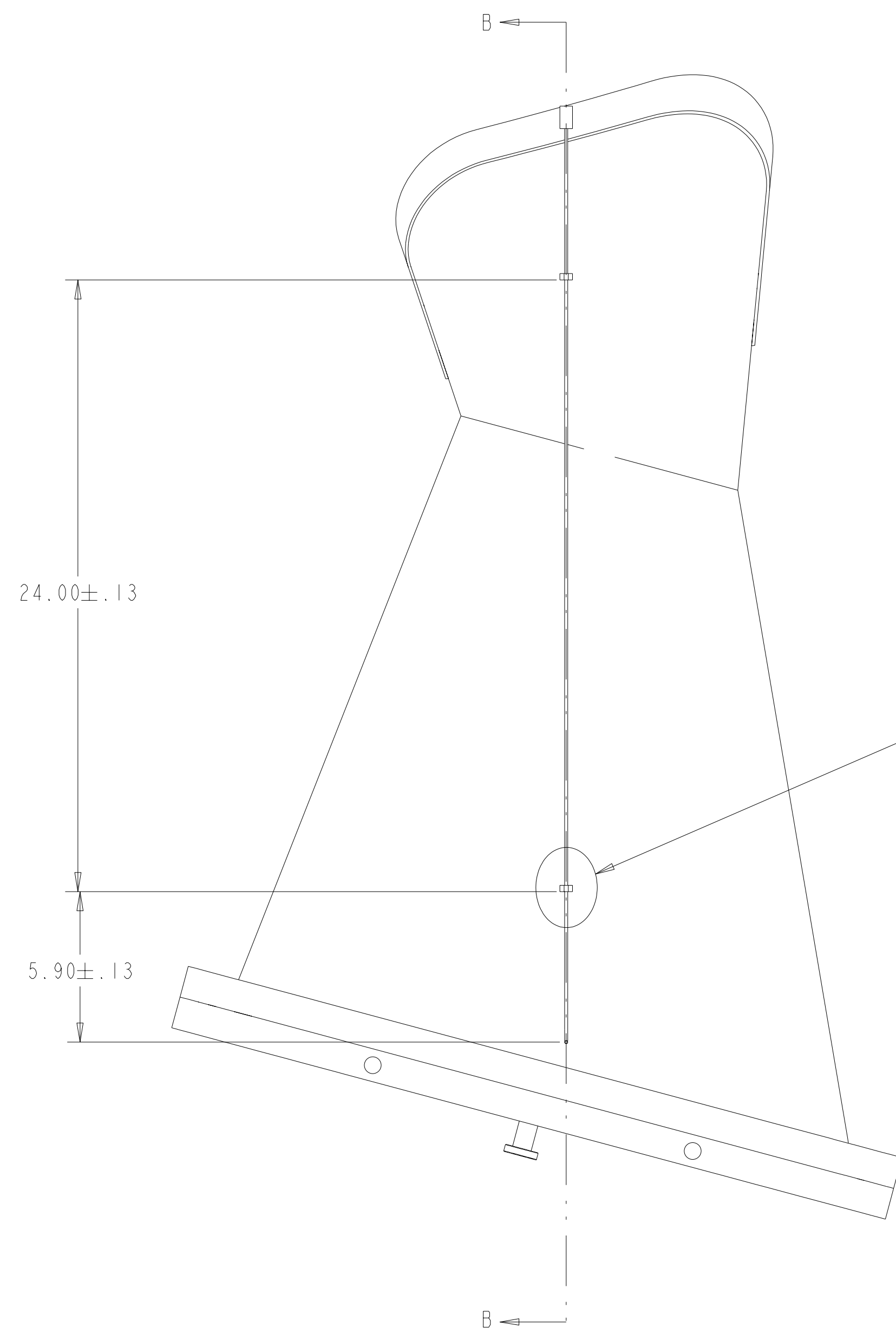
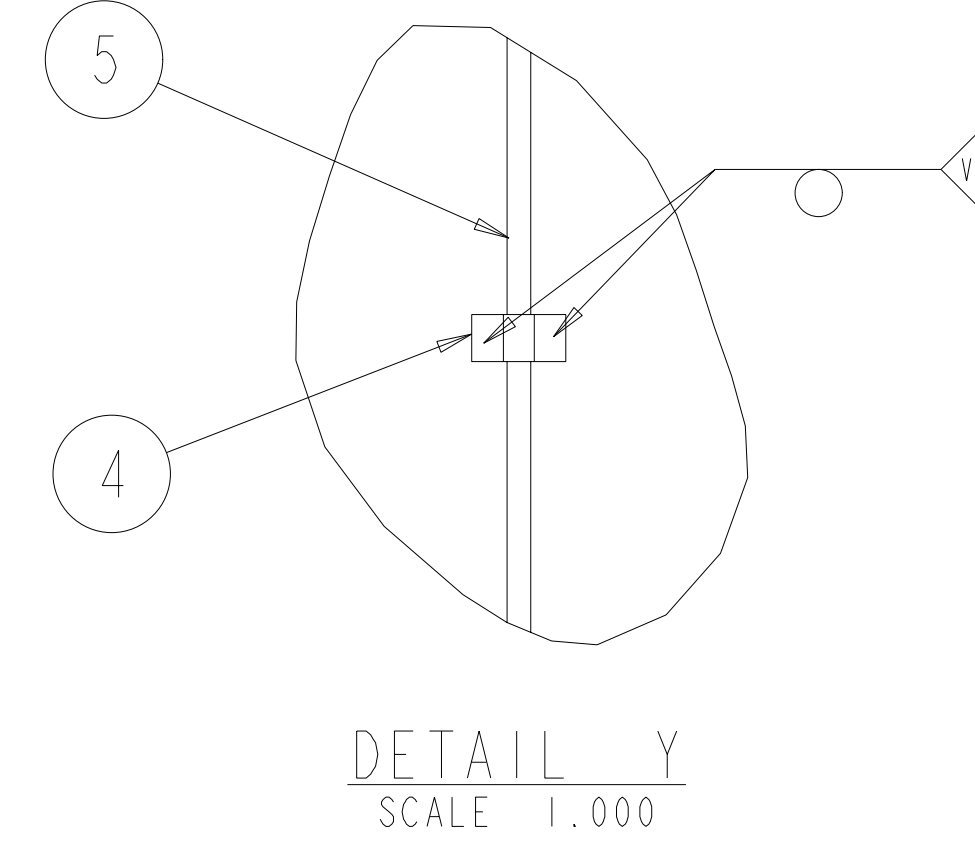
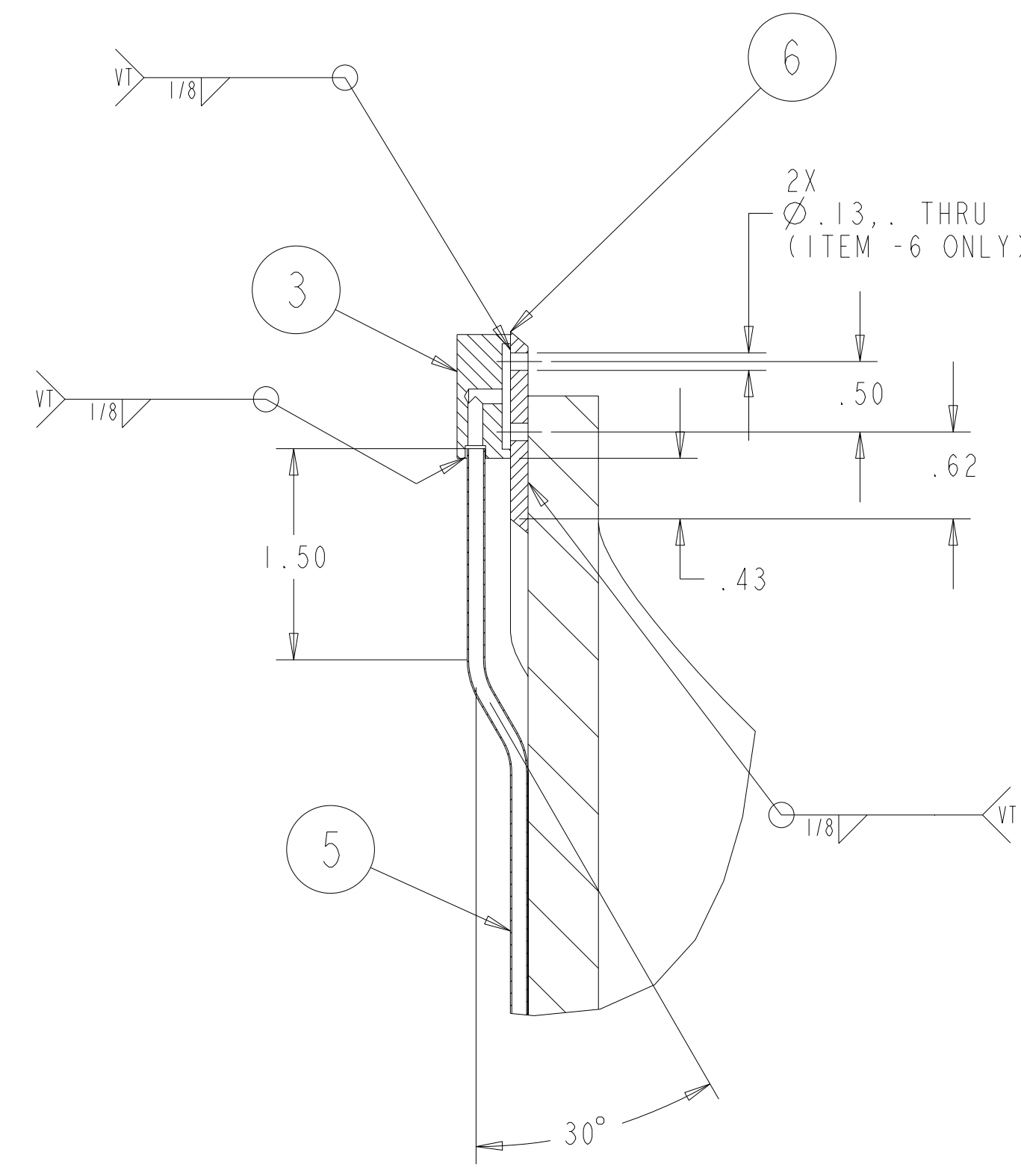


NOTES:

1. INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M
2. DIMENSIONS ARE IN INCHES
3. PORT 4A WELDMENT AND PORT 4B WELDMENT CREATED AT SE120-003, AS A RESULT OF MATCH MARKING FOR RE-ASSEMBLY.
4. BACKING RING PROFILE 1/2" OFFSET FROM VACUUM VESSEL. CUT NORMAL TO PORT 4.
5. FABRICATION, INSPECTION, AND TESTING SHALL BE PERFORMED IN ACCORDANCE WITH SPECIFICATION NCSX-CSPEC-121-02 AND STATEMENT OF WORK NCSX-SOW-121-03.

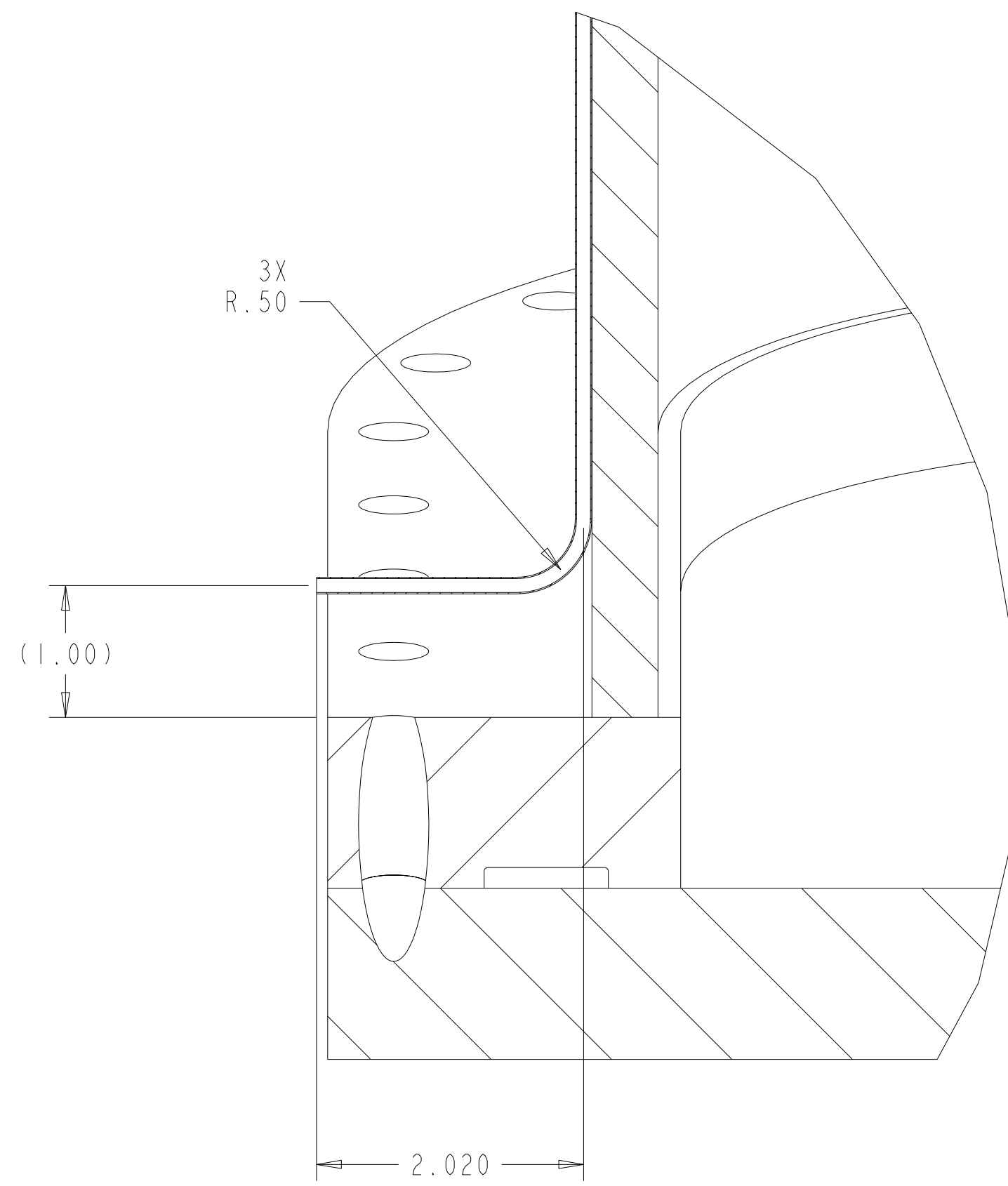
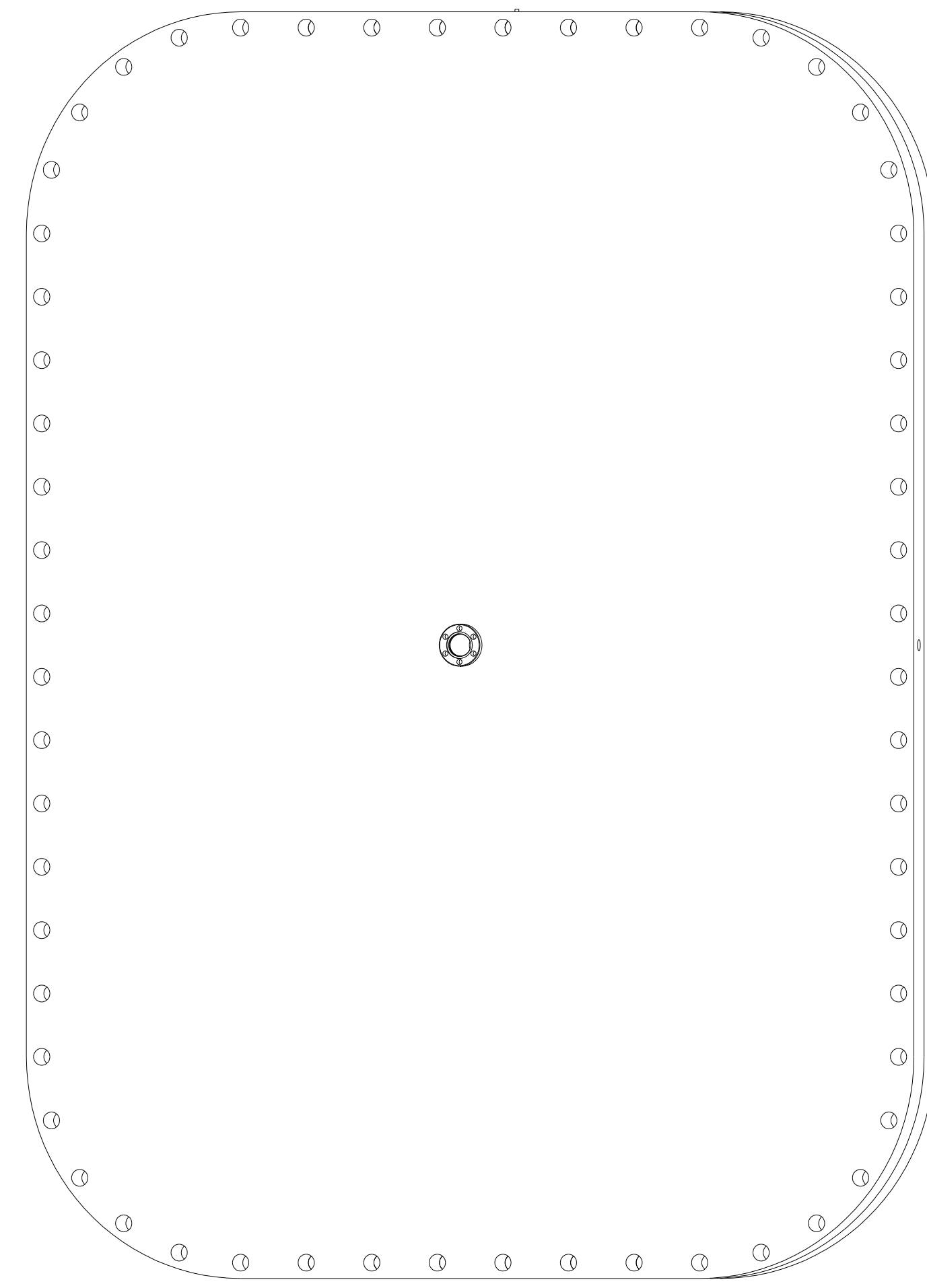
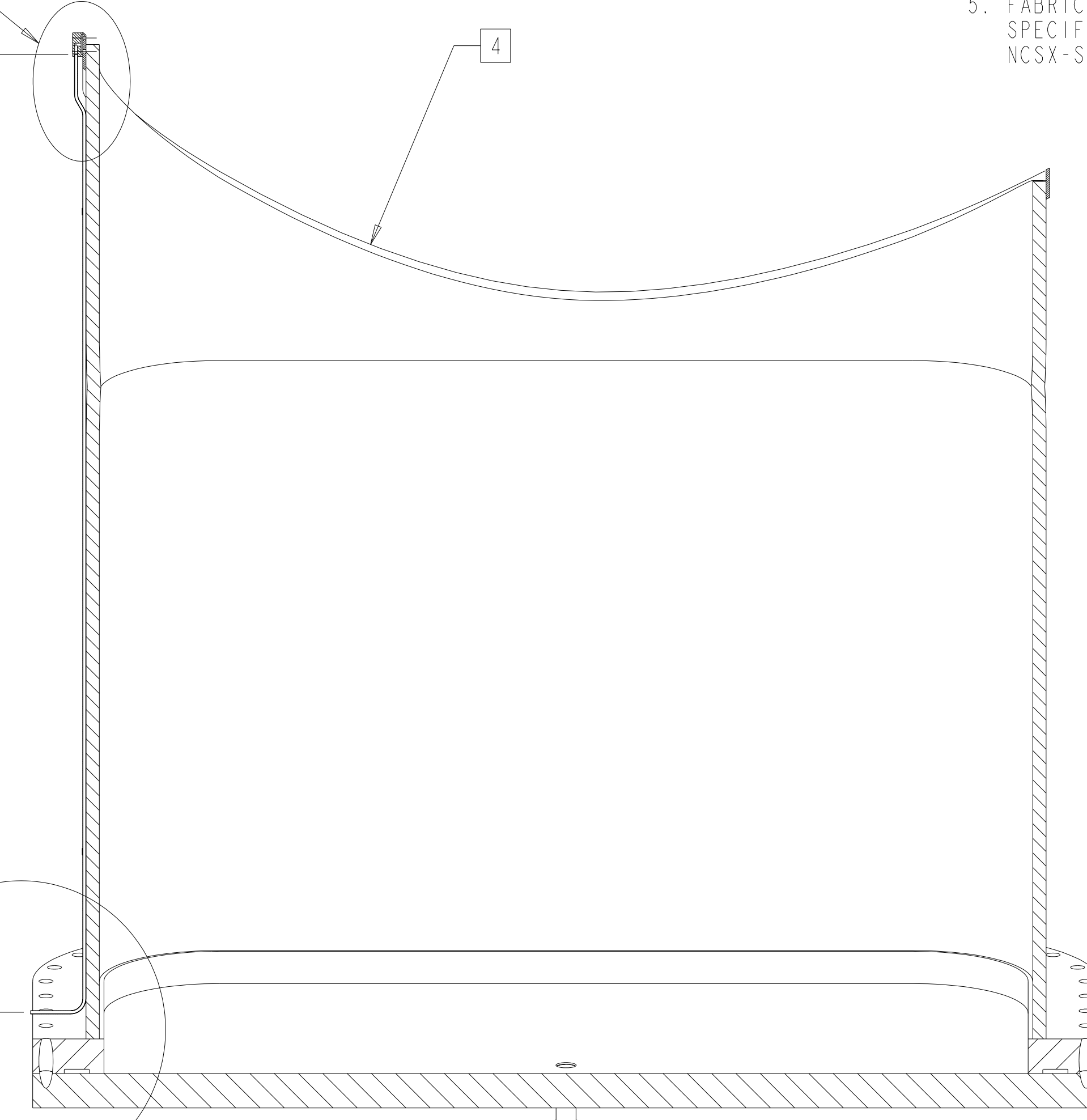


SEE DETAIL Y



SEE DETAIL X
35.91 ± .13
(ITEM -5)

SEE DETAIL Z



(1) (2) SCALE .250

WELDING ENGINEER

APPROVED: R PARSELLS DATE: 6/04

**RELEASED FOR
FABRICATION / INSTALLATION**
PPPL Drafting:

REV	AR	AR	DESCRIPTION	WELD, FILLER METAL	FIND NO
1	1	-7	PORT 4 BACKING RING	UNS N06625	6
2	2	-5	TUBEING 1/8 X .035 WALL	316L SST	5
3	3	SE120-005-39	CLIP		4
4	4	SE122-105	BLOCK		3
5	5	-2	PORT 4B WELDMENT		2
6	6	-1	PORT 4A WELDMENT		1

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

CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO

← NEXT ASSEMBLY

PARTS LIST

SCALE NOTED	DES. P. L. GORANSON 8/03	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. G. H. JONES 8/03	
FRACTIONS	CHK. M. COLE 6/04	PROJECT NAME
XX DECIMALS ± .01		NATIONAL COMPACT STELLARATOR EXPERIMENT
XXX DECIMALS ± .005		VACUUM VESSEL
ANGLES ± 0°15'		PORT EXTENSION
BREAK SHARP EDGES .06 MAX		WELDMENT
FINISH .125 UNLESS OTHERWISE SPECIFIED	PPPL DRFT J. SIEGEL 6/04	VERSION NO. 23
		PLANT X-10
		BLDG 5700
		FL 3
		SHT 1
		OF 1
		TYPE I
		CLASS S
		REV 0
		RELEASE LEVEL Fabrication
		SE122-006

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P THIS DRAWING PRODUCED ON PRO-ENGINEER

SE122-006

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