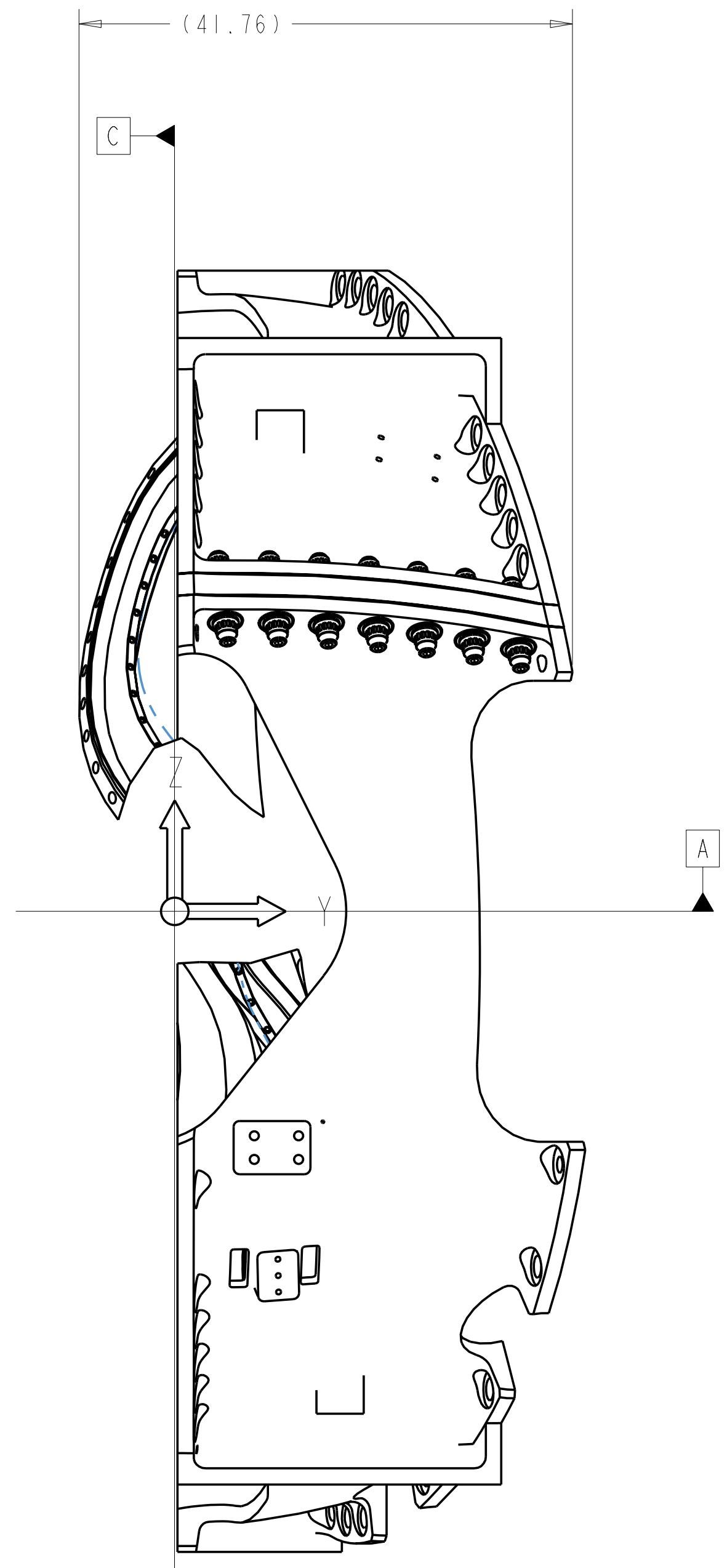
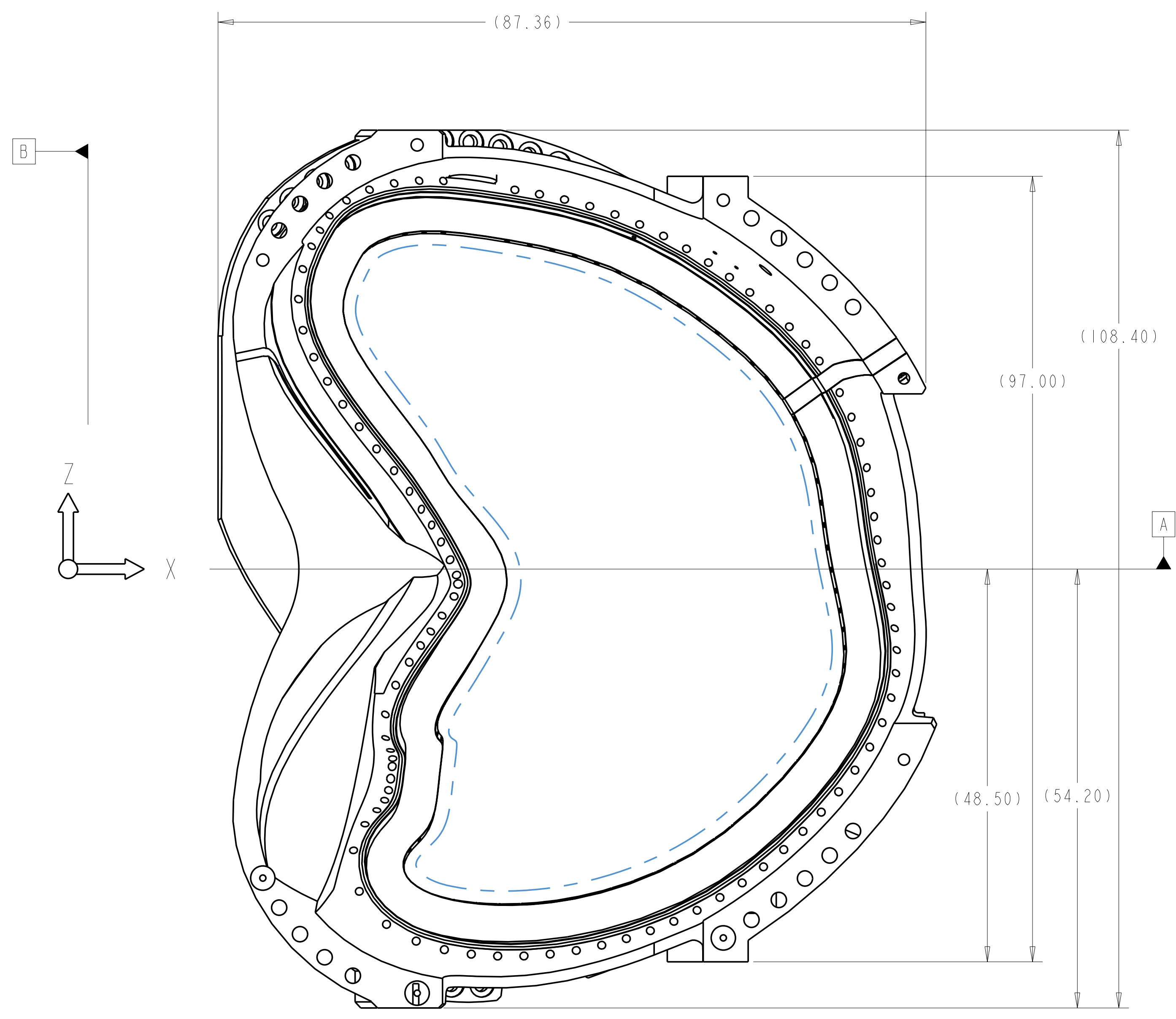
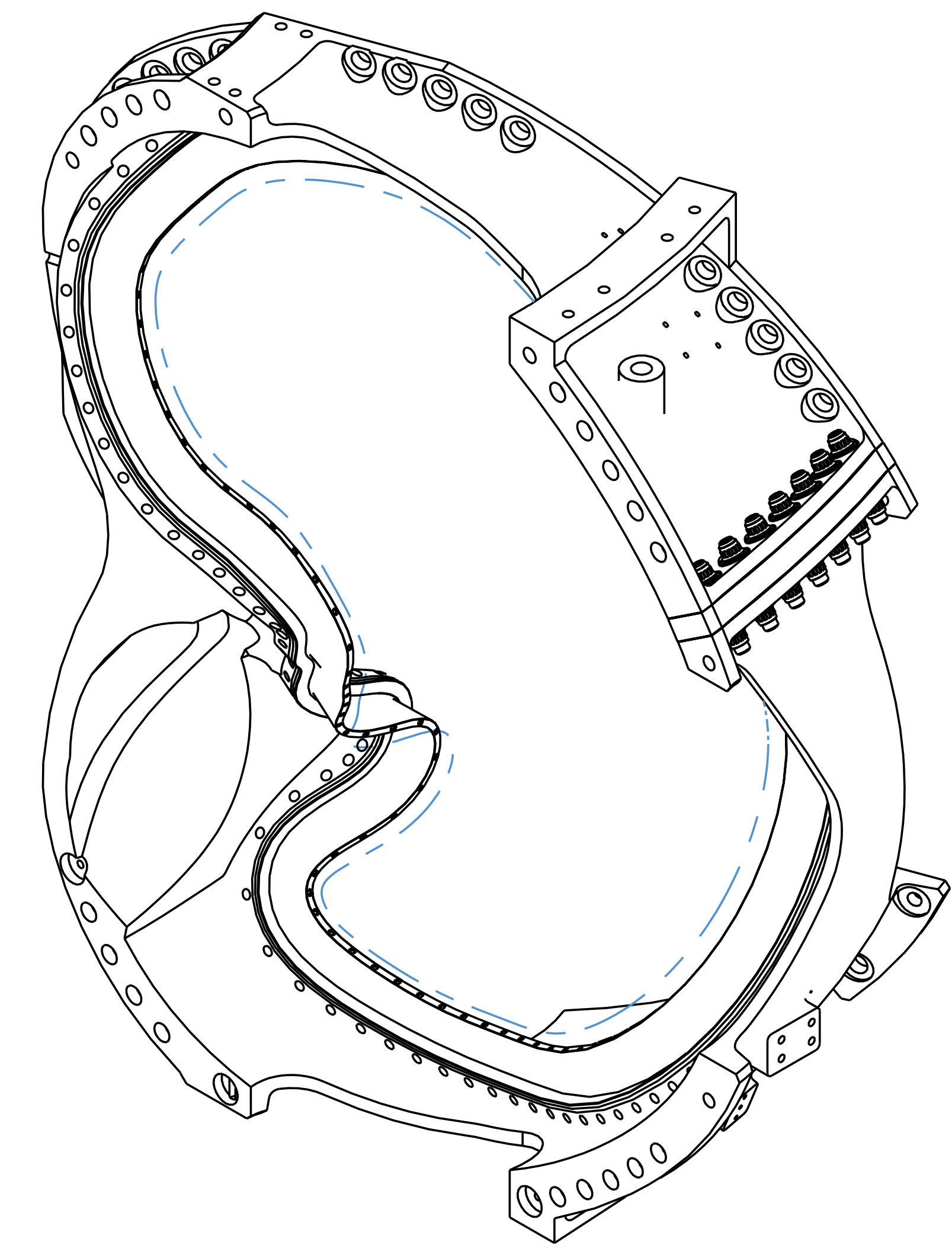
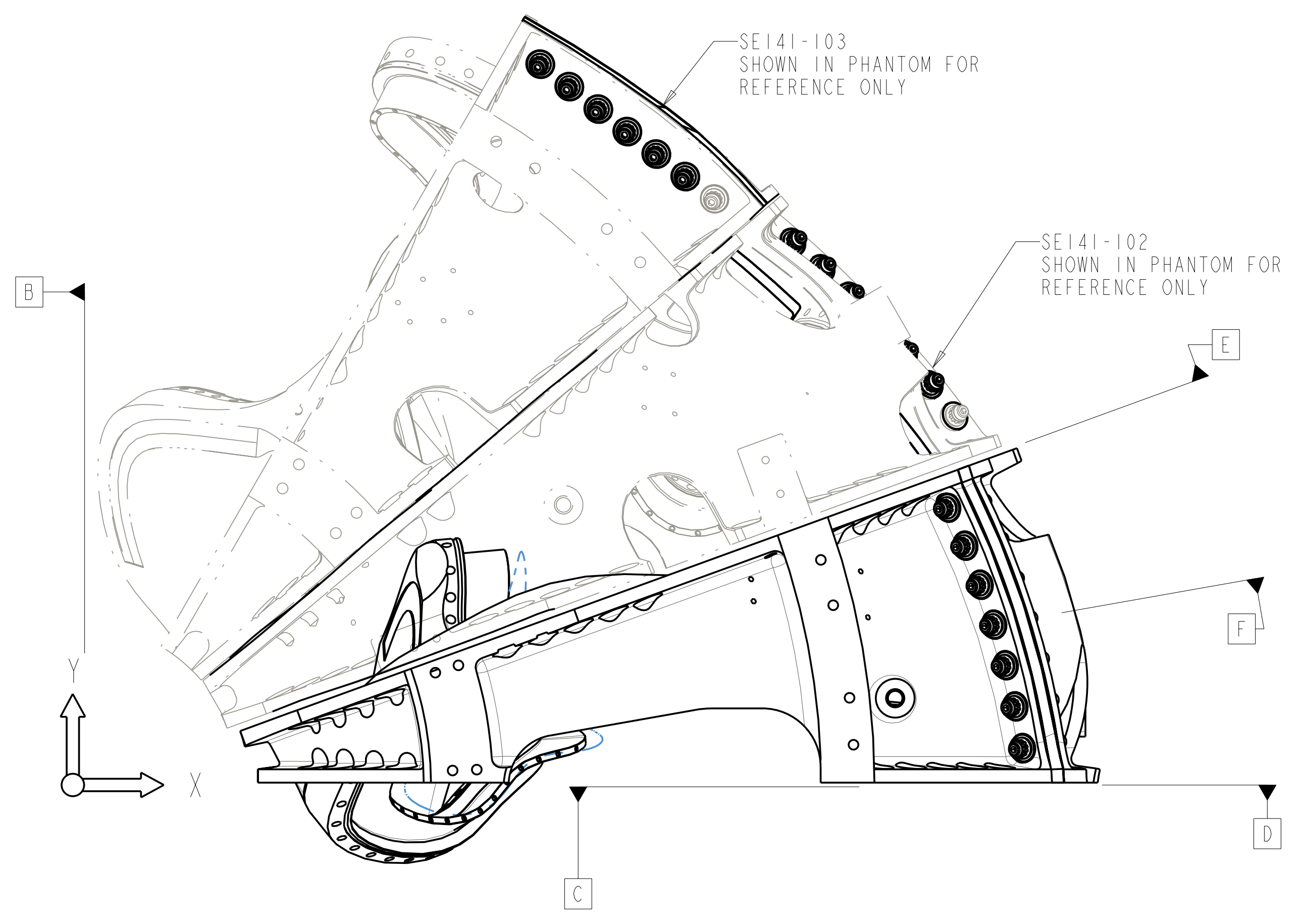


- NOTES:
- DRAWING PREPARED IN ACCORDANCE WITH ASME Y14.8M-1996
 - INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M-1994.
 - DIMENSIONS ARE IN INCHES
 - DRAWING DEPICTS FINAL MACHINED STATE OF ASSEMBLY DEFINED BY PRO/ENGINEER FILE SE141-101.PRT.
 - UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE RELATED 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 ROOM TEMPERATURE. OPERATING TEMP 80 K
 - DIMENSIONS AND TOLERANCES EXCLUDE PROCESS MATERIAL ALLOWANCES WHICH MAY ADD MASS.
 - APPROXIMATE WEIGHT = 4983 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 SPECIFICATION NCSX-CSPEC-141-01-04, FOR ADDITIONAL REQUIREMENTS.
 - BOND INSULATING SLEEVE (F/N 5) TO WINDING FORM (F/N 2) USING LOCTITE 411, PER MANUFACTURERS INSTRUCTIONS.



REV	DESCRIPTION	BY	DATE	CHK	DEPT	DATE	PE	REQ	DATE	ORNL	DOE	DATE
14	-9											
14	-8											
7	-7											
14	-6											
14	-5											
AR	-4											
I	SE141-048											
I	SE141-114											
AR	-1											

CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
		NUT, 12PT HEX, 1-3/8-6 UNC-2B	A286 SILVER PLATED	DS141-060	9
		WASHER, 2.75 OD X 1.56 ID X .50 THK	316 SS	DS141-079	8
		STUD, 1-3/8-6 UNC-2A	316 SS	DS141-036	7
		INSULATING WASHER	GIICR	DS141-038	6
		INSULATING SLEEVE	GIICR	NEMA LI 1 - 1998	5
		INSULATING SHEET, .062 +/- .0075 THK	GIICR	NEMA LI 1 - 1998	4
		POL BREAK SHIM TYPE-A ASSEMBLY			3
		PRODUCTION WINDING FORM TYPE-A			2
		WINDING FORM TYPE-A ASSEMBLY			1

FOR INFORMATION ONLY
 NOT APPROVED FOR FABRICATION

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 PROJECT NAME: NATIONAL COMPACT STELLARATOR EXPERIMENT
DRW: PAUL MILLER	6-30-04	
CHK: M COLE	6-30-04	
SECT:		
DEPT:		WINDING FORM TYPE- A ASSEMBLY
PE: D WILLIAMSON	6-30-04	
CR:		
PJ:		
BREAK SHARP EDGES .06 MAX		VERSION NO. 16+ PLANT X-10 BLDG 5700 FL 3 SHT OF 1 TYPE 2 CLASS S U RELEASE LEVEL WIP SEI41-101
FINISH .125 UNLESS OTHERWISE SPECIFIED		
PPPL DRFT J SIEGEL	6-30-04	
DRAWING APPROVALS	DATE	

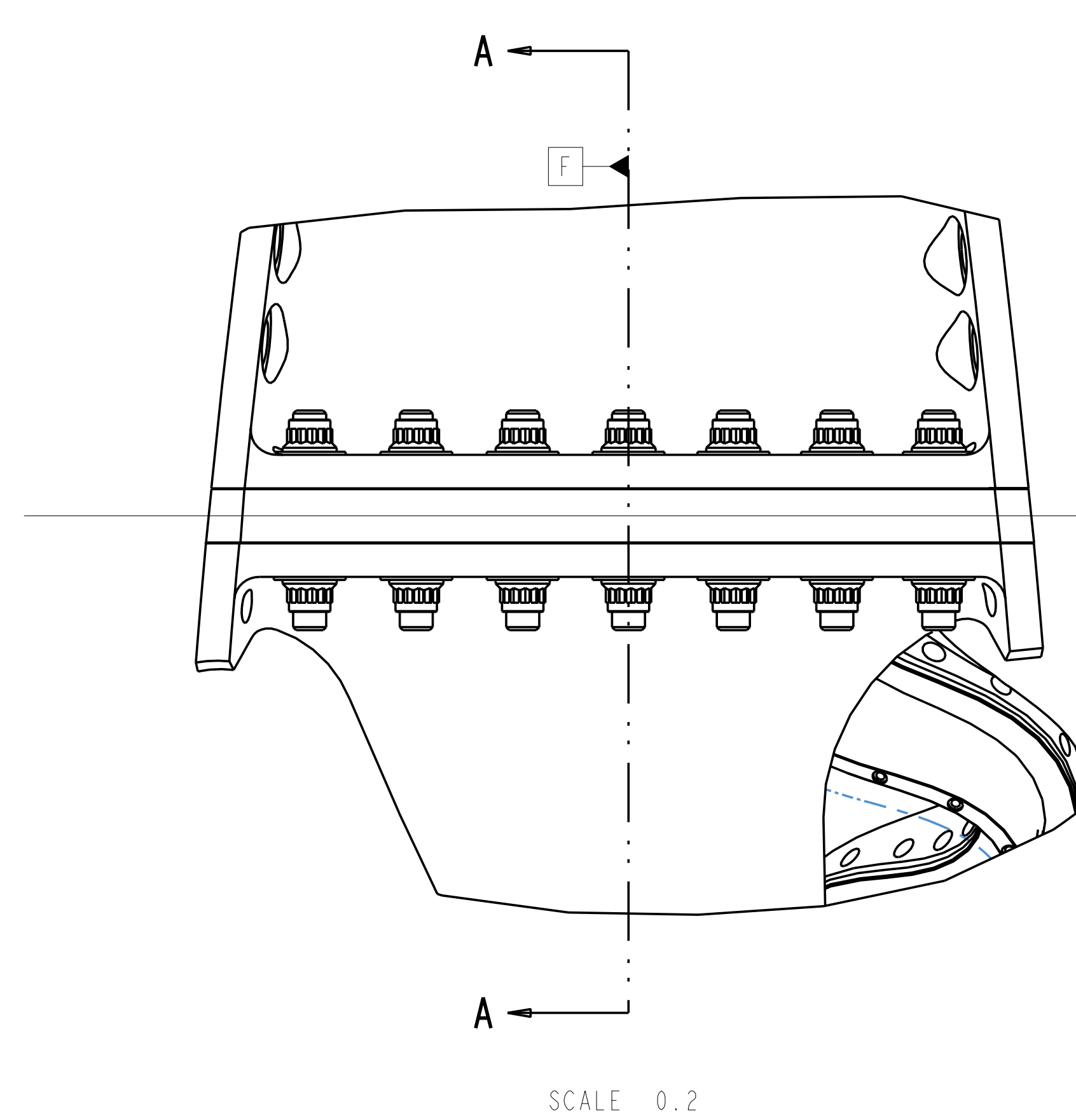
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P THIS DRAWING PRODUCED ON PRO-ENGINEER

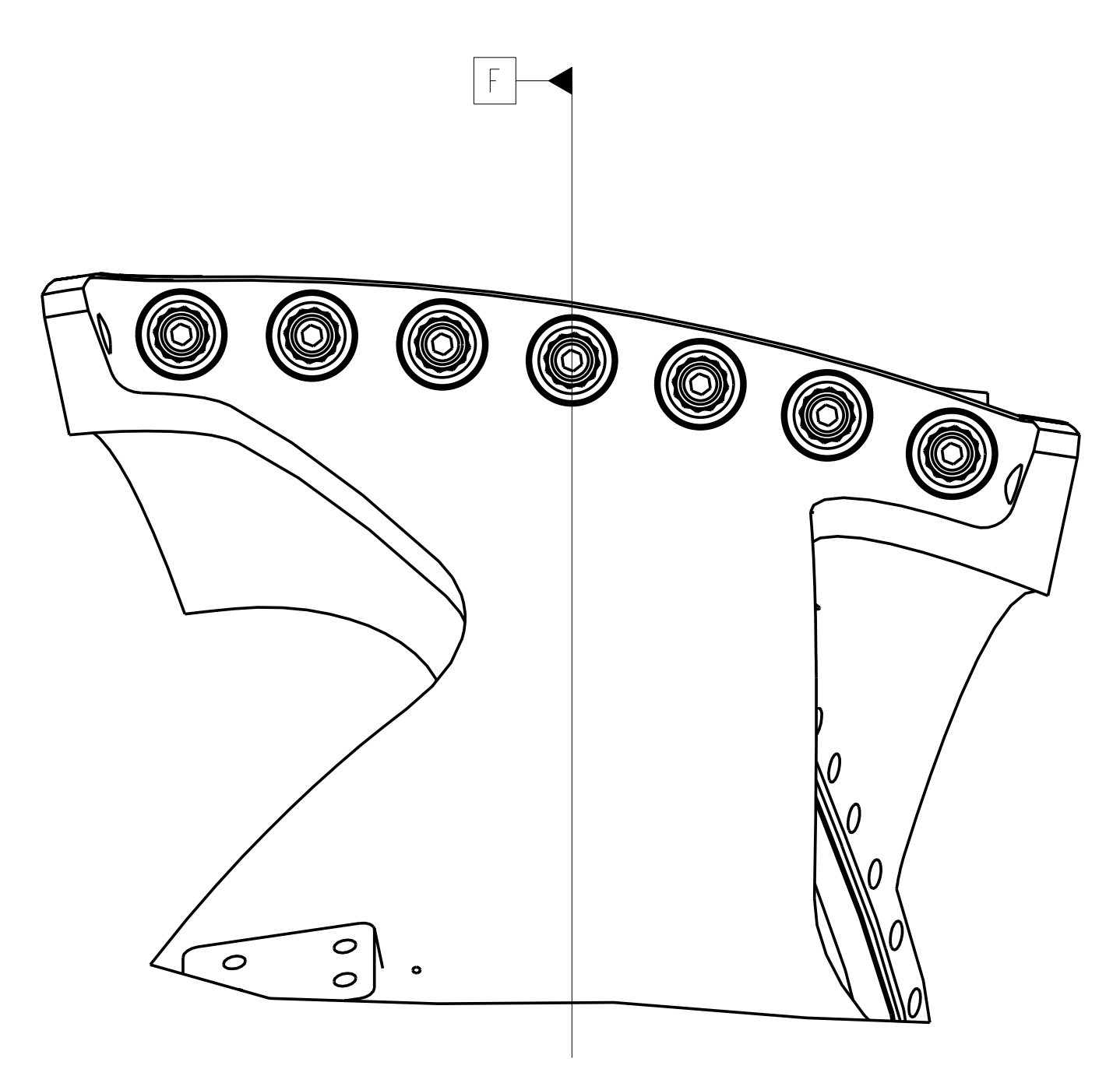
SCALE .10

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

H
G
F
E
D
C
B
A

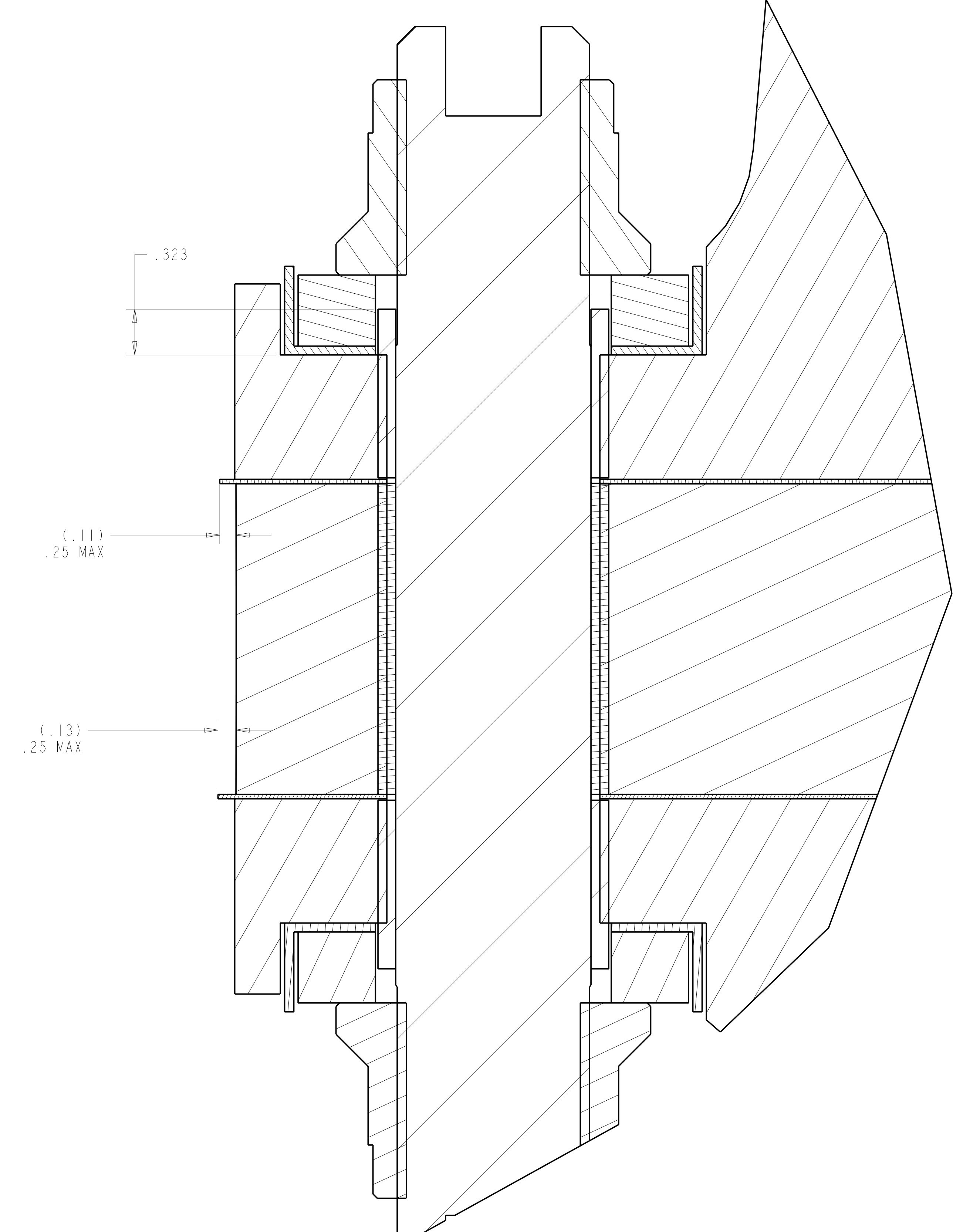


SCALE 0.2

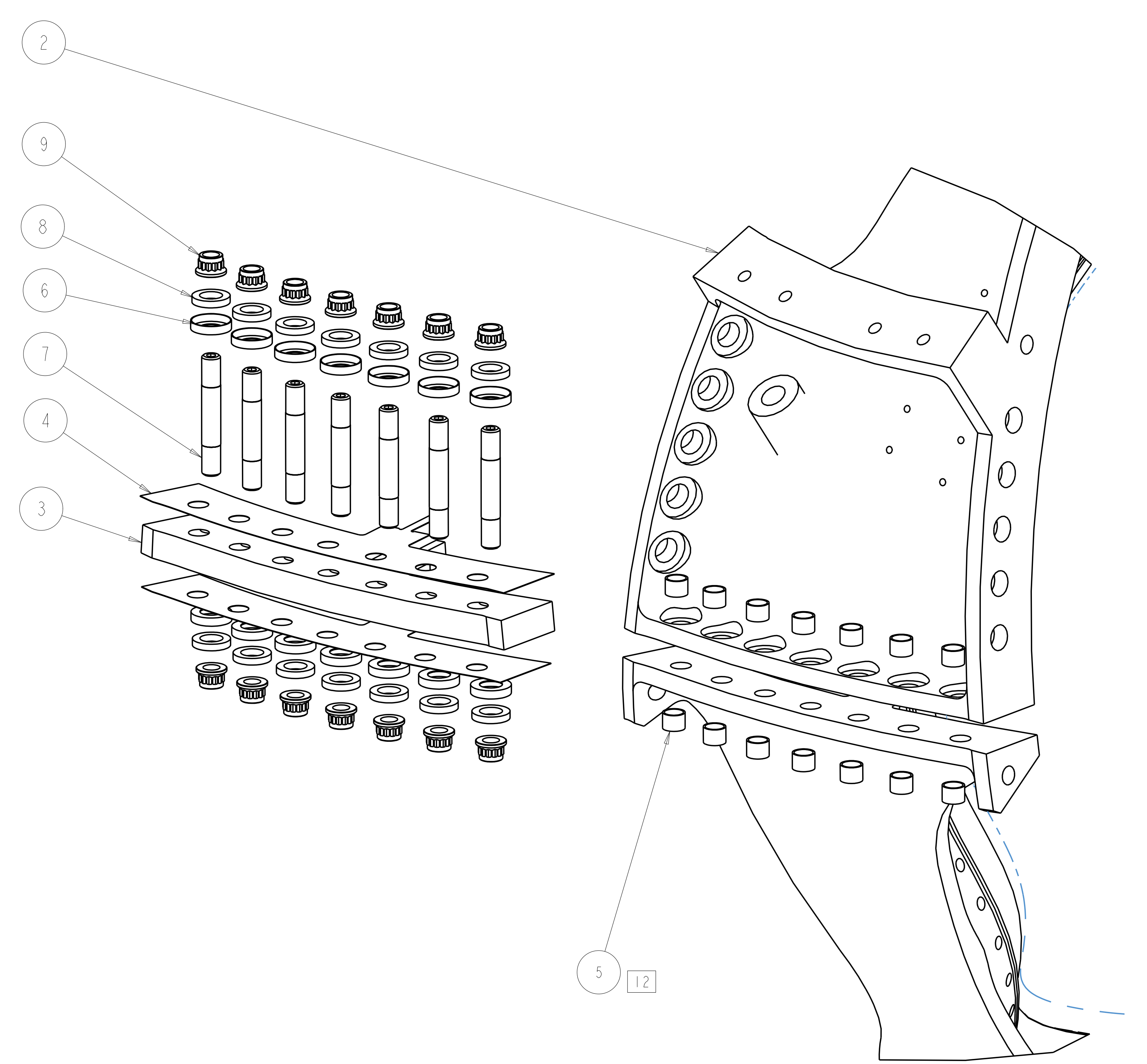


SEE DETAIL X

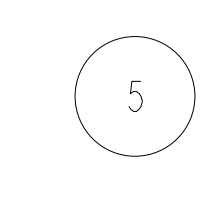
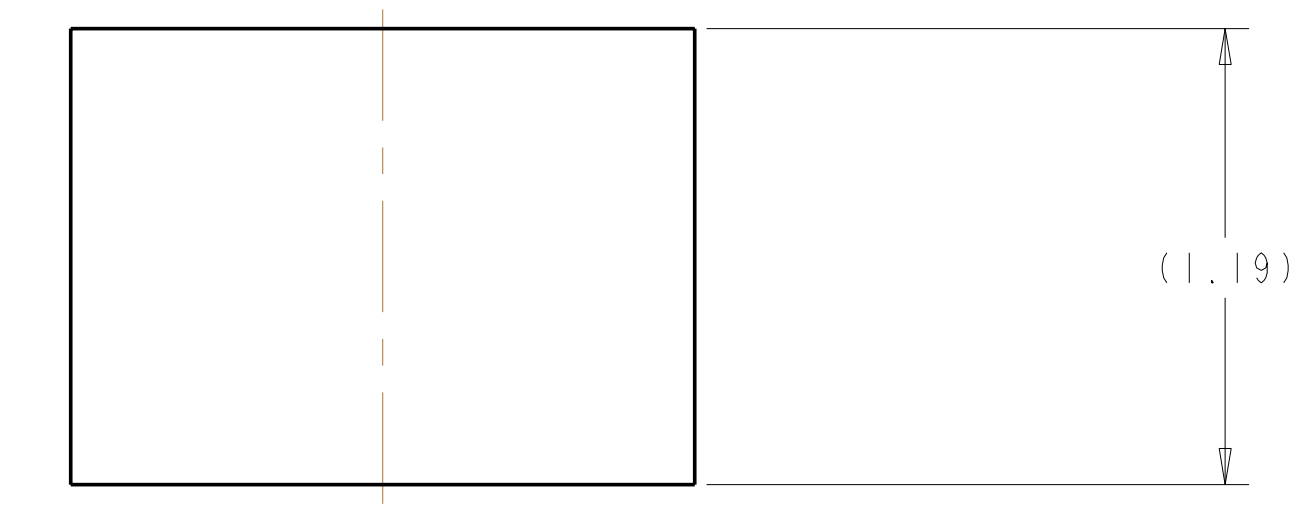
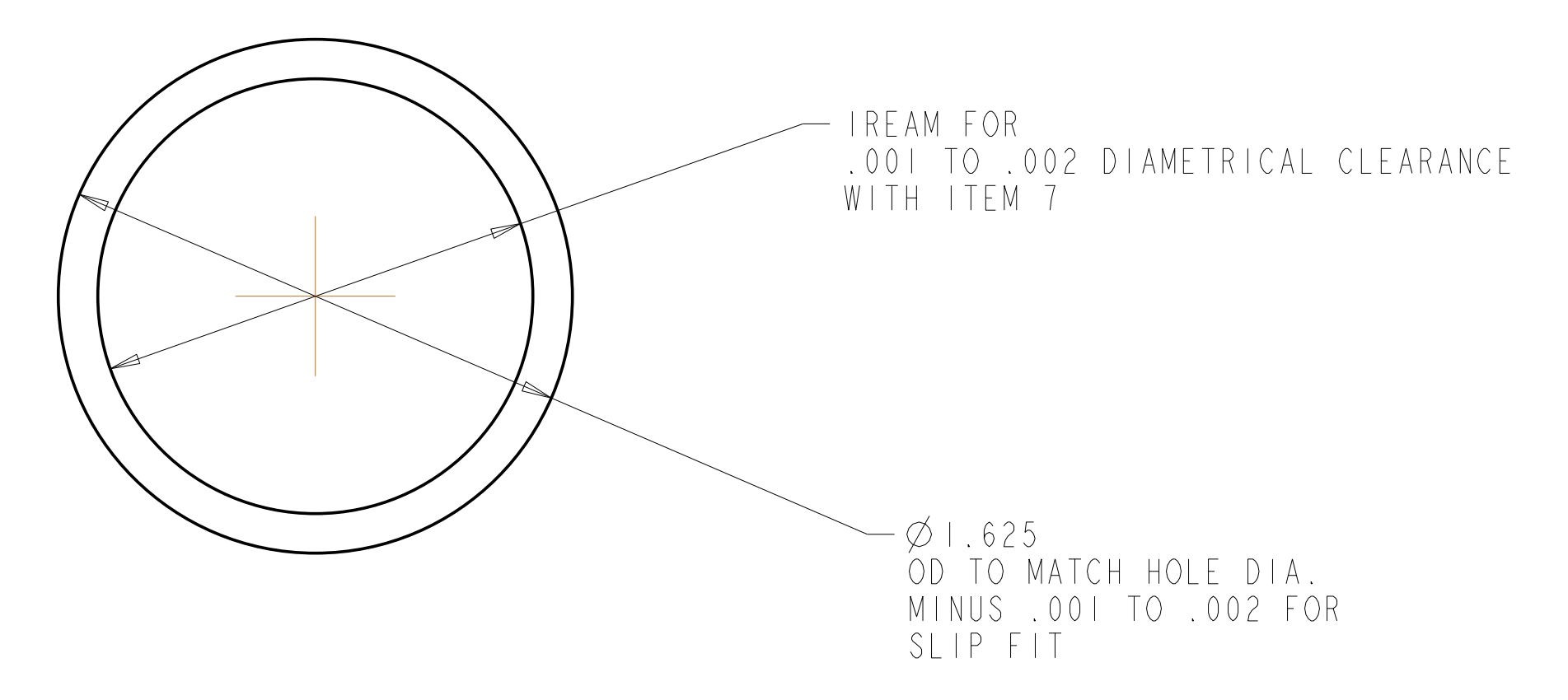
SECTION A-A



DETAIL X
SCALE 2.00



EXPLODED VIEW
SCALE 0.2



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							
UT-BATTELLE NATIONAL COMPACT STELLARATOR EXPERIMENT							
WINDING FORM TYPE- A ASSEMBLY							
VERSION NO.	PLANT	BLDG	FL	SHT OF	TYPE	CLASS	
31	X-10	5700	3	2	S	U	
RELEASE LEVEL		SEI41-101					
WIP							