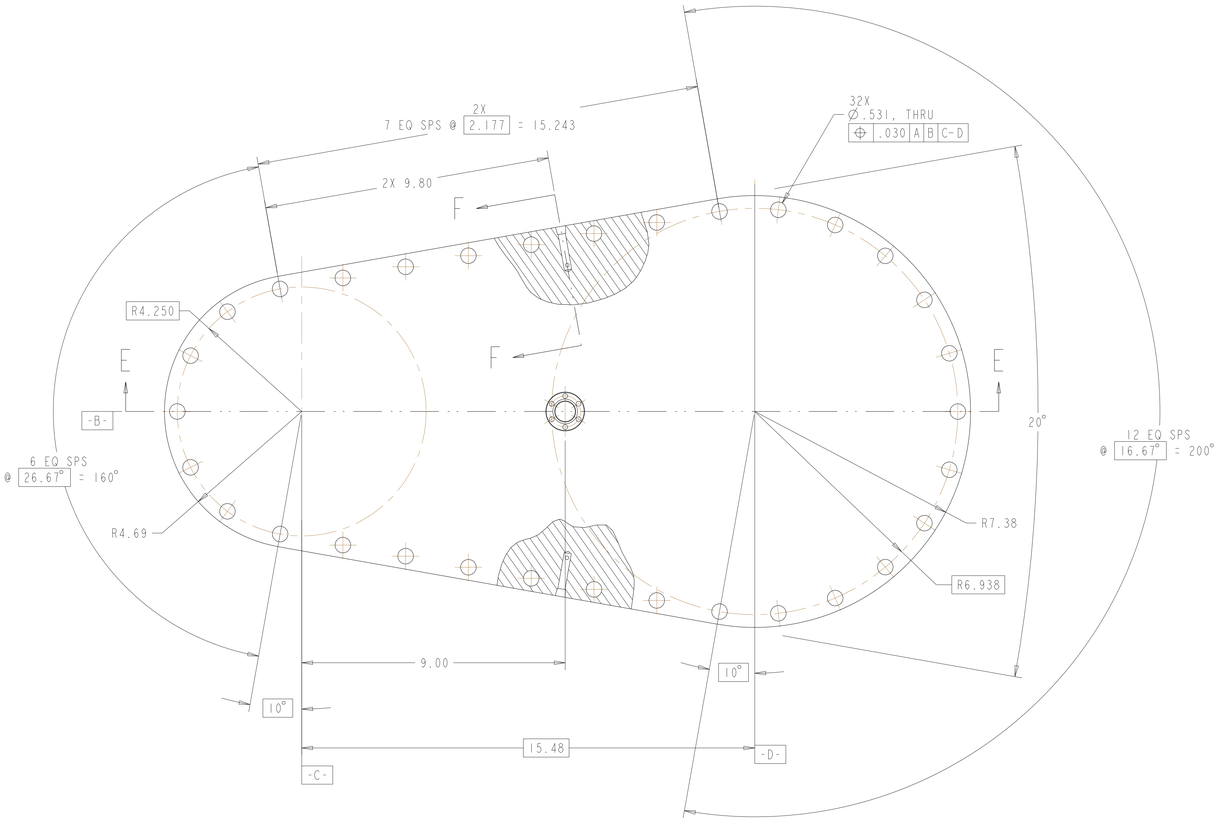
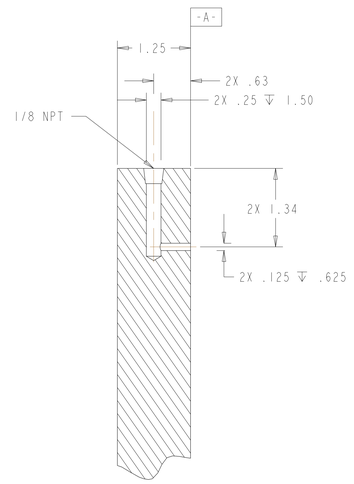
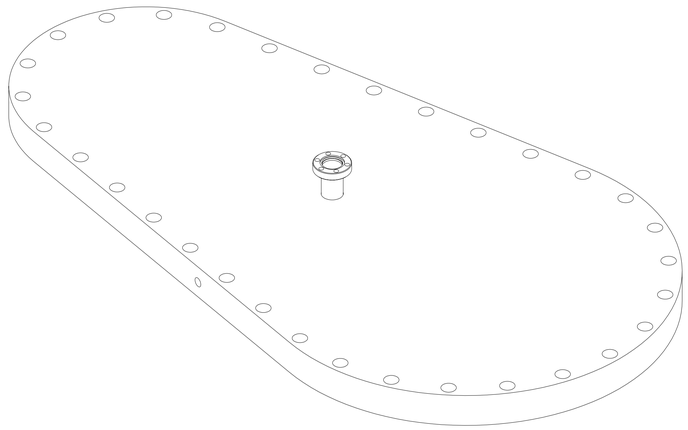
NOTES:

1. INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M.
2. DIMENSION ARE IN INCHES.
3. FABRICATION, INSPECTION, AND TESTING SHALL BE PERFORMED IN ACCORDANCE WITH SPECIFICATION NCSX-CSPEC-121-02 AND STATEMENT OF WORK NCSX-SOW-121-03.

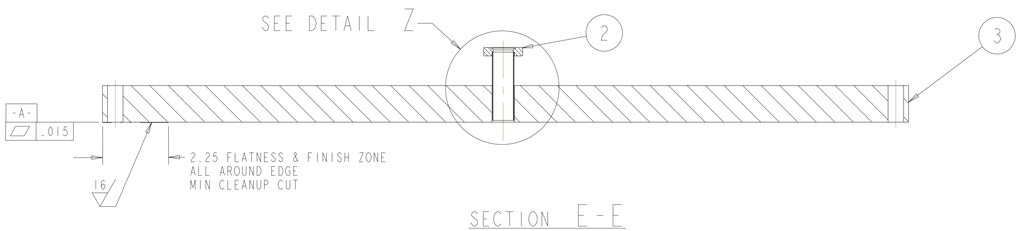



SECTION F-F
SCALE 1.00



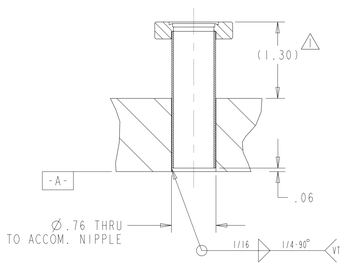
ISOMETRIC VIEW




SECTION E-E

| | | | | | | |
|---|---|---|---|---|---|---|
| | AR | | -4 | WELD, FILLER METAL | | 4 |
| | 1 | | -3 | PORT 12 FLANGE | 316L SST | 3 |
| | 1 | | -2 | HALF NIPPLE 1 1/3 DEL-SEAL CF CUSTOM LENGTH 2.50" | MDC VACUUM PRODUCTS CORP. 23842 CABBOT BOULEVARD HAYWARD, CA. 94545-1651 | 2 |
| | AR | | -1 | PORT 12 COVER TEST FLANGE WELDMENT | | 1 |
| SE120-004 | - | CAGE CODE | PART OR IDENTIFYING NO | NOMENCLATURE OR DESCRIPTION | MATERIAL / SPECIFICATION | FIND NO |
| | | ← | NEXT ASSEMBLY | PARTS LIST | | |

**RELEASED FOR FABRICATION / INSTALLATION**
PPPL Drafting: Jerry Siegel
2004.11.24 11:26:29 -05'00'




DETAIL Z
SCALE 1.00

WELDING ENGINEER
APPROVED R. PARSELLS DATE: 6/04

1 SCALE: .50

| REV | DESCRIPTION | BY | DATE | CHK | DEPT | DATE | PE | REQ | DATE | ORNL | DOE | DATE |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | REVISION OR ISSUE PURPOSE | REVISION APPROVAL | | | | | | | | | | |
| | REVISED PER ECN-4933 | MJC | 11/02/04 | PLG | | | | | | | | |
| 1 | ⚠ ADDED REF DIMENSION | | | | | | | | | | | |

SCALE NOTED
TOLERANCES UNLESS OTHERWISE SPECIFIED
FRACTIONS :
XX DECIMALS ±.01
XXX DECIMALS ±.005
ANGLES ±0°15'
BREAK SHARP EDGES .06 MAX
FINISH 125 UNLESS OTHERWISE SPECIFIED

| DRAWING APPROVALS | DATE |
|---|---|
| DES P.L.GORANSON | 8/03 |
| DRW G.H.JONES | 8/03 |
| CHK M. J. COLE | 6/04 |
| SECT : | : |
| DEPT : | : |
| PE : | : |
| CR : | : |
| PJ : | : |
| REQ : | : |
| PPPL DRFT J. SIEGEL | 6/04 |
| : | : |
| : | : |

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

VACUUM VESSEL
PORT 12 COVER TEST FLANGES
WELDMENT

| VERSION NO. | PLANT | BLDG | FL | SHT | OF | TYPE | CLASS |
|---|---|---|---|---|---|---|---|
| 1 | X-10 | 5700 | 03 | 1 | 1 | S | U |

RELEASE LEVEL: Fabrication
SE122-104
REV 1

SE122-104

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