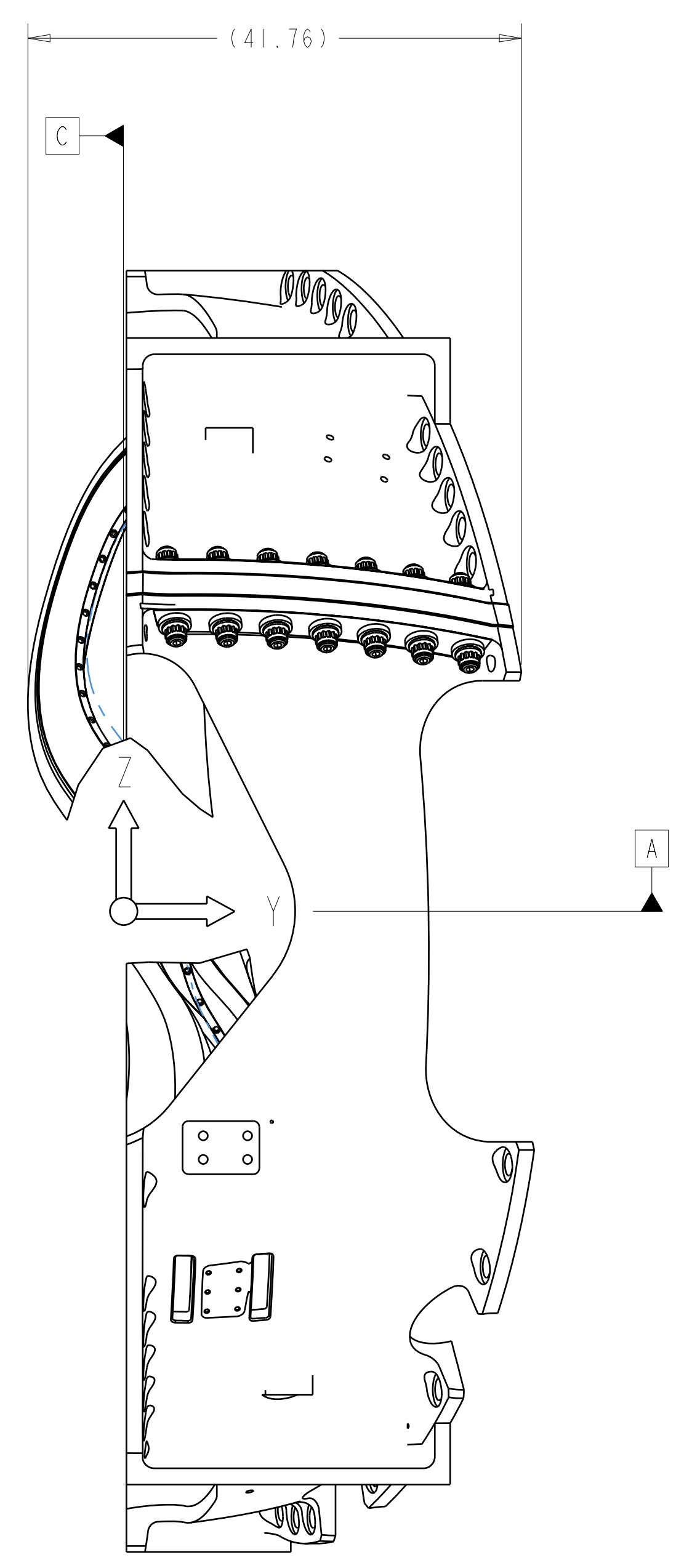
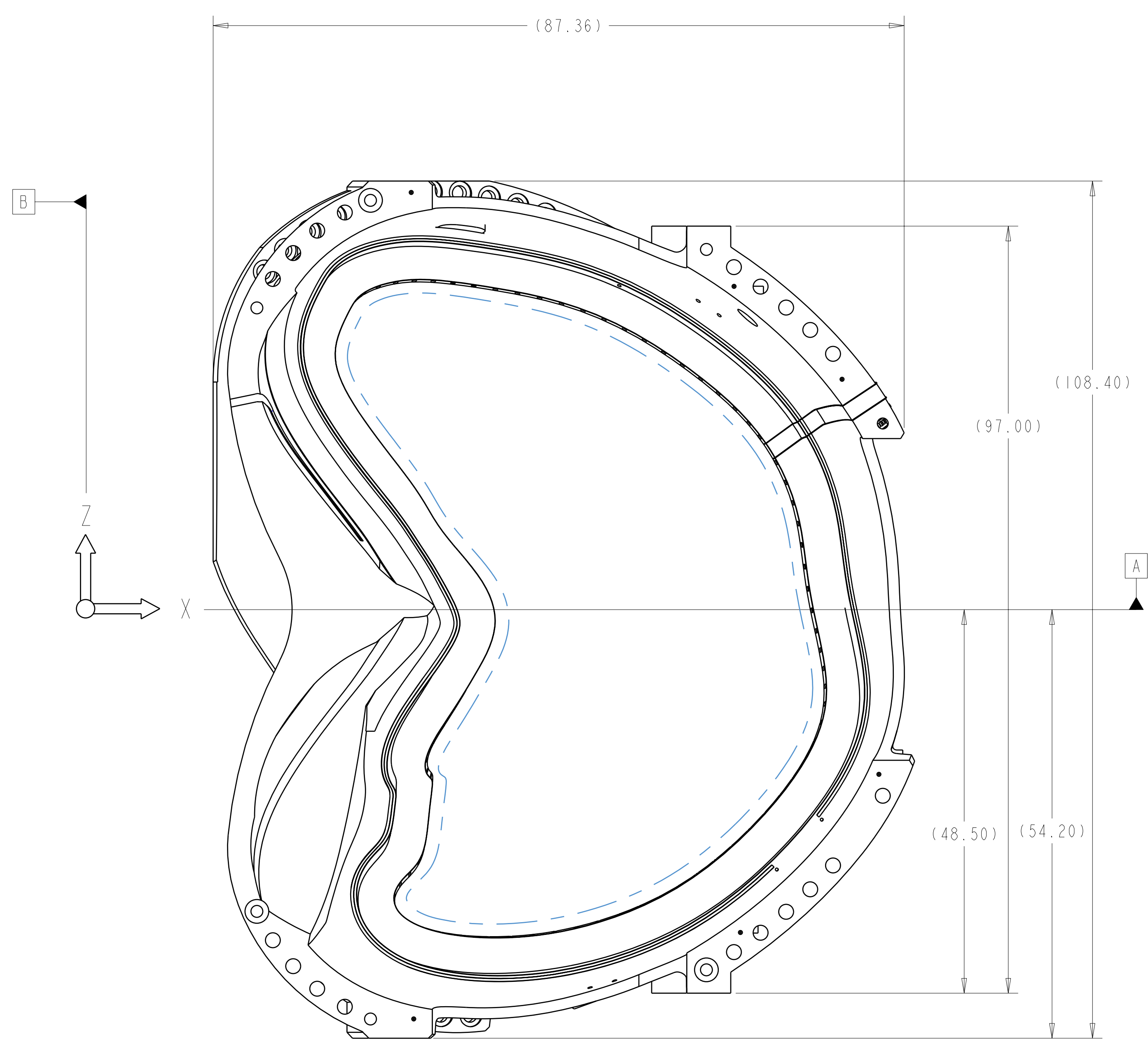
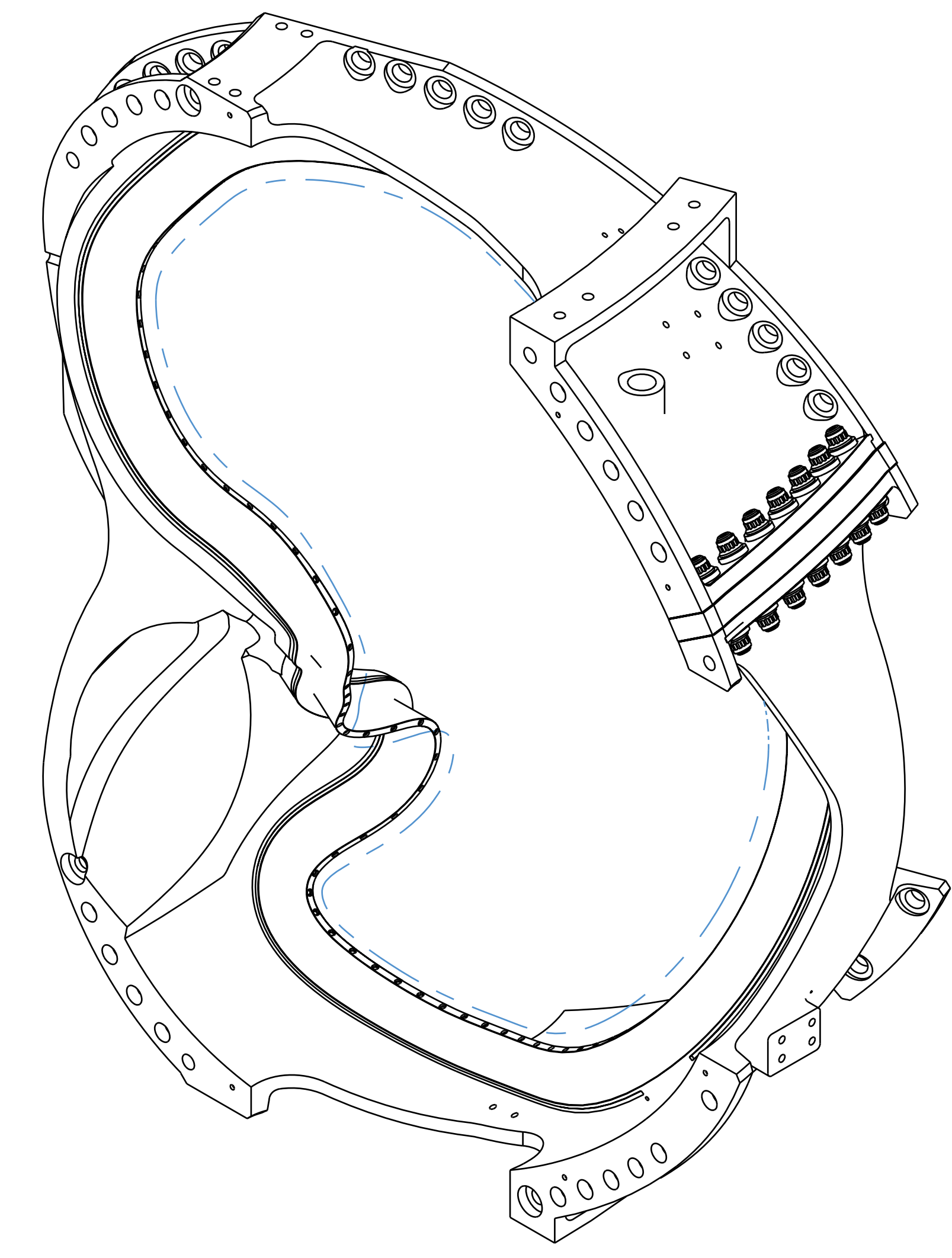
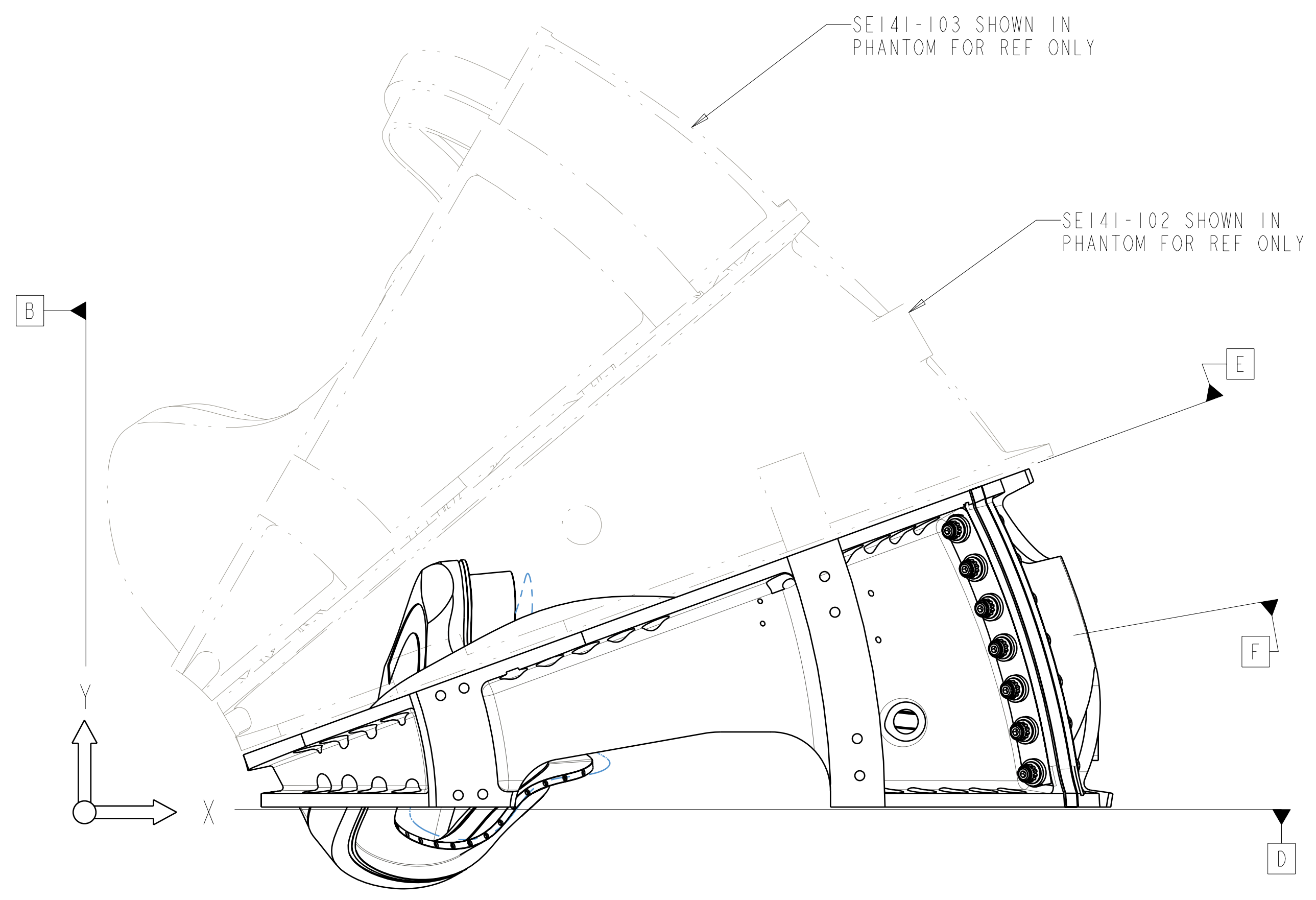


- NOTES:
- DRAWING PREPARED IN ACCORDANCE WITH ASME Y14.8M-1996.
 - INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M-1994.
 - DIMENSIONS ARE IN INCHES.
 - DRAWING DEPICTS FINAL MACHINED STATE OF ASSEMBLY DEFINED BY PRO/ENGINEER FILE SEI41-101.PRT.
 - UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE RELATED 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 TEMPERATURE OF 20-30°C (68-86°F).
 - 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 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	DESCRIPTION	BY	DATE	CHK	DEPT	DATE	PE	REQ	DATE	ORNL	DOE	DATE
2	REVISED ASSEMBLY AND DRAWING PER ECN 5009	GLL	7-05	MJC			DEW					
1	REVISED F/N 2 PER ECN-4903	DW	9/04	MJC			DEW					

QTY	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPECIFICATION	FIND NO
14	DS141-079	WASHER, 2.75 OD X 1.66 ID X 0.5 THK		9
14	DS141-060	NUT, 12PT HEX 1.375-6UNC-2B		8
2	-7	INS SHEET, 26 X 3 X .063 THK	NEMA GRADE G-11CR	7
7	DS141-036	STUD, 1.375-6UNC-2A X 9.5 LG		6
14	-5	INS BUSHING, 1.63 OD X 1.38 ID X 1.7 LG	NEMA GRADE G-11CR	5
1	-4	INS SHEET, 15 X 32 X .063 THK	NEMA GRADE G-11CR	4
1	SEI41-048	POL BREAK SHIM ASSEMBLY TYPE-A		3
1	SEI41-114	PRODUCTION WINDING FORM TYPE-A		2
AR	X	-1	MOD COIL WINDING FORM ASSEMBLY TYPE-A	1

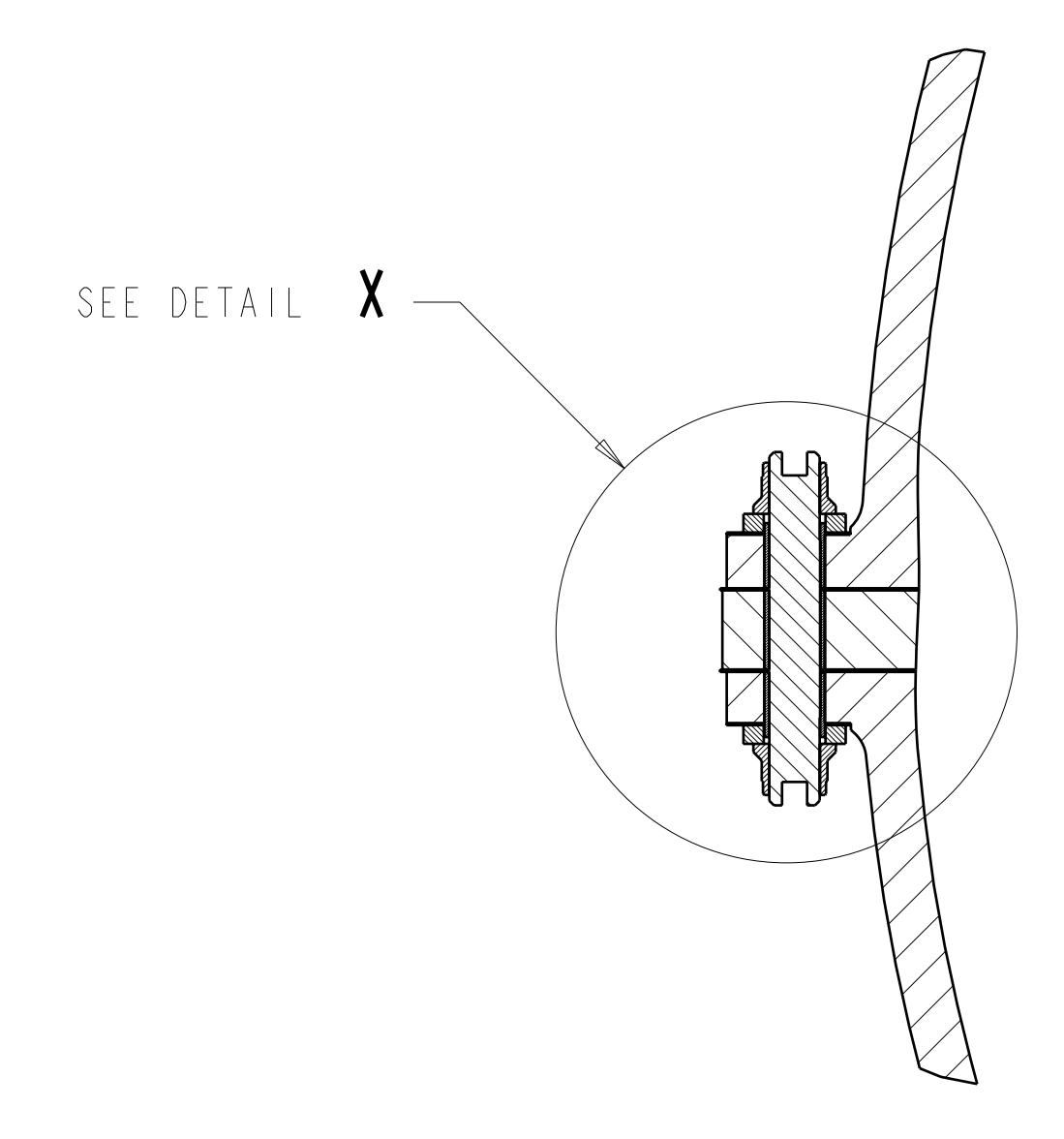
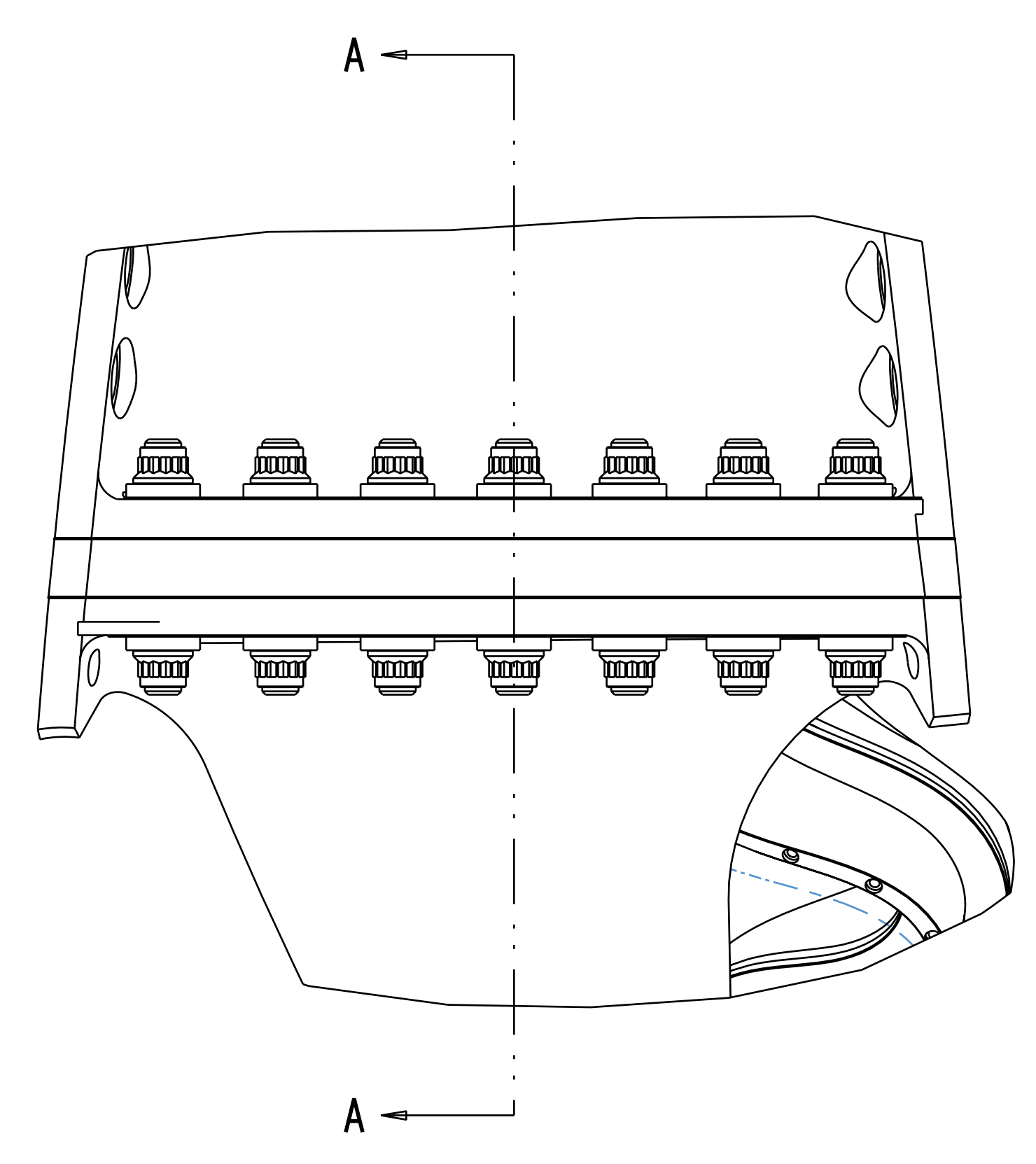
SCALE .10

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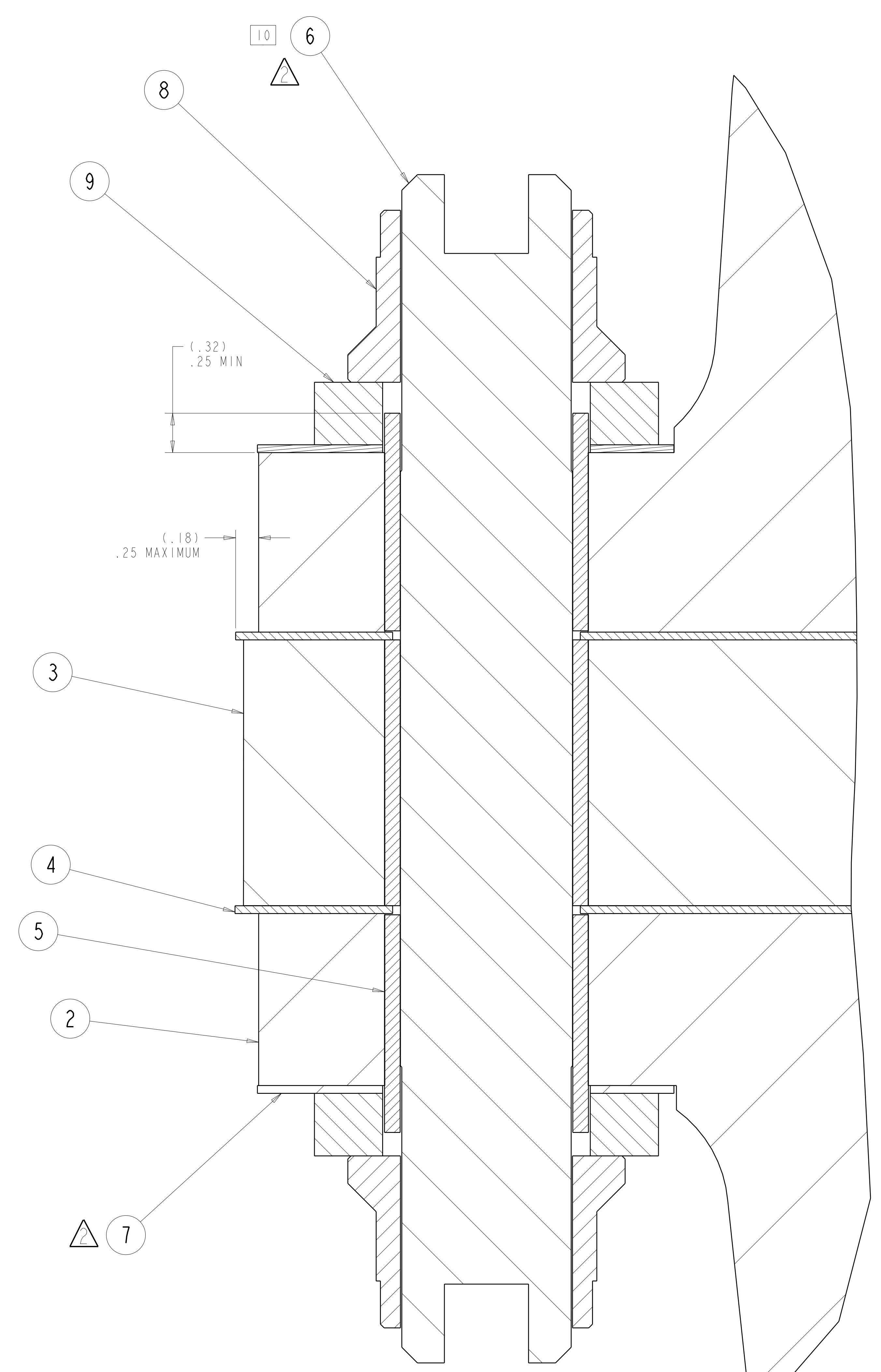
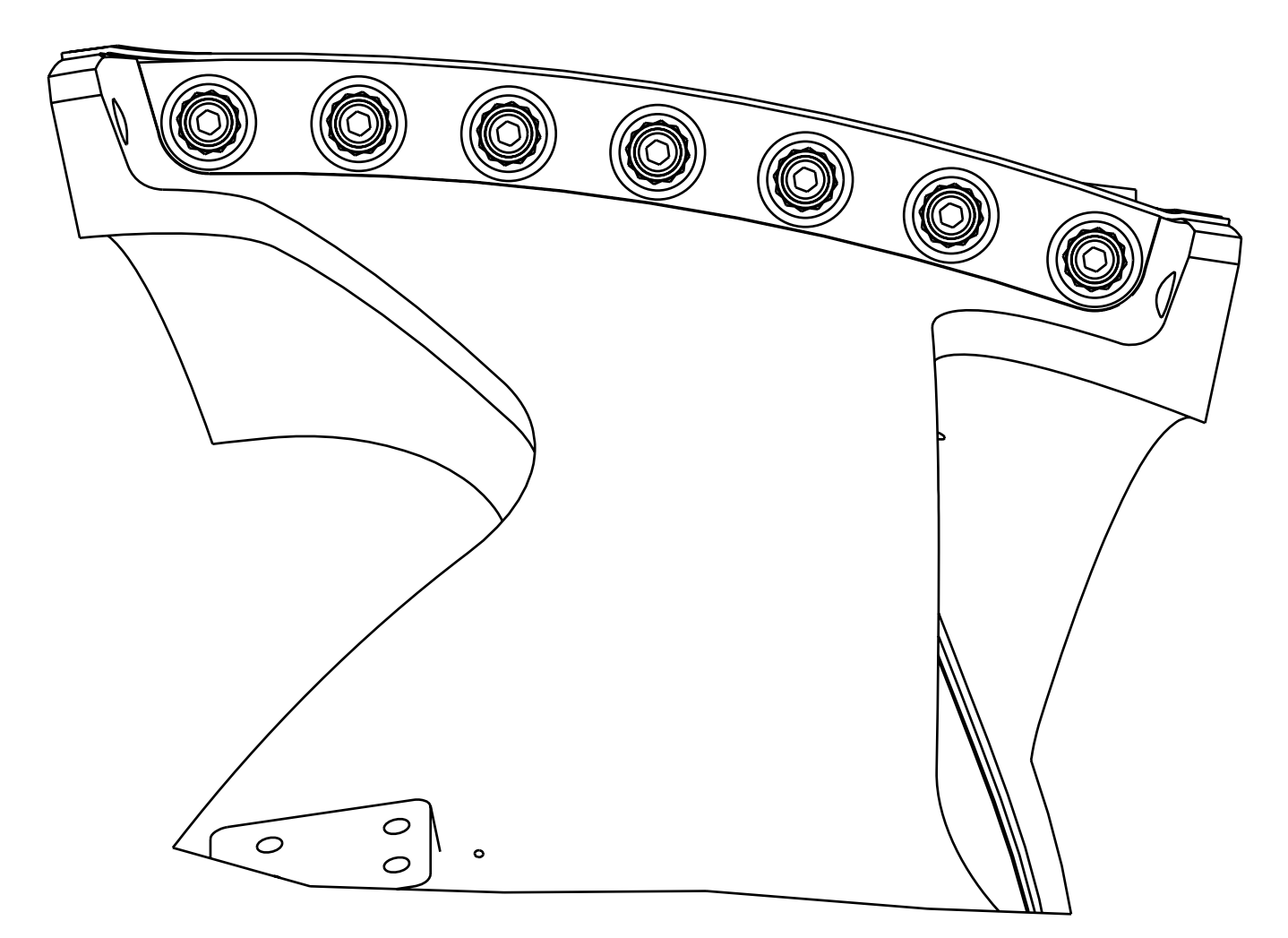
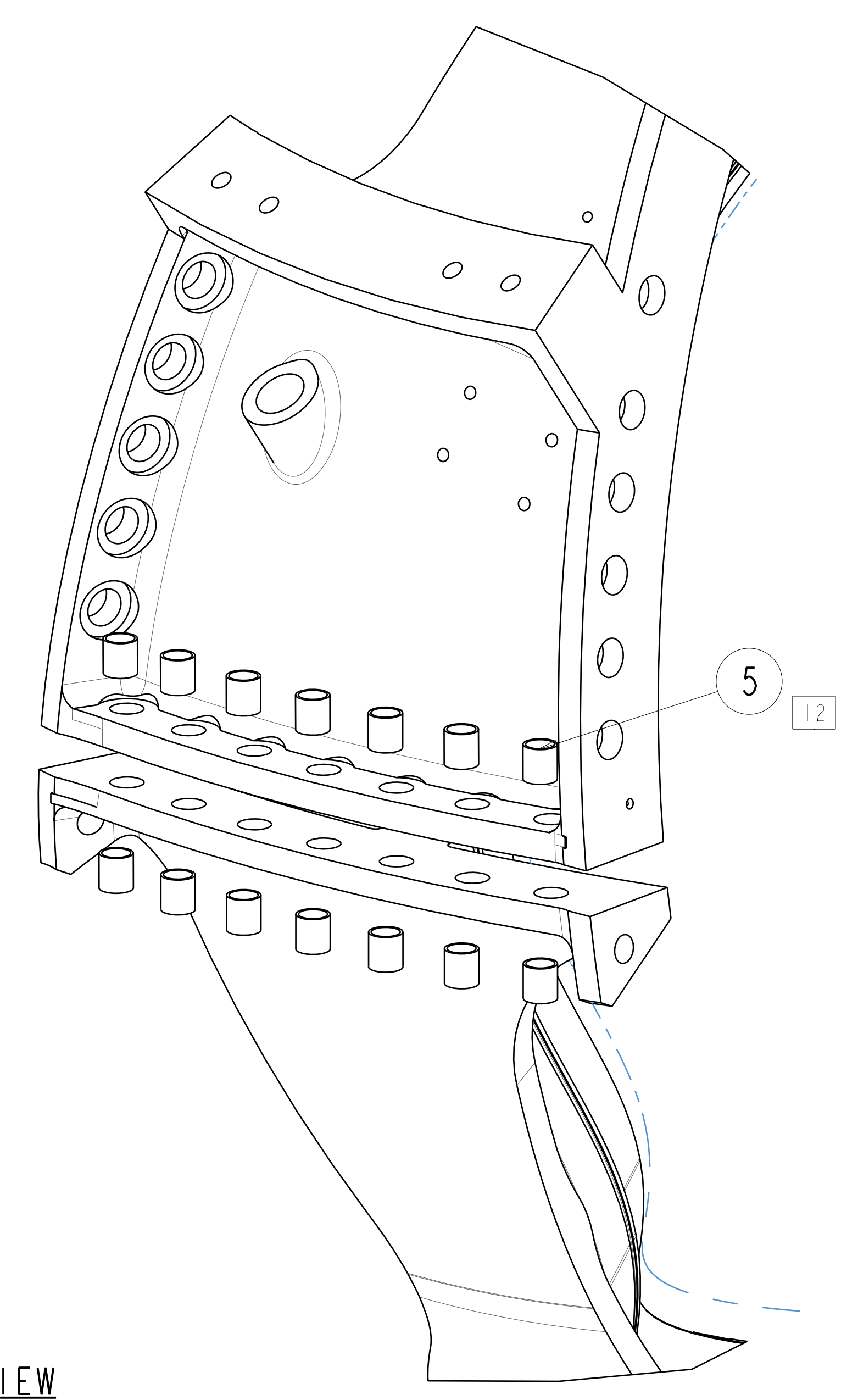
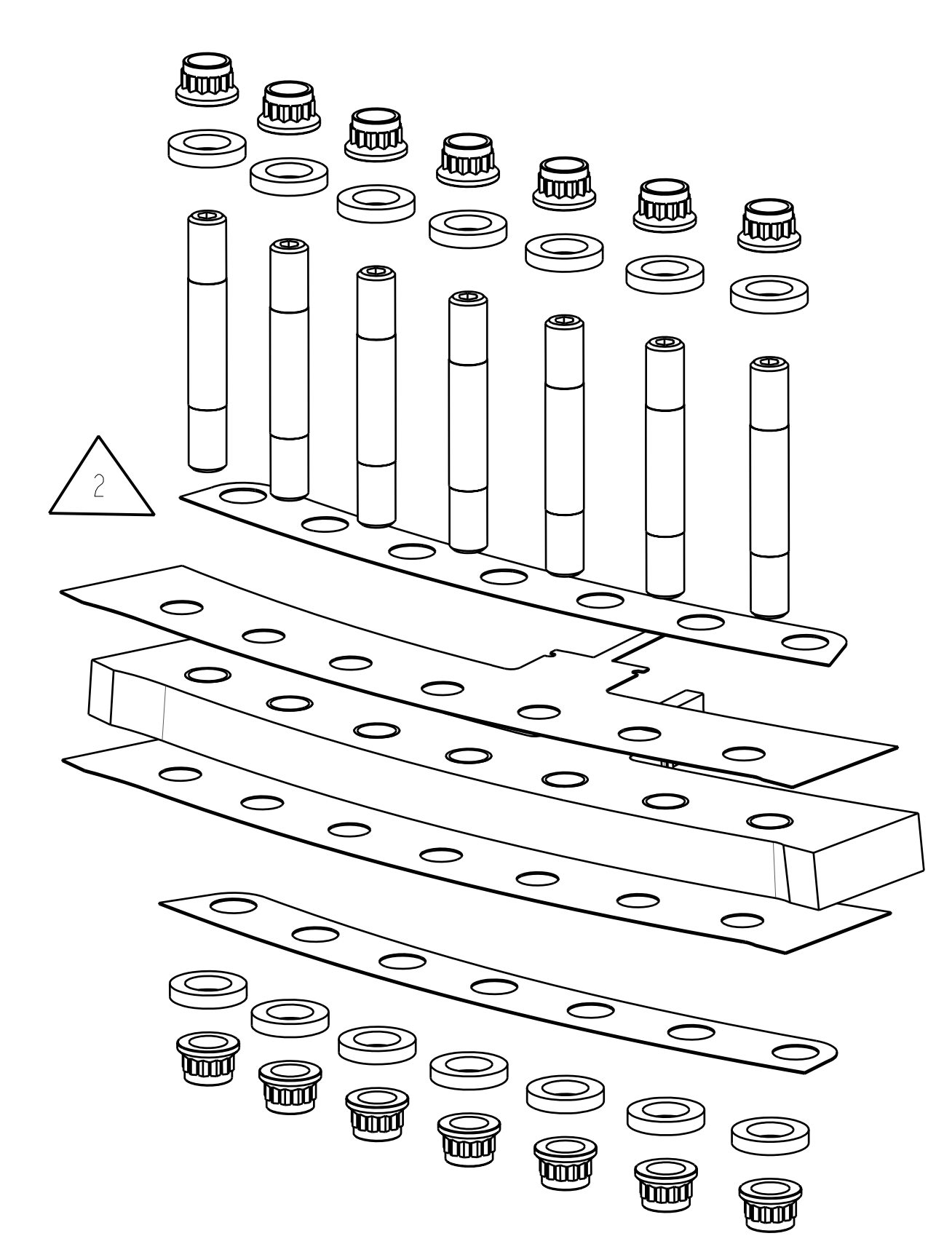
P THIS DRAWING PRODUCED ON PRO-ENGINEER

SCALE NOTED		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	
TOLERANCES UNLESS OTHERWISE SPECIFIED		DRW P MILLER 6-30-04	NATIONAL COMPACT STELLARATOR EXPERIMENT		PROJECT NAME	
FRACTIONS		CHK M COLE 6-30-04	MOD COIL WINDING FORM ASSEMBLY TYPE-A		VERSION NO. 7	
XX DECIMALS ±.01		SECT :	PPPL DRFT J SIEGEL 6-30-04		PLANT X-10	
XXX DECIMALS ±.005		DEPT :	PPPL DRFT J SIEGEL 6-30-04		BLDG 5700	
ANGLES ±0°15'		PE D WILLIAMSON 6-30-04	PPPL DRFT J SIEGEL 6-30-04		FL 3	
BREAK SHARP EDGES .06 MAX		CR :	PPPL DRFT J SIEGEL 6-30-04		SHT OF 1	
FINISH .125 UNLESS OTHERWISE SPECIFIED		PJ :	PPPL DRFT J SIEGEL 6-30-04		TYPE S	
		RED :	PPPL DRFT J SIEGEL 6-30-04		CLASS U	
		REV :	PPPL DRFT J SIEGEL 6-30-04		REV 2	
		DATE :	PPPL DRFT J SIEGEL 6-30-04		SEI41-101	
		DATE :	PPPL DRFT J SIEGEL 6-30-04		WIP	

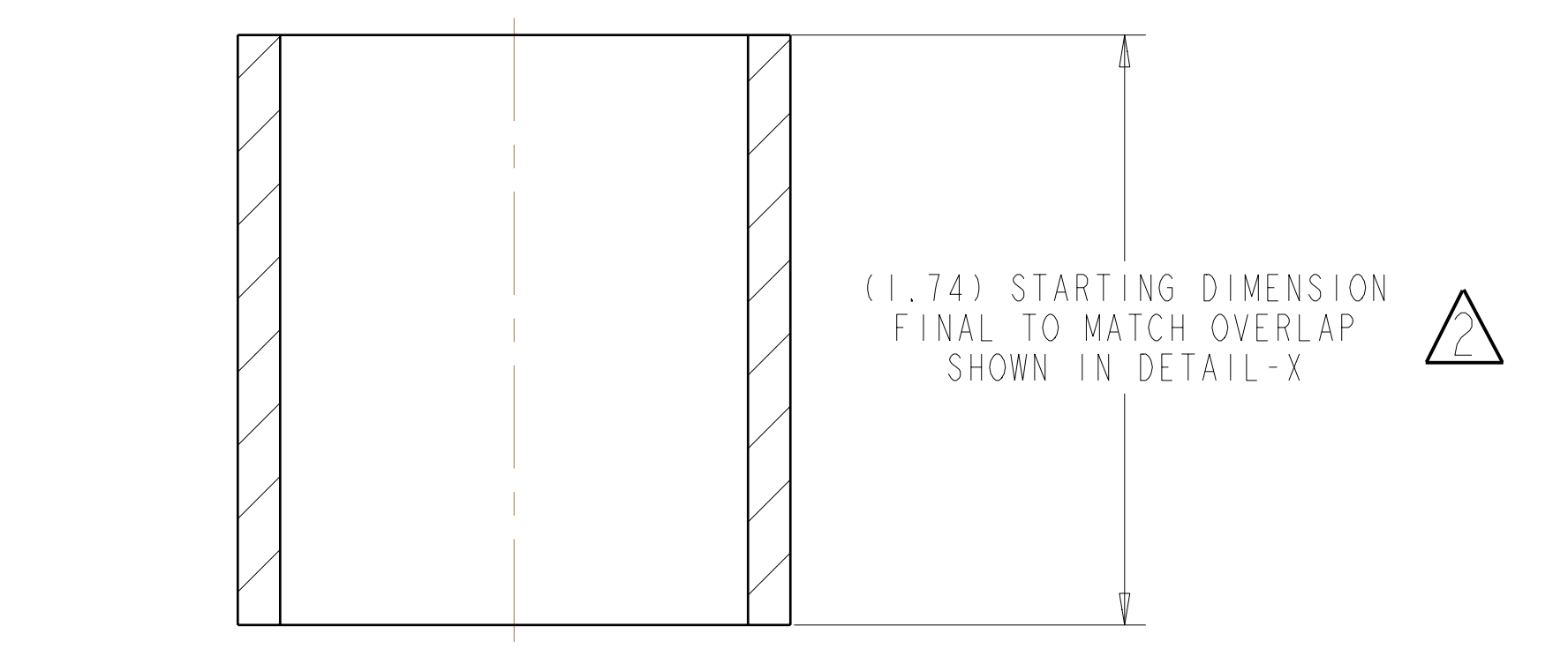
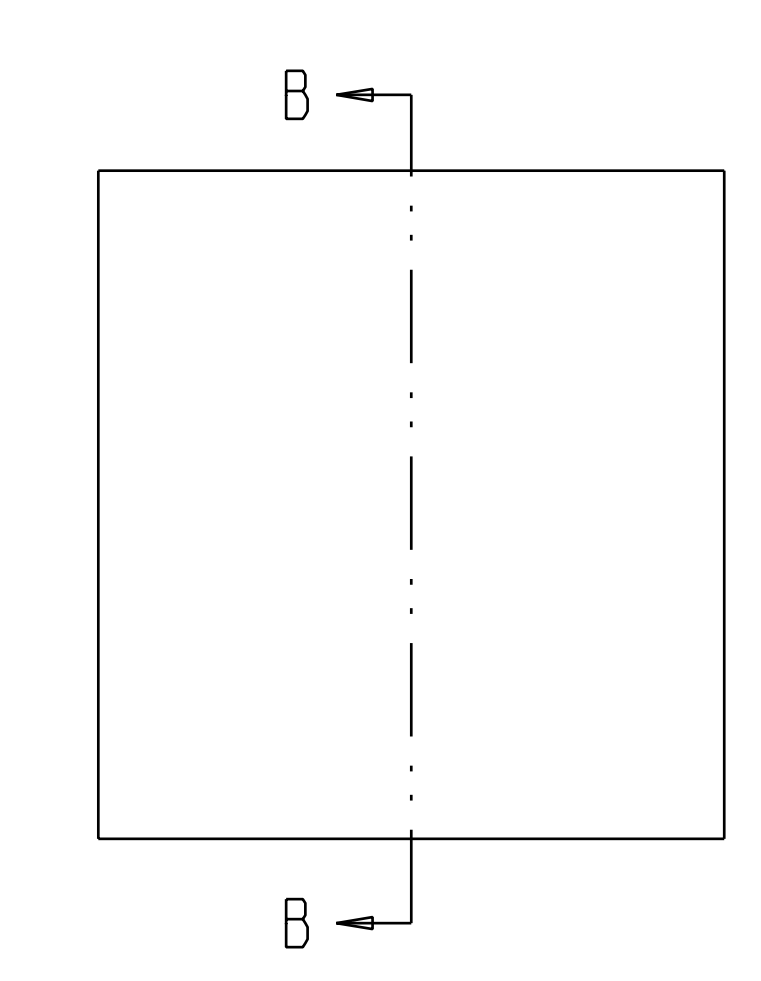
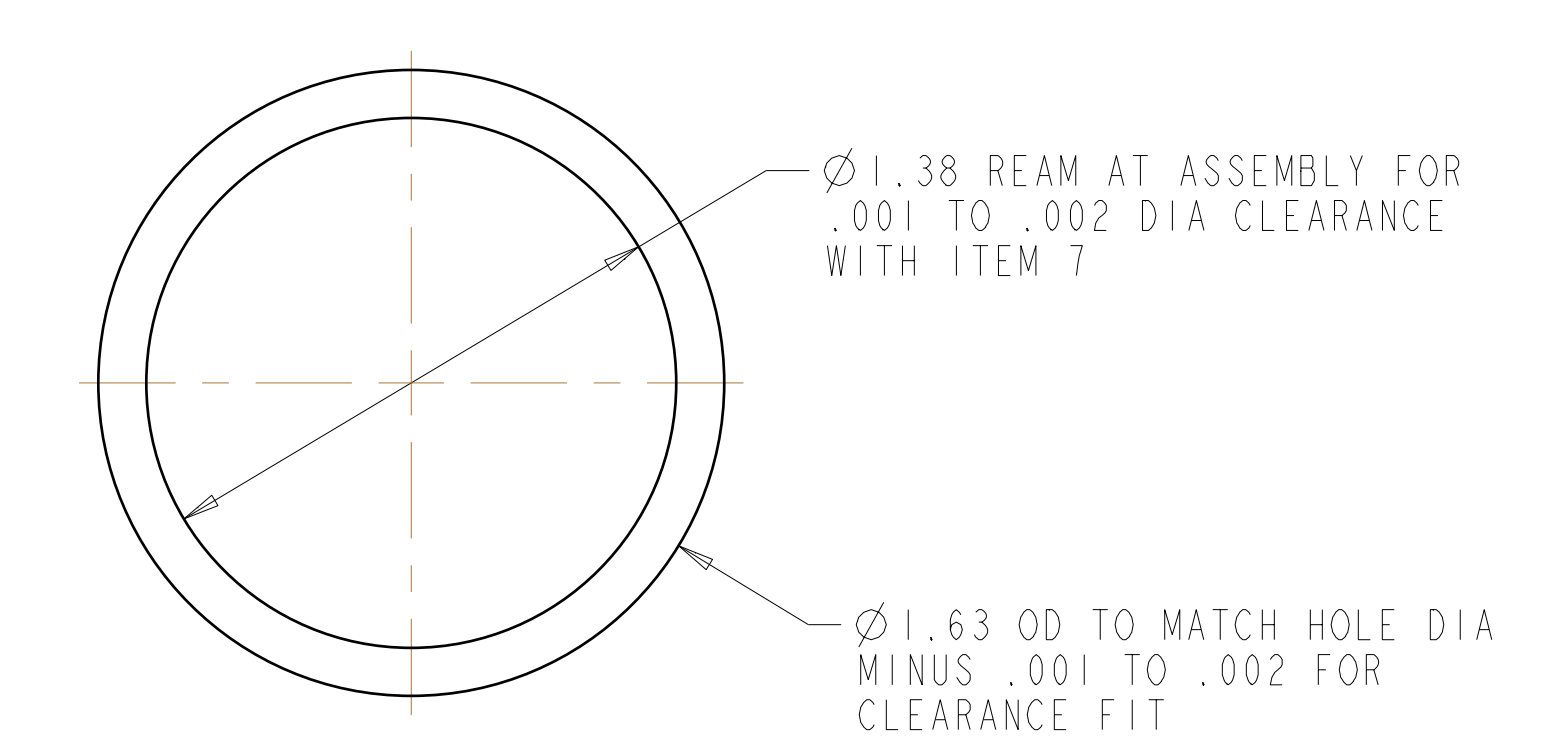
FOR NOTES AND PARTS LIST SEE SHEET 1



SECTION A-A
 SCALE 0.20



DETAIL X
 SCALE 2.00



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

H
G
F
E
D
C
B
A