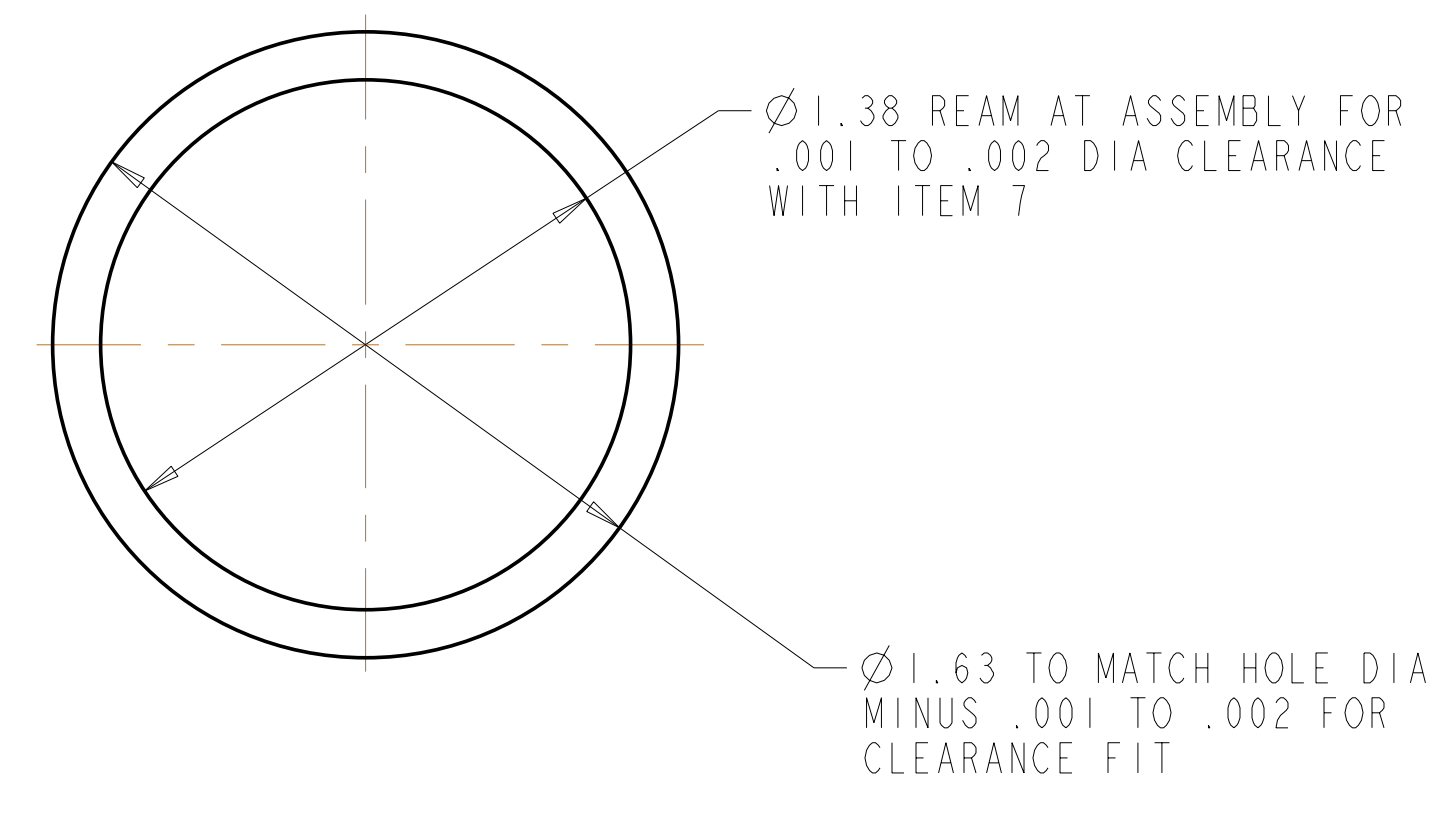
POLOIDAL BREAK DETAIL



DETAIL X
SCALE 2.00

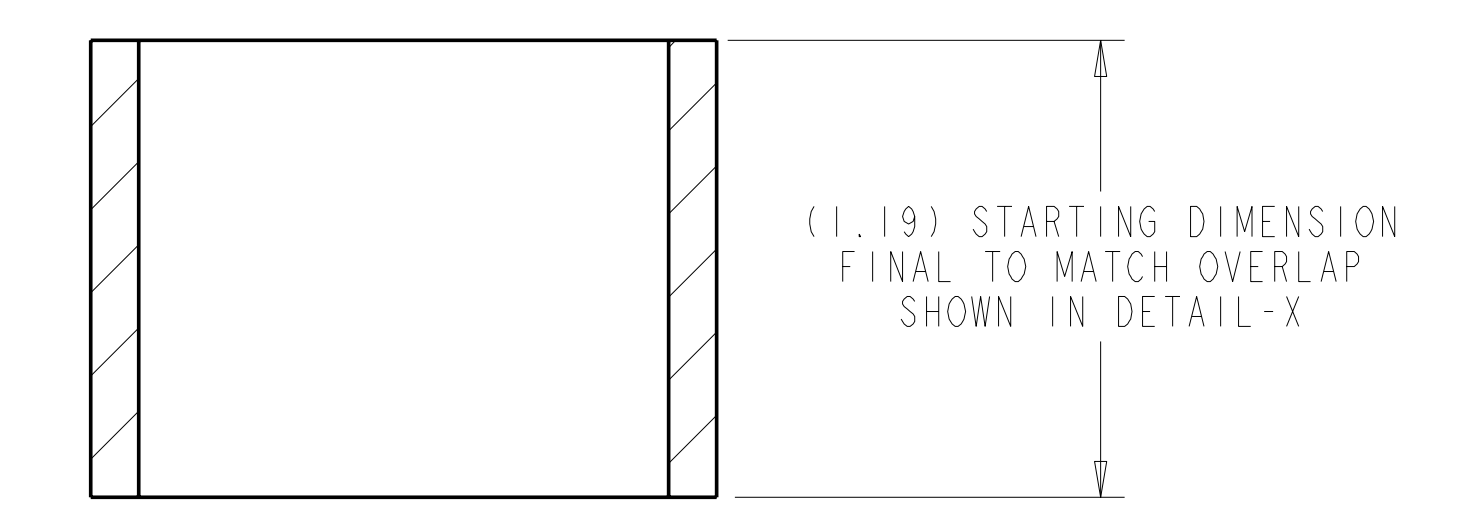
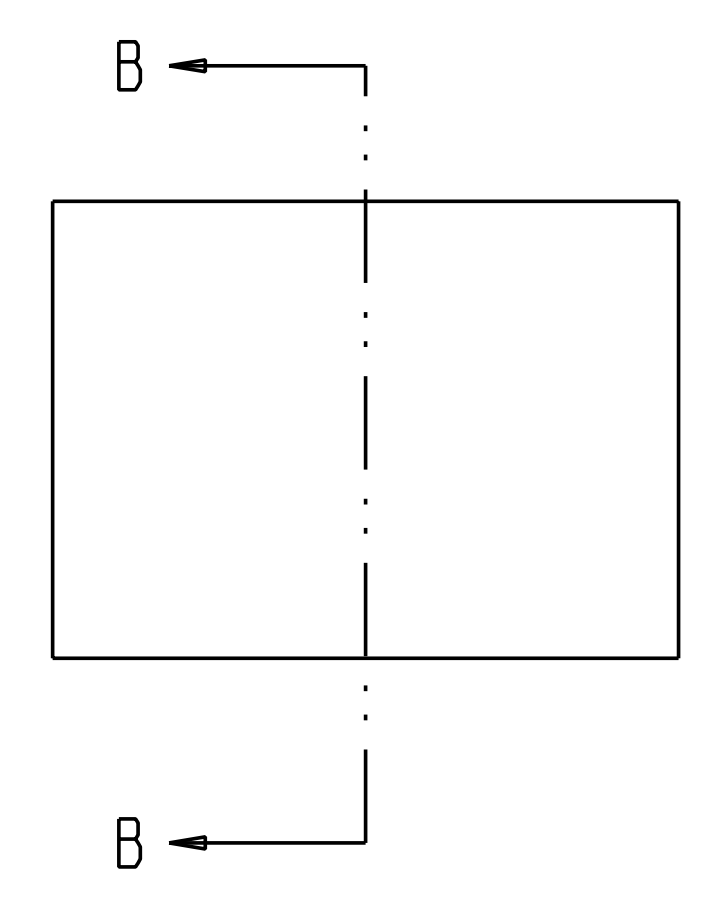


EXPLODED VIEW
SCALE 0.20



$\varnothing 1.38$ REAM AT ASSEMBLY FOR
.001 TO .002 DIA CLEARANCE
WITH ITEM 7

$\varnothing 1.63$ TO MATCH HOLE DIA
MINUS .001 TO .002 FOR
CLEARANCE FIT



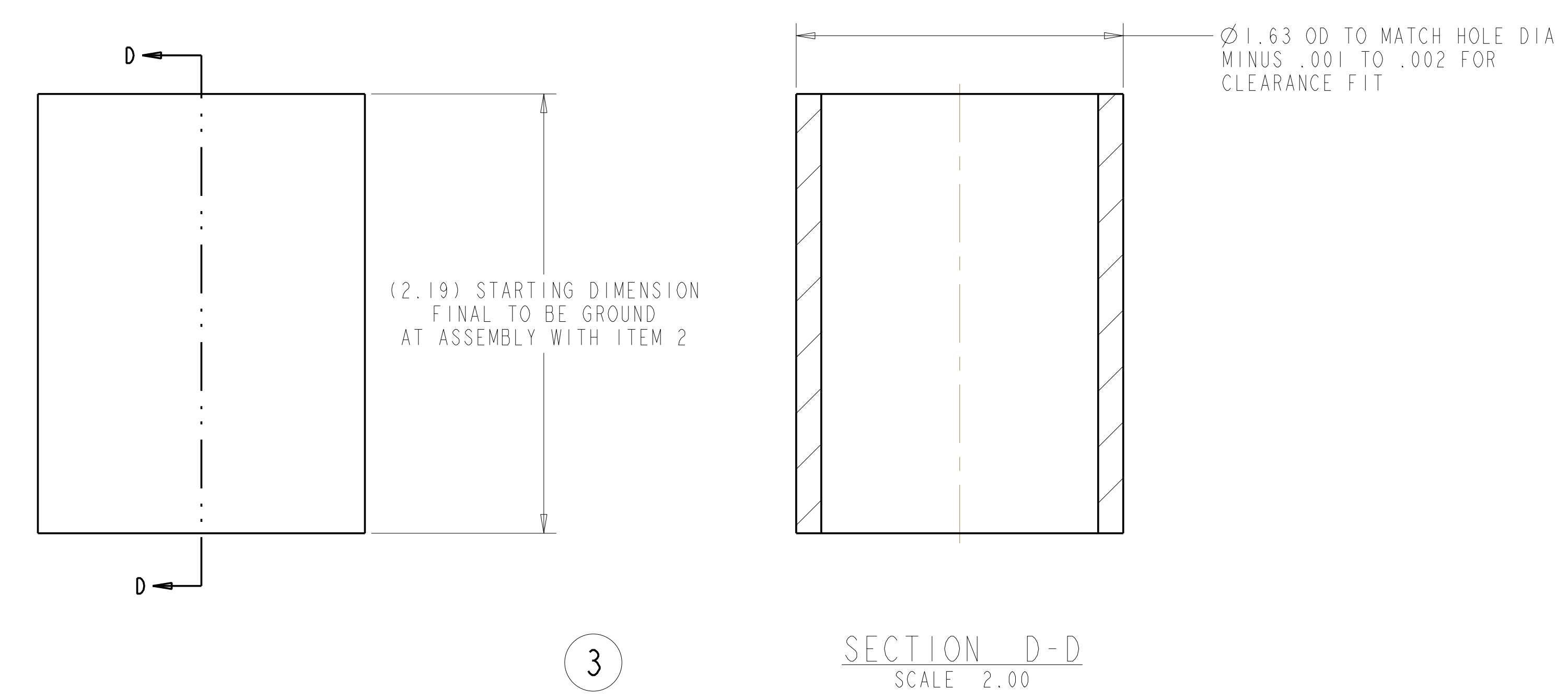
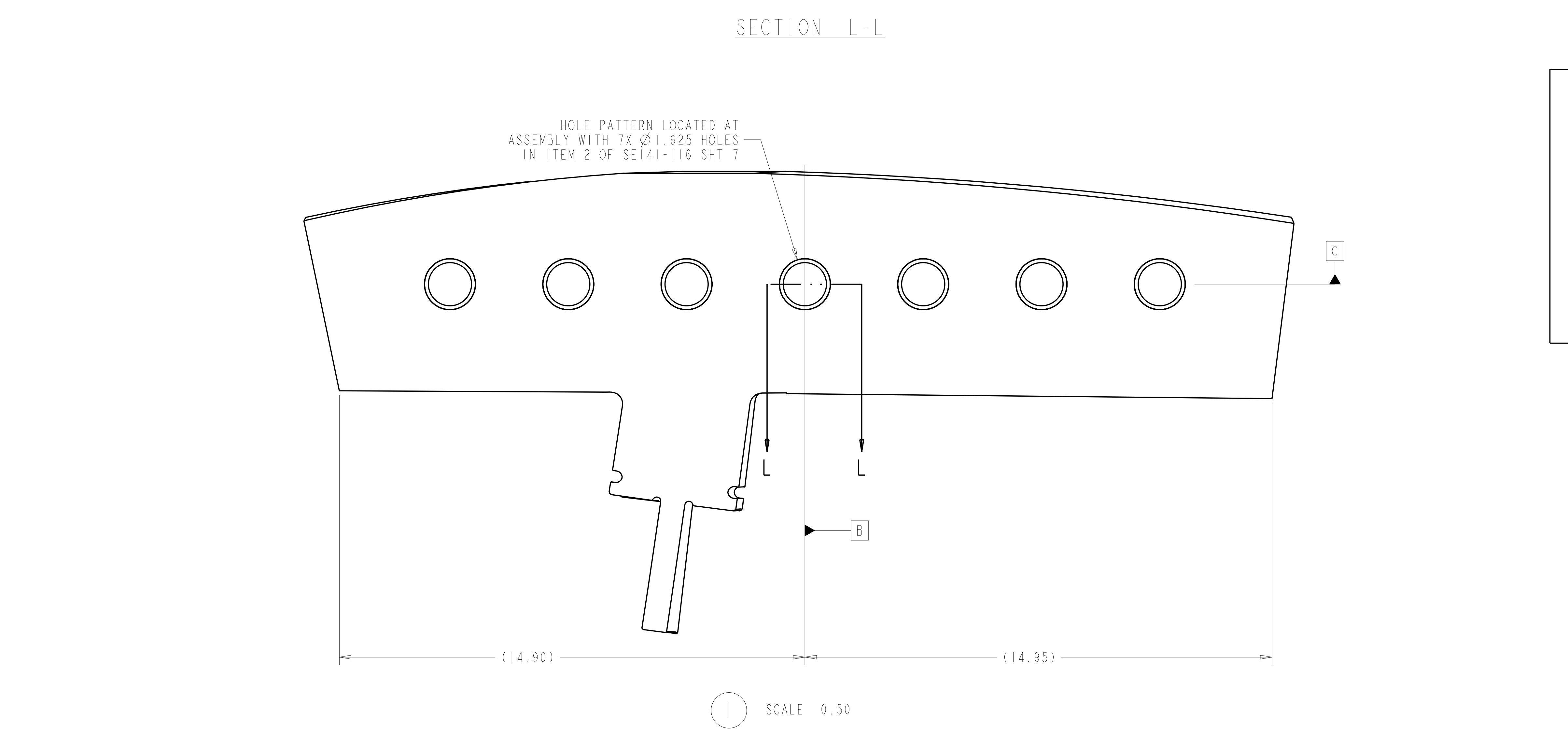
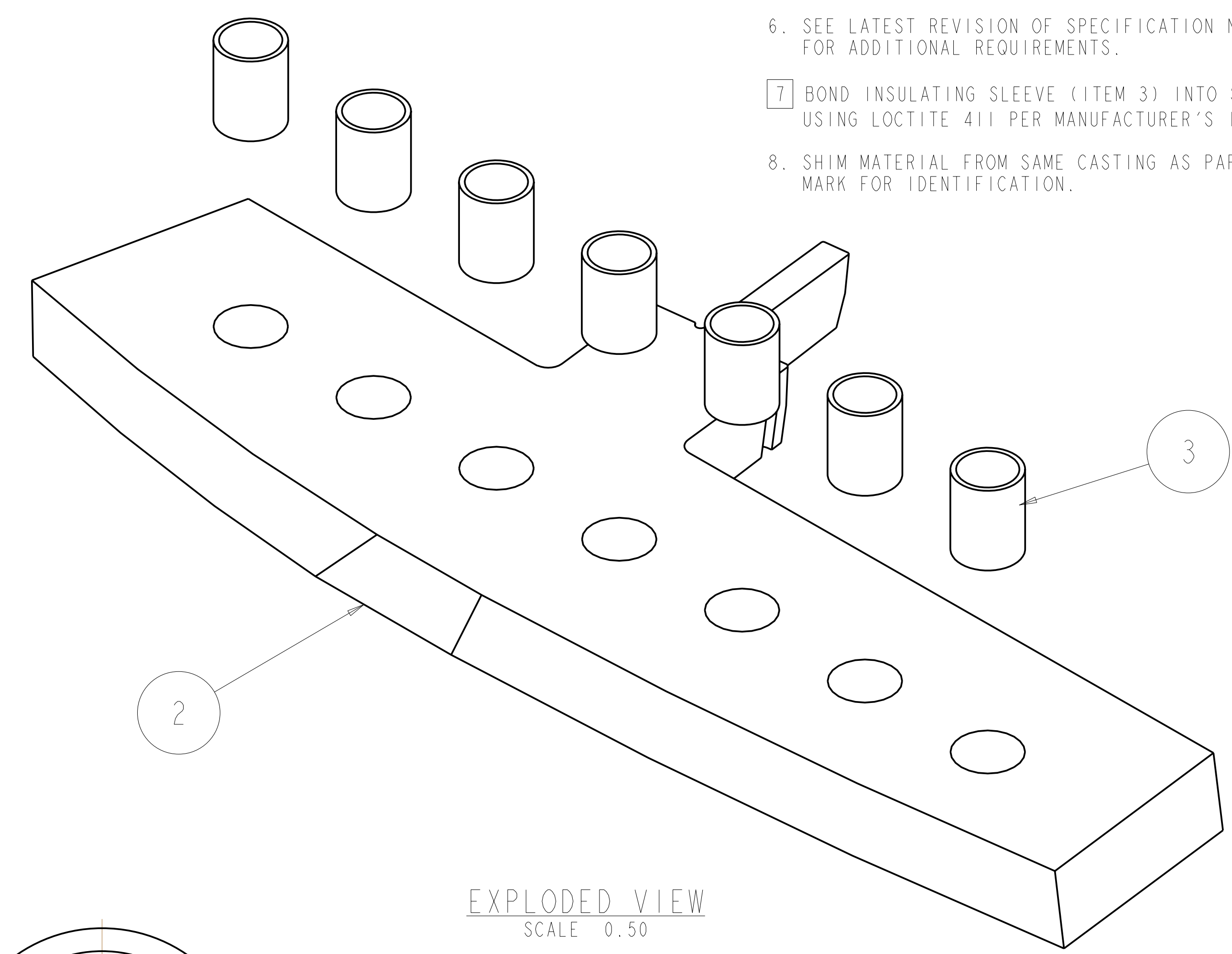
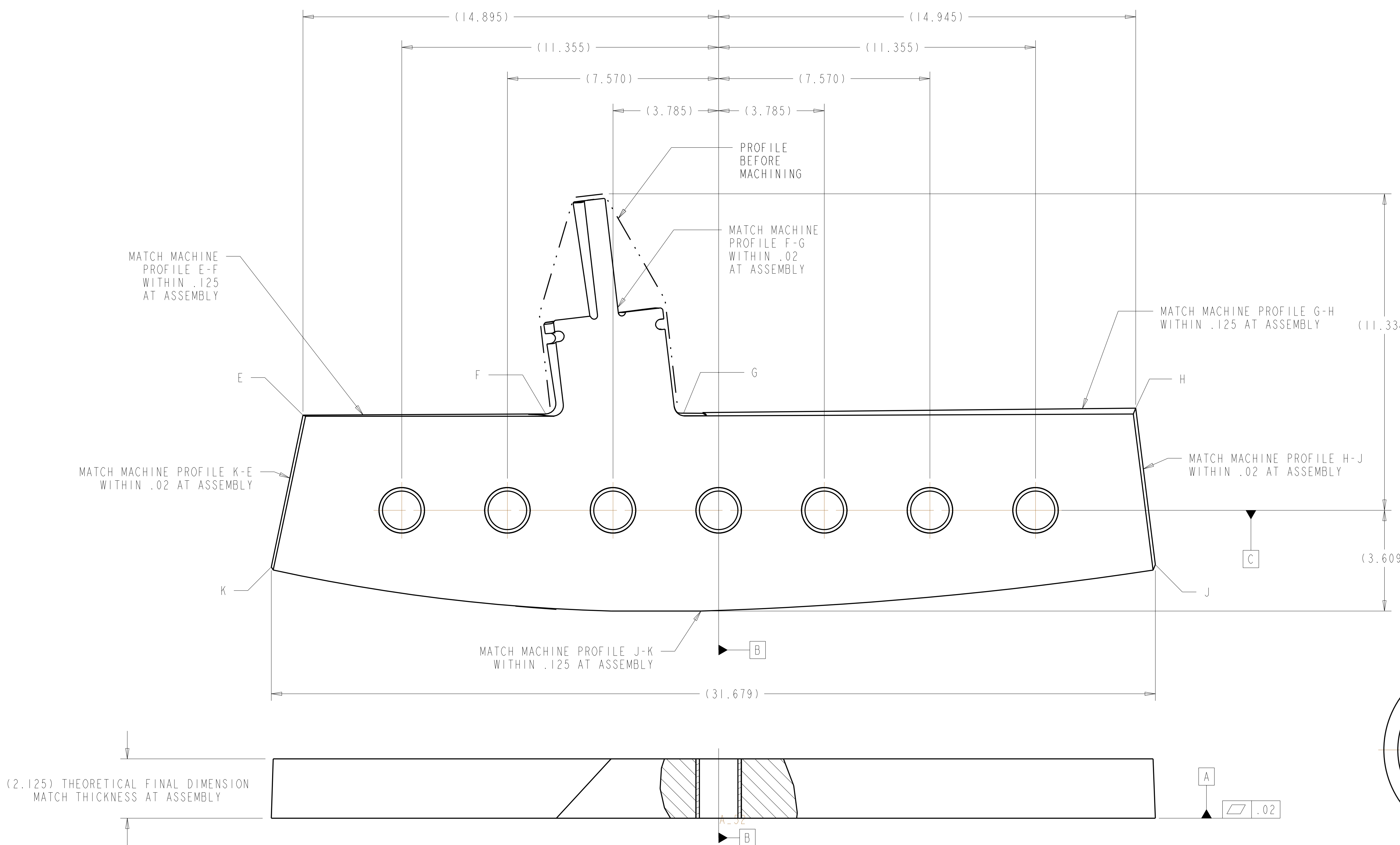
SECTION B-B
SCALE 2.00

Oak Ridge National Laboratory managed for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT contract DE-AC05-00OR22725 UT-BATTELLE, LLC, Oak Ridge, Tennessee						
UT-BATTELLE						
NATIONAL COMPACT STELLARATOR EXPERIMENT						
MOD COIL WINDING FORM ASSEMBLY TYPE-C						
VERSION NO.	PLANT	BLDG	FL	SHT OF	TYPE	CLASS
28+	X-10	5700	3	2	S	U
RELEASE LEVEL	SEI41-103				REV	0
WIP						

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SEI41-103

- NOTES:
1. INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M.
 2. DIMENSIONS ARE IN INCHES.
 3. DIMENSIONS APPLY AT TEMPERATURE OF 20-30°C (68-86°F).
 4. DRAWING DEPICTS FINAL MACHINED STATE OF ASSEMBLY DEFINED BY PRO/ENGINEER FILE SE141-078.ASM.
 5. APPROXIMATE WEIGHT = 129 LBS.
 6. SEE LATEST REVISION OF SPECIFICATION NCSX-CSPEC-141-03 FOR ADDITIONAL REQUIREMENTS.
 - 7 BOND INSULATING SLEEVE (ITEM 3) INTO SHIM (ITEM 2) USING LOCTITE 411 PER MANUFACTURER'S INSTRUCTIONS.
 8. SHIM MATERIAL FROM SAME CASTING AS PART SE141-116. MARK FOR IDENTIFICATION.



REV	CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
7	-3		SHIM INSULATING SLEEVE ALL TYPES	GIICR	NEMA LI 1 - 1998	3
1	-2		POLOIDAL BREAK SHIM TYPE-C	NOTE 8	--	2
AR X	-1		POL BREAK SHIM ASSEMBLY TYPE-C			1

SE141-103 ← NEXT ASSEMBLY

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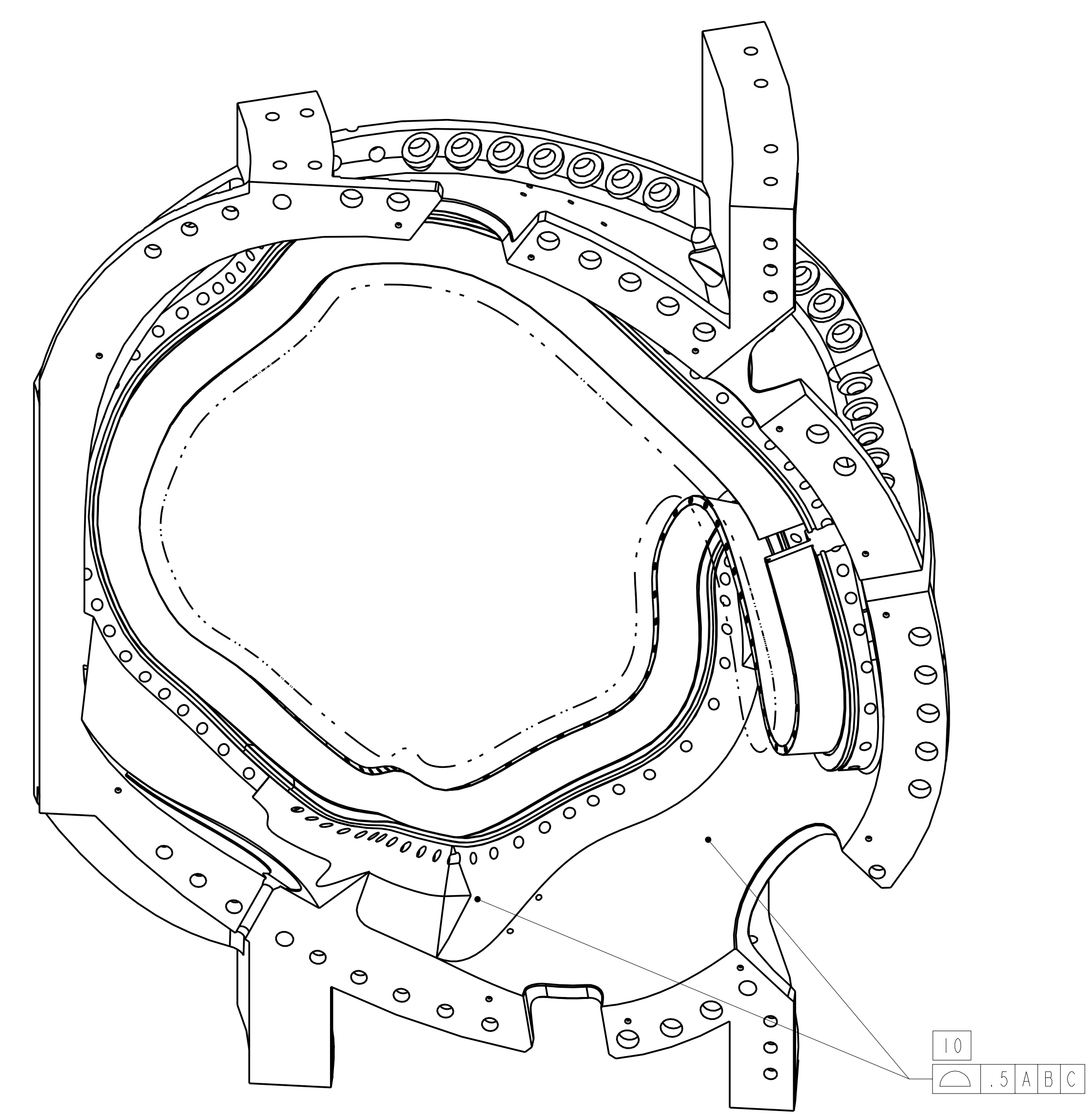
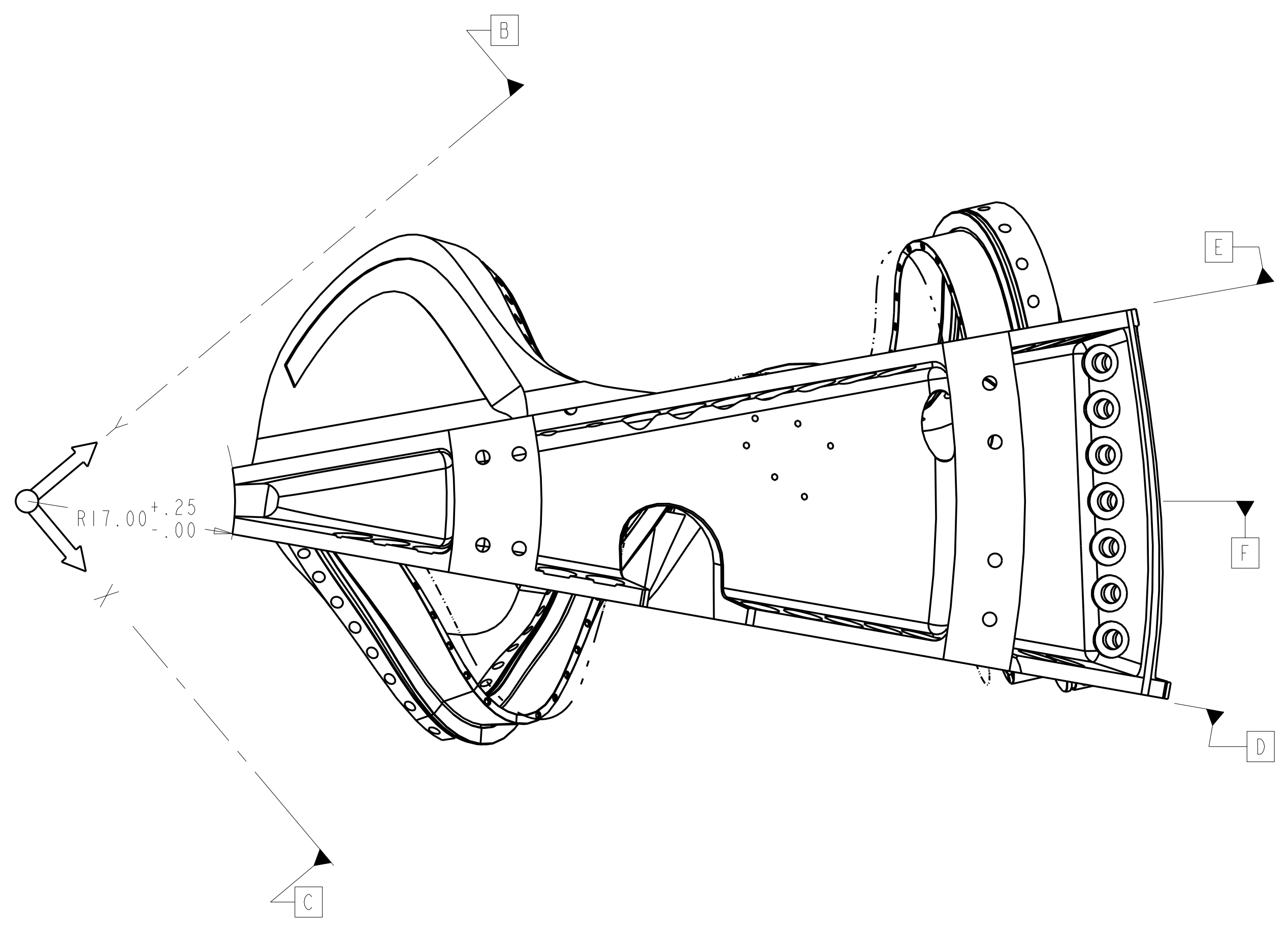
P THIS DRAWING PRODUCED ON PRO-ENGINEER

REV	DESCRIPTION	BY	DATE	CHK	DEPT	DATE	PE	REQ	DATE	DRNL	DOE	DATE

SCALE NOTED	DES	DATE
TOLERANCES UNLESS OTHERWISE SPECIFIED	P MILLER	6-30-04
FRACTIONS	P MILLER	6-30-04
XX DECIMALS ±.01	M COLE	6-30-04
XXX DECIMALS ±.005		
ANGLES ±0°15'		
BREAK SHARP EDGES 06 MAX		
FINISH .125 UNLESS OTHERWISE SPECIFIED		

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	
PROJECT NAME			
NATIONAL COMPACT STELLARATOR EXPERIMENT			
PART NAME			
POL BREAK SHIM ASSEMBLY TYPE-C			
VERSION NO.	PLANT	BLDG	FL
21+	X-10	5700	3
RELEASE LEVEL			
WIP			

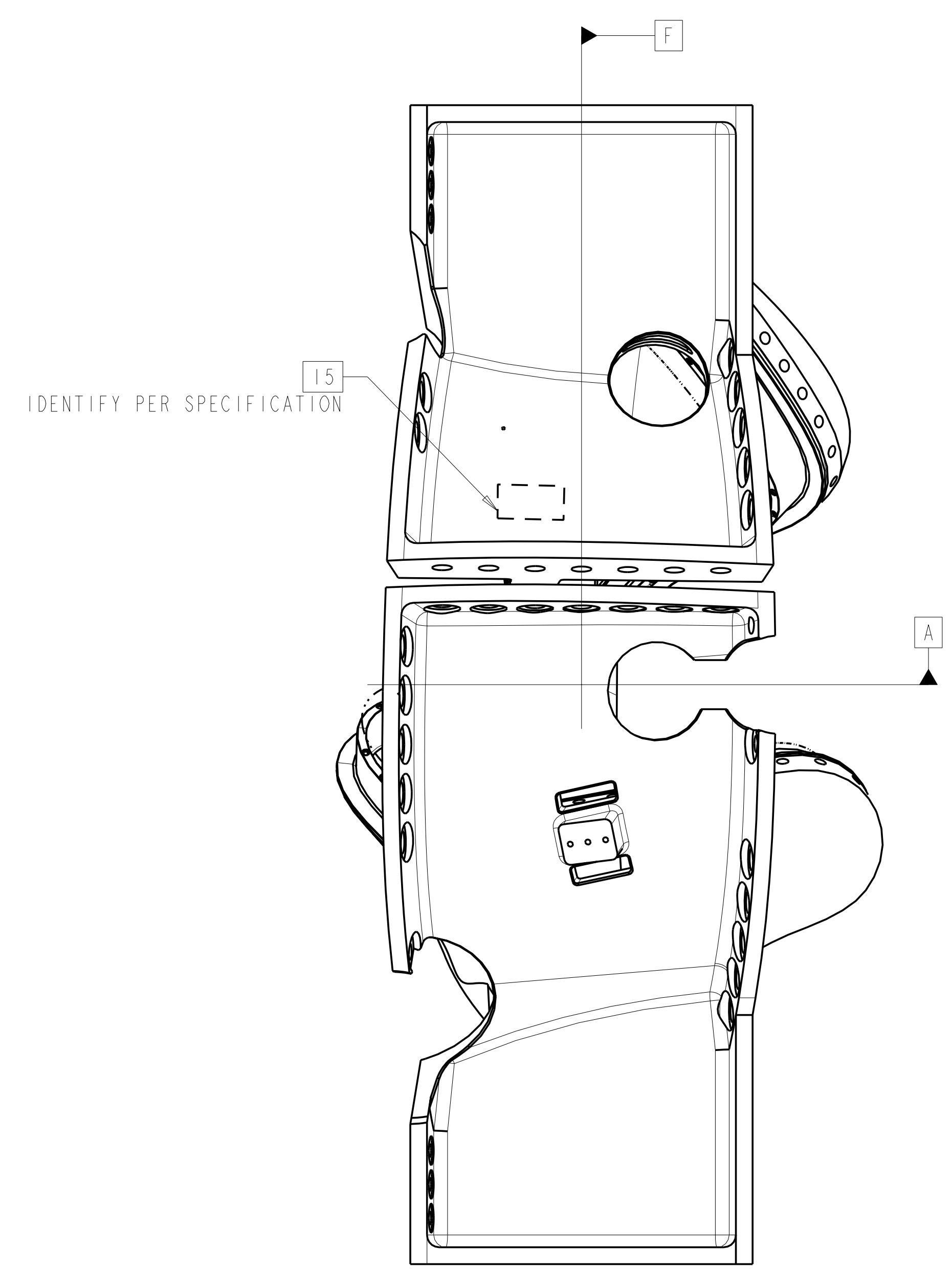
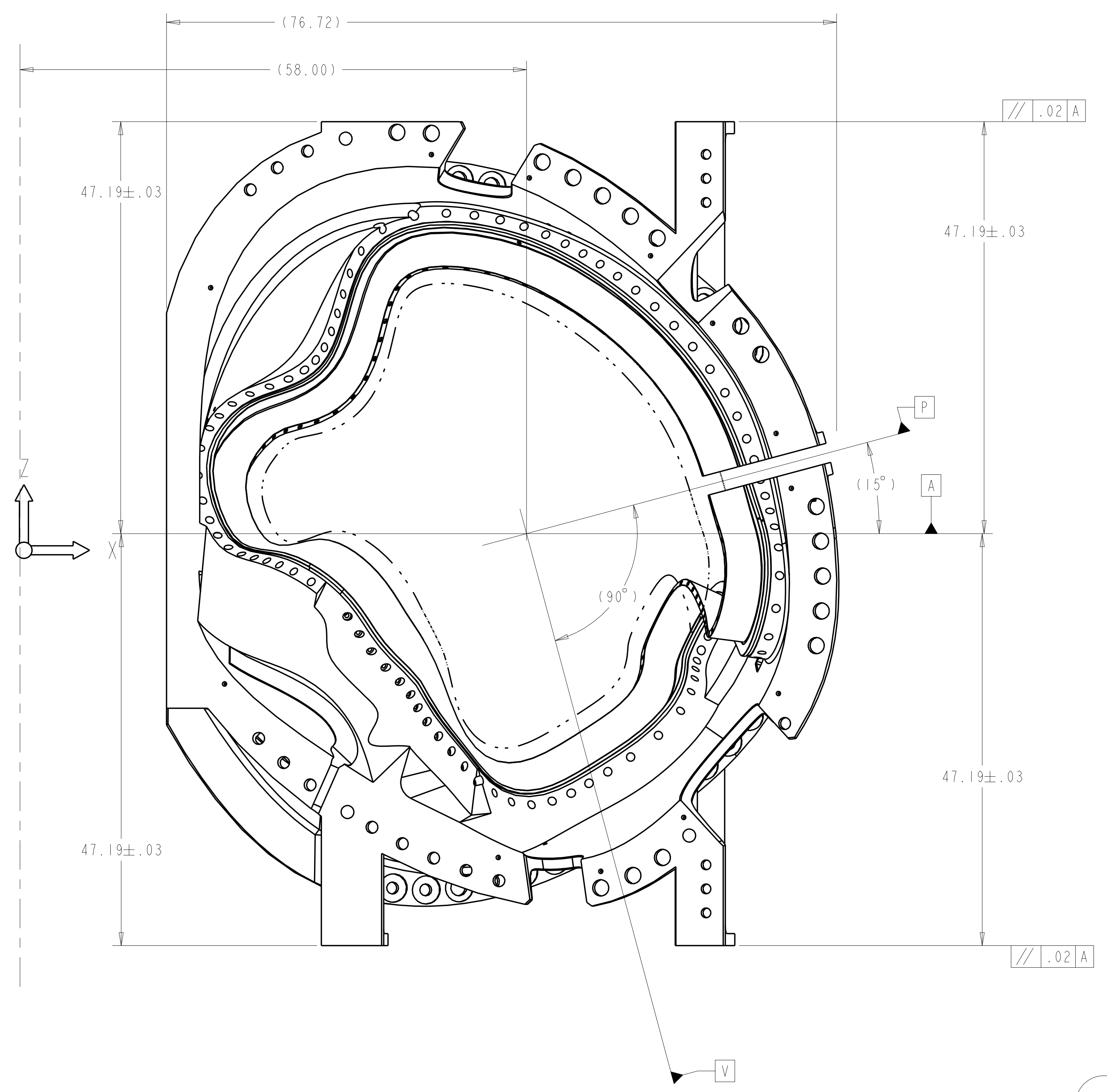
SE141-078



ISOMETRIC VIEW

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 SE141-116.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 TEMPERATURE OF 20-30°C (68-86°F)
7. DIMENSIONS AND TOLERANCES EXCLUDE PROCESS MATERIAL ALLOWANCES WHICH MAY ADD MASS.
8. APPROXIMATE WEIGHT = 4898 LBS. WEIGHT OF FINISHED PART NOT TO EXCEED 6000 LBS.
9. UNLESS OTHERWISE SPECIFIED, AS-CAST SURFACE PROFILE TOLERANCE = $\pm .25$ INCH, WITH EXEMPTION FOR INTERSECTING SURFACES WHERE FILLETS ARE EXPECTED. MIN FILLET AND CORNER RADII = $0.5 \pm .1$ IN.
10. DESIGNATED SURFACE REGIONS HAVE PROFILE TOLERANCE = ± 0.125 IN.
11. MIN THICKNESS PER CAD GEOMETRY, TOLERANCE = $+0.25$ IN / -0.0 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. BACK SPOTFACE ALL THRU HOLES MINIMUM TO CLEAN UP.
15. SEE LATEST REVISION OF SPECIFICATION NCSX-CSPEC-141-03 FOR ADDITIONAL REQUIREMENTS.



SCALE .125

AR	X	SE141-116	WINDING FORM TYPE-C	CAST SS	SEE NOTE #15	I
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

REV	DESCRIPTION	BY	DATE	CHK	DEPT	DATE	PE	REQ	DATE	ORNL	DOE	DATE
REVISION OR ISSUE PURPOSE	REVISION APPROVAL											

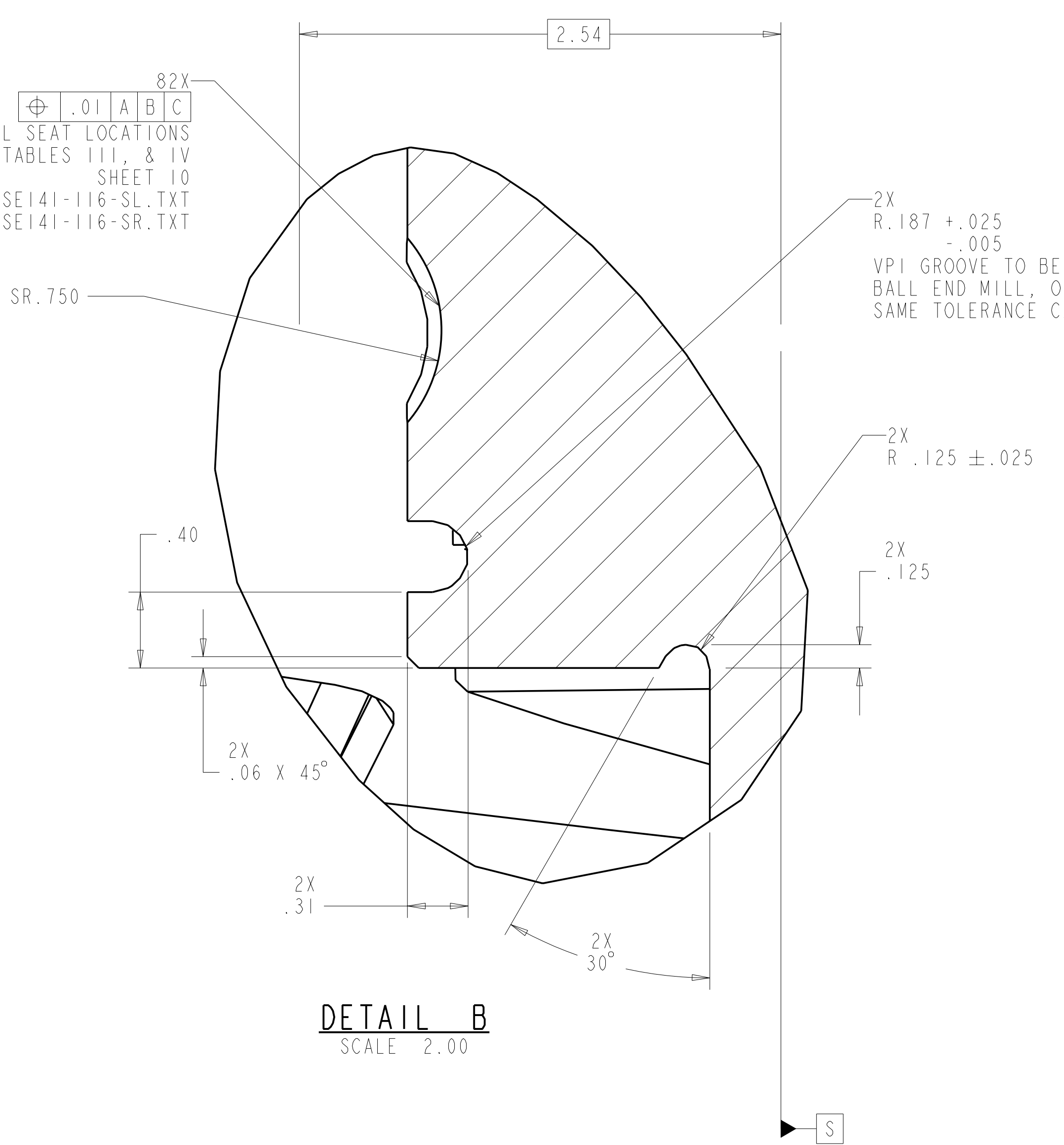
SCALE NOTED	DES T BROWN	5-5-04
TOLERANCES UNLESS OTHERWISE SPECIFIED	DRW P MILLER	5-5-04
FRACTIONS	CHK M. COLE	6-25-04
XX DECIMALS ± .01	DEPT :	
XXX DECIMALS ± .005	PE D. WILLIAMSON	6-25-04
ANGLES ± 0°15'	CR :	
BREAK SHARP EDGES .06 MAX	PJ :	
FINISH .125 UNLESS OTHERWISE SPECIFIED	RED :	
	PPPL DRFT J. SIEGEL	6-25-04

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 PROJECT NAME									
NATIONAL COMPACT STELLARATOR EXPERIMENT									
PRODUCTION WINDING FORM TYPE-C									
VERSION NO.	PLANT	BLDG	FL	SHT OF	TYPE	CLASS	REV		
36	X-10	5700	3	1	S	U	0		
RELEASE LEVEL	SE141-116								
WIP									

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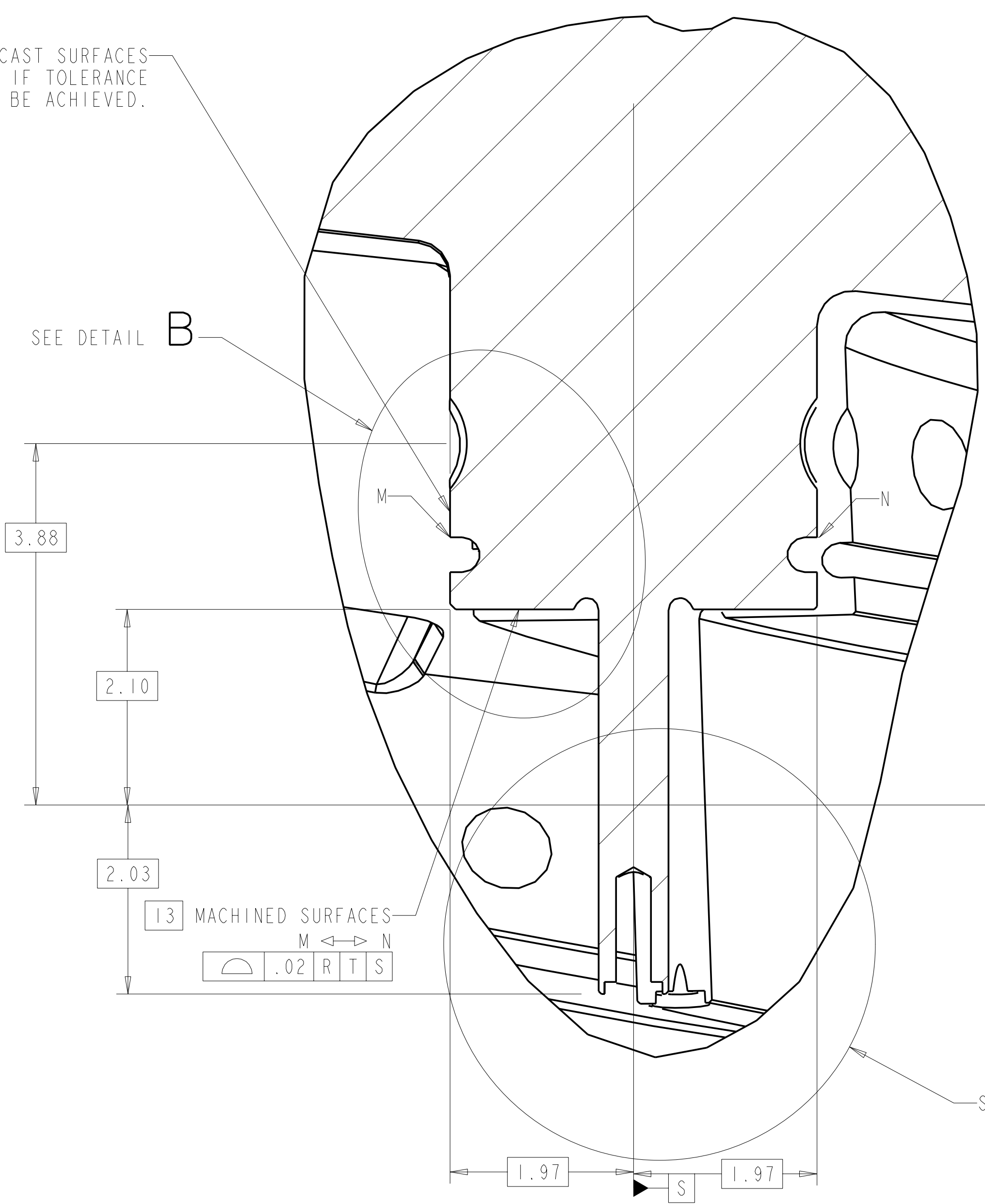
FOR NOTES AND PARTS LIST SEE SHEET 1

82X
 $\oplus .01 \begin{matrix} A \\ B \\ C \end{matrix}$
 SPHERICAL SEAT LOCATIONS
 SHOWN IN TABLES III, & IV
 SHEET 10
 DATA FILES SE141-116-SL.TXT
 AND SE141-116-SR.TXT



DETAIL B
 SCALE 2.00

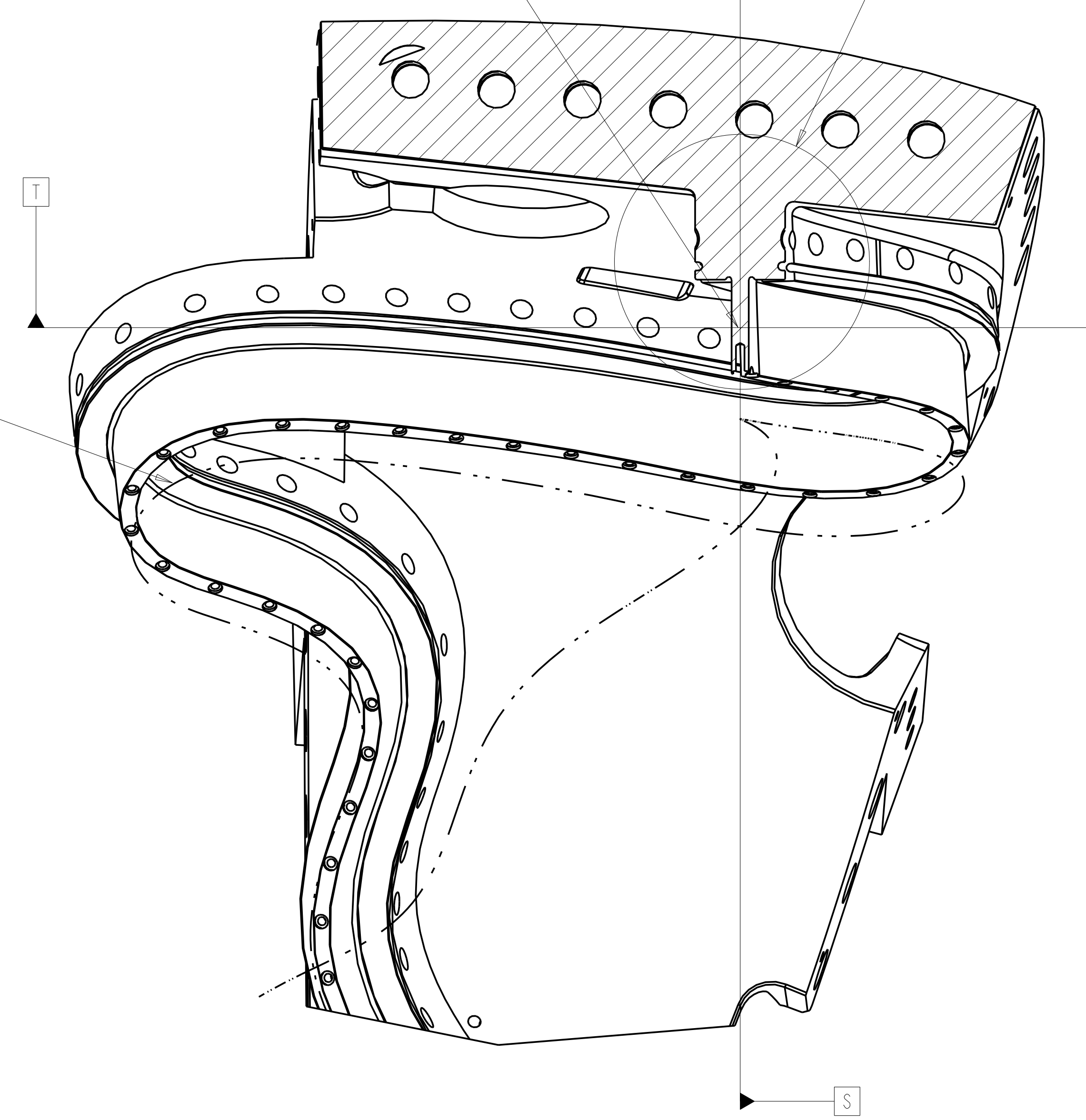
AS CAST SURFACES
 ACCEPTABLE. IF TOLERANCE
 CAN BE ACHIEVED.



DETAIL A
 SCALE 1.00

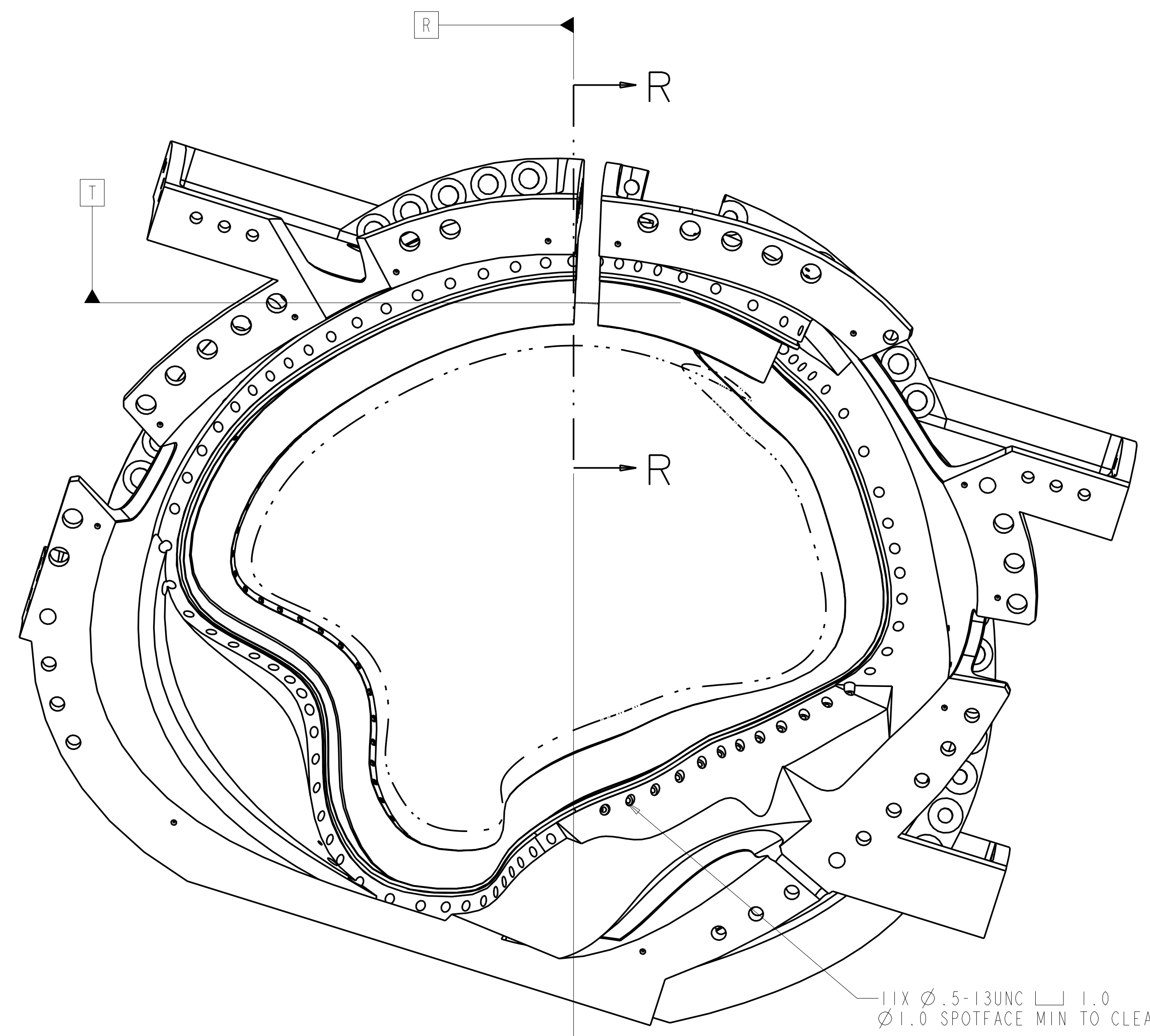
TYPICAL FOR ALL POINTS ALONG WINDING CENTER

WINDING CENTER CURVE
 SPLINE PASSING THRU POINTS
 SHOWN IN TABLE I, SHT 11
 DATA FILE SE141-116-WC.TXT

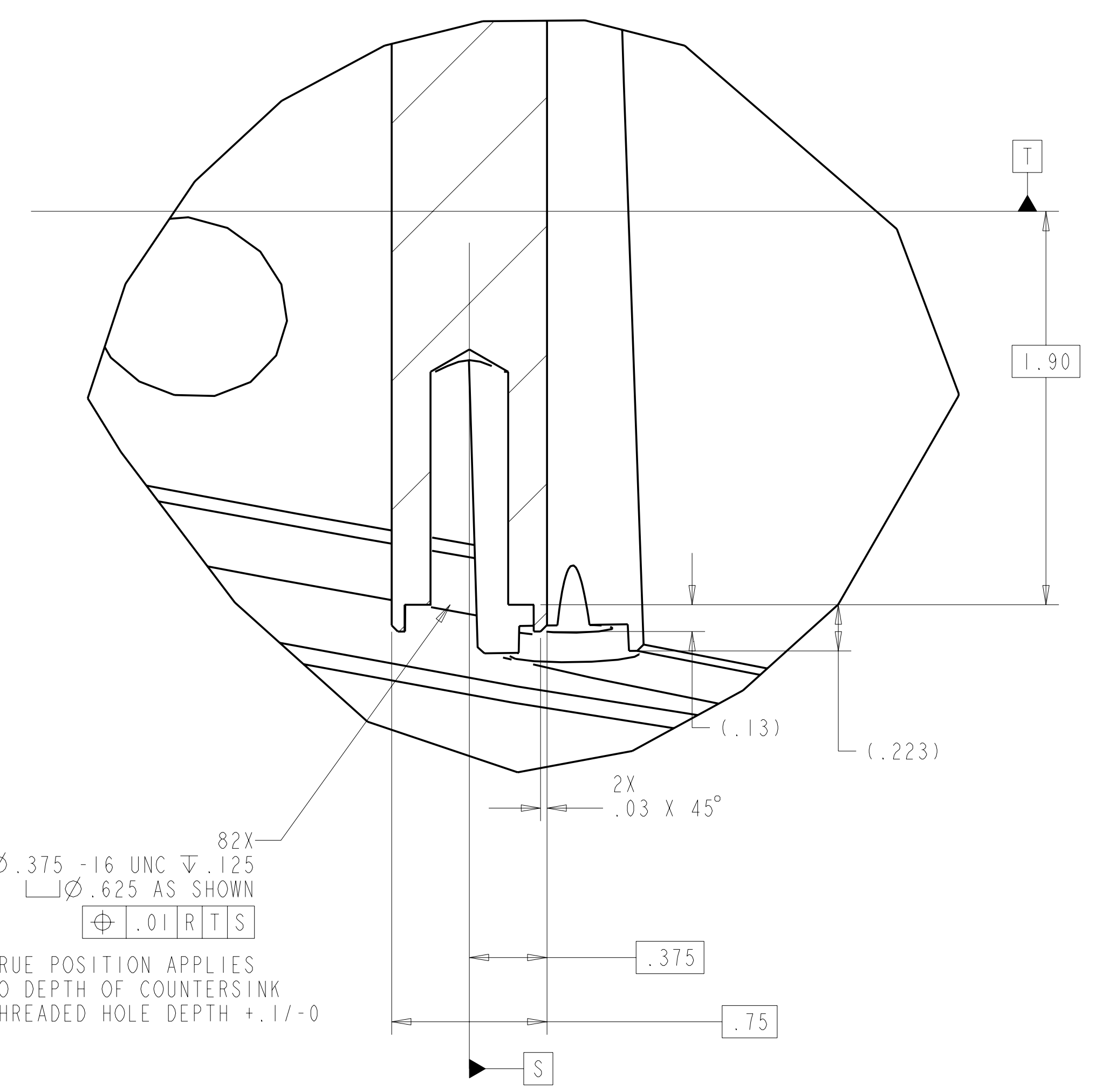


SECTION R-R
 SCALE 0.25

X VECTOR CURVE
 SPLINE PASSING THRU POINTS
 SHOWN IN TABLE II, SHT 11
 DATA FILE SE141-116-XV.TXT



11X $\phi .5-13\text{UNC}$ 1.0
 $\phi 1.0$ SPOTFACE MIN TO CLEAN UP



DETAIL C
 SCALE 2.00

TRUE POSITION APPLIES
 TO DEPTH OF COUNTERSINK
 THREADED HOLE DEPTH $+ .17 \pm 0$

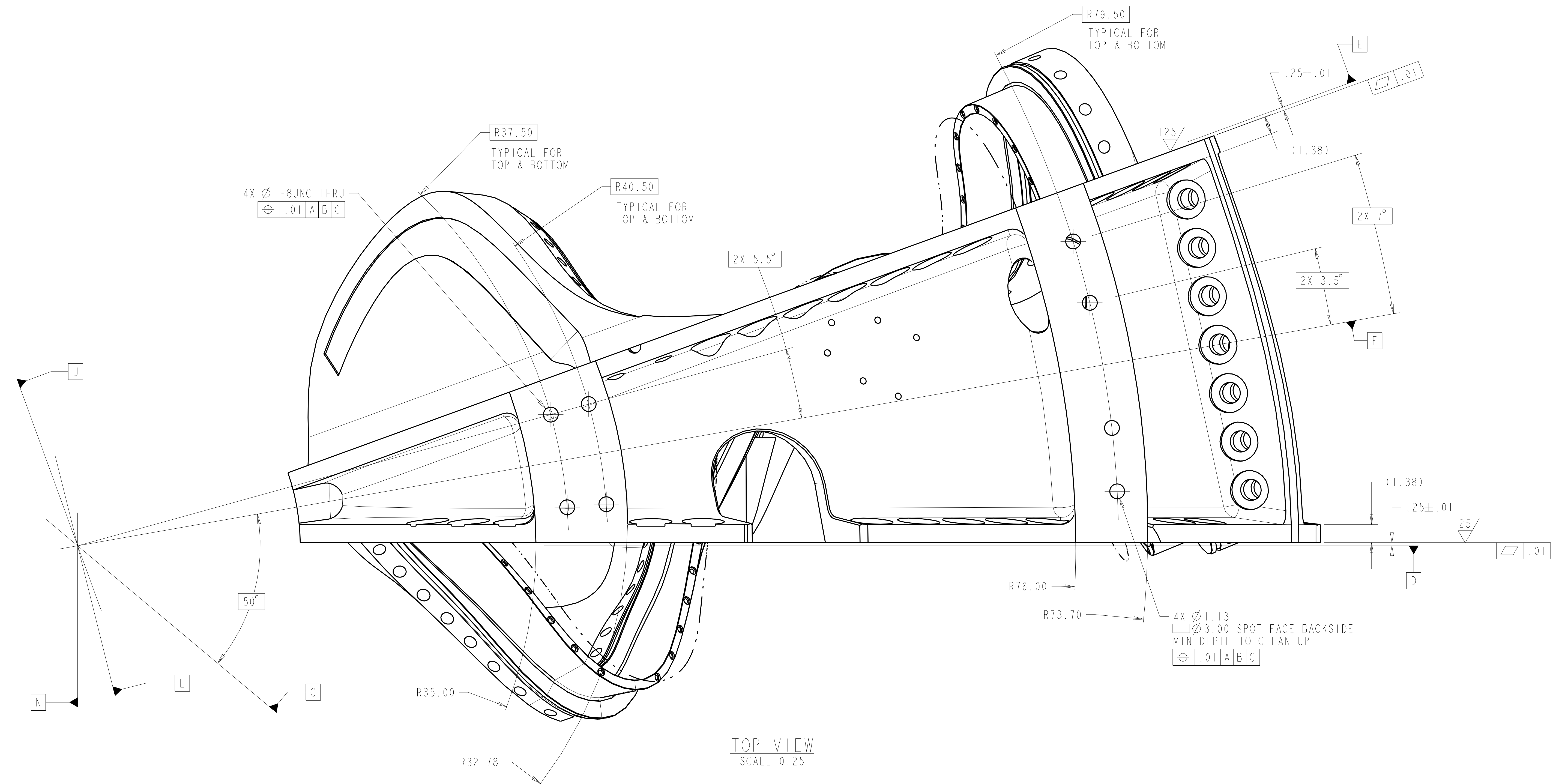
DATUM R = PLANE NORMAL TO WINDING CENTER
 DATUM S = PLANE PASSING THRU WINDING CENTER AND X VECTOR AT DATUM R
 DATUM T = PLANE PASSING THRU WINDING CENTER ORTHOGONAL TO DATUM S

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							
UT-BATTELLE NATIONAL COMPACT STELLARATOR EXPERIMENT							
PRODUCTION WINDING FORM TYPE-C							
VERSION NO.	PLANT	BLDG	FL	SHT OF	TYPE	CLASS	
36	X-10	5700	3	2	11	S	U
RELEASE LEVEL	SE141-116						REV
WIP							0

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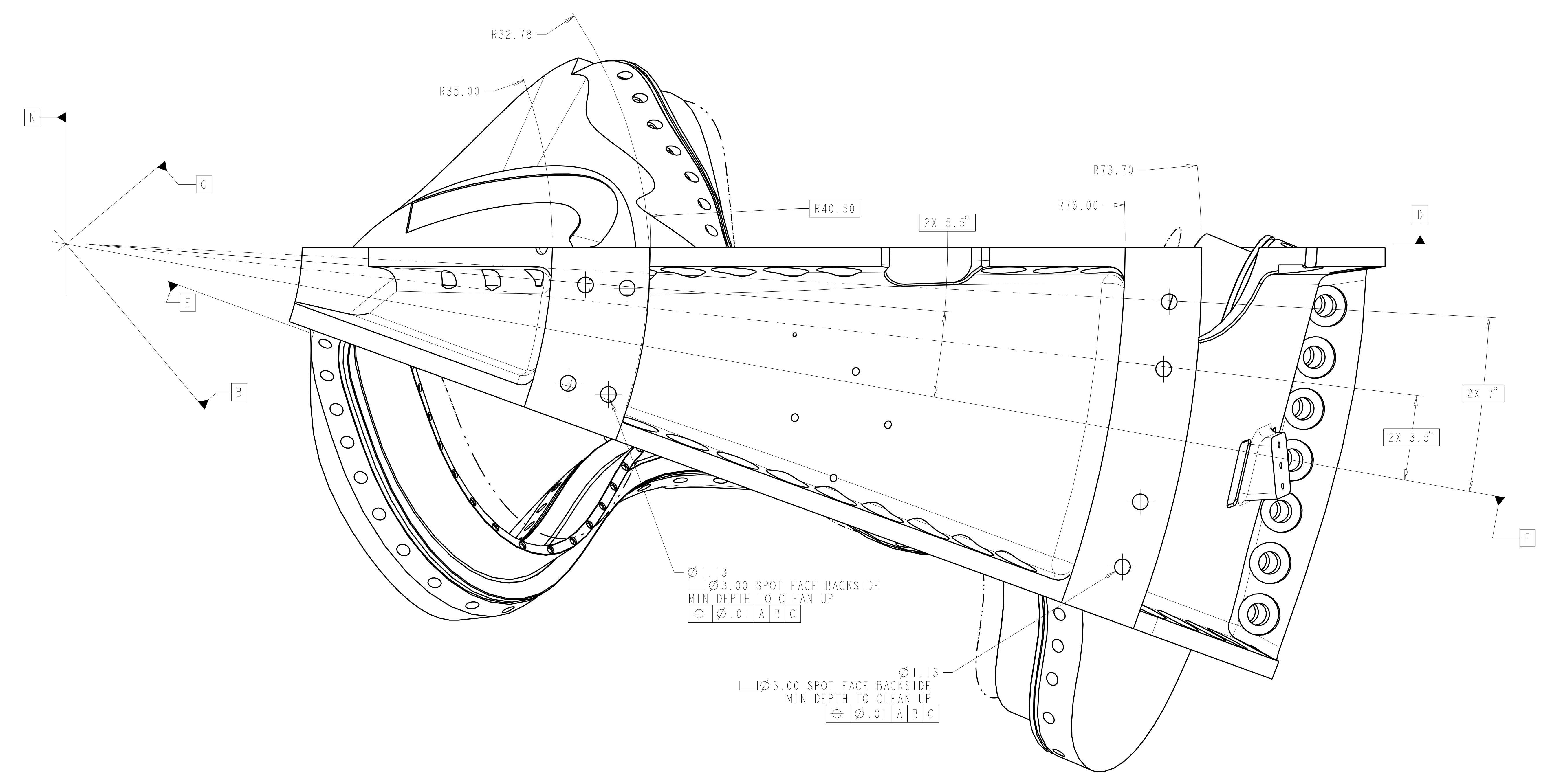
SE141-116

FOR NOTES AND PARTS LIST SEE SHEET 1



TOP VIEW
SCALE 0.25

DATUMS A B & C ARE MACHINE SPECIFIC.
ALL OTHER DATUMS LISTED ON THIS DRAWING
ARE SPECIFIC TO THIS PART

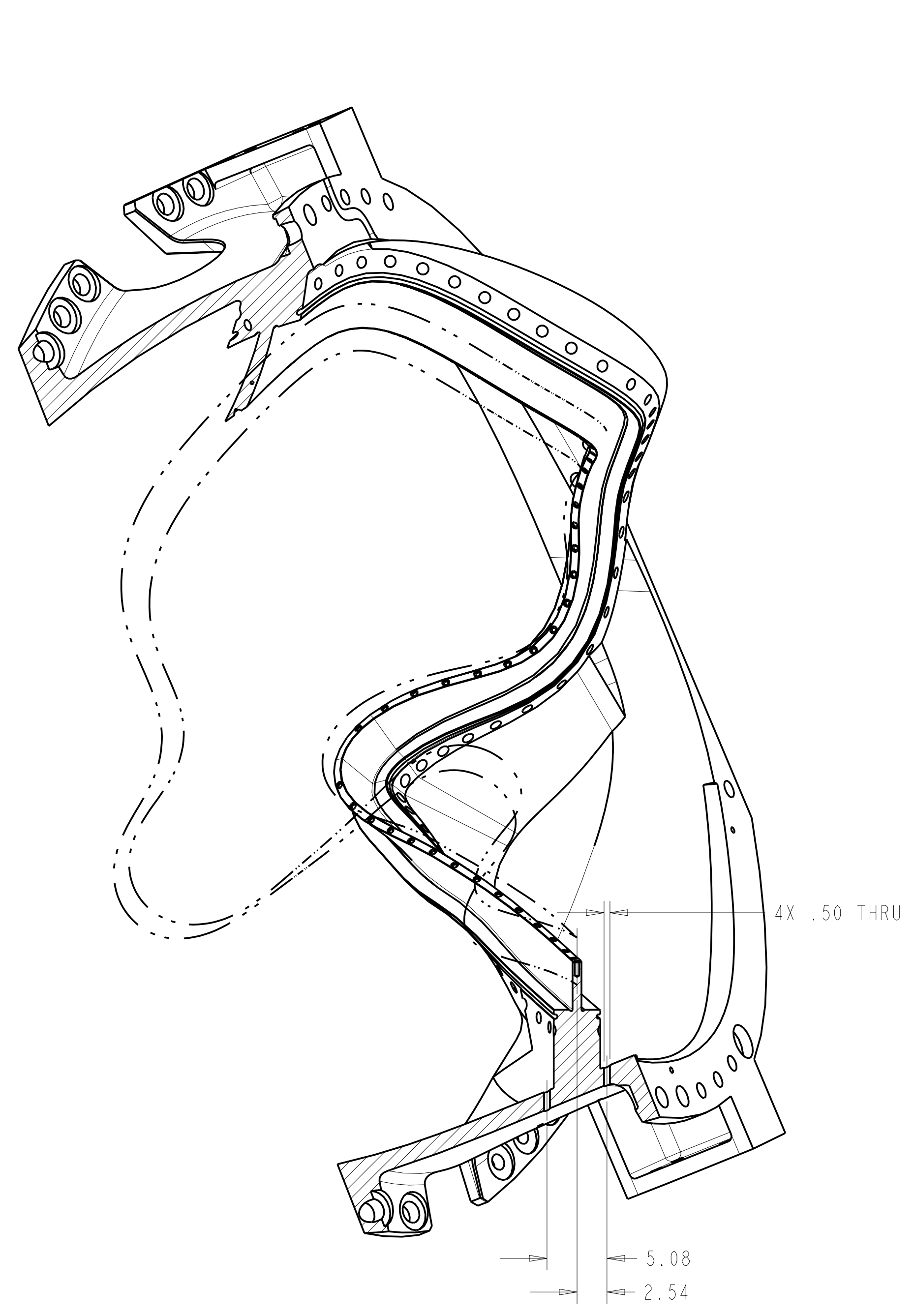


BOTTOM VIEW
SCALE 0.25

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							
PRODUCTION WINDING FORM TYPE-C							
VERSION NO.	PLANT	BLDG	FL	SHT OF	TYPE	CLASS	
36	X-10	5700	3	3	11	S	U
RELEASE LEVEL	SEI41-116					REV	0
WIP							

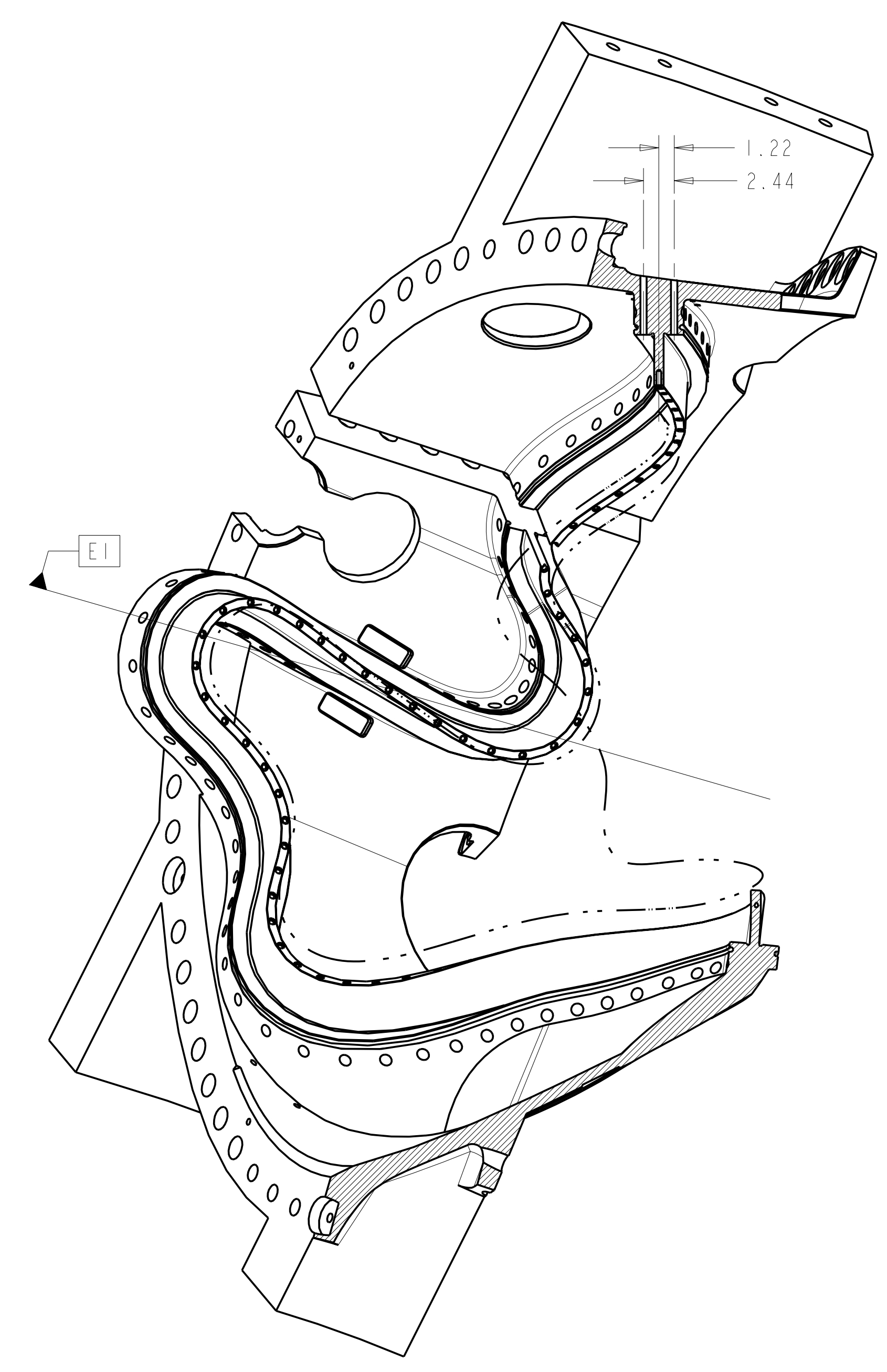
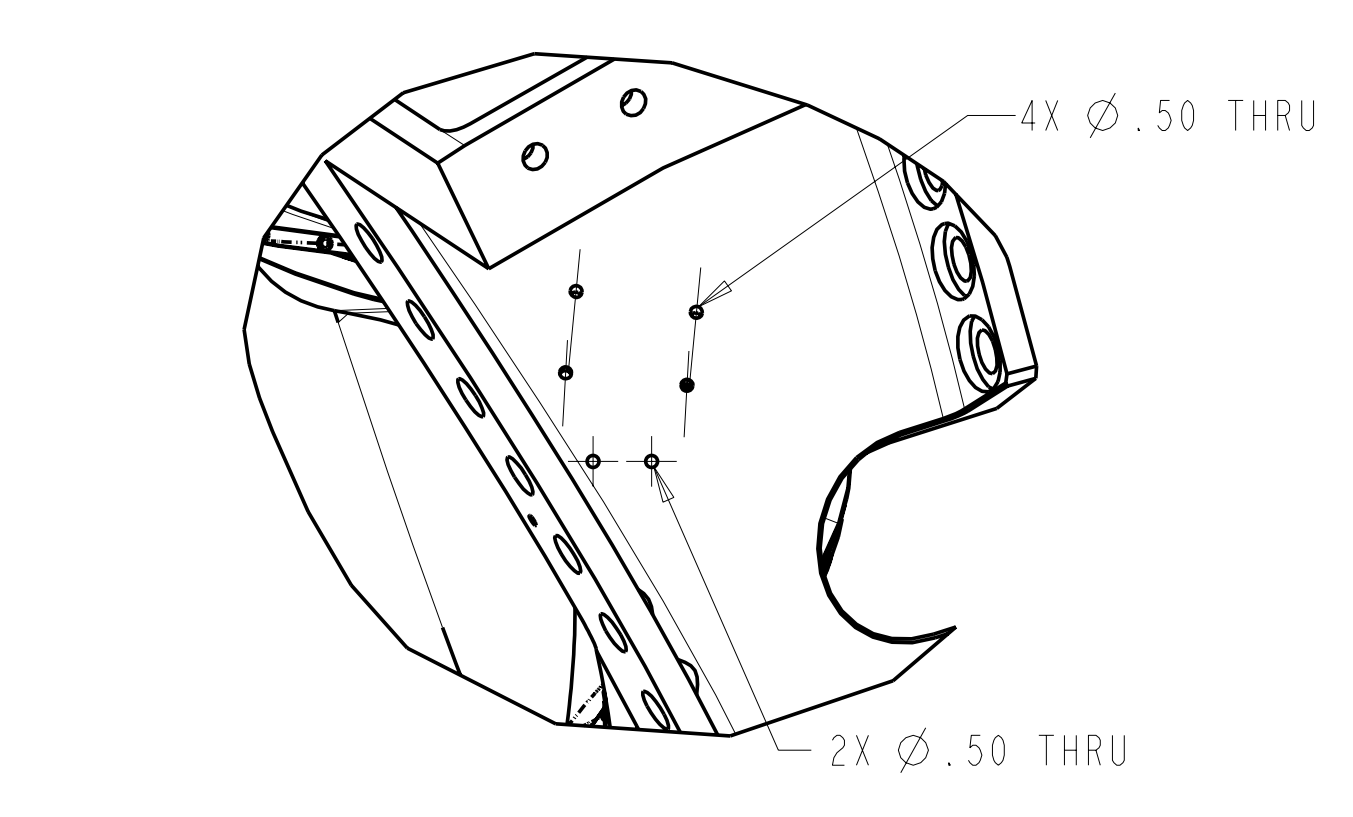
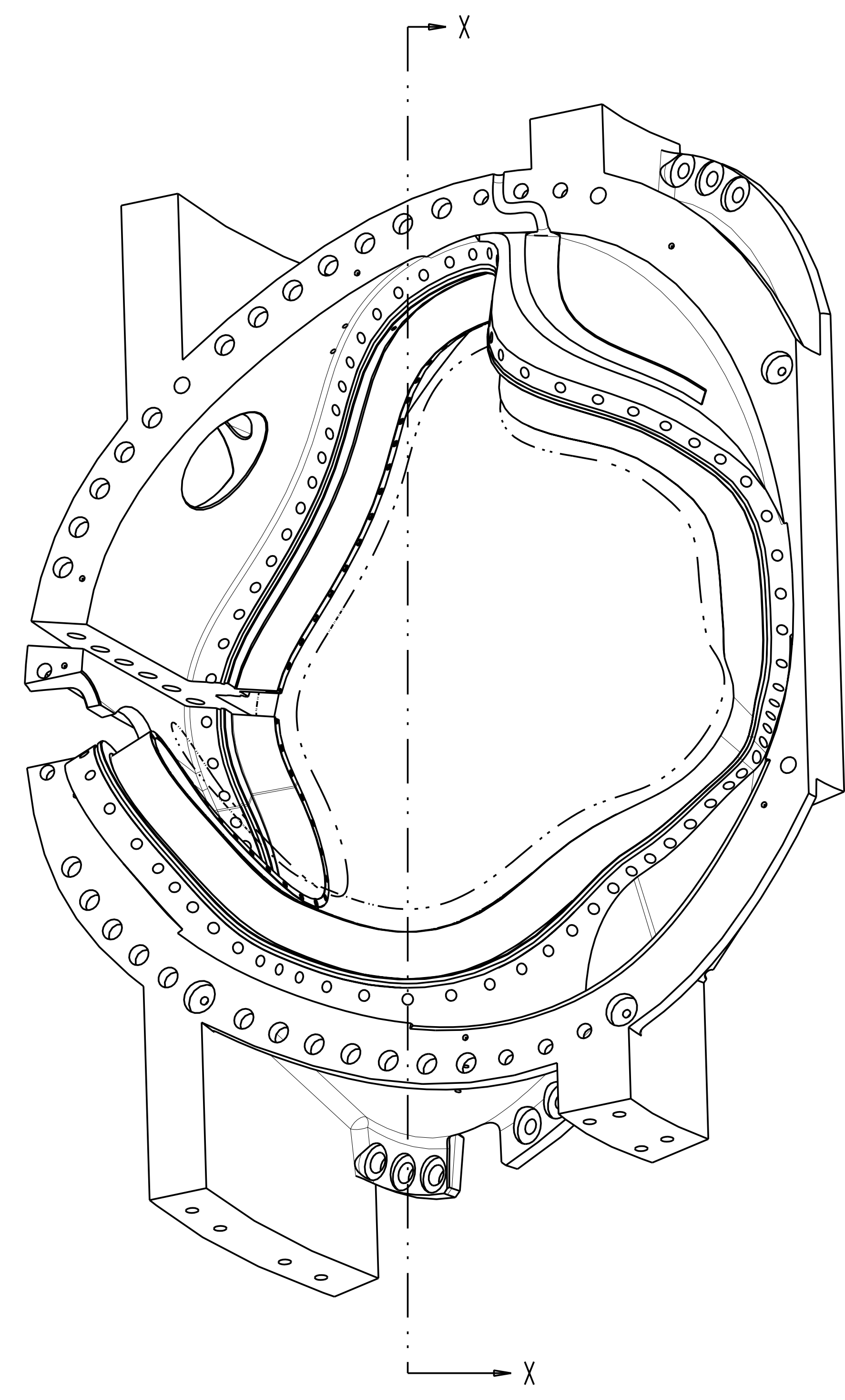
SEI41-116

FOR NOTES AND PARTS LIST SEE SHEET I



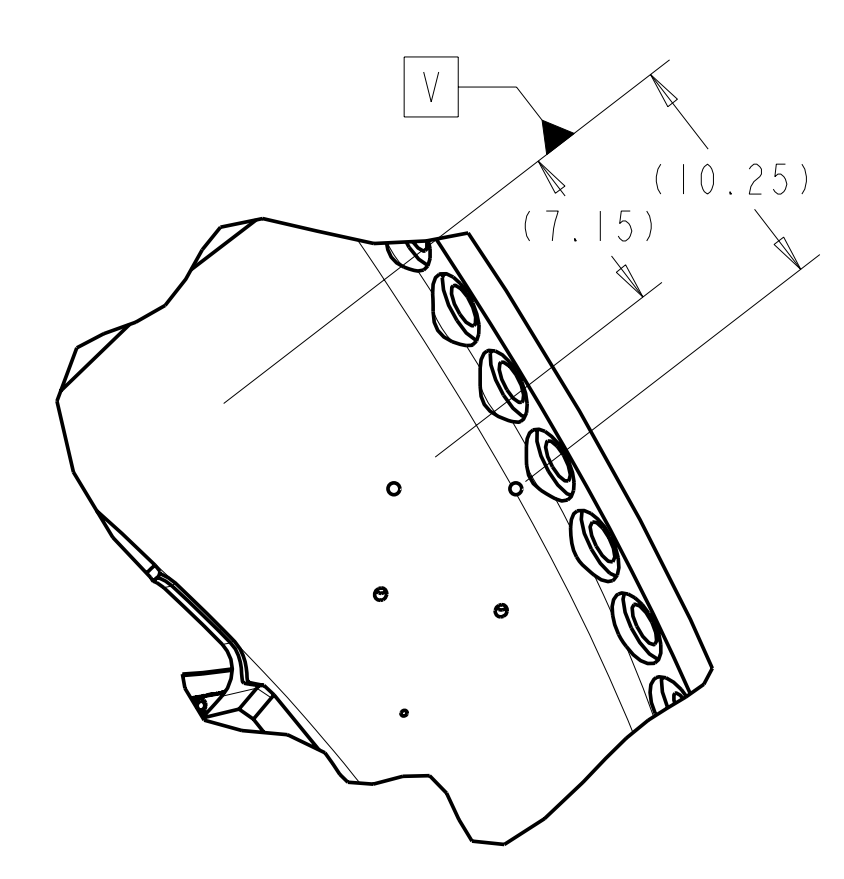
SECTION X-X
 SCALE 0.13

USE PRO/E MODEL GEOMETRY TO DETERMINE SECTION ORIENTATION

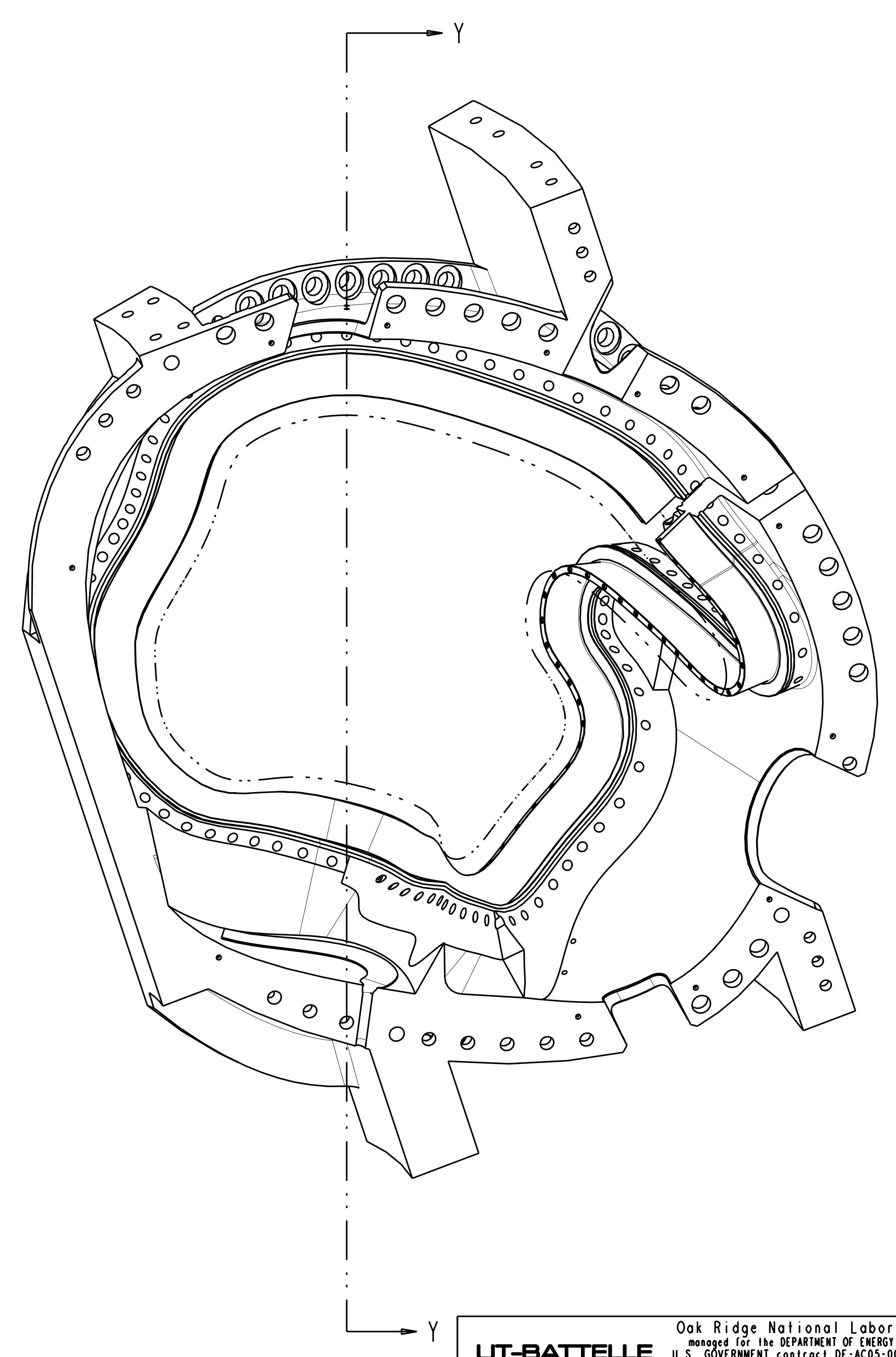


SECTION Y-Y
 SCALE 0.13

USE PRO/E MODEL GEOMETRY TO DETERMINE SECTION ORIENTATION



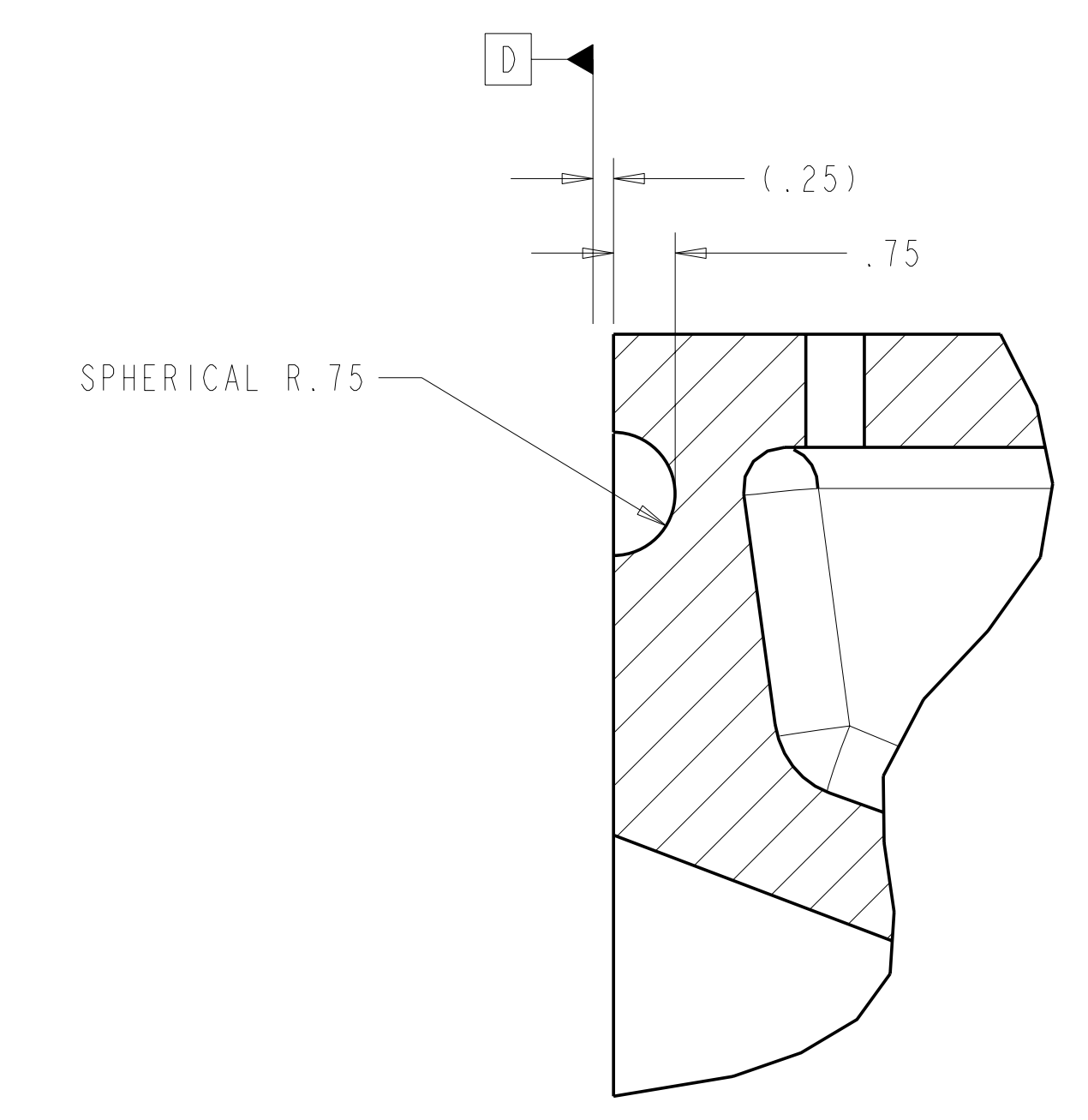
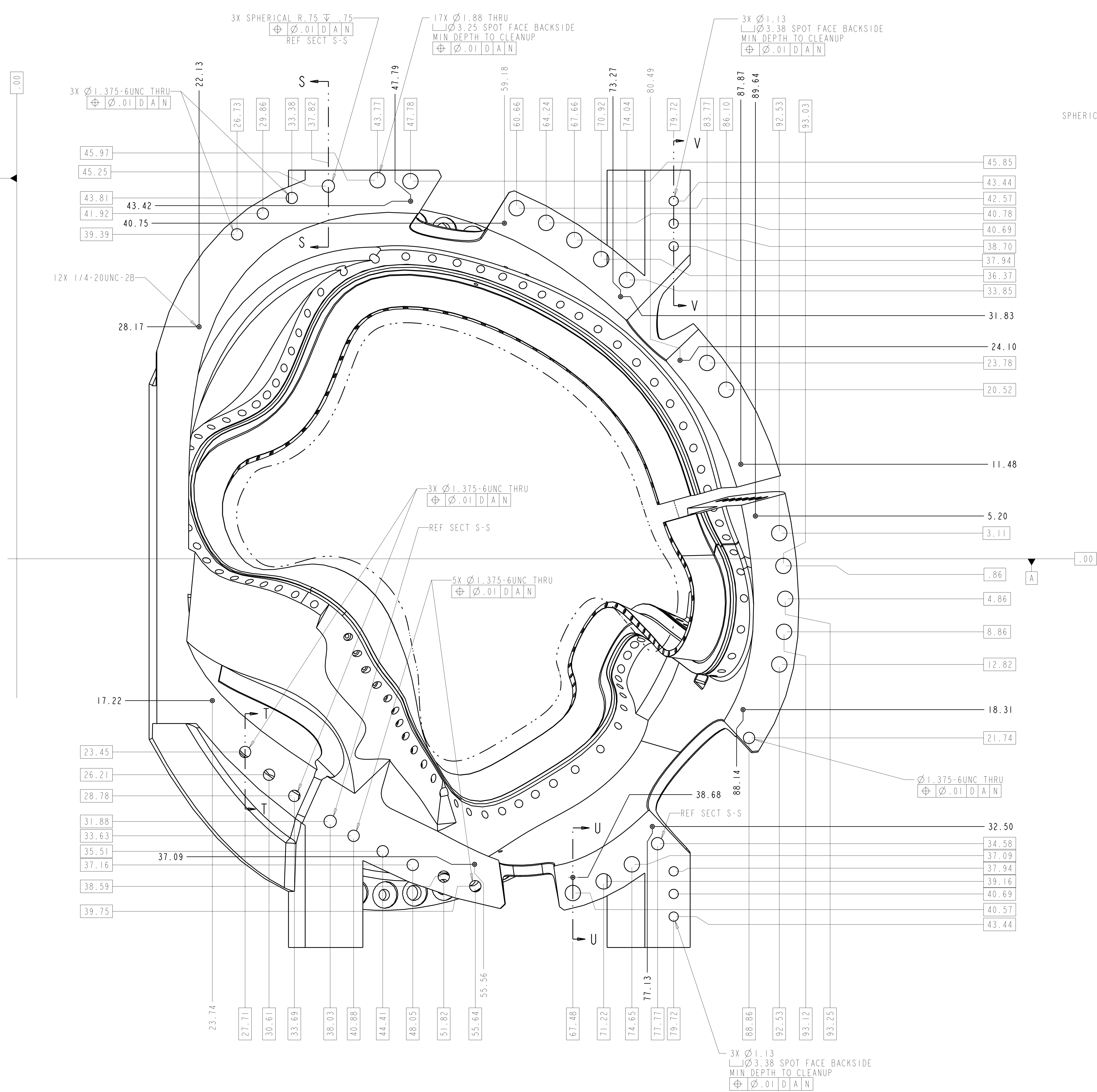
COOLING INLET / OUTLET HOLES
 TYPICAL 2 PLACES



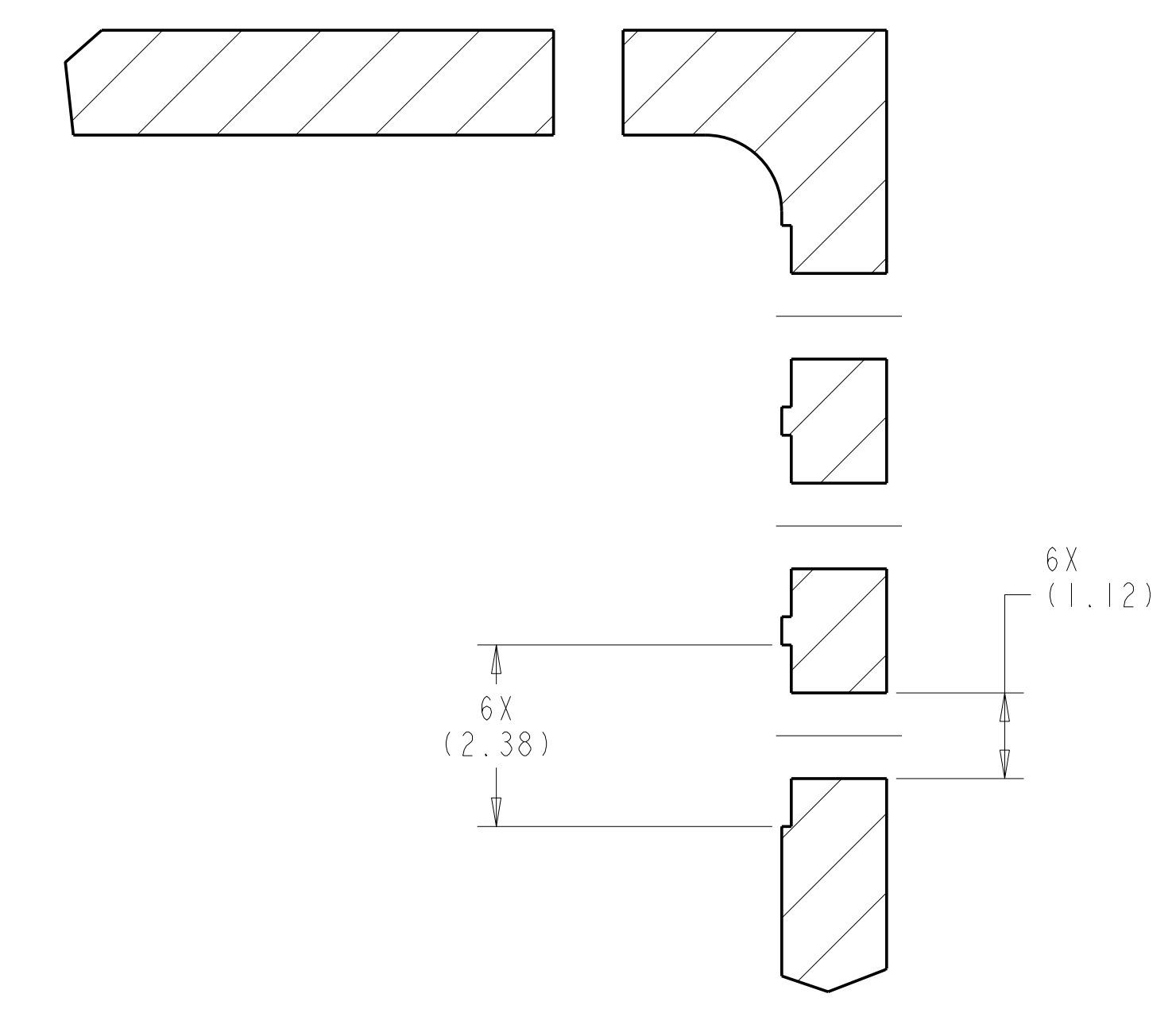
Oak Ridge National Laboratory managed for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT contract DE-AC05-00OR22725 UT-BATTELLE, LLC, Oak Ridge, Tennessee							
UT-BATTELLE							
NATIONAL COMPACT STELLARATOR EXPERIMENT							
PRODUCTION WINDING FORM TYPE-C							
VERSION NO.	PLANT	BLDG	FL	SHT OF	TYPE	CLASS	
36	X-10	5700	3	4	11	S	U
RELEASE LEVEL	SEI41-116						REV
WIP							0

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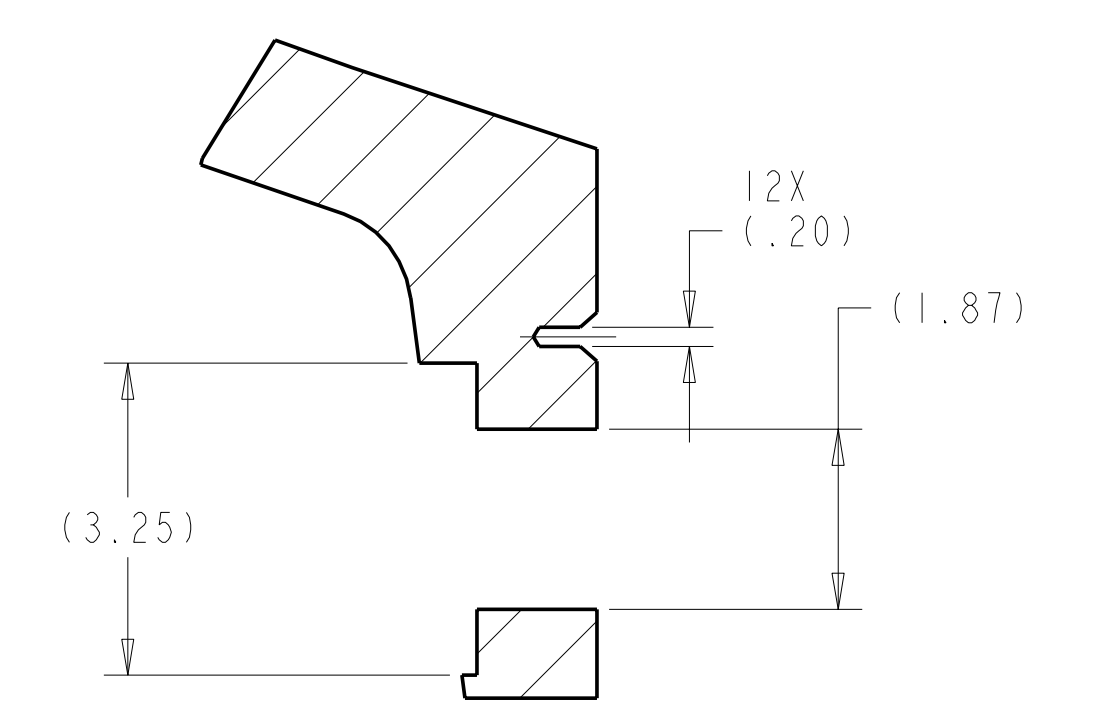
FOR NOTES AND PARTS LIST SEE SHEET 1



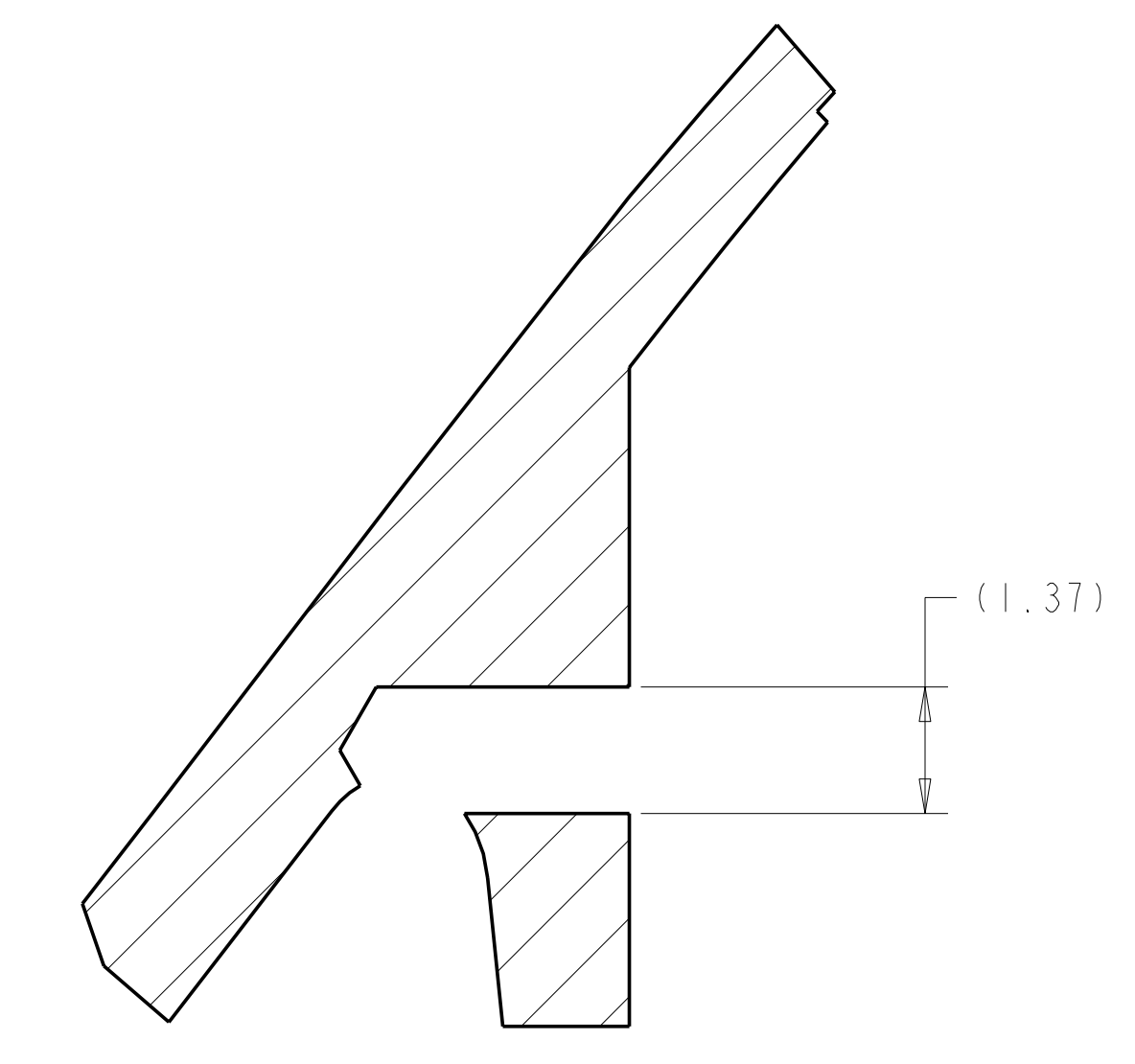
SECTION S-S
SCALE 0.50



SECTION V-V
SCALE 0.50



SECTION U-U
SCALE 0.50



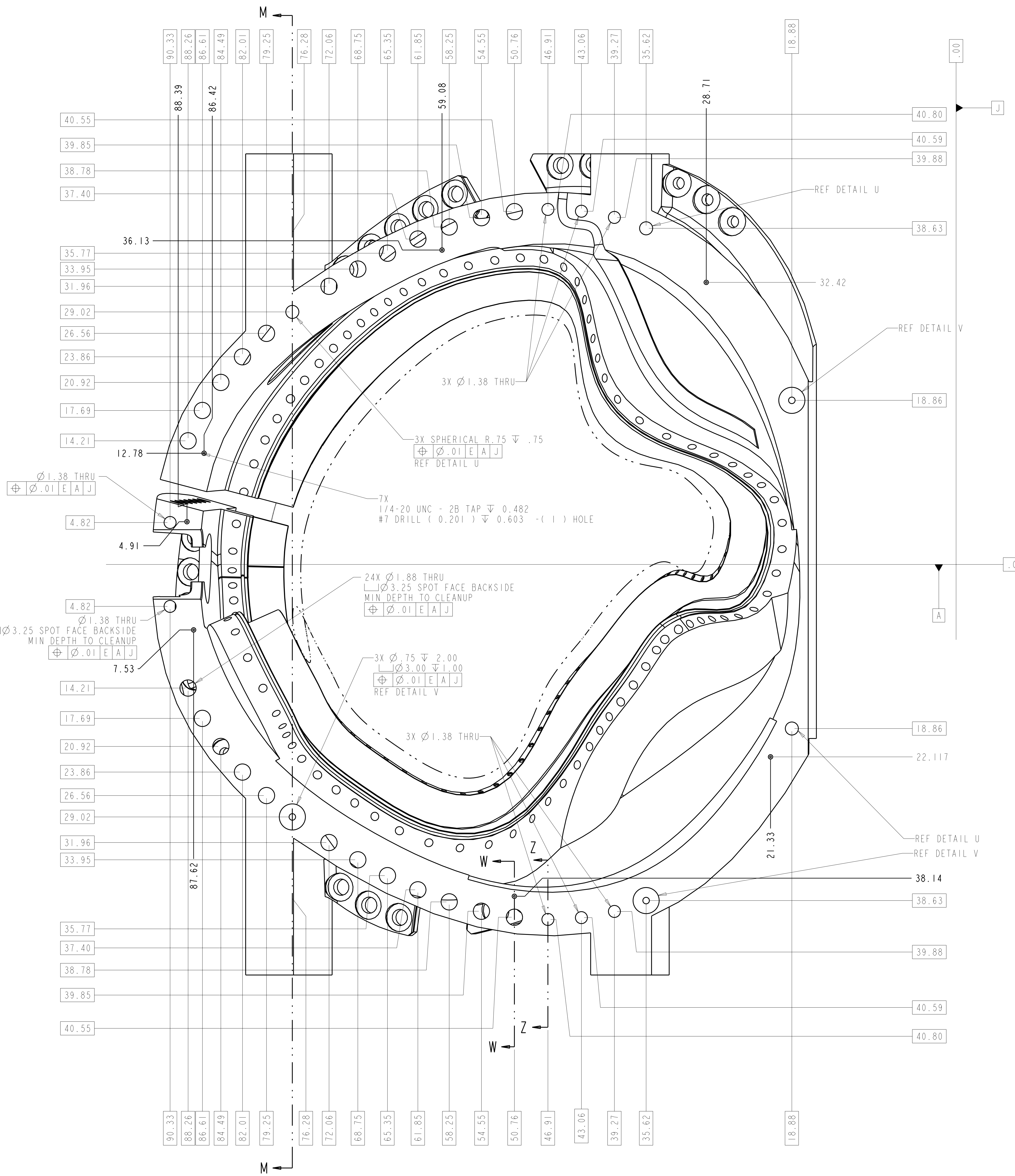
SECTION T-T
SCALE 0.50

VIEW AT DATUM D
SCALE 0.20

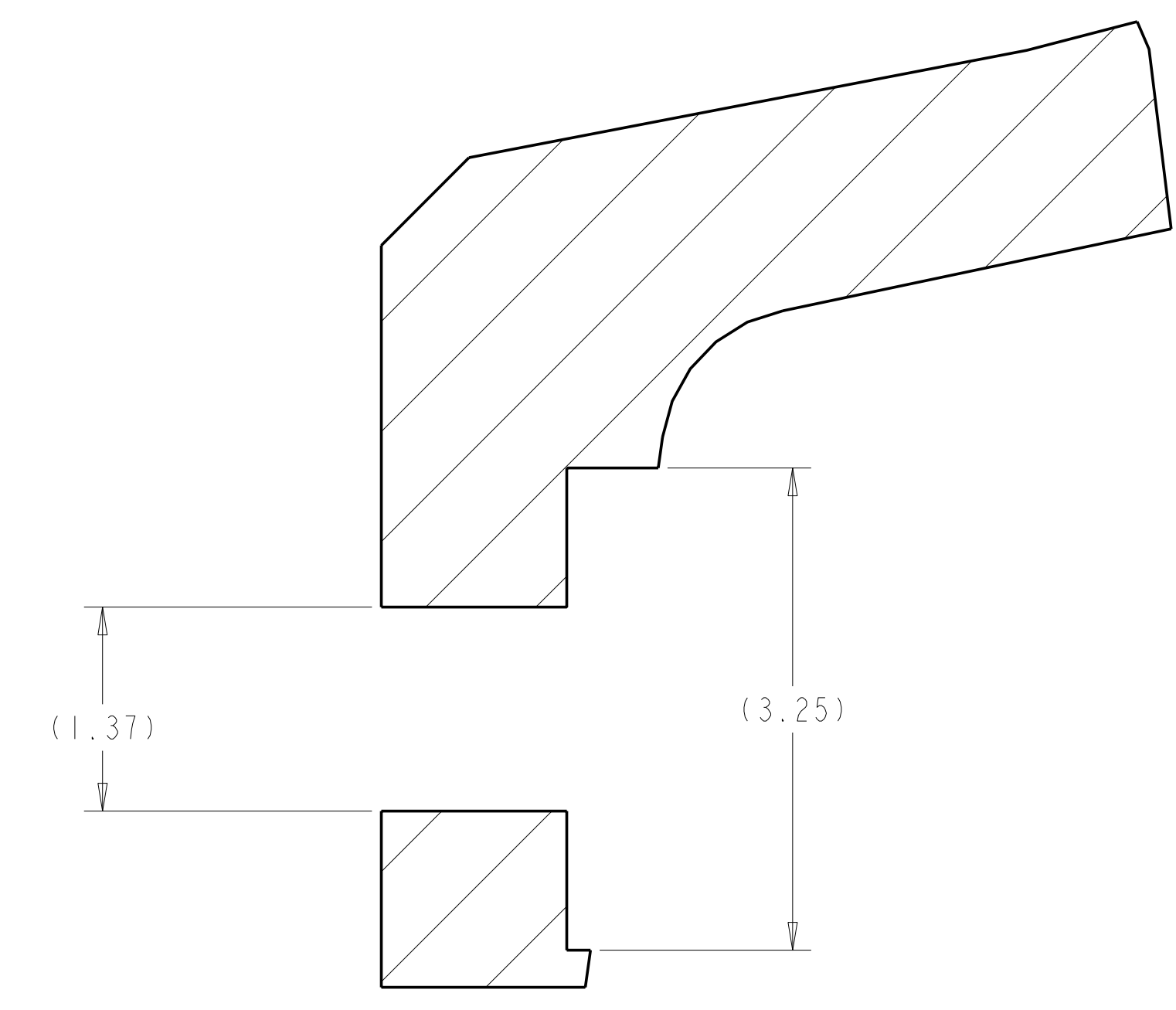
Oak Ridge National Laboratory managed for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT contract DE-AC05-00OR22725 UT-BATTELLE, LLC, Oak Ridge, Tennessee PROJECT NAME:								
UT-BATTELLE NATIONAL COMPACT STELLARATOR EXPERIMENT								
PRODUCTION WINDING FORM TYPE-C								
VERSION NO.	PLANT	BLDG	FL	SHT OF	TYPE	CLASS		
36	X-10	5700	3	5	11	S	U	
RELEASE LEVEL	SEI41-116						REV	0
WIP								

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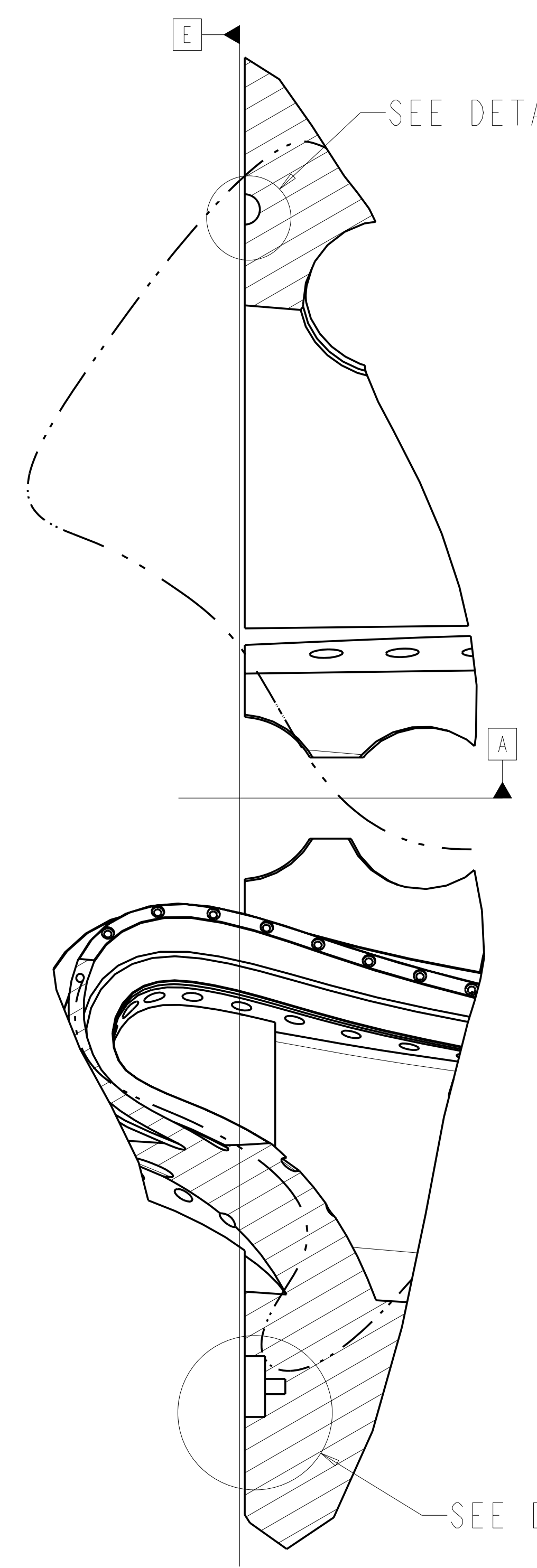
SEI41-116



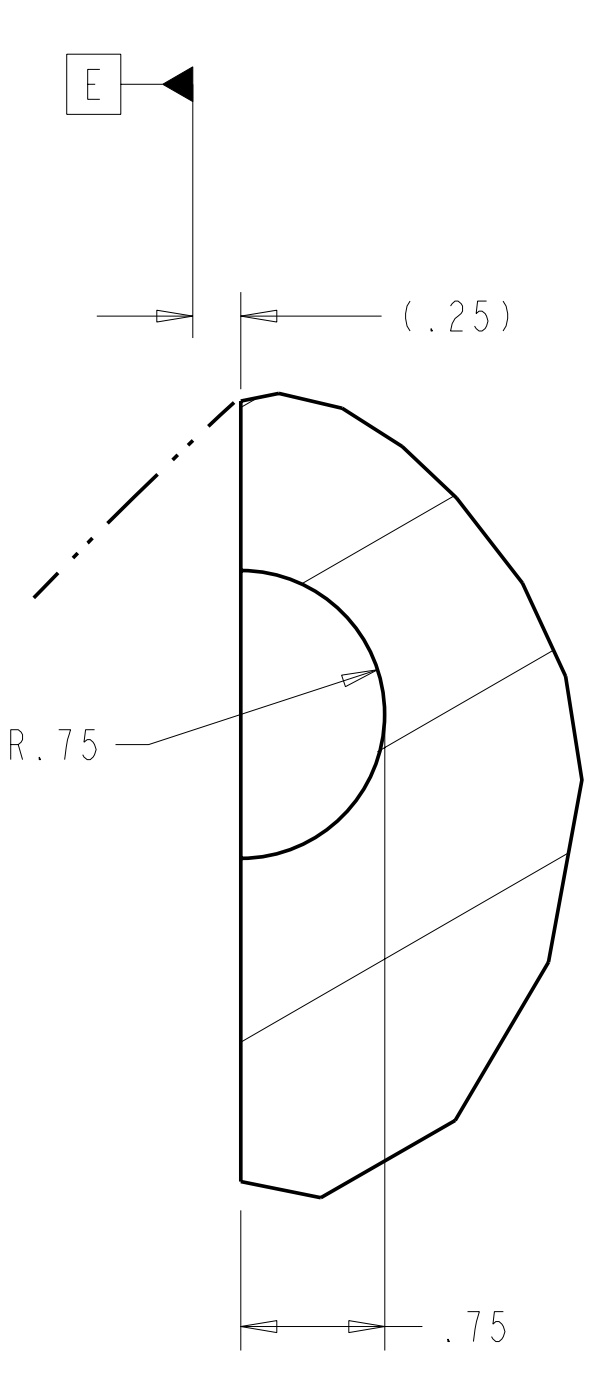
VIEW AT DATUM E
SCALE 0.20



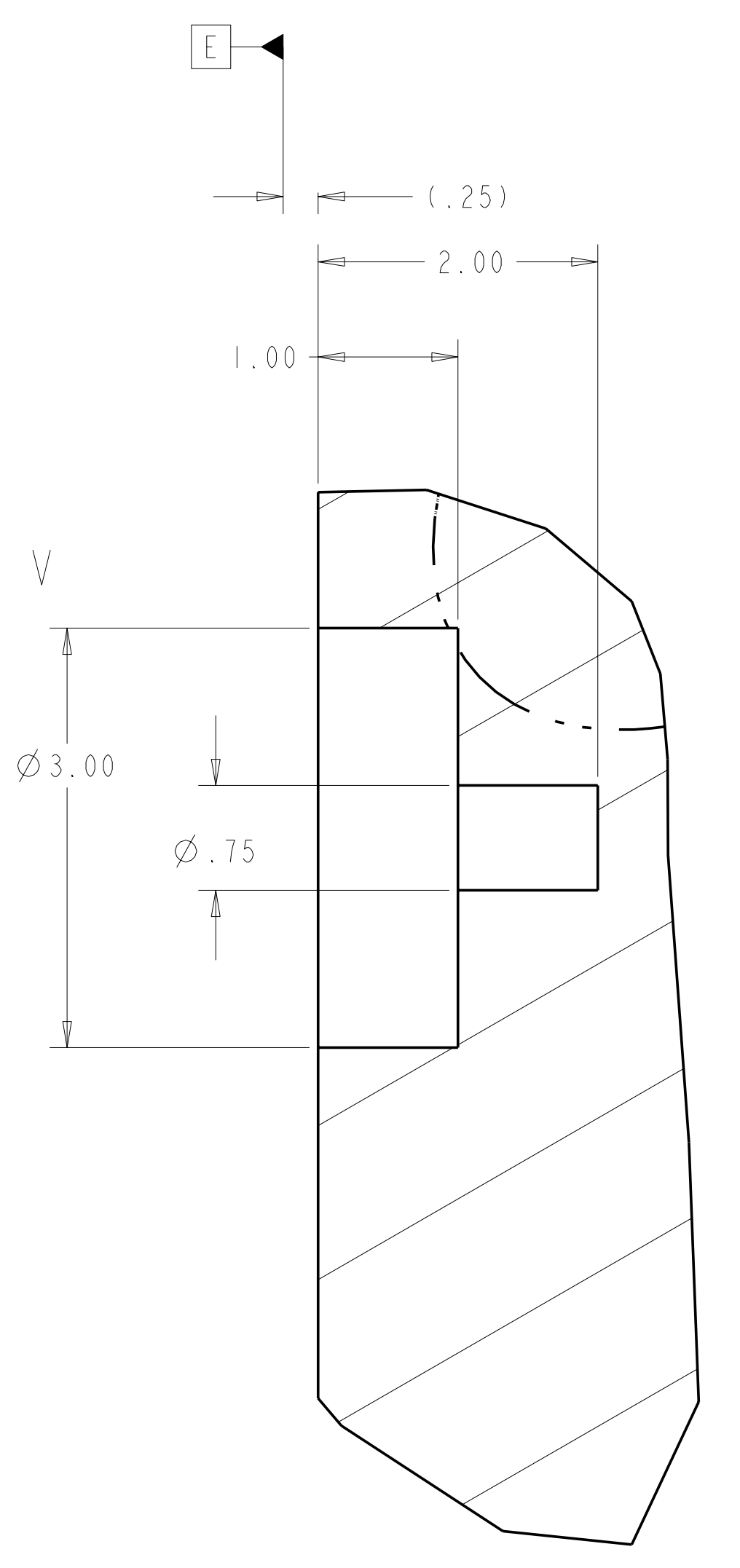
SECTION Z-Z
SCALE 1.00



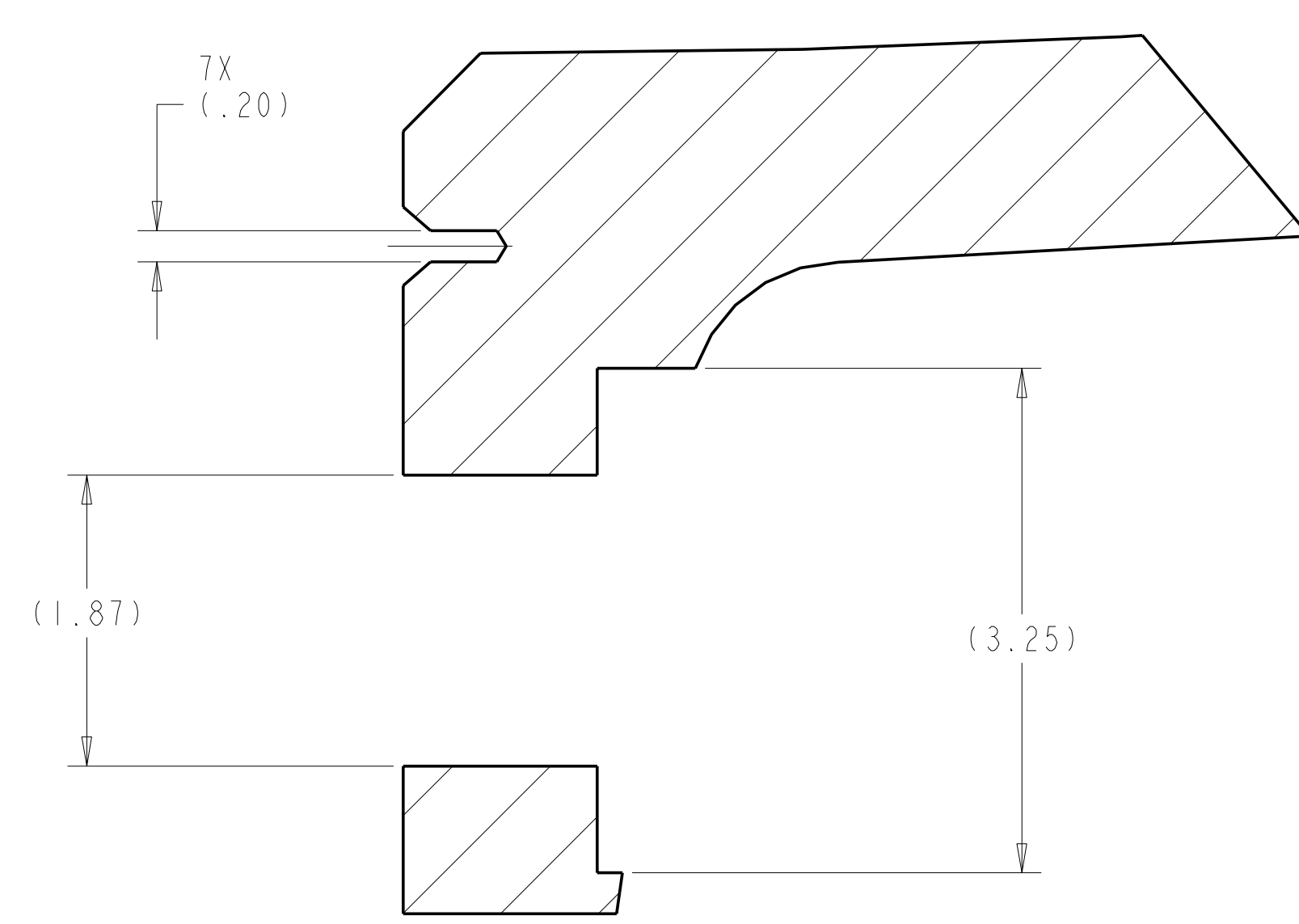
SECTION M-M



DETAIL U
SCALE 1.00



DETAIL V
SCALE 1.00

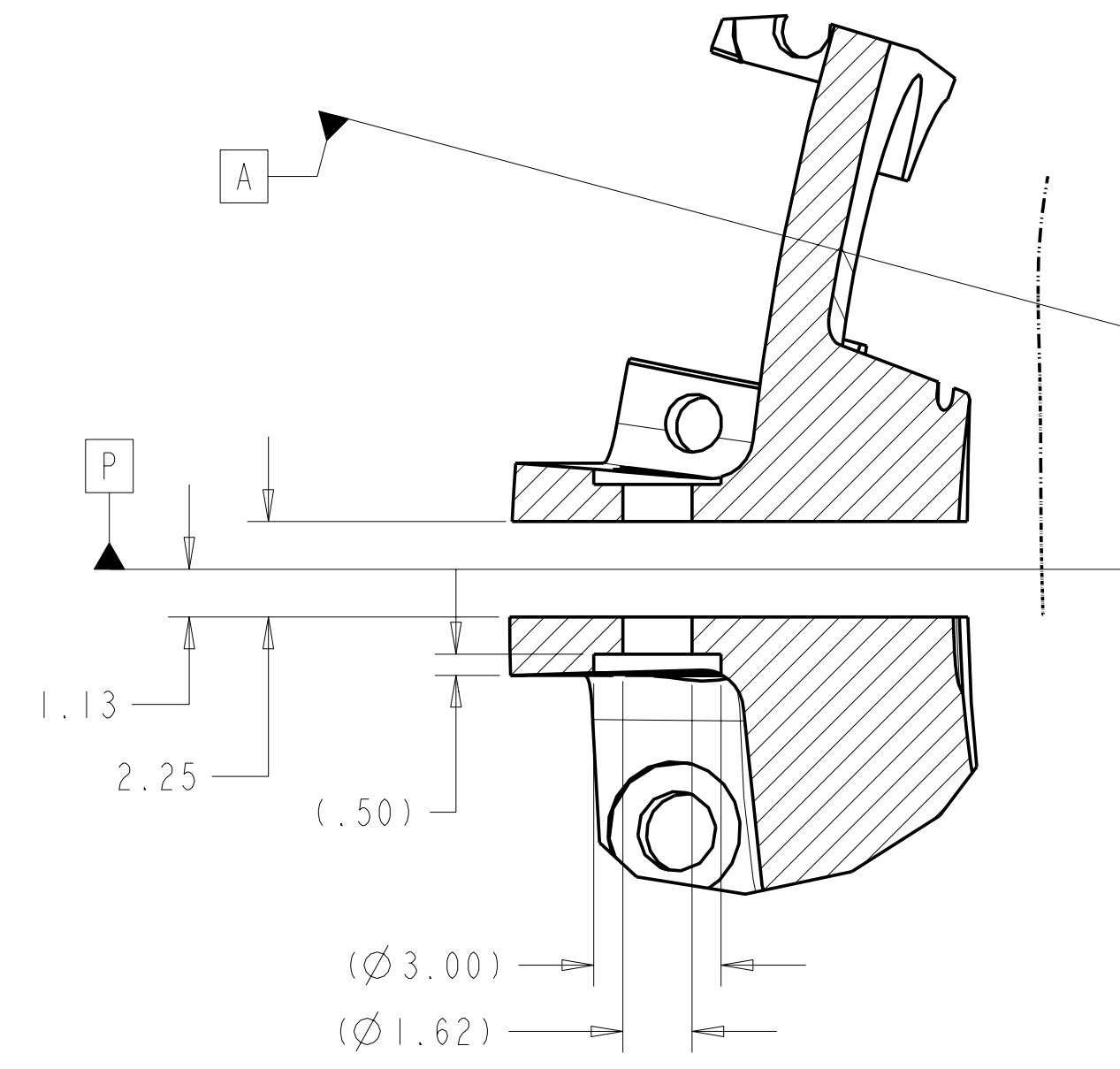
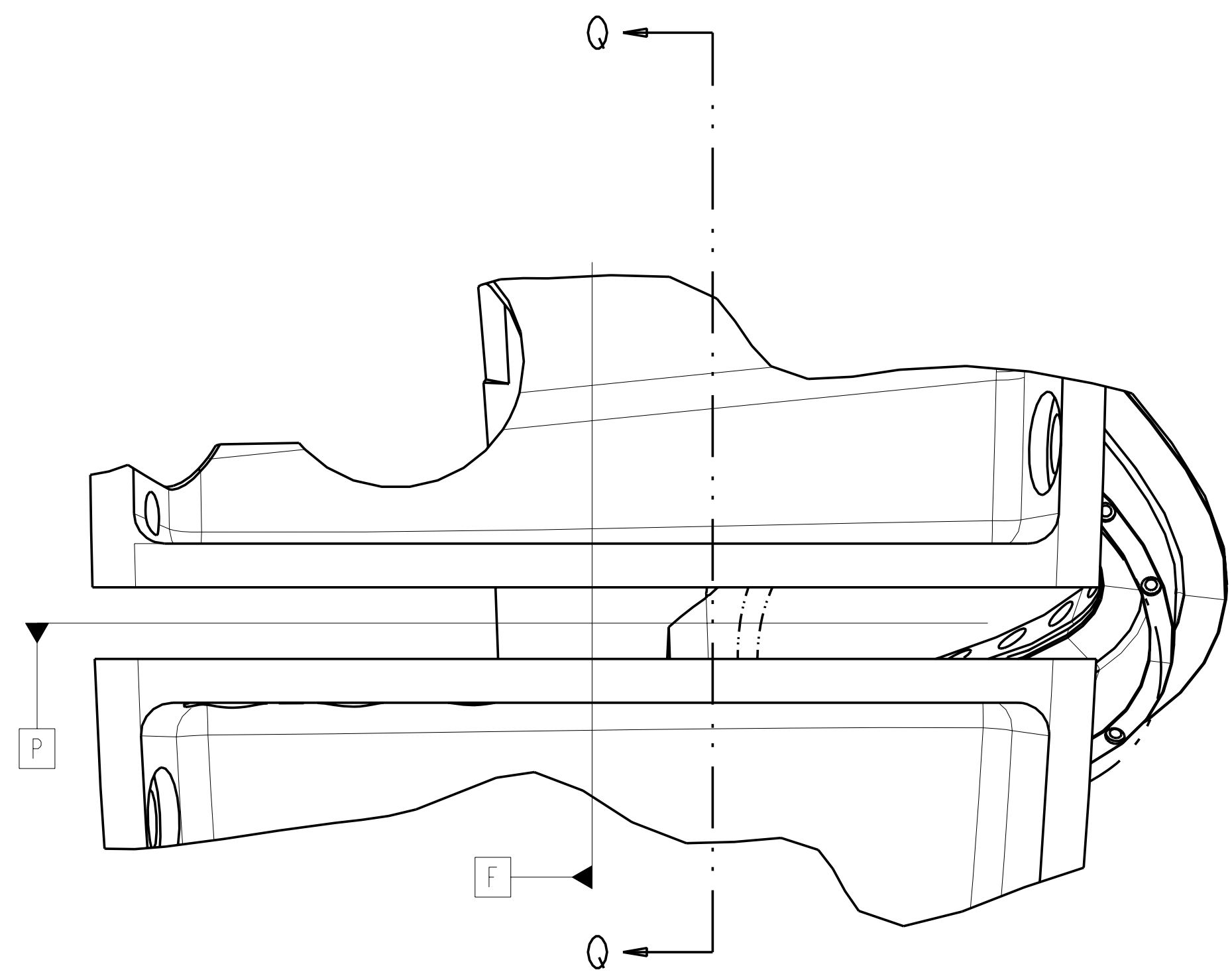
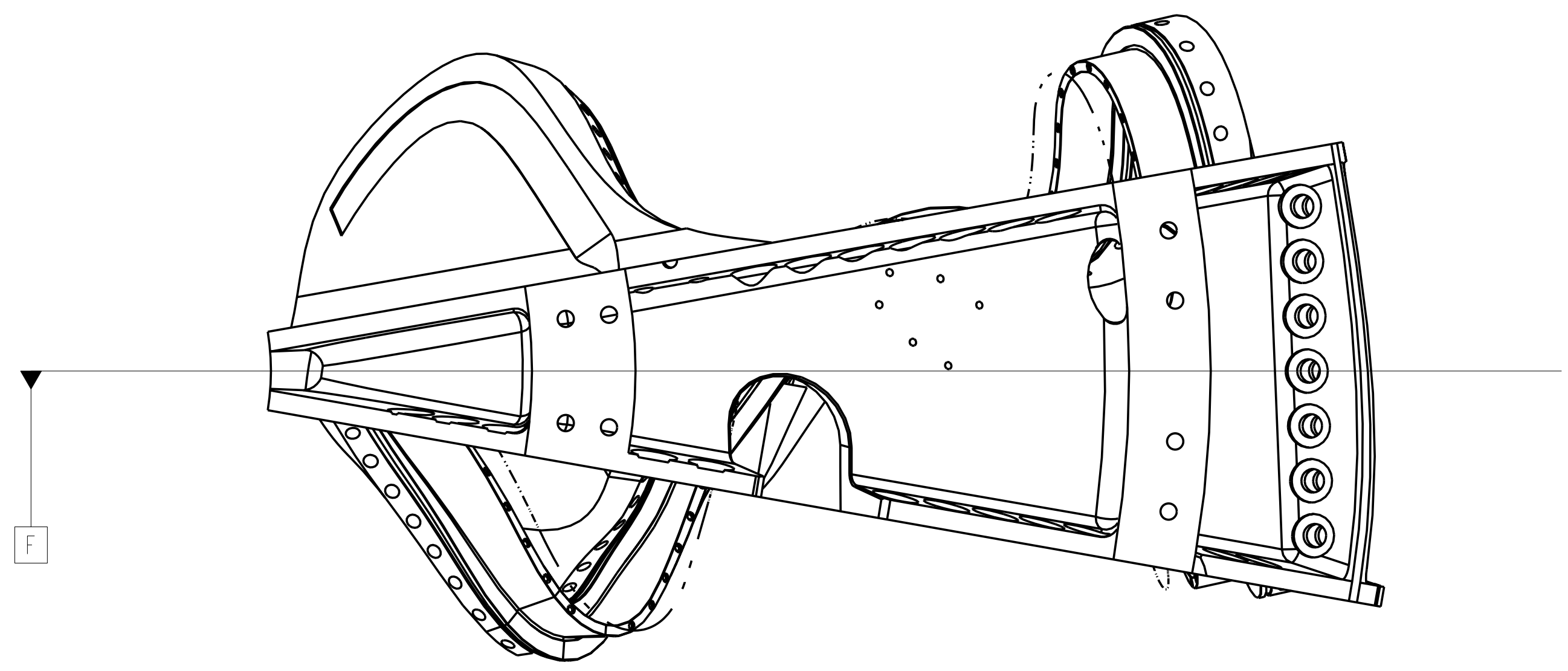


SECTION W-W
SCALE 1.00

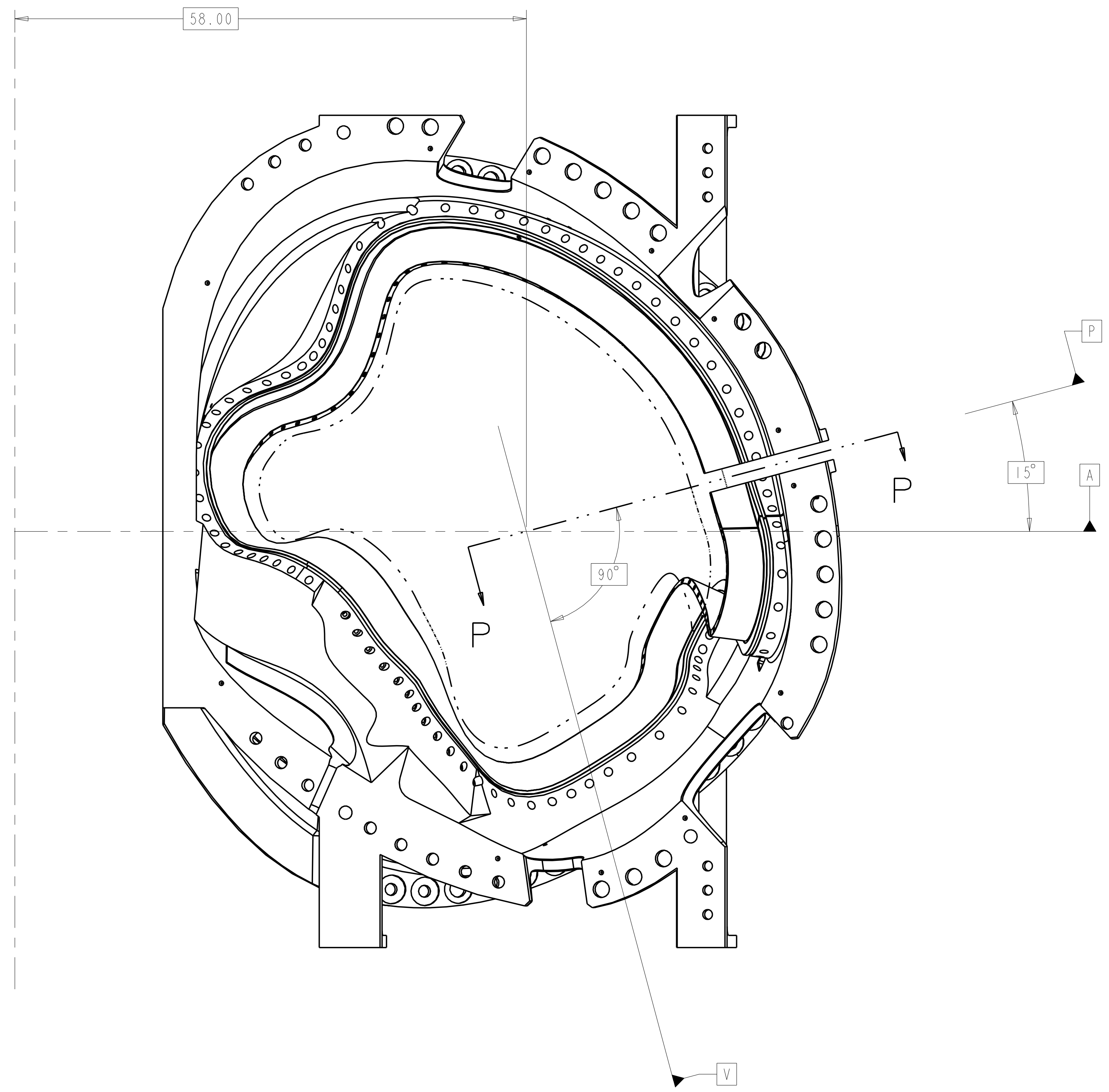
Oak Ridge National Laboratory managed for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT contract DE-AC05-00OR22725 UT-BATTELLE, LLC, Oak Ridge, Tennessee PROJECT NAME								
UT-BATTELLE NATIONAL COMPACT STELLARATOR EXPERIMENT								
PRODUCTION WINDING FORM TYPE-C								
VERSION NO.	PLANT	BLDG	FL	SHT OF	TYPE	CLASS		
36	X-10	5700	3	6	11	S	U	
RELEASE LEVEL	SEI41-116						REV	0
WIP								

SEI41-116

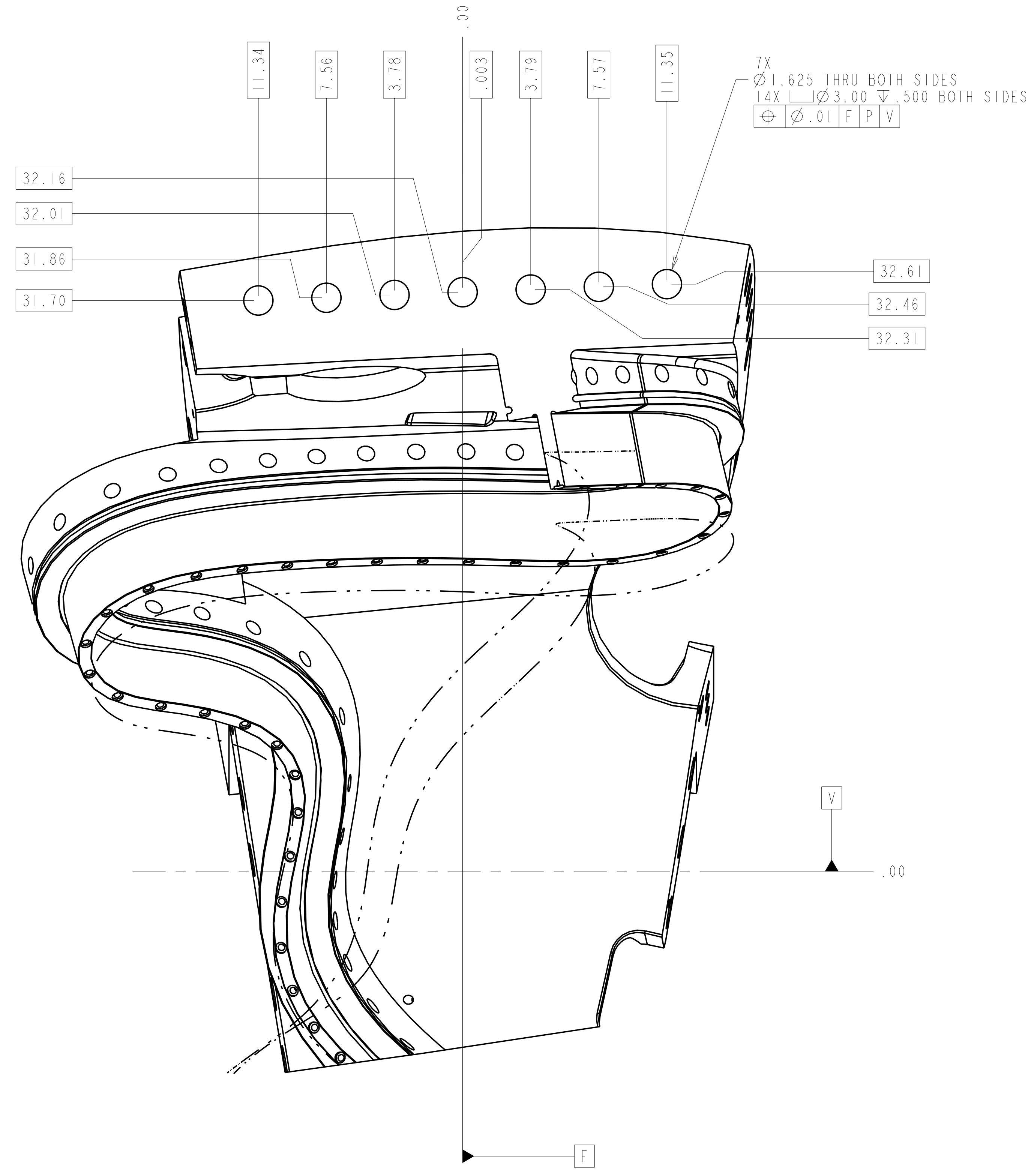
FOR NOTES AND PARTS LIST SEE SHEET 1



SECTION Q-Q



POLOIDAL BREAK DETAIL

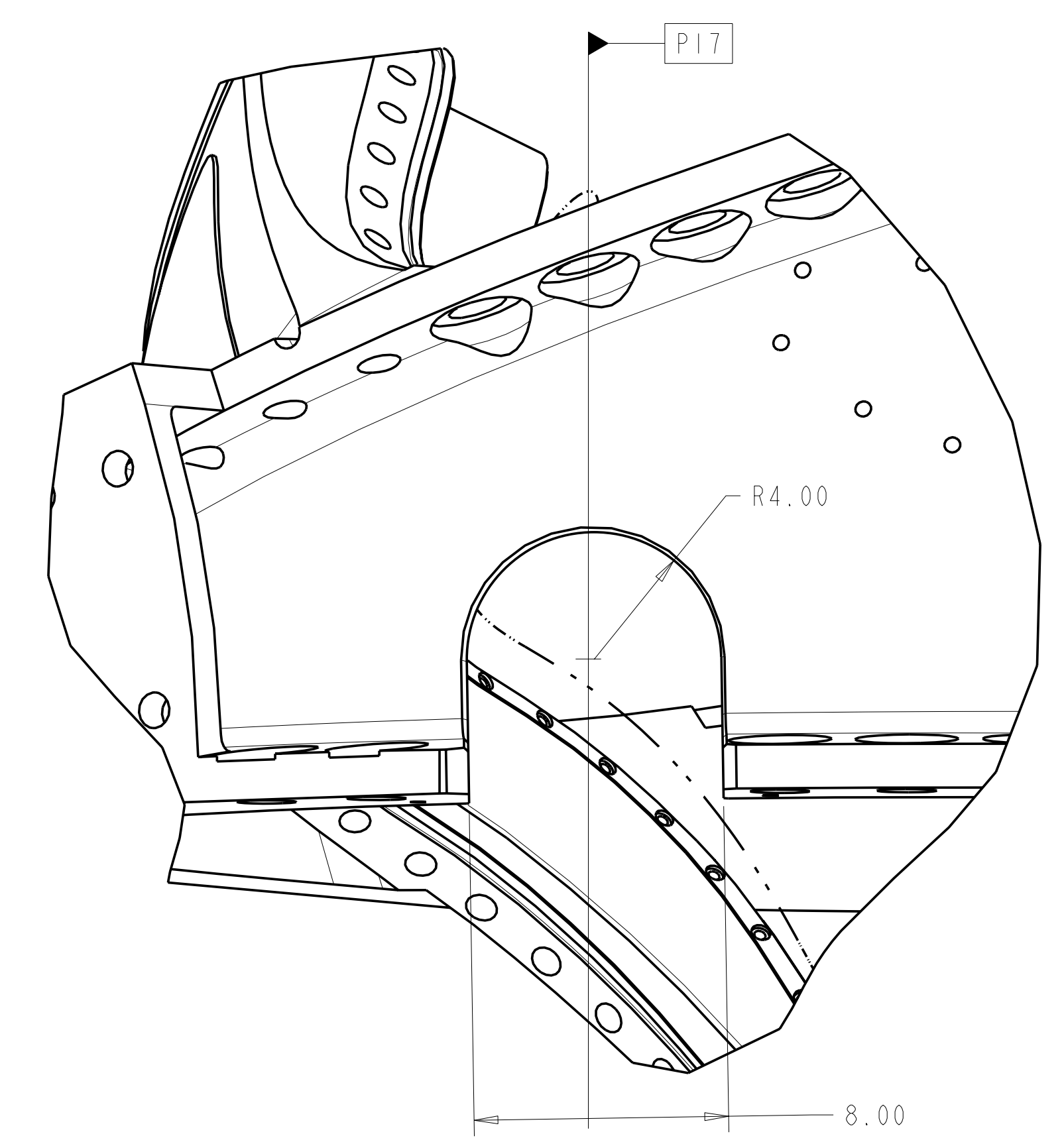
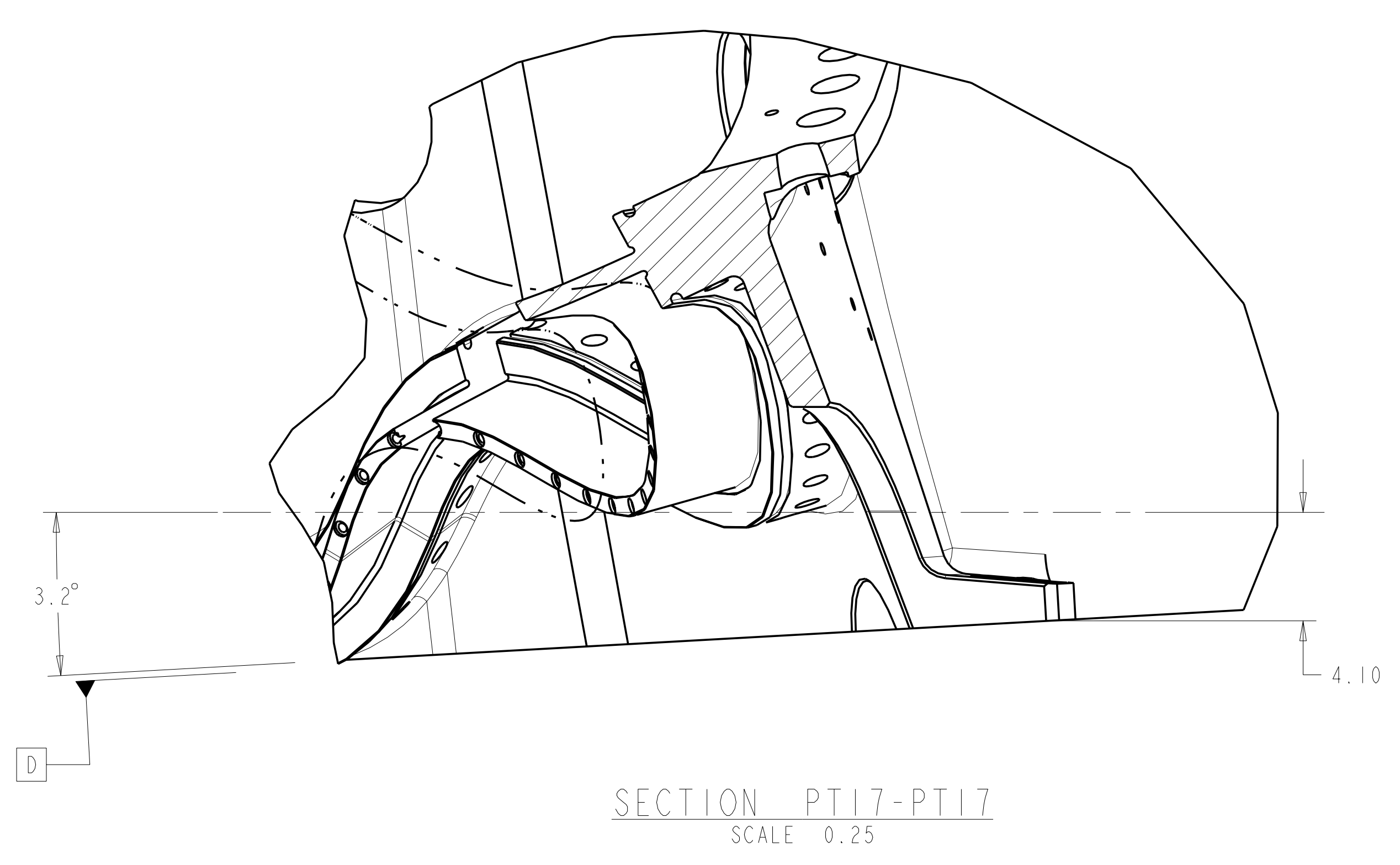
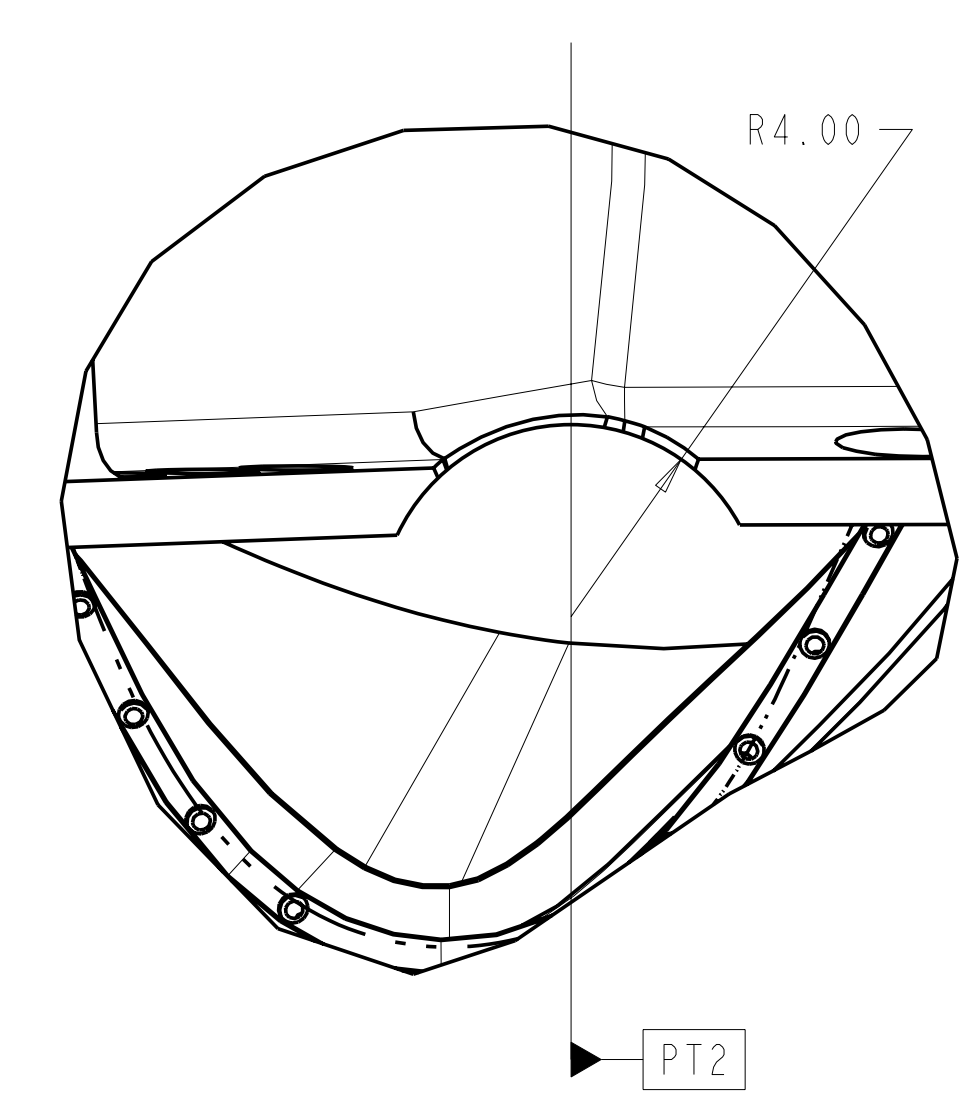
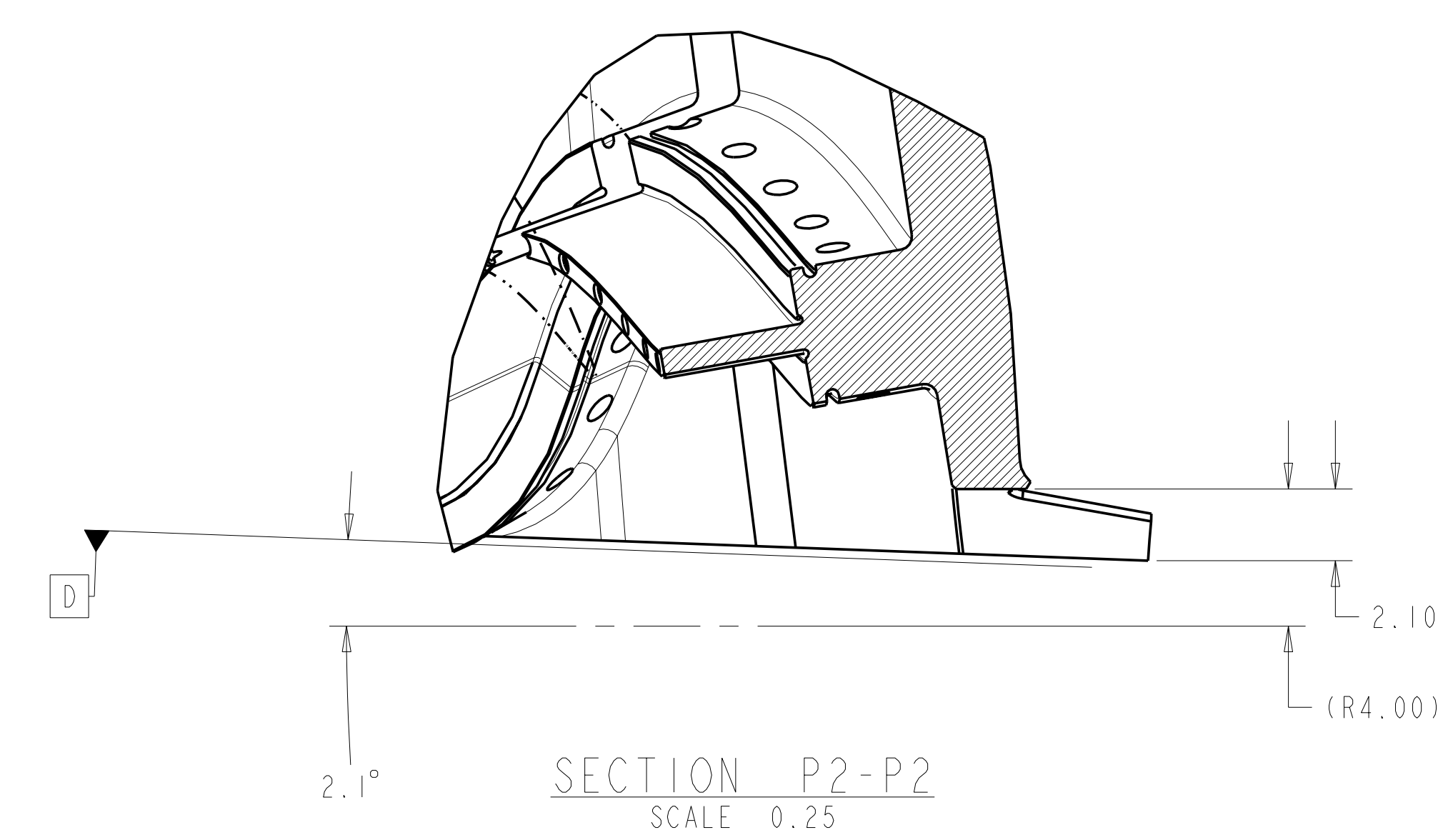
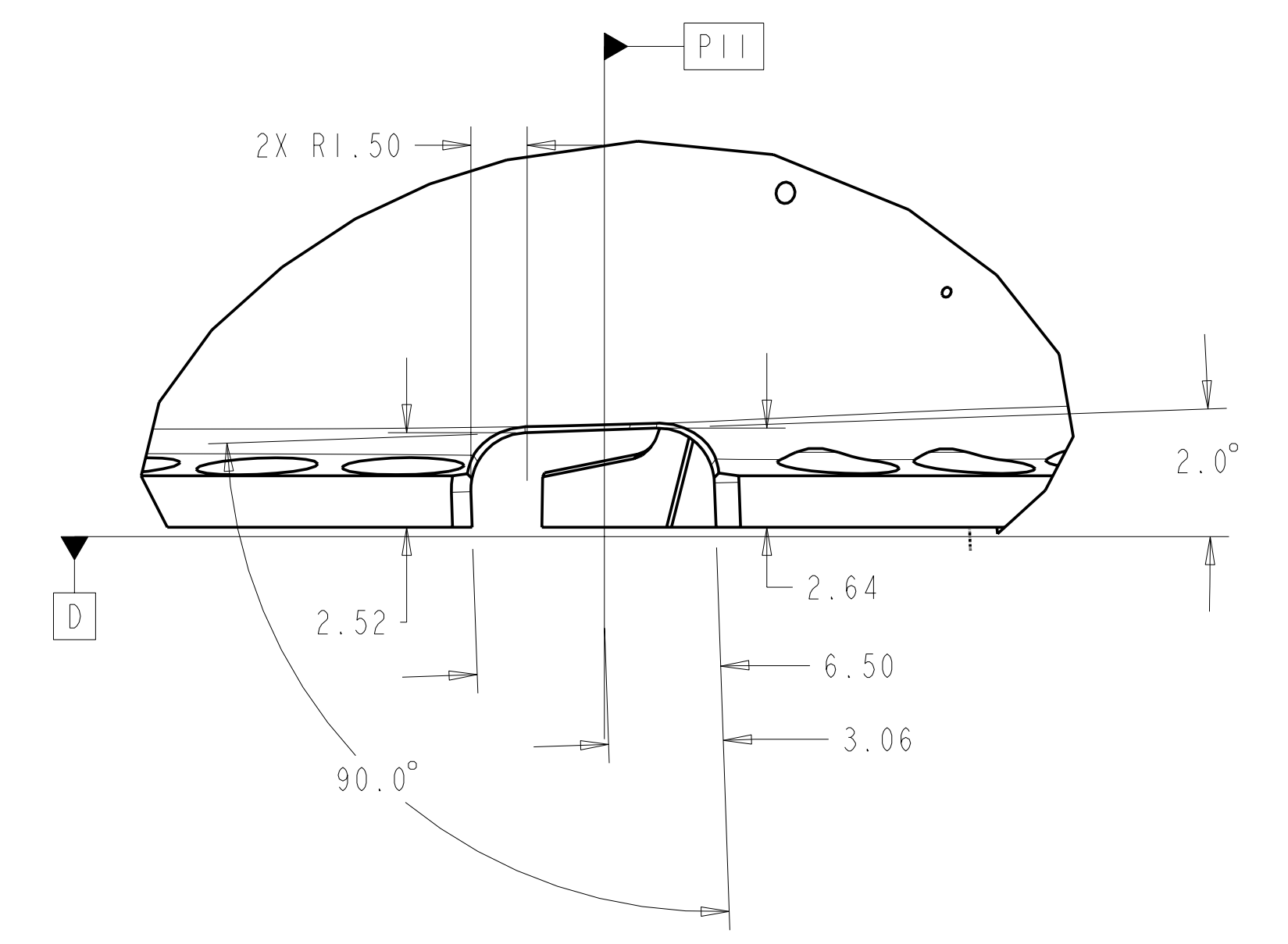
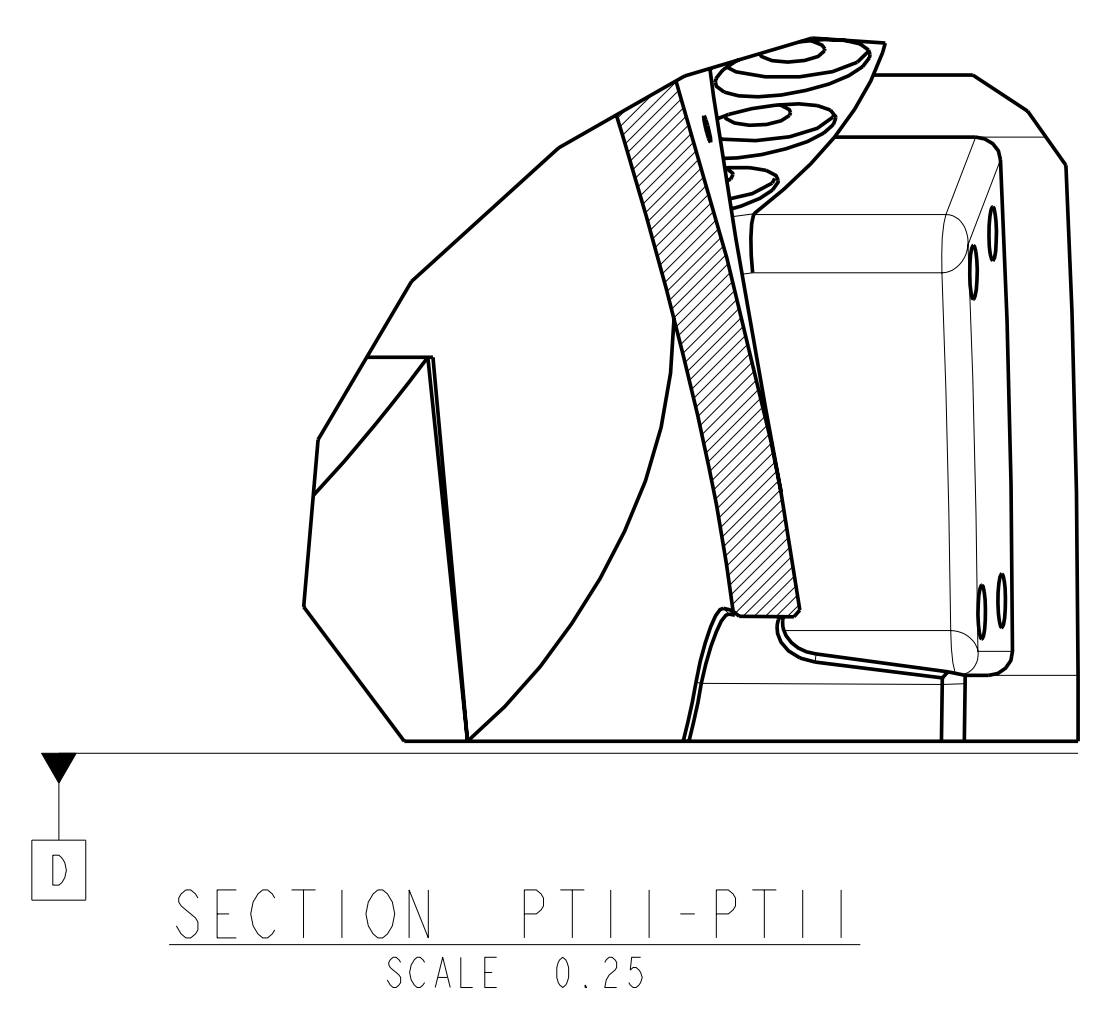
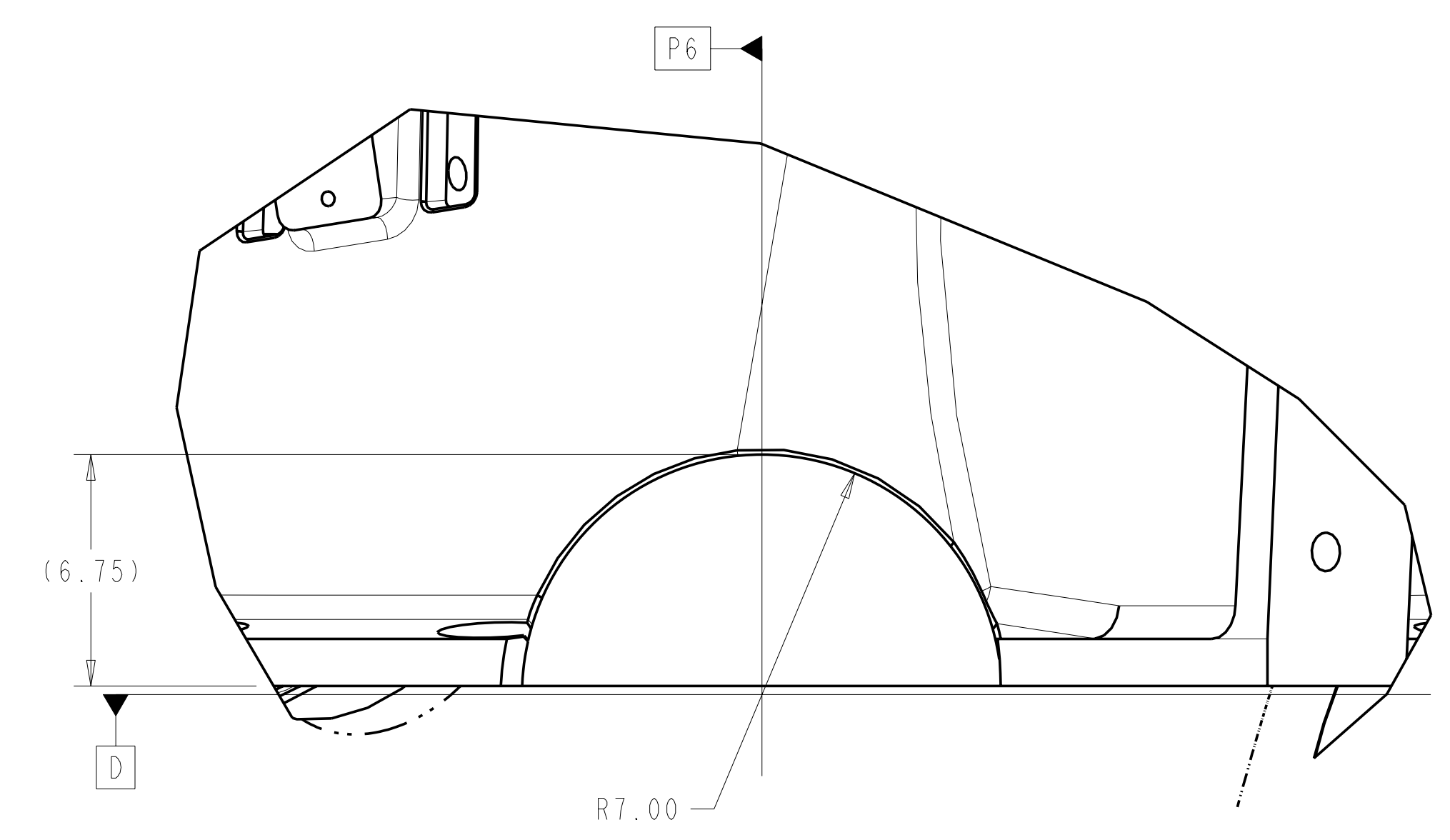
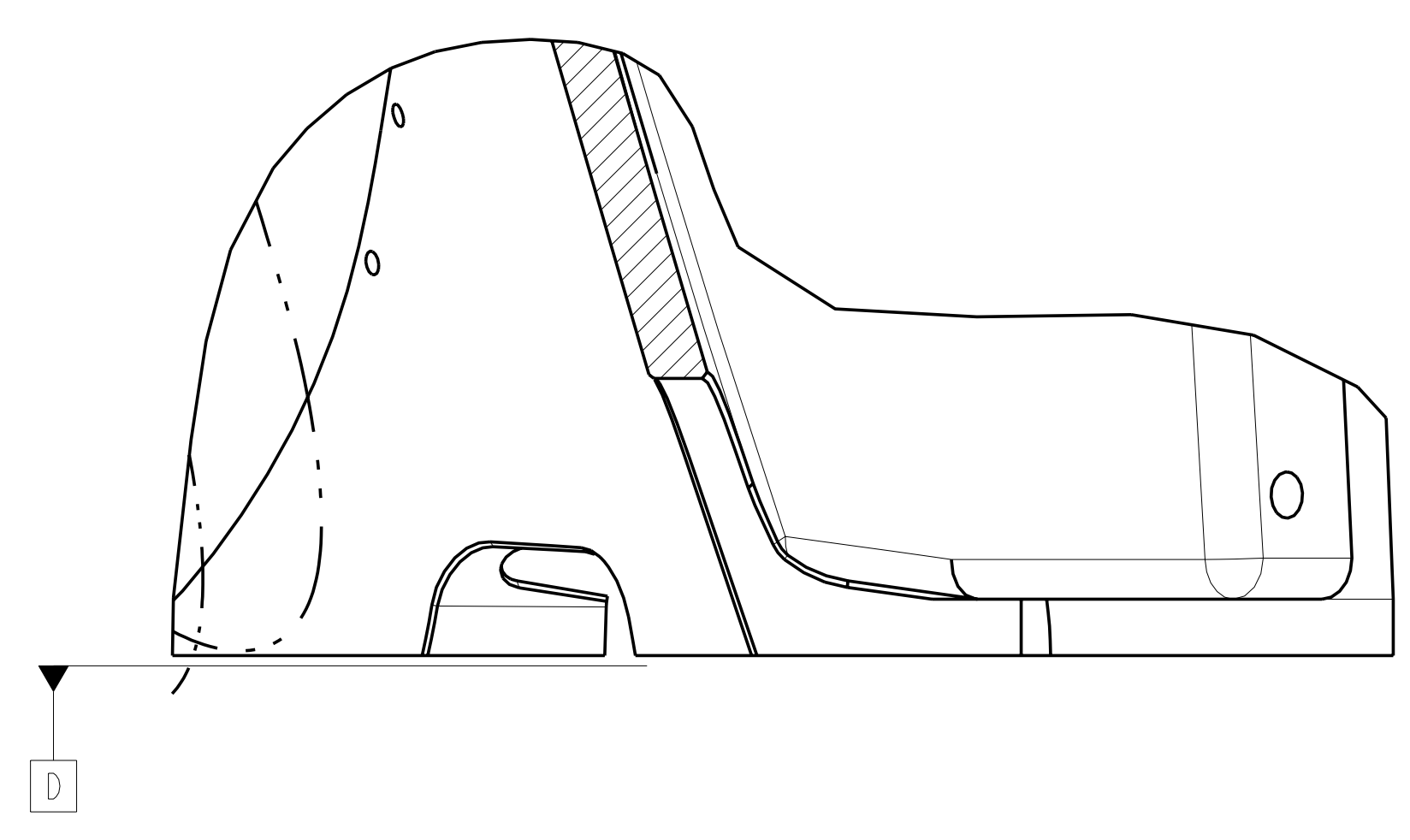
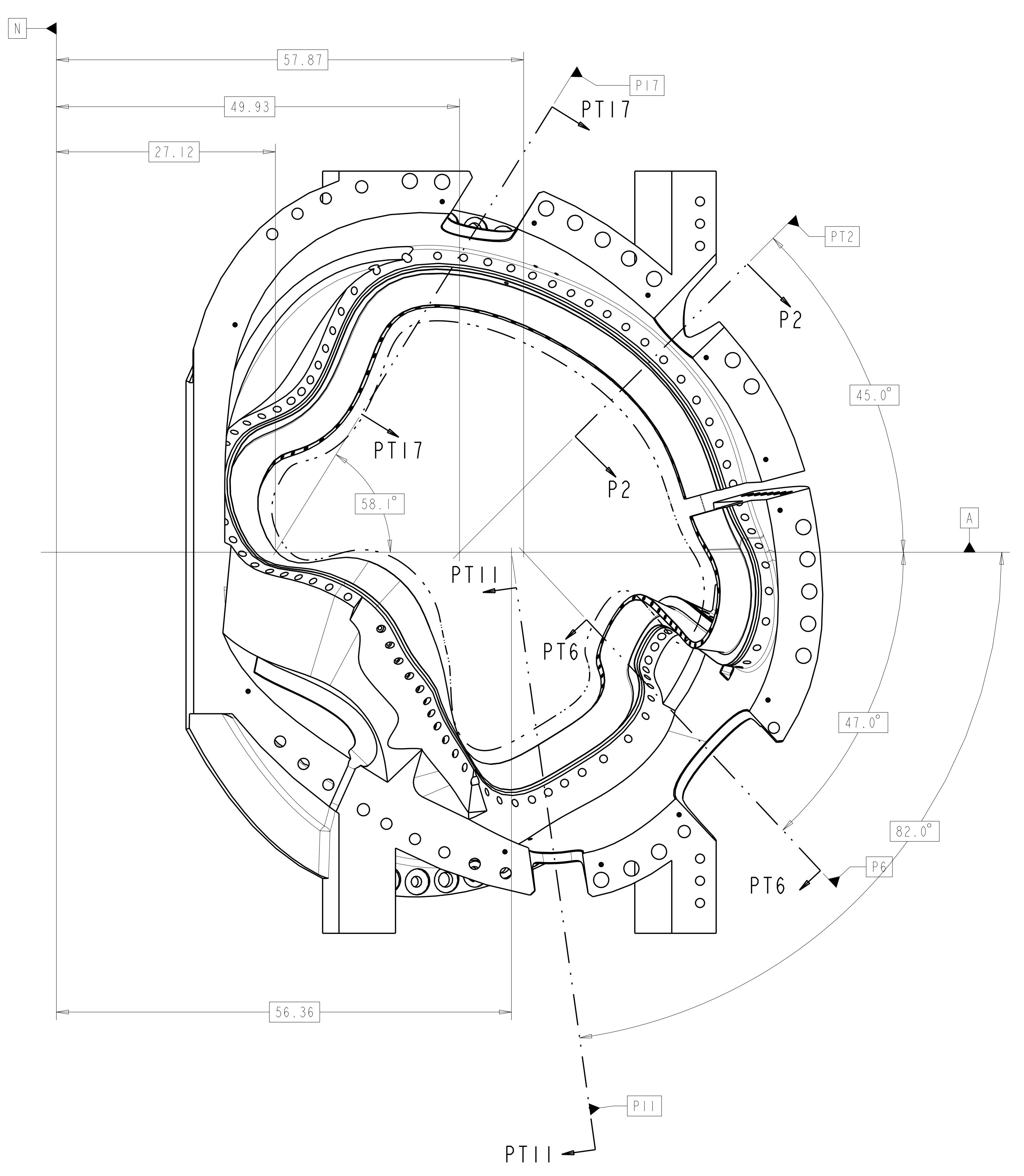


SECTION P-P
 SCALE 0.25

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UT-BATTELLE								
NATIONAL COMPACT STELLARATOR EXPERIMENT								
PRODUCTION WINDING FORM TYPE-C								
VERSION NO.	PLANT	BLDG	FL	SHT OF	TYPE	CLASS		
36	X-10	5700	3	7	11	S	U	
RELEASE LEVEL	SEI41-116						REV	0
WIP								

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FOR NOTES AND PARTS LIST SEE SHEET 1

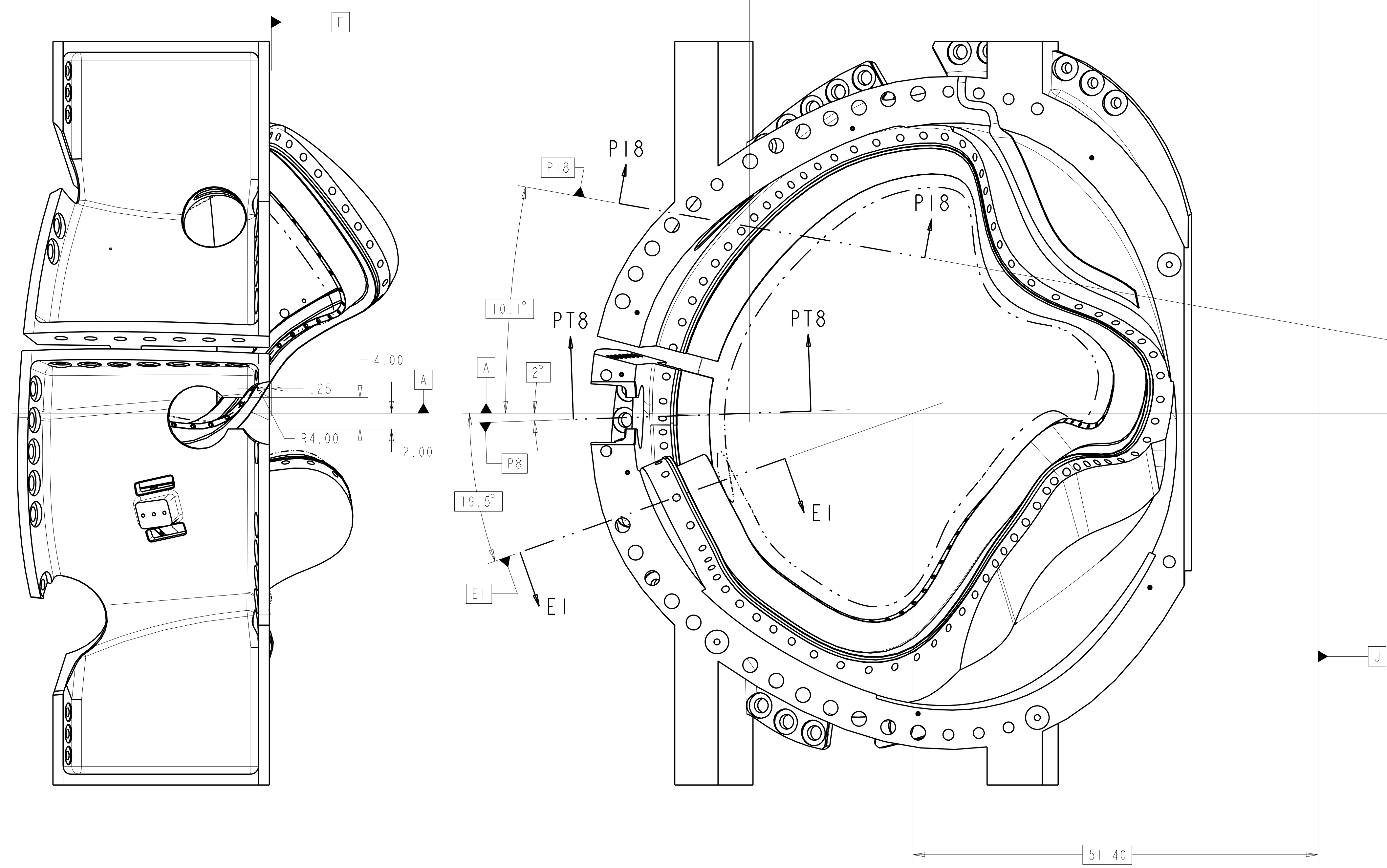


Oak Ridge National Laboratory managed for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT contract DE-AC05-00OR22725 UT-BATTELLE, LLC, Oak Ridge, Tennessee							
UT-BATTELLE							
NATIONAL COMPACT STELLARATOR EXPERIMENT							
PRODUCTION WINDING FORM TYPE-C							
VERSION NO.	PLANT	BLDG	FL	SHT OF	TYPE	CLASS	
36	X-10	5700	3	8	11	S	U
RELEASE LEVEL	SEI41-116						REV
WIP							0

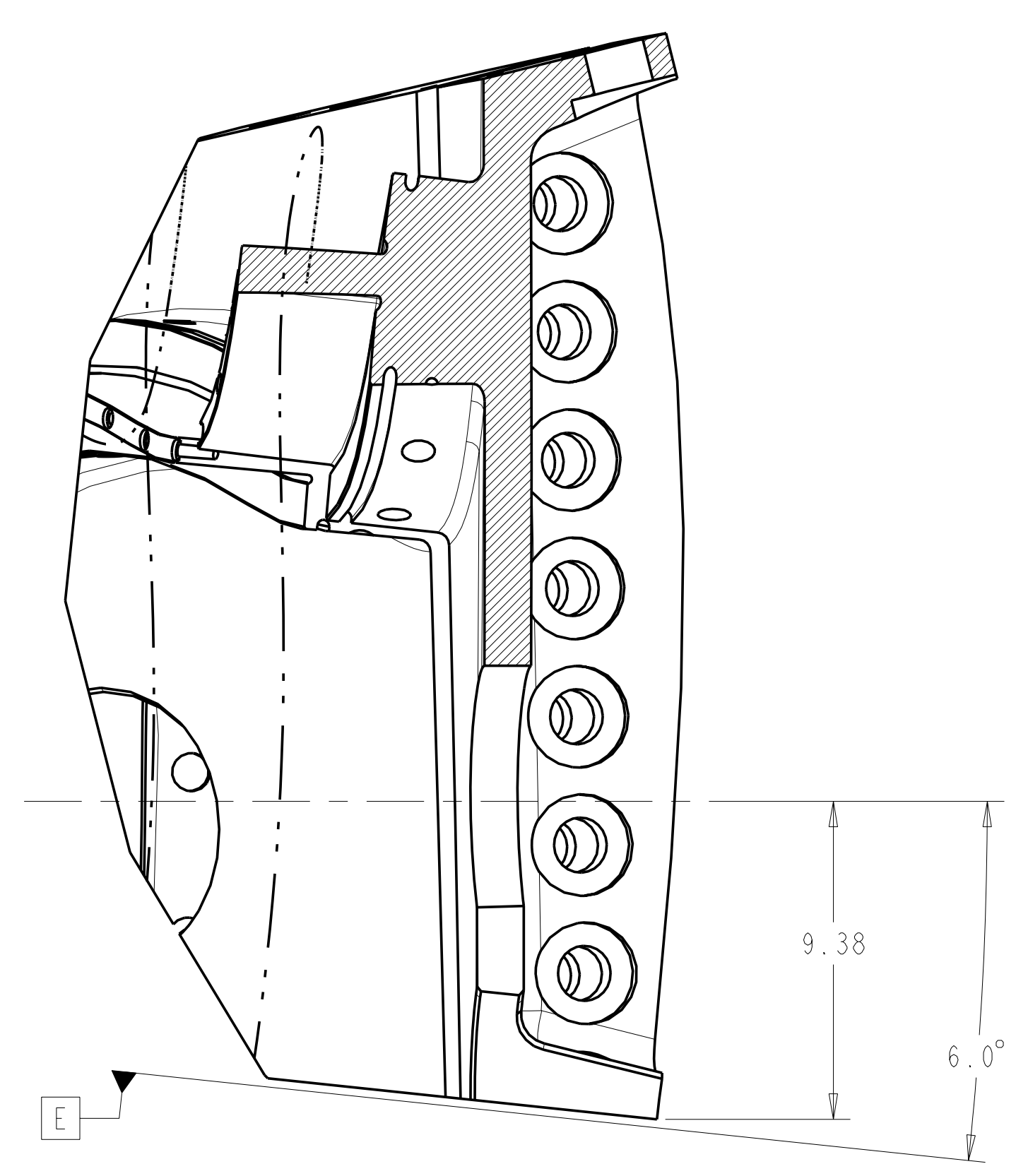
SEI41-116

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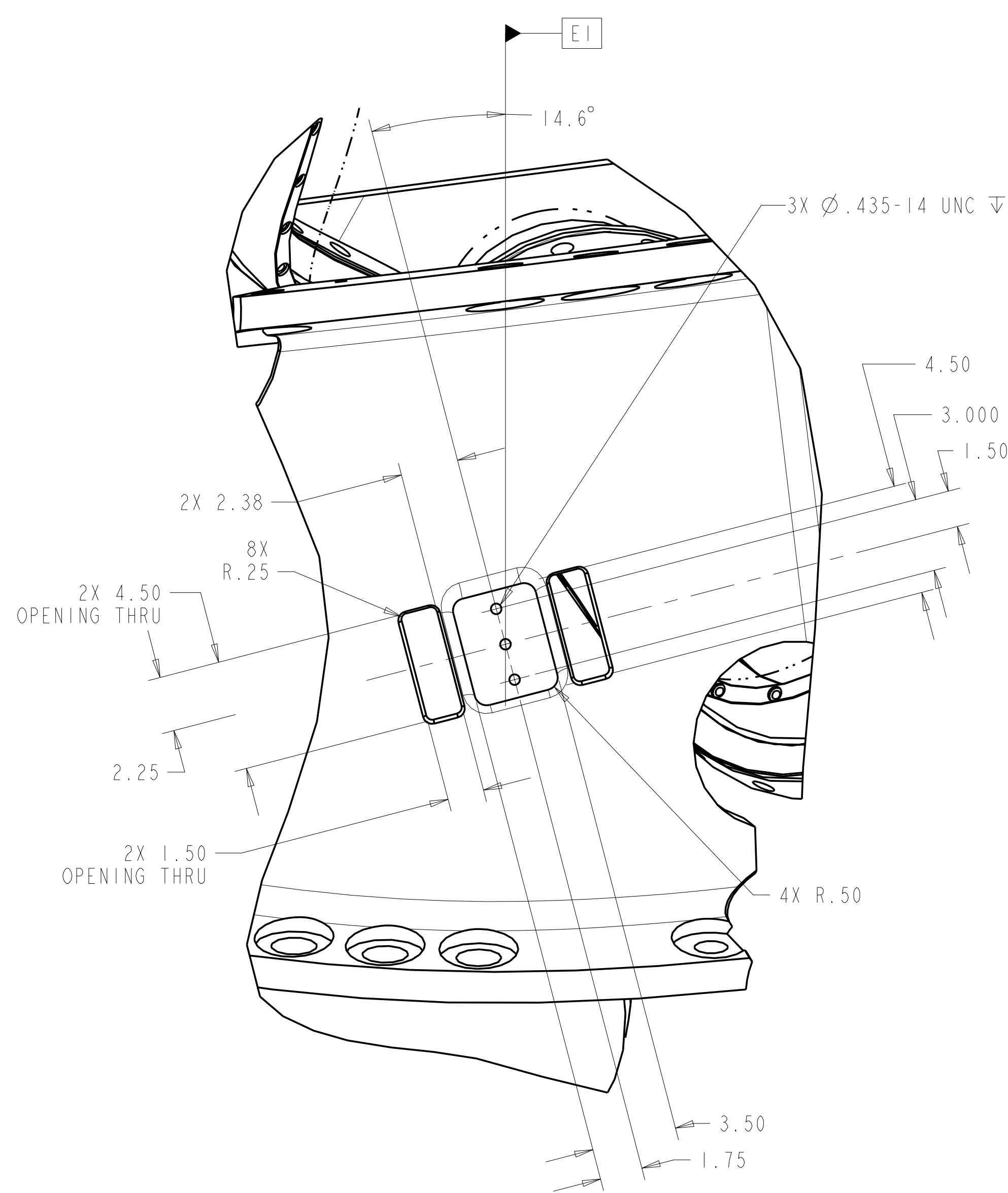
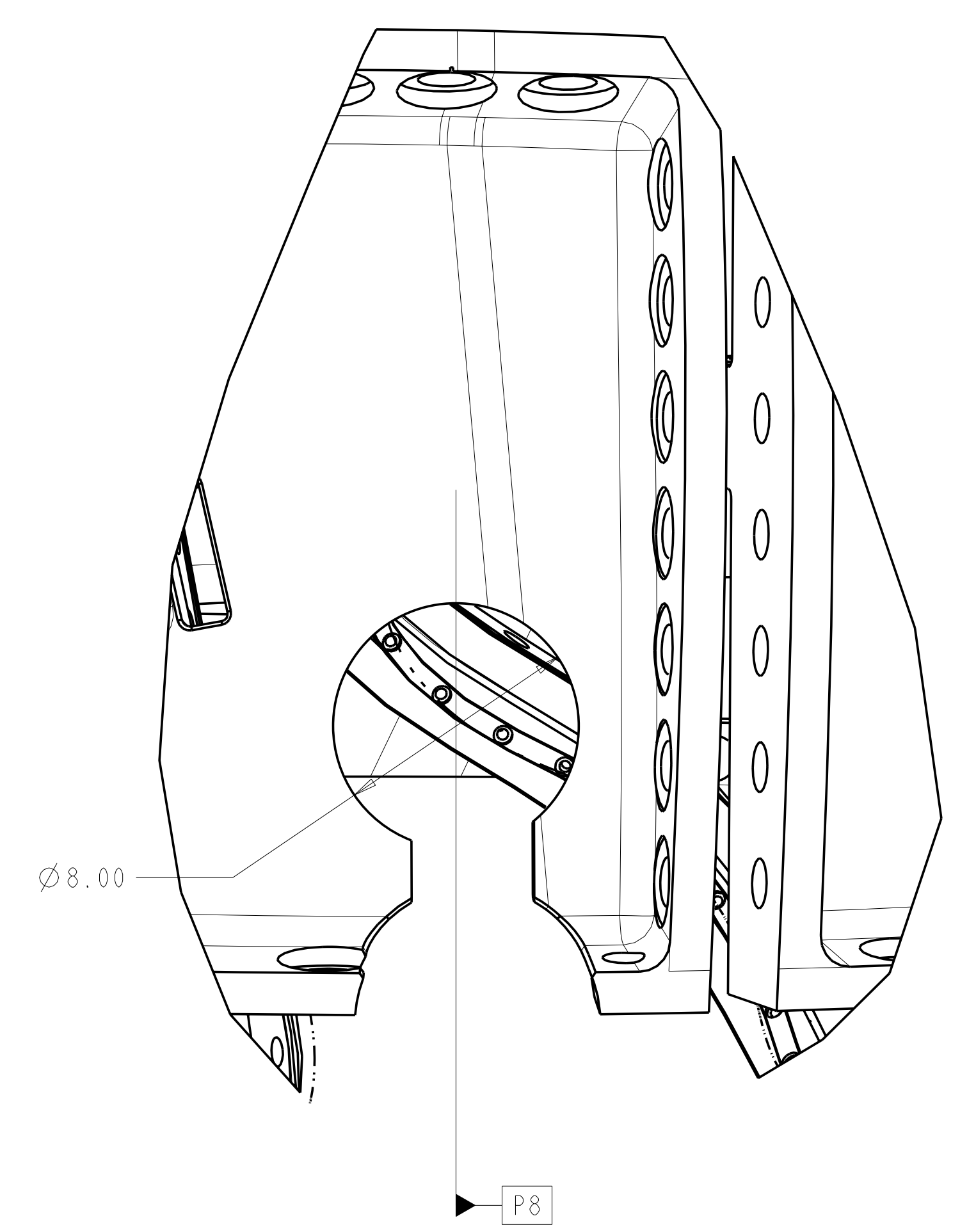
FOR NOTES AND PARTS LIST SEE SHEET 1



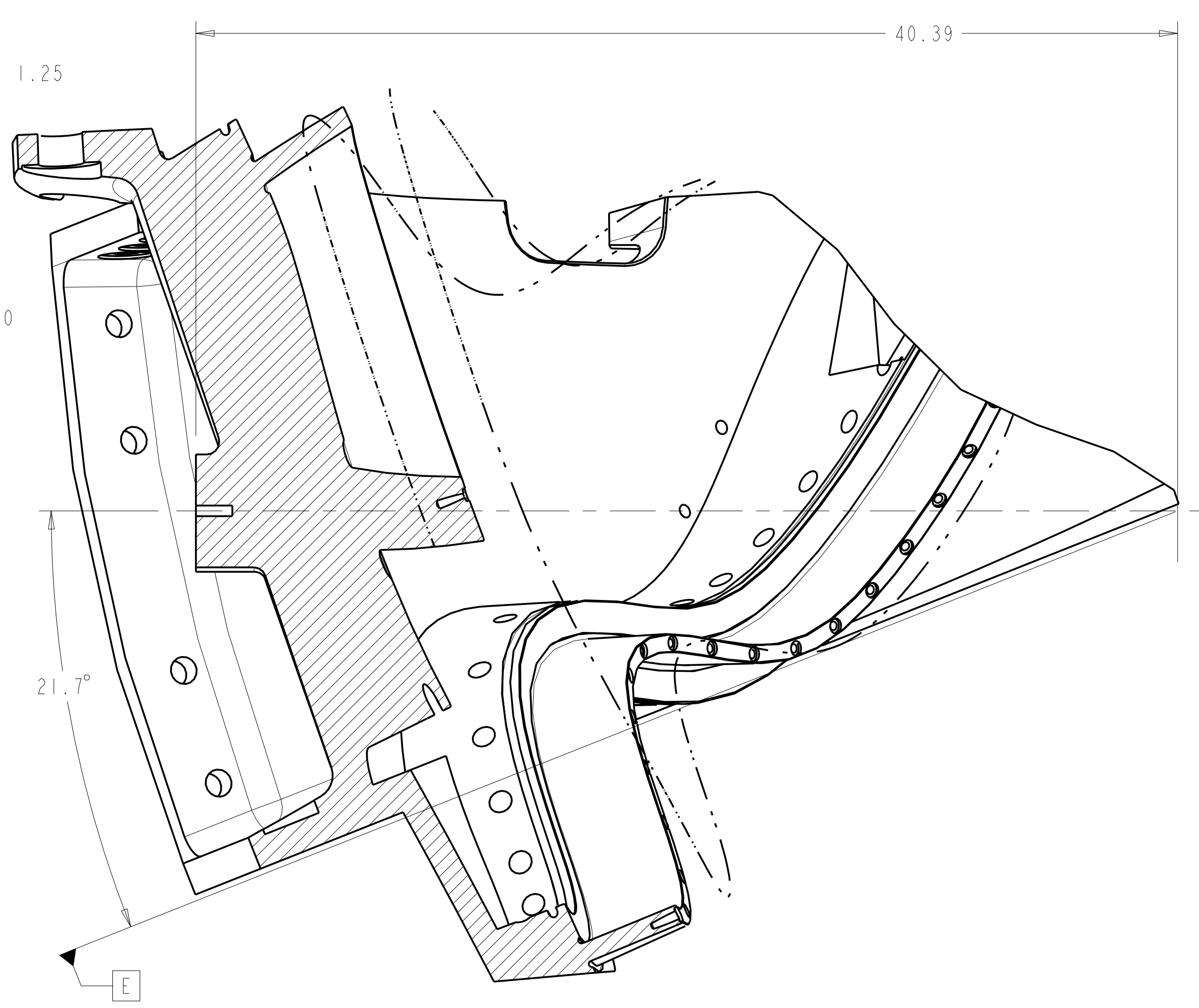
VIEW AT DATUM E
 SCALE 0.13



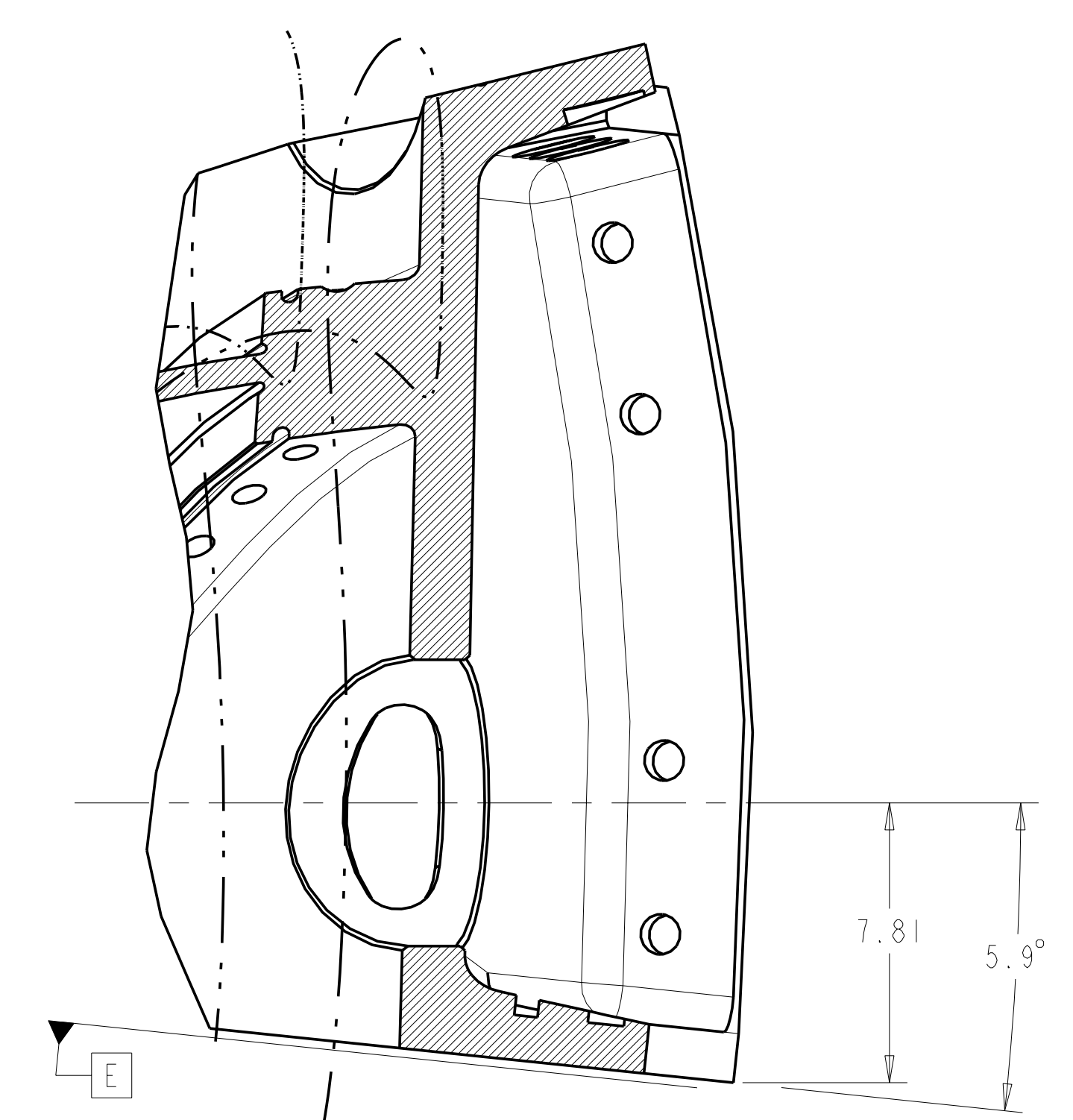
SECTION PT8-PT8
 SCALE 0.25



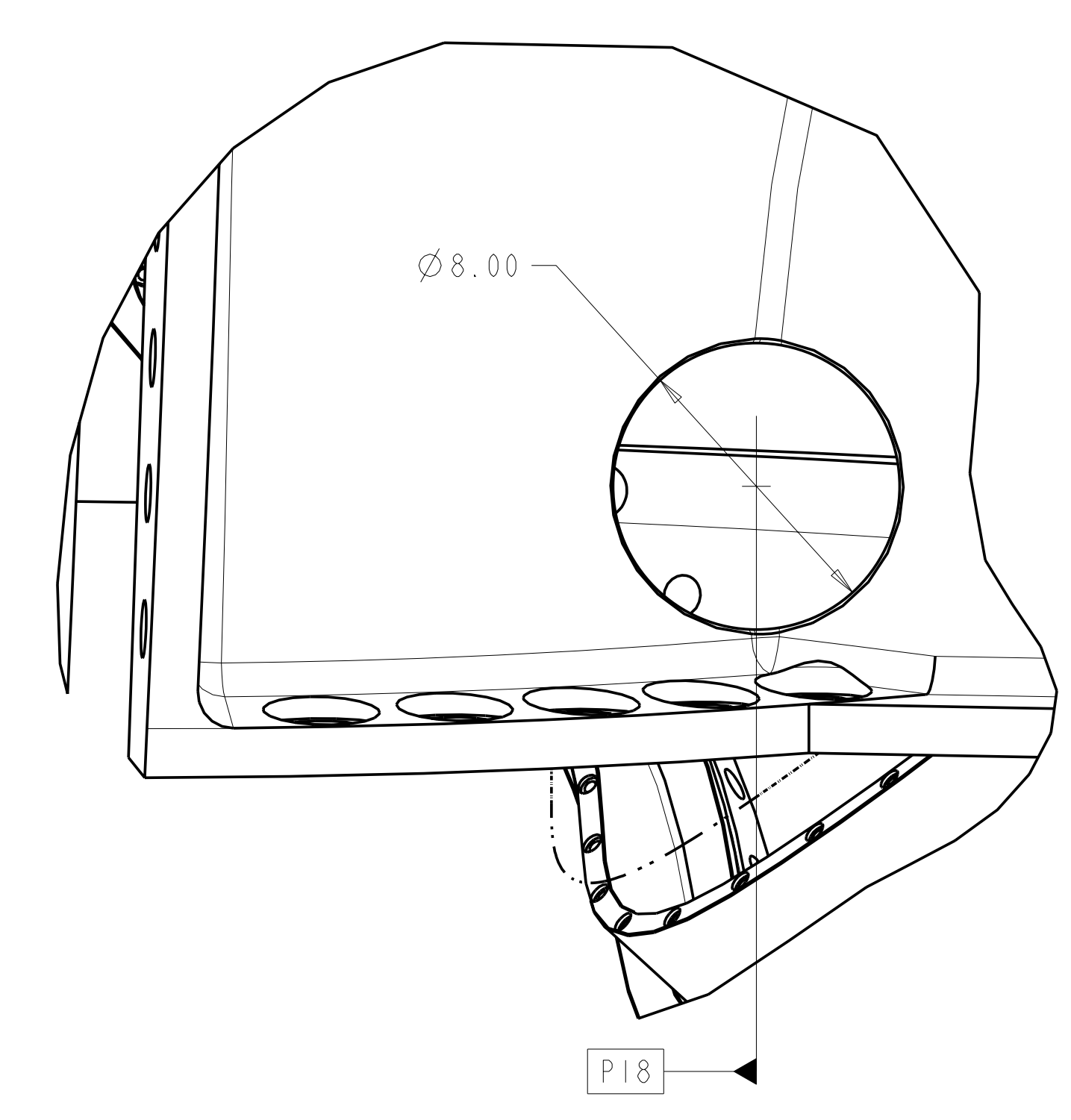
LEAD BLOCK DETAIL



SECTION E1-E1
 SCALE 0.25



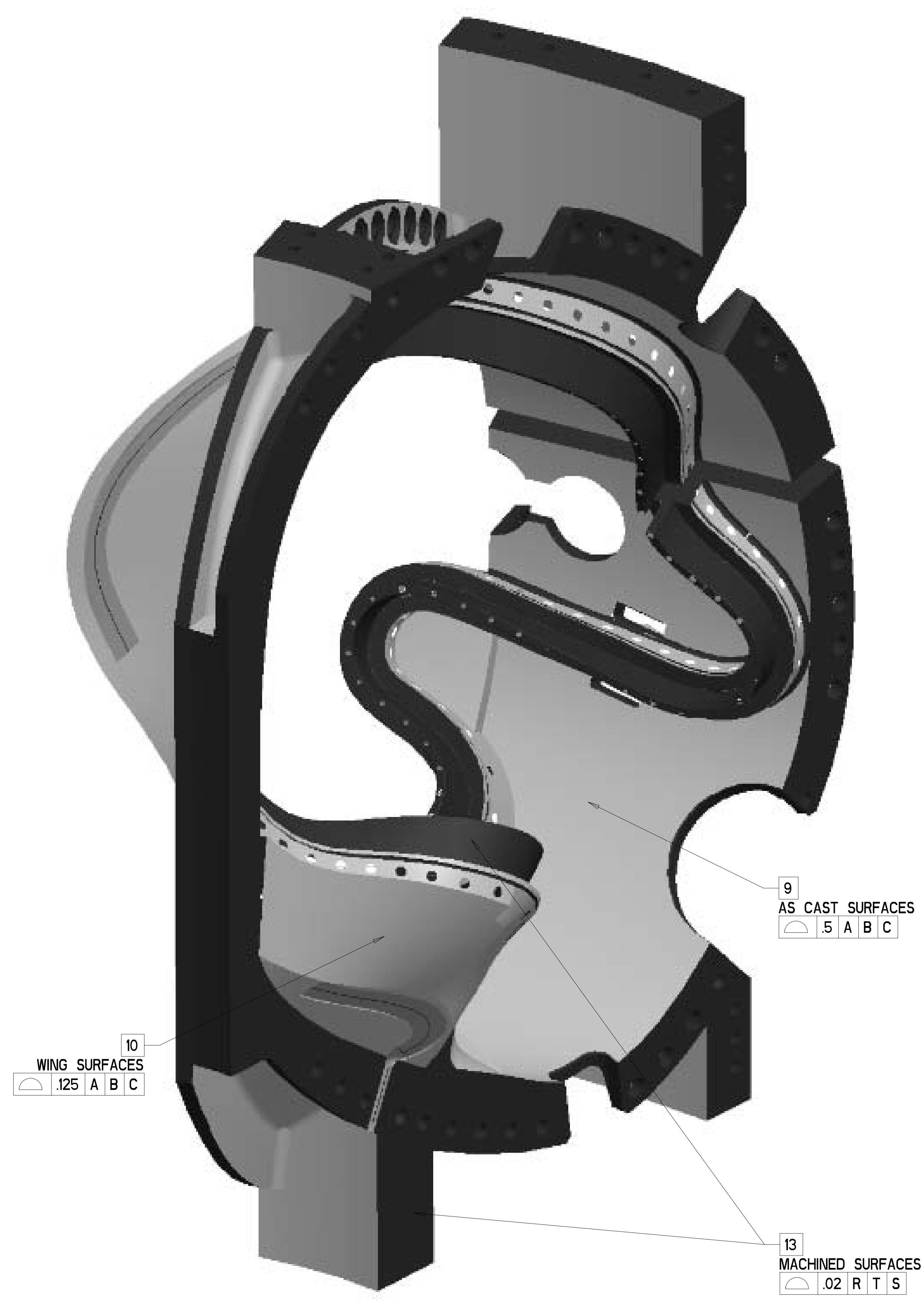
SECTION P18-P18
 SCALE 0.25



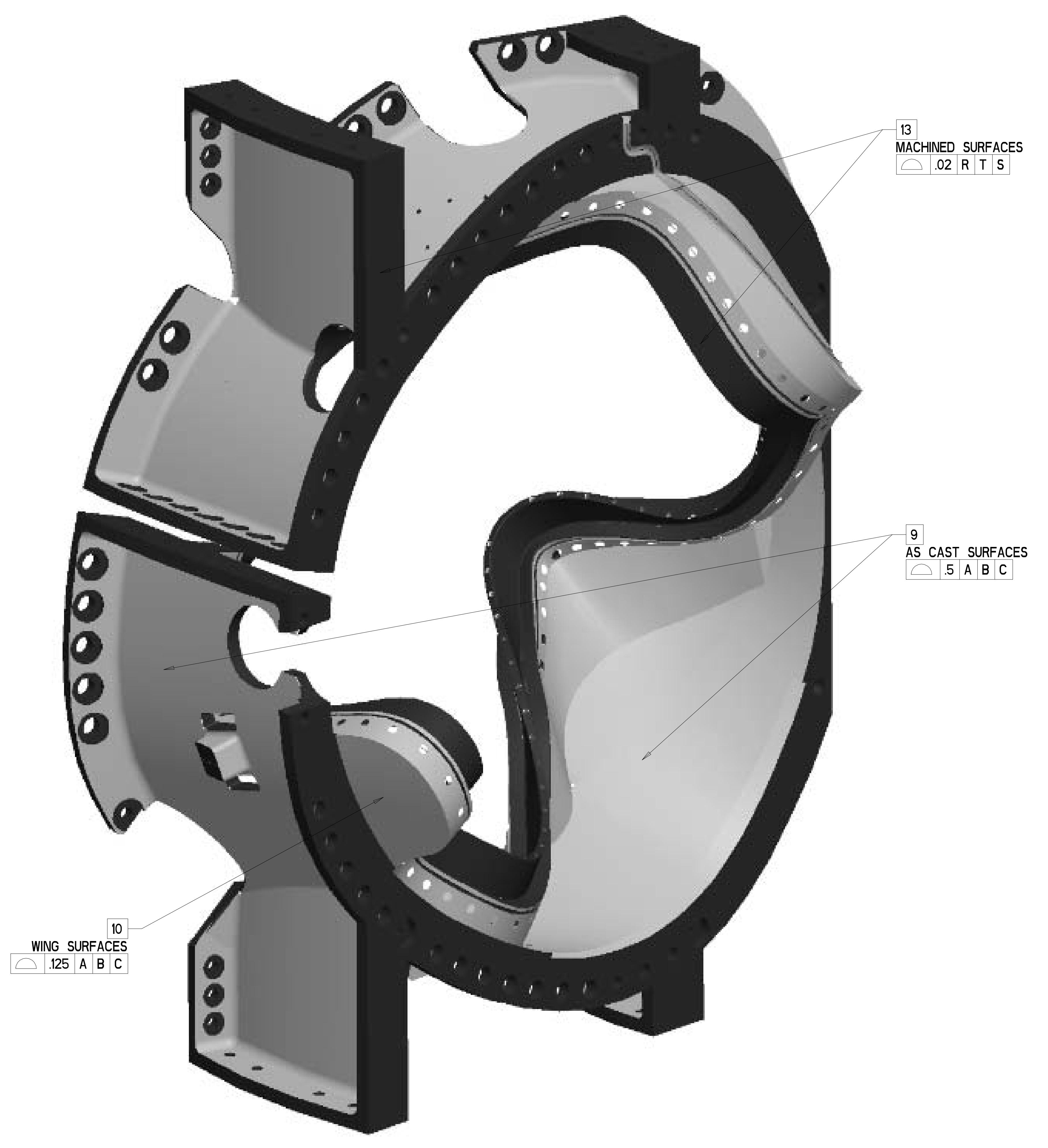
Oak Ridge National Laboratory managed for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT contract DE-AC05-00OR22725 UT-BATTELLE, LLC, Oak Ridge, Tennessee PROJECT NAME:							
UT-BATTELLE NATIONAL COMPACT STELLARATOR EXPERIMENT							
PRODUCTION WINDING FORM TYPE-C							
VERSION NO.	PLANT	BLDG	FL	SHT OF	TYPE	CLASS	
36	X-10	5700	3	9	11	S	U
RELEASE LEVEL	SEI41-116						REV
WIP							0

SEI41-116

FOR NOTES AND PARTS LIST SEE SHEET 1



ISOMETRIC VIEW
 NOT TO SCALE



ISOMETRIC VIEW
 NOT TO SCALE

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					
PROJECT NAME							
NATIONAL COMPACT STELLARATOR EXPERIMENT							
PRODUCTION WINDING FORM TYPE-C							
VERSION NO.	PLANT	BLDG	FL	SHT OF	TYPE	CLASS	
36	X-10	5700	3	10	11	S	U
RELEASE LEVEL		SEI41-116				REV	0
WIP							

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TABLE I WINDING CENTER SPLINE (FILE SEI4I-II6-WC.TXT)

Table with 4 columns: #, X, Y, Z. Rows 1-101 containing coordinates for the winding center spline.

TABLE II X-VECTOR SPLINE (FILE SEI4I-II6-XV.TXT)

Table with 4 columns: #, X, Y, Z. Rows 1-101 containing coordinates for the x-vector spline.

TABLE III SPH SEAT CENTER SIDE A (FILE SEI4I-II6-SA.TXT)

Table with 4 columns: #, X, Y, Z. Rows 1-83 containing coordinates for the sph seat center side A.

TABLE IV SPH SEAT CENTER SIDE B (FILE SEI4I-II6-SB.TXT)

Table with 4 columns: #, X, Y, Z. Rows 1-83 containing coordinates for the sph seat center side B.

ALL POINT LOCATIONS ARE BASIC FOR NOTES AND PARTS LIST SEE SHEET I

Administrative header box containing Oak Ridge National Laboratory logo, contract number DE-AC05-00OR22725, and production details for the National Compact Stellarator Experiment, including version 36 and revision U.