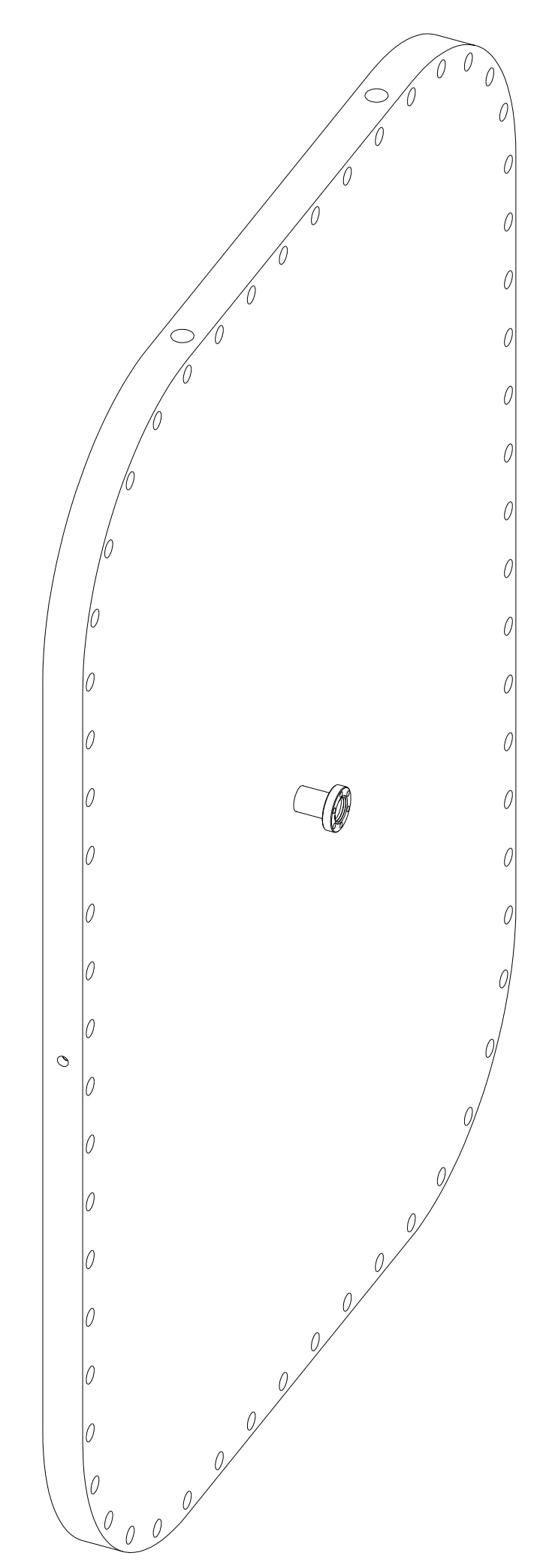
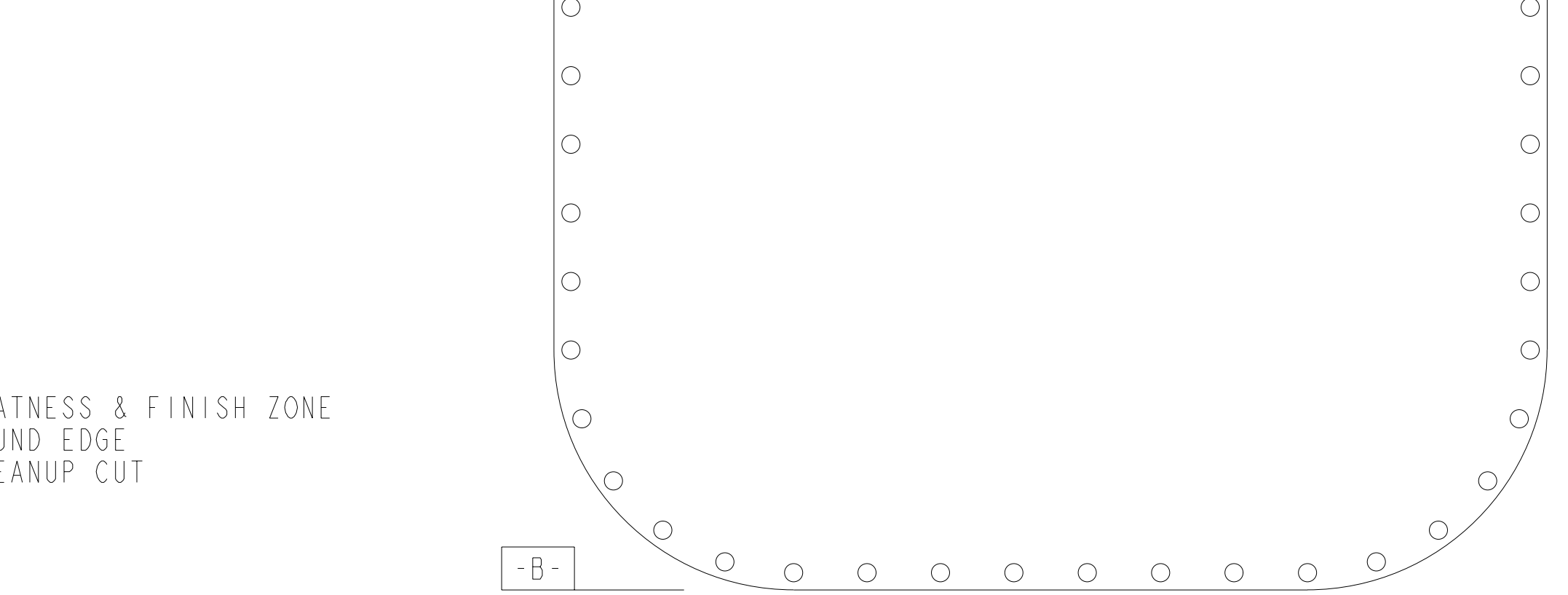
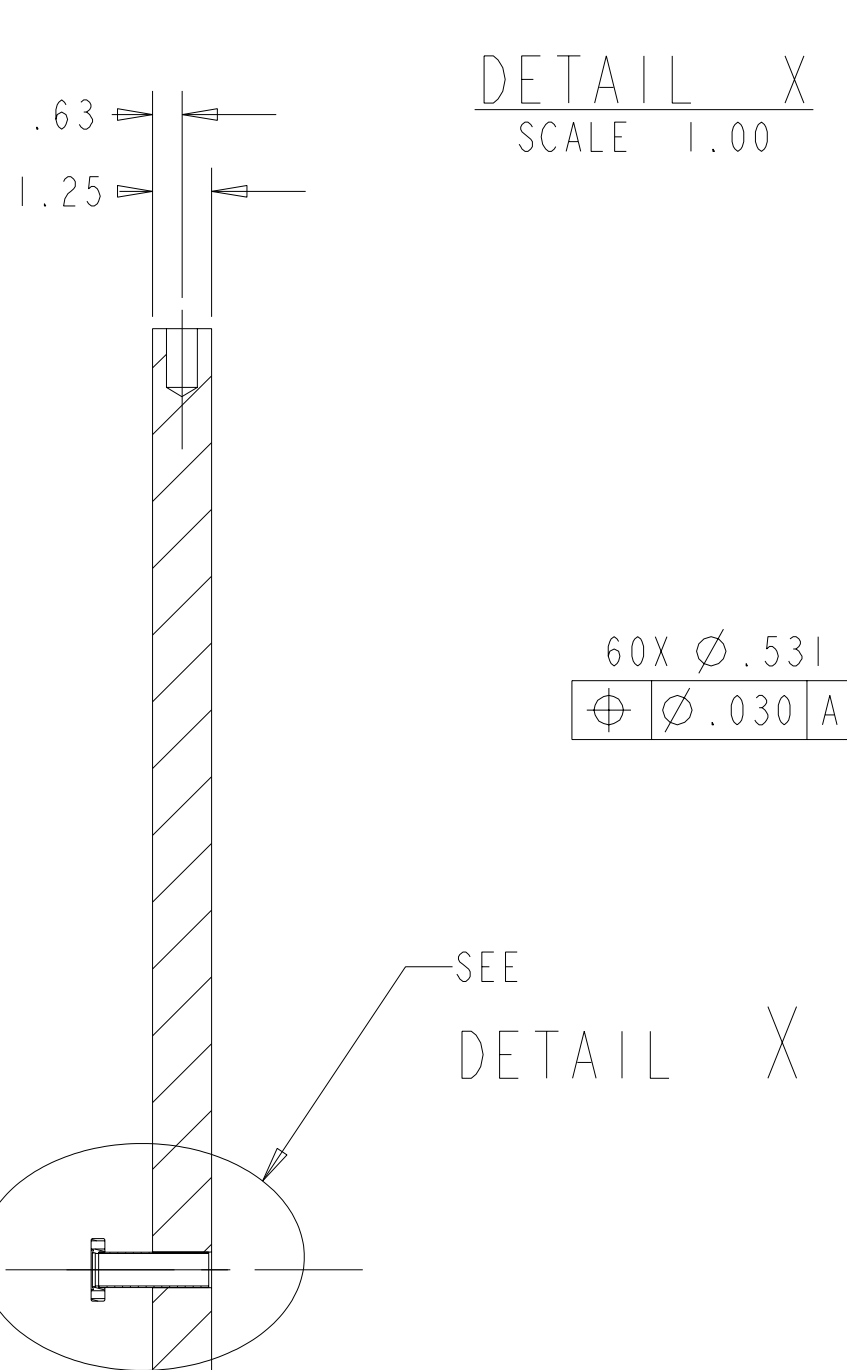
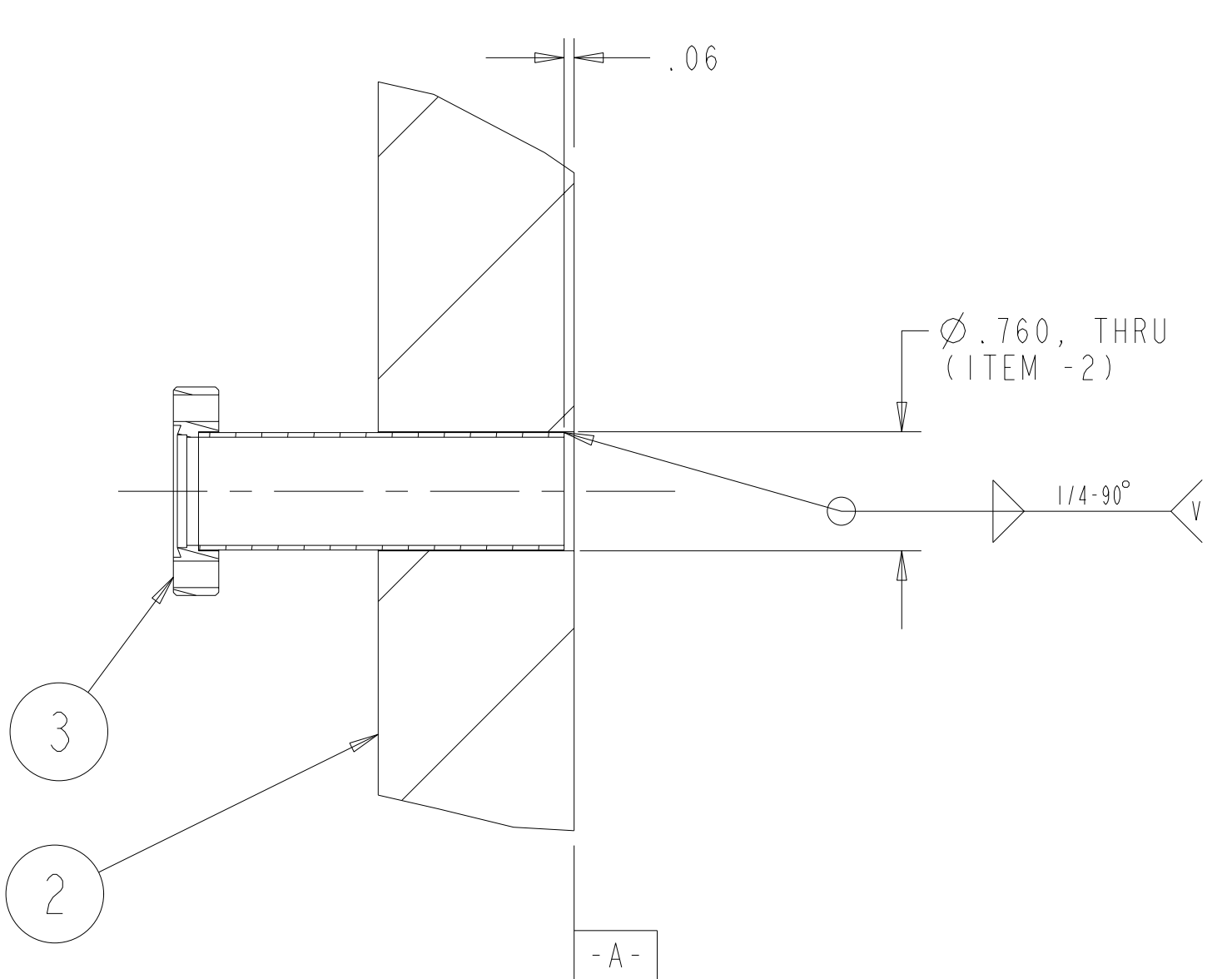
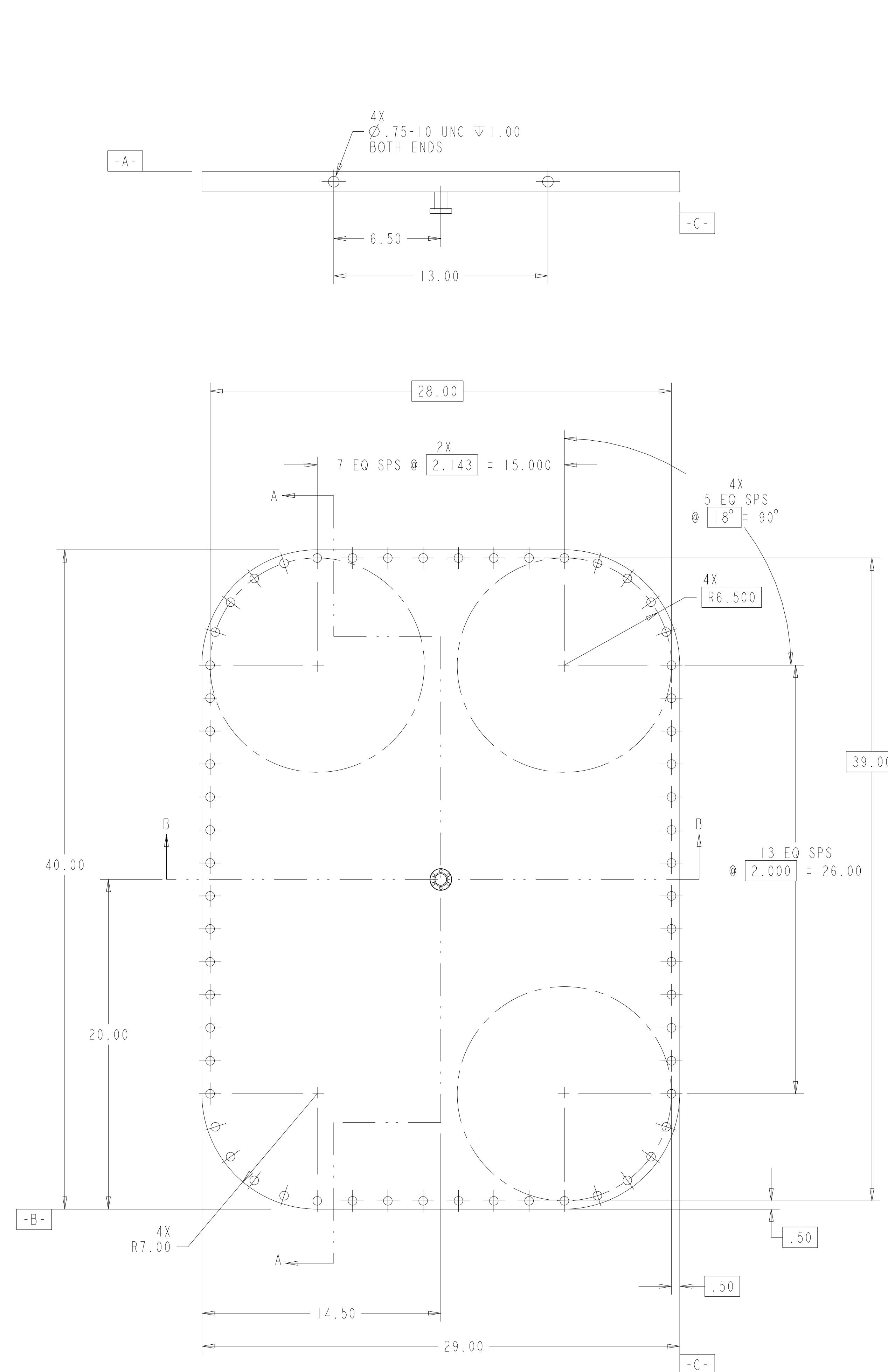
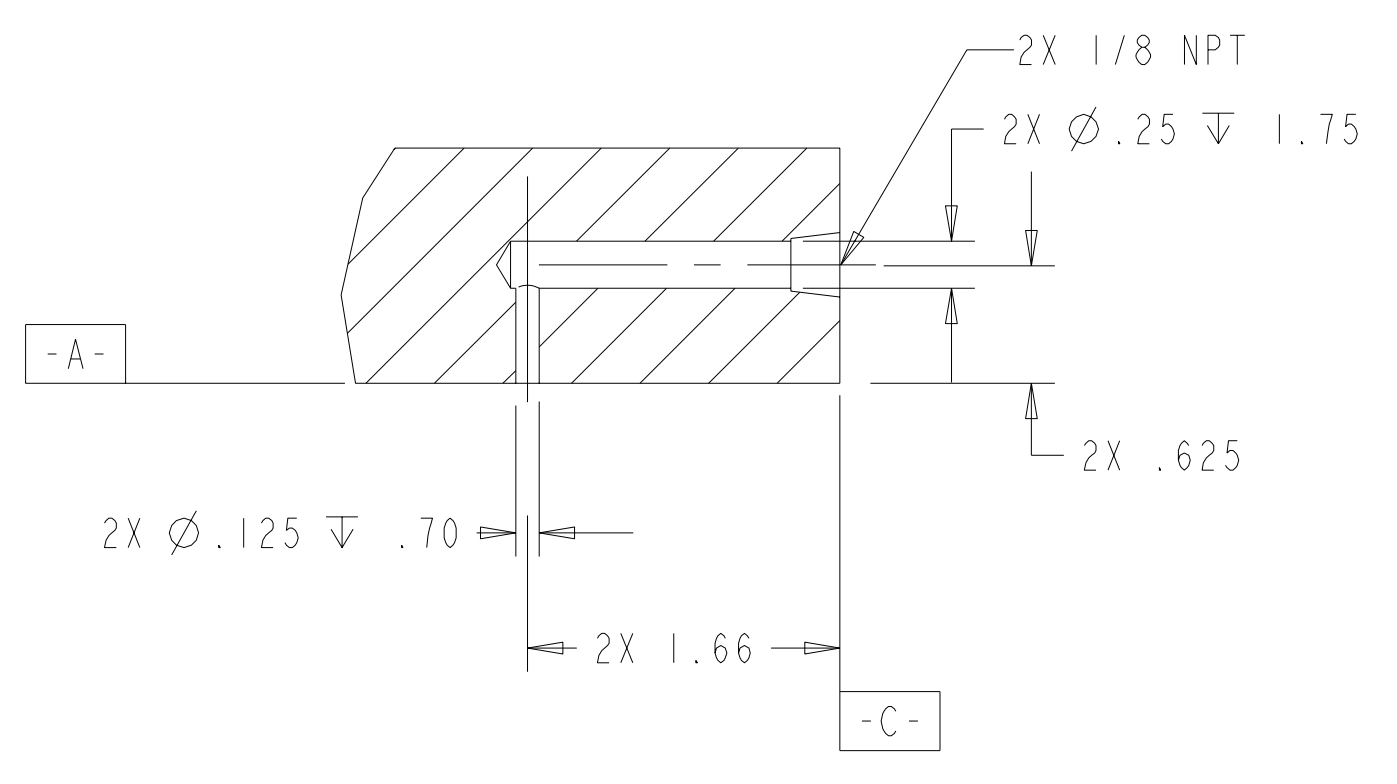
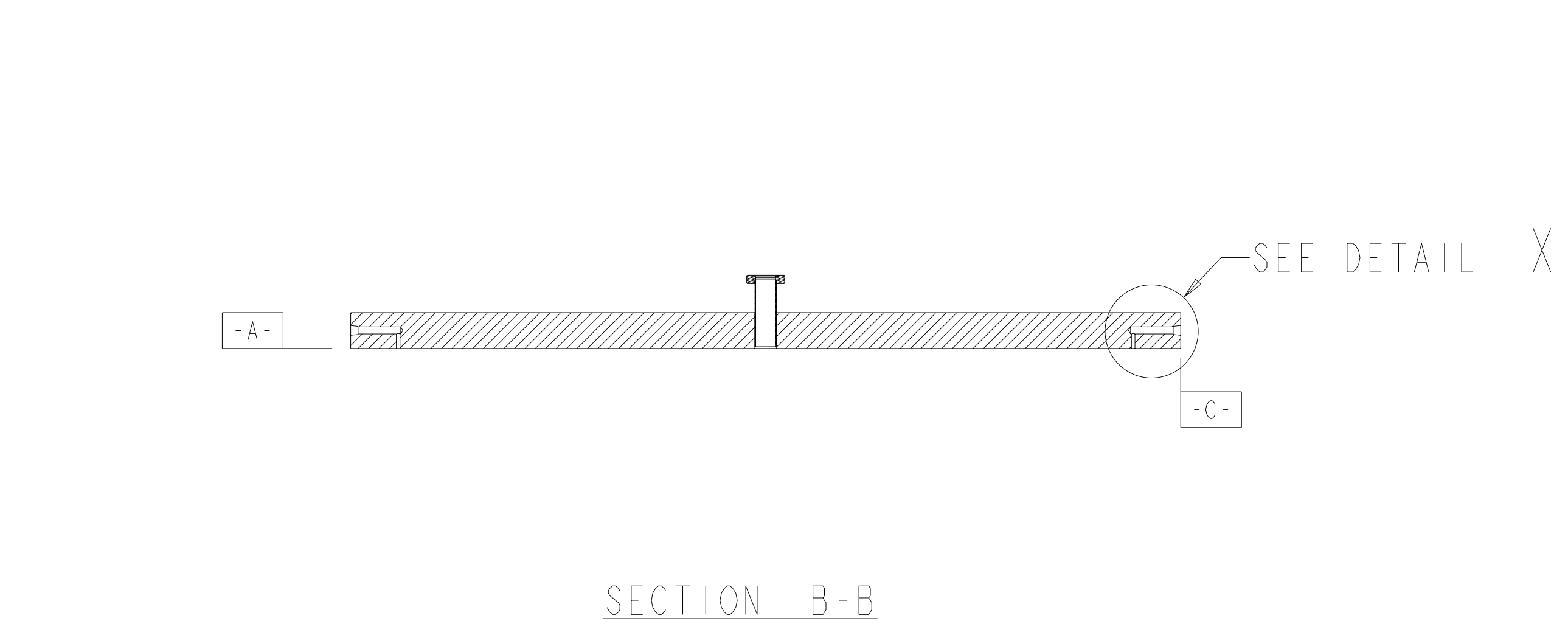


- NOTES:
1. INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M.
 2. DIMENSIONS ARE IN INCHES.
 3. FABRICATION, INSPECTION, AND TESTING SHALL BE PERFORMED IN ACCORDANCE WITH SPECIFICATION NCSX-CSPEC-121-02 AND STATEMENT OF WORK NCSX-SOW-121-03.



ISOMETRIC VIEW



SCALE: .25

DETAIL X SCALE: 1.00

WELDING ENGINEER
APPROVED R. PARSELLS DATE: 6/09

RELEASED FOR FABRICATION / INSTALLATION
PPPL Drafting:

AR	QTY	DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO	
AR	-4	WELD FILLER METAL			4	
I	-3	HALF NIPPLE 1/3 DEL-SEAL CF CUSTOM LENGTH = 2.50"	NDC VACUUM PRODUCTS CORP. 23842 CABOT BOULEVARD, HAYWARD CA. 94545-1615		3	
I	-2	PORT 4 COVER TEST FLANGE	316L SST		2	
AR	-1	PORT 4 COVER TEST FLANGE WELDMENT			1	
SE 20-004	-1	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

SCALE NOTED	DES PL GORANSON 8/03
TOLERANCES UNLESS OTHERWISE SPECIFIED	DRW G.H. JONES 8/03
FRACTIONS	CHK D SPARKS 6/04
XX DECIMALS ±.01	SECT :
XXX DECIMALS ±.005	DEPT :
ANGLES ±0°15'	PE :
BREAK SHARP EDGES .06 MAX	CR :
FINISH .125 UNLESS OTHERWISE SPECIFIED	PJ :
	REQ :
	PPPL DRFT J. SIEGEL 6/04
	VERSION NO. 15
	PLANT X-10
	BLDG 5700
	FL 03
	SHT 1
	TYPE 1
	CLASS A
	RELEASE LEVEL Fabrication
	DATE

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 4 COVER TEST FLANGE WELDMENT			
VERSION NO.	PLANT	BLDG	FL
15	X-10	5700	03
SHT	TYPE	CLASS	REV
1	1	A	U
RELEASE LEVEL Fabrication			REV 0
SE122-149			