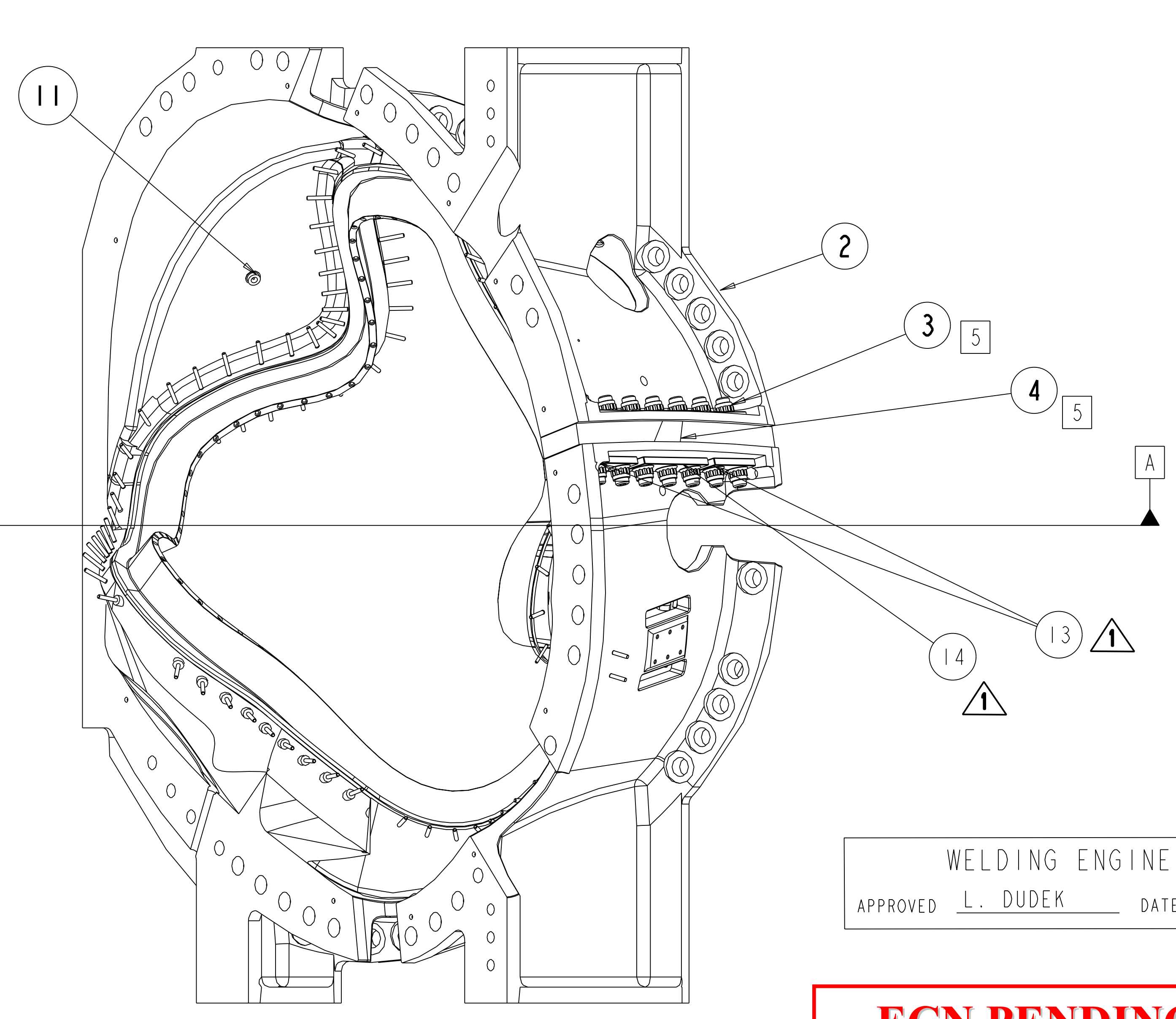
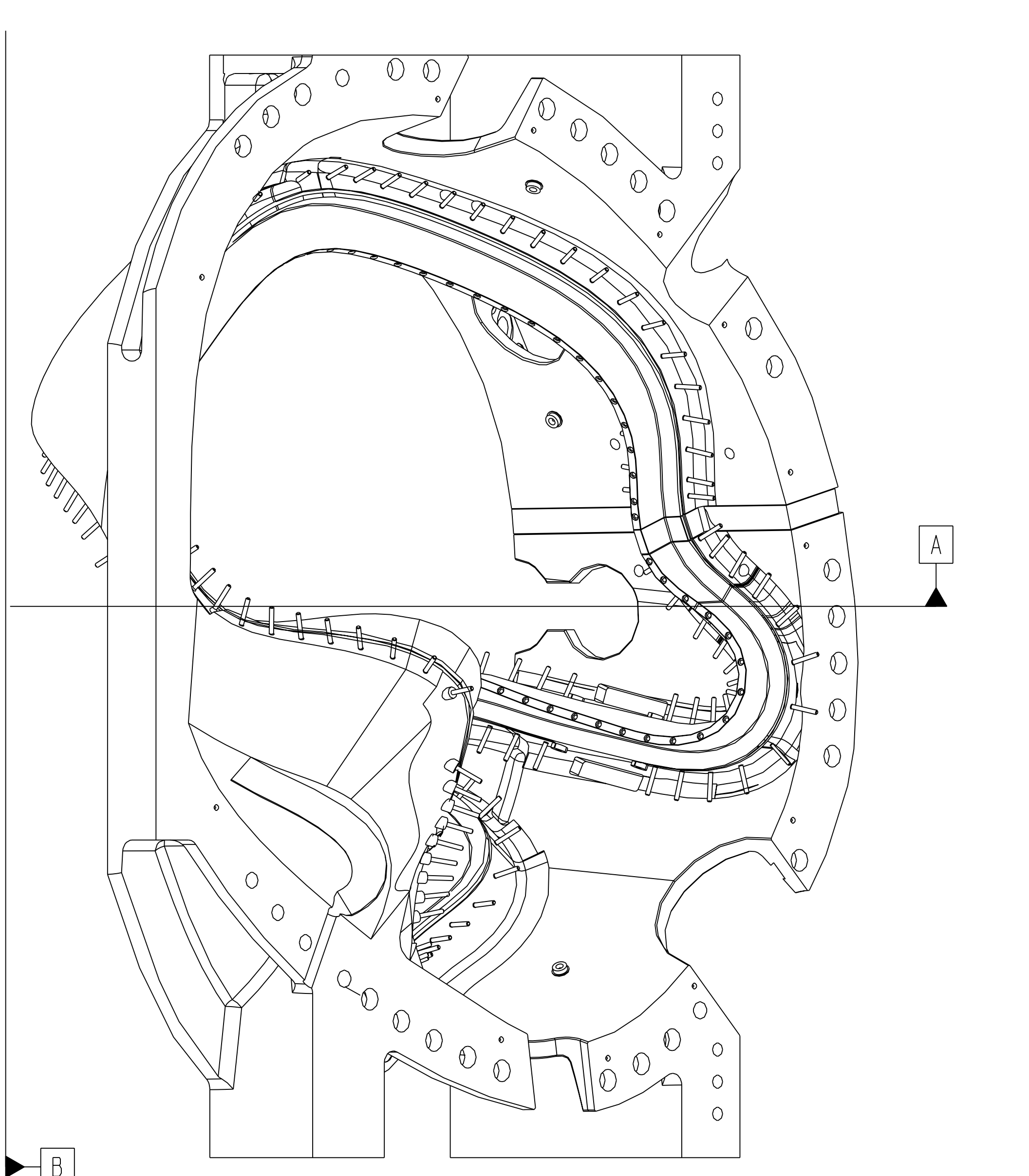
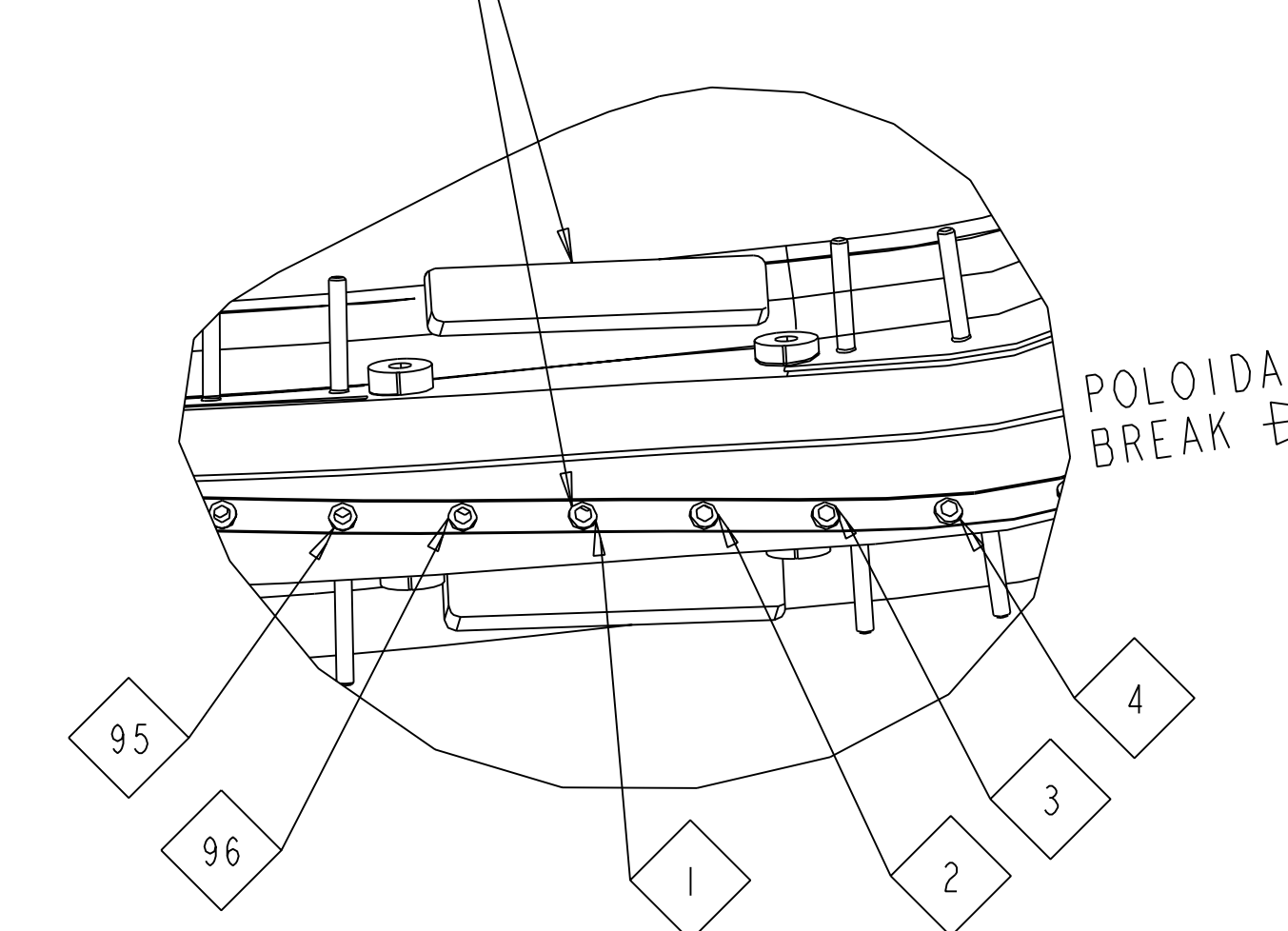
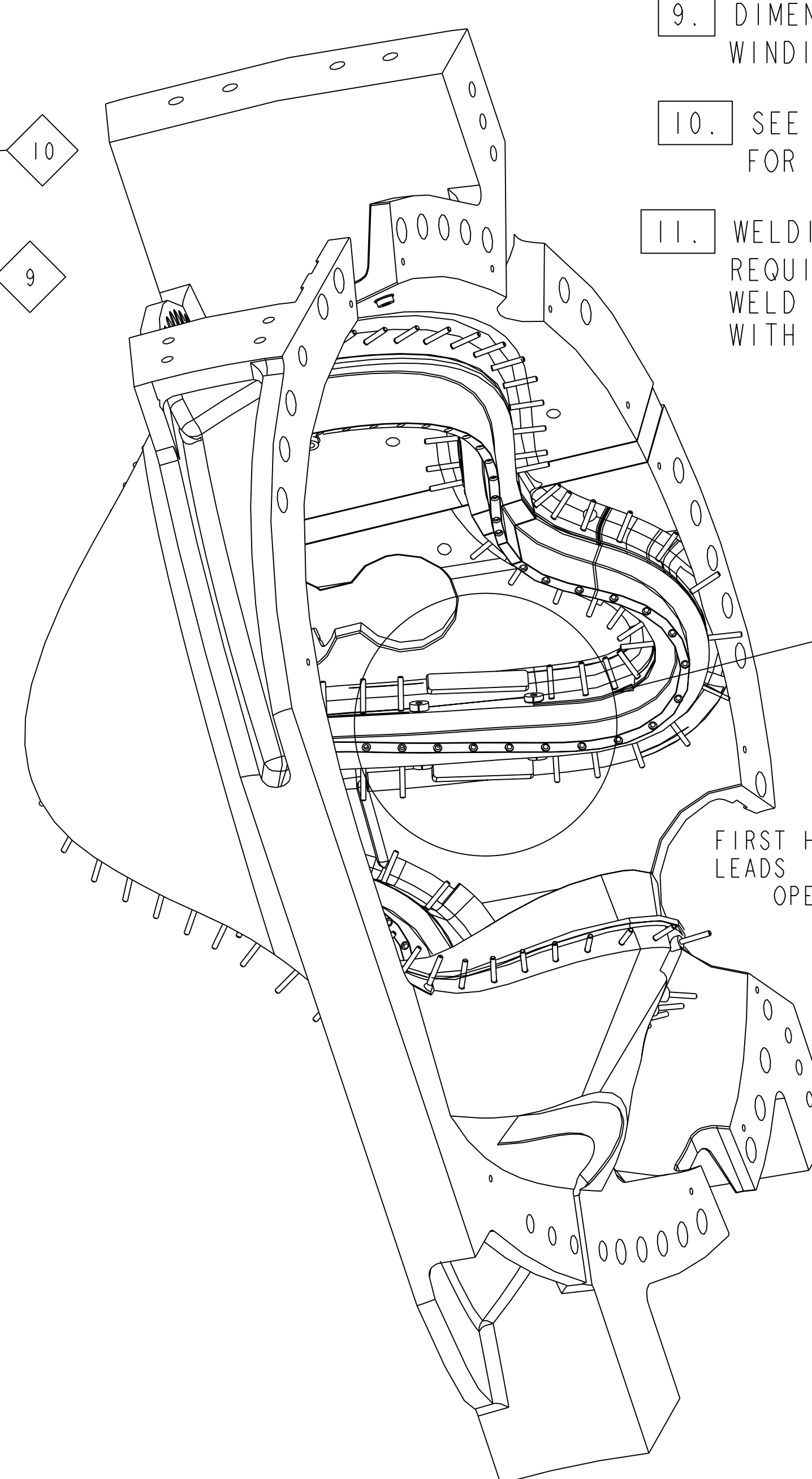
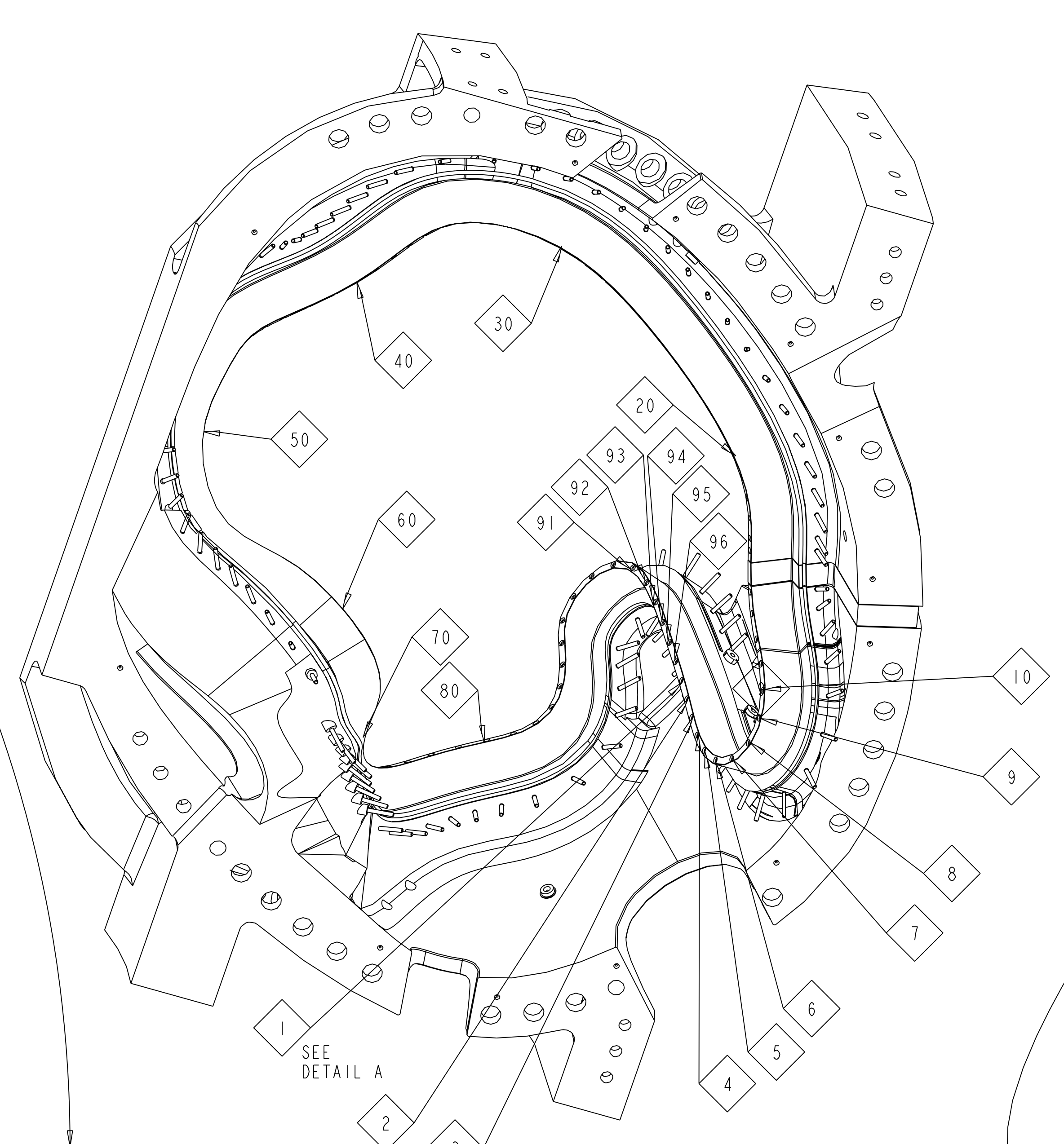
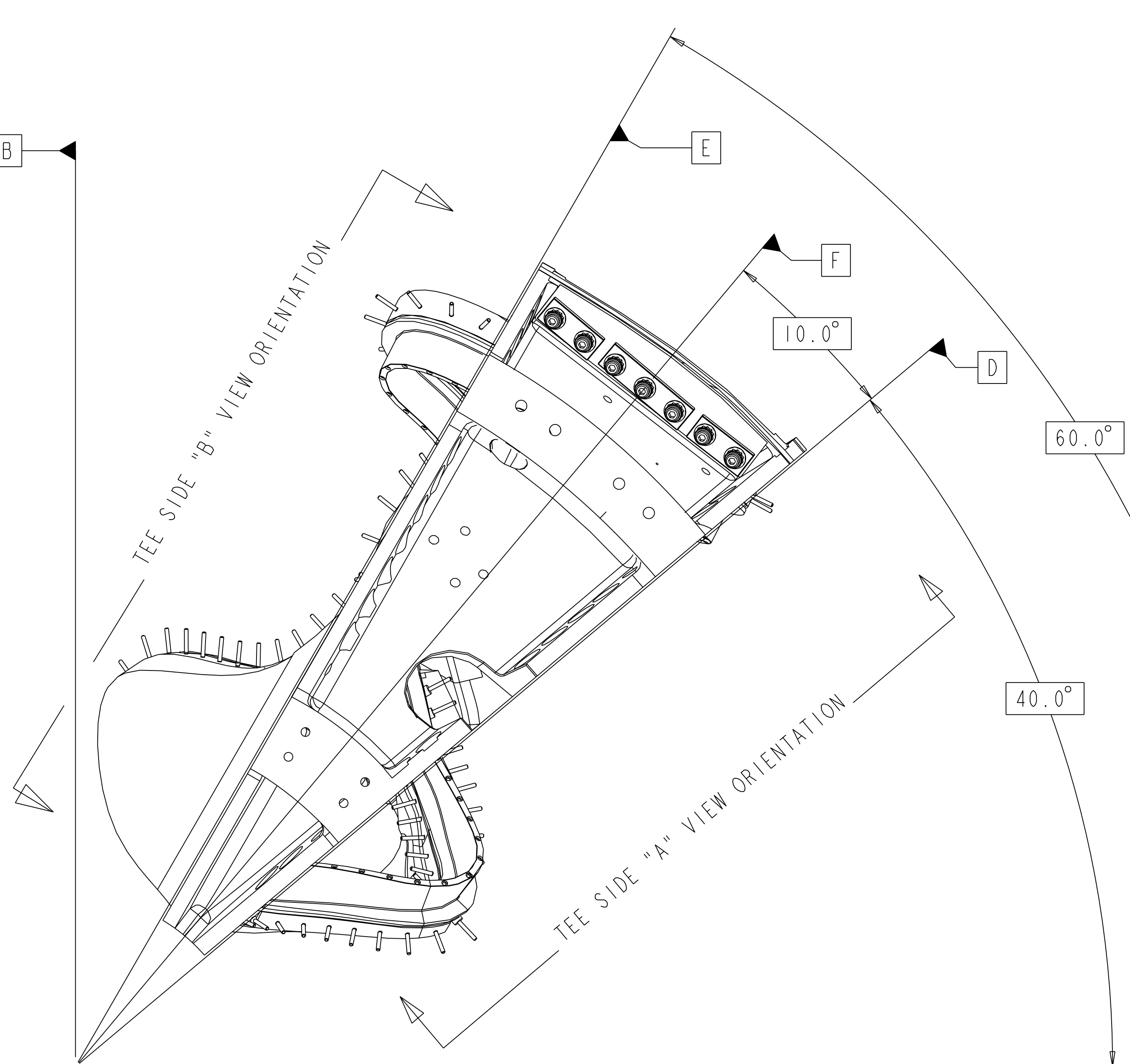


NOTES:

- 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 PART DEFINED BY PRO/ENGINEER FILE SE141-123.PRT.
- ITEMS 3 AND 4 ARE SHOWN FOR REFERENCE ONLY.
- 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)
- APPROXIMATE WEIGHT = 5602 LBS
- DIMENSIONS INDICATE INTERSECTION OF HOLE AXIS AND WINDING FORM SURFACE.
- SEE LATEST REVISION OF PROCEDURE D-NCSX-MCF-001 FOR ADDITIONAL REQUIREMENTS.
- WELDING SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF PPPL PROCEDURE NO. ENG-037. VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH THE ACCEPTANCE CRITERIA OF AWS D1.6.



REV	DESCRIPTION	BY	DATE	CHK	DEPT	DATE	PE	REG	DATE	ORNL	DOE	DATE
0	INITIAL RELEASE											
1	REVISE POL BREAK ASM PER ECN 5026	GLL	10-05				DEW					

REV	DESCRIPTION	BY	DATE	CHK	DEPT	DATE	PE	REG	DATE	ORNL	DOE	DATE
1	REVISE POL BREAK ASM PER ECN 5026	GLL	10-05				DEW					

REV	DESCRIPTION	BY	DATE	CHK	DEPT	DATE	PE	REG	DATE	ORNL	DOE	DATE
1	REVISE POL BREAK ASM PER ECN 5026	GLL	10-05				DEW					

WELDING ENGINEER
APPROVED L. DUDEK DATE: 08/05

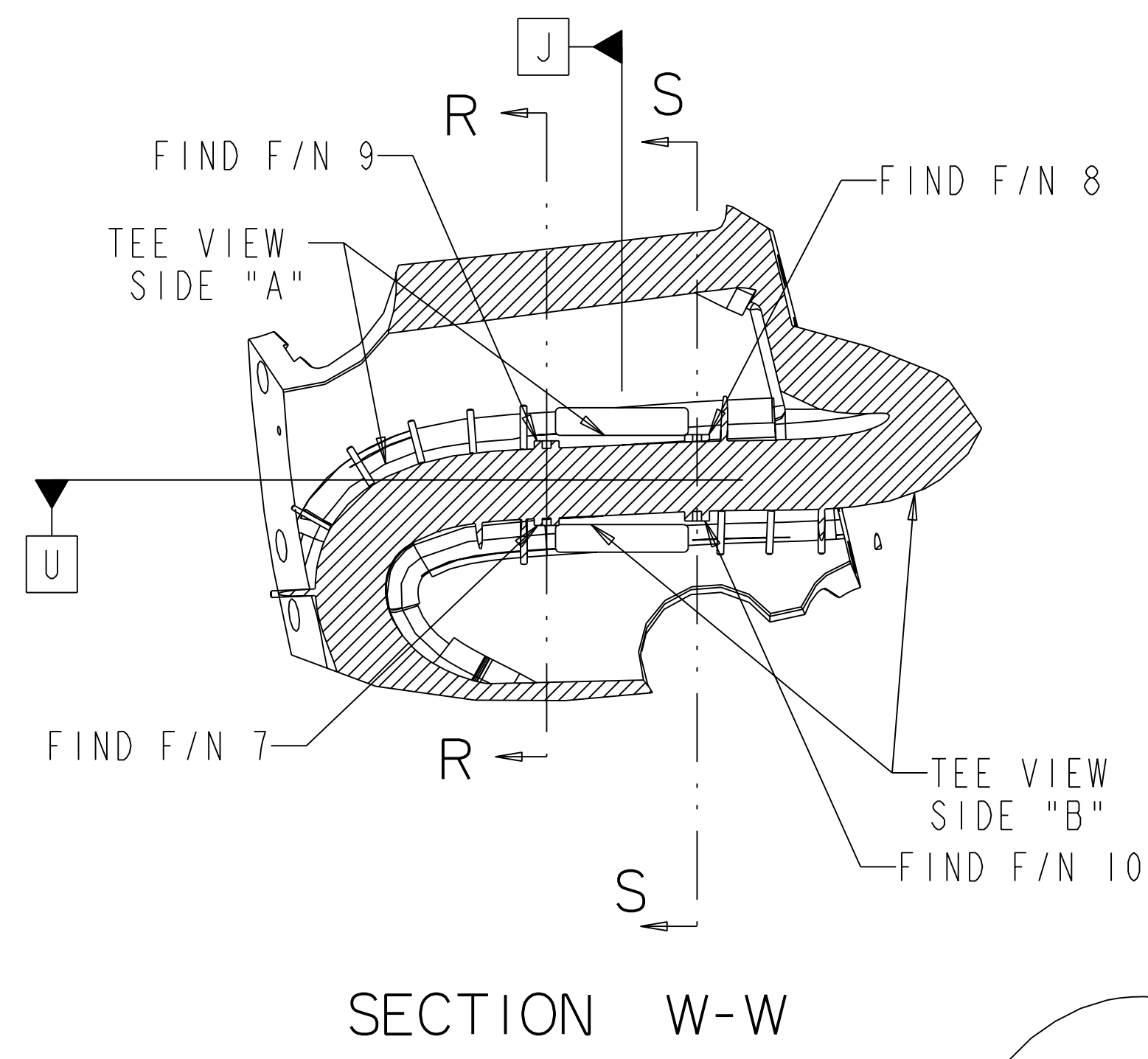
ECN PENDING

I
SCALE 0.125

SCALE NOTED	DES: D WILLIAMSON 08/05	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 LOVETT 08/05	PROJECT NAME: NATIONAL COMPACT STELLARATOR EXPERIMENT	
FRACTIONS: :	CHK: T BROWN 08/05	MODULAR COIL TYPE-C WINDING FORM AND STUD WELDMNT	
XX DECIMALS ±.01	SECT: :	PPPL DRFT: J SIEGEL 08/05	
XXX DECIMALS ±.005	DEPT: :	VERSION NO. 6	
ANGLES ±0°15'	PE: D WILLIAMSON 08/05	PLANT X-10 BLDG 5700 FL 3 SHT 4 OF 4 TYPE CLASS	
BREAK SHARP EDGES OR MAX FINISH .125 UNLESS OTHERWISE SPECIFIED	CR: :	RELEASE LEVEL WIP	
	PJ: :	SE141-123	
	RD: :	REV 1	
	REG: :		
		DRAWING APPROVALS: DATE	

NO REPRESENTATION OR WARRANTY, EXPRESSED OR IMPLIED, IS MADE AS TO THE ACCURACY, COMPLETENESS OR USEFULNESS OF THE INFORMATION OR STATEMENTS CONTAINED IN THESE DRAWINGS, OR THAT THE USE OR DISCLOSURE OF ANY INFORMATION, APPARATUS, METHOD OR PROCESS DISCLOSED IN THESE DRAWINGS MAY NOT INFRINGE PRIVATE RIGHTS OF OTHERS. NO LIABILITY IS ASSUMED WITH RESPECT TO THE USE OF, OR FOR DAMAGES RESULTING FROM THE USE OF, ANY INFORMATION, APPARATUS, METHOD OR PROCESS DISCLOSED IN THESE DRAWINGS. DRAWINGS MADE AVAILABLE FOR INFORMATION TO BIDDER ARE NOT TO BE USED FOR OTHER PURPOSES, AND ARE TO BE RETURNED UPON REQUEST OF THE FORWARDING CONTRACTOR.

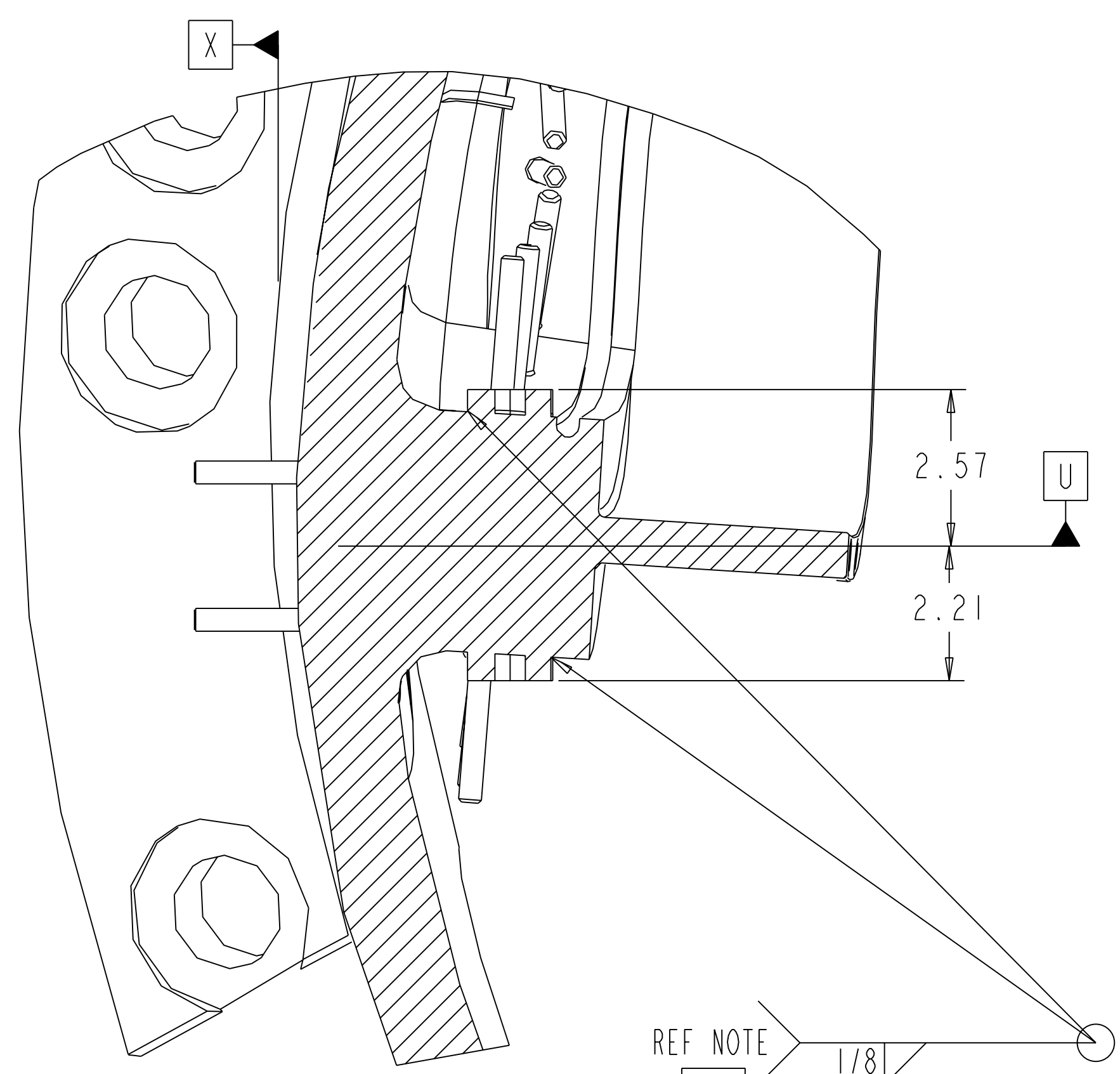
P THIS DRAWING PRODUCED ON PRO-ENGINEER



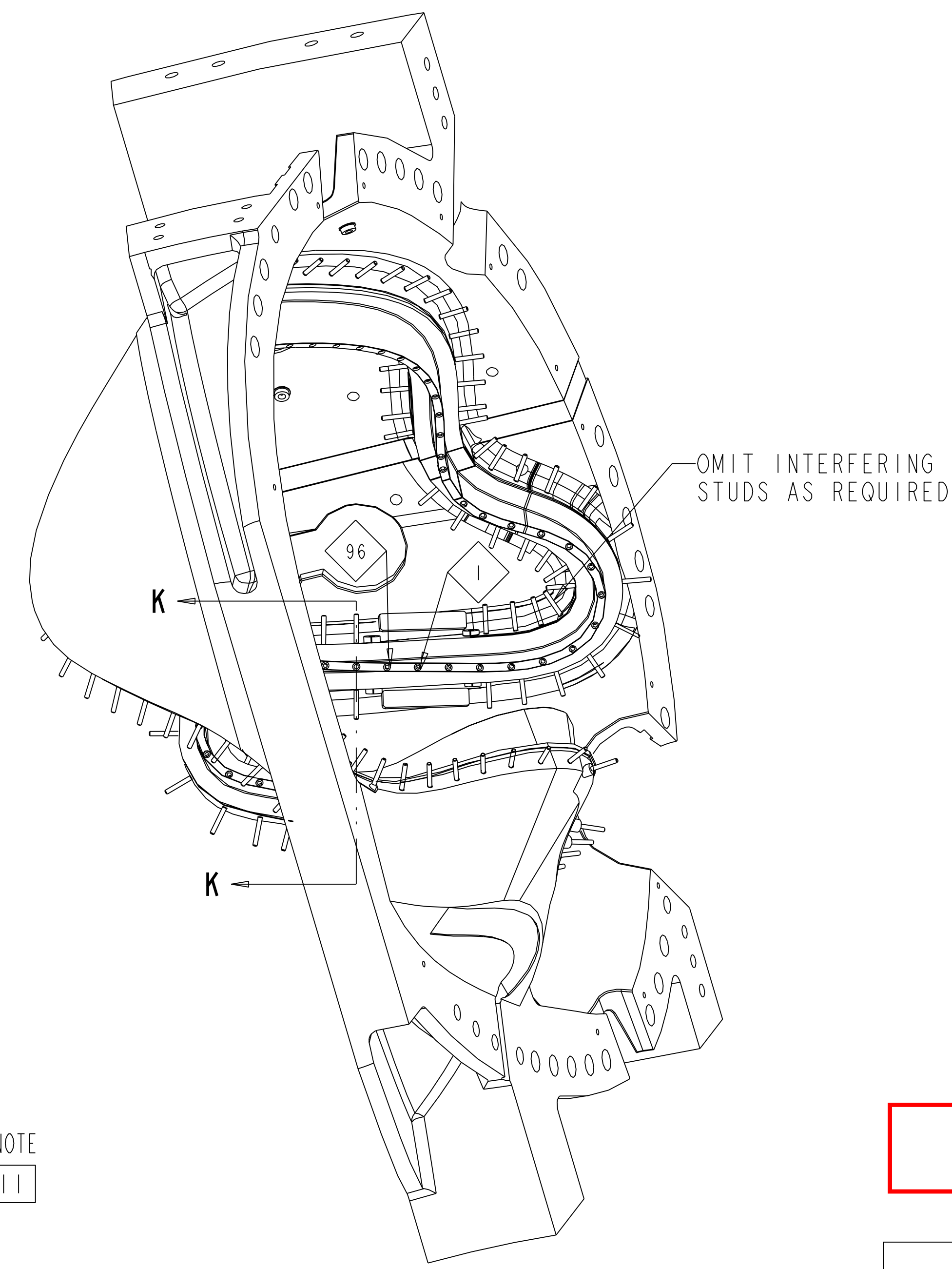
SECTION W-W

TURN NOTCH TOWARD WINDING CENTER TYP F/N 7, 8, 9, 10

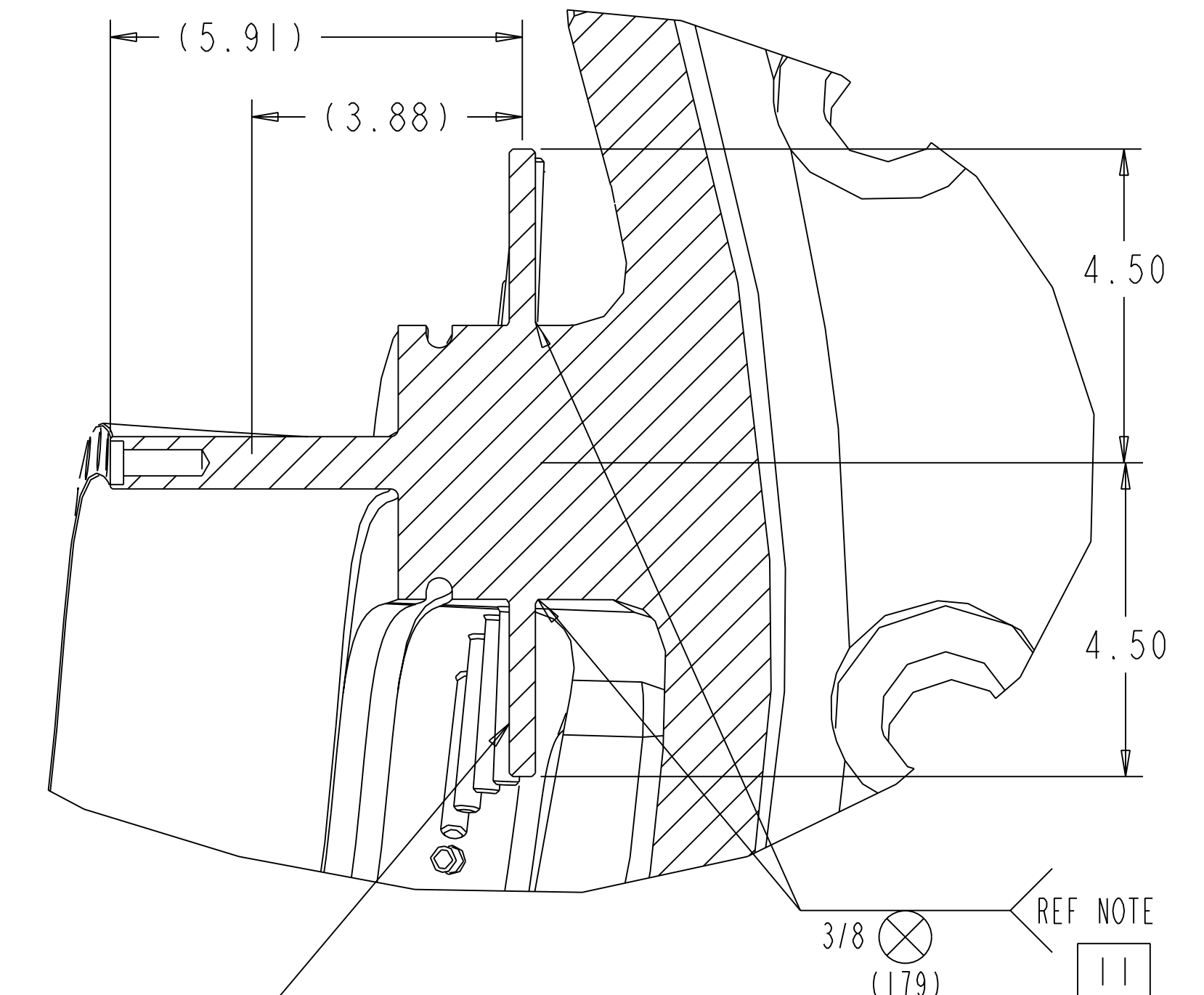
DETAIL D SCALE 1.00



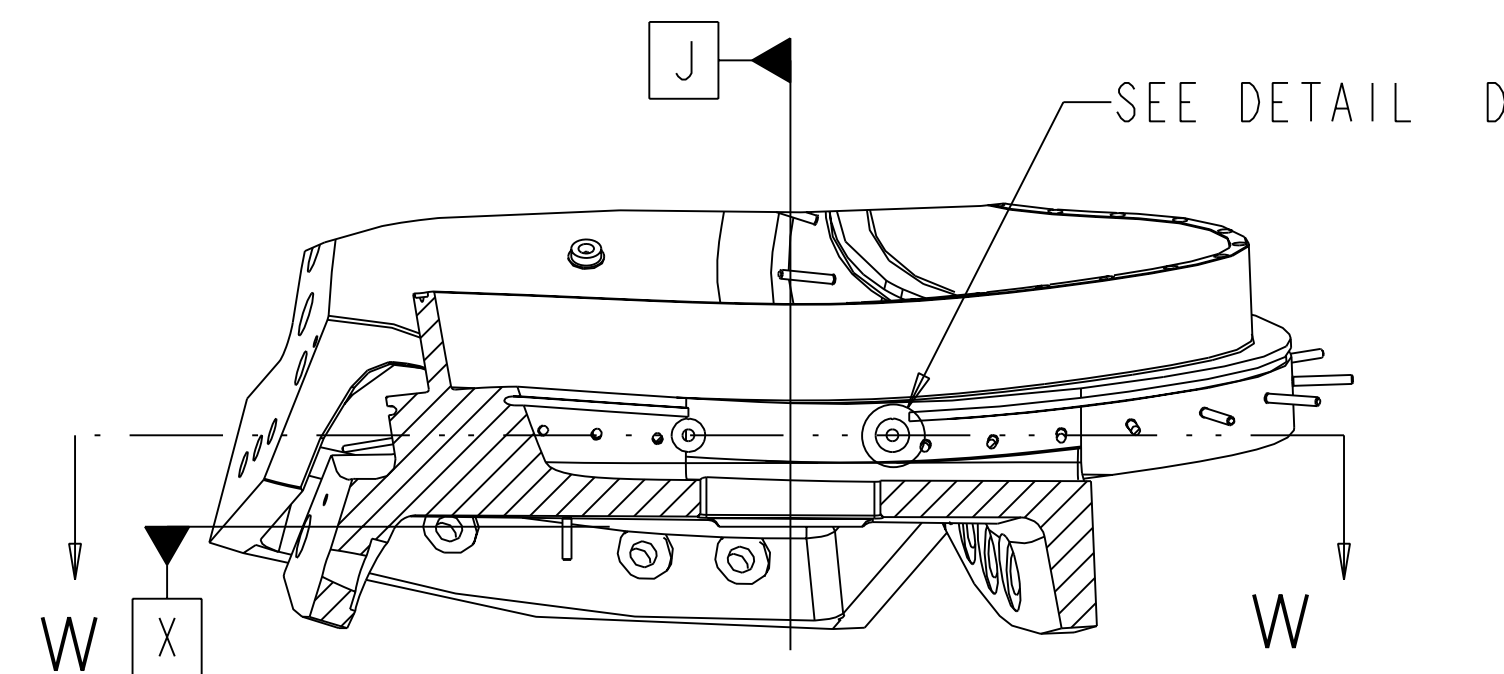
SECTION R-R SCALE 0.50



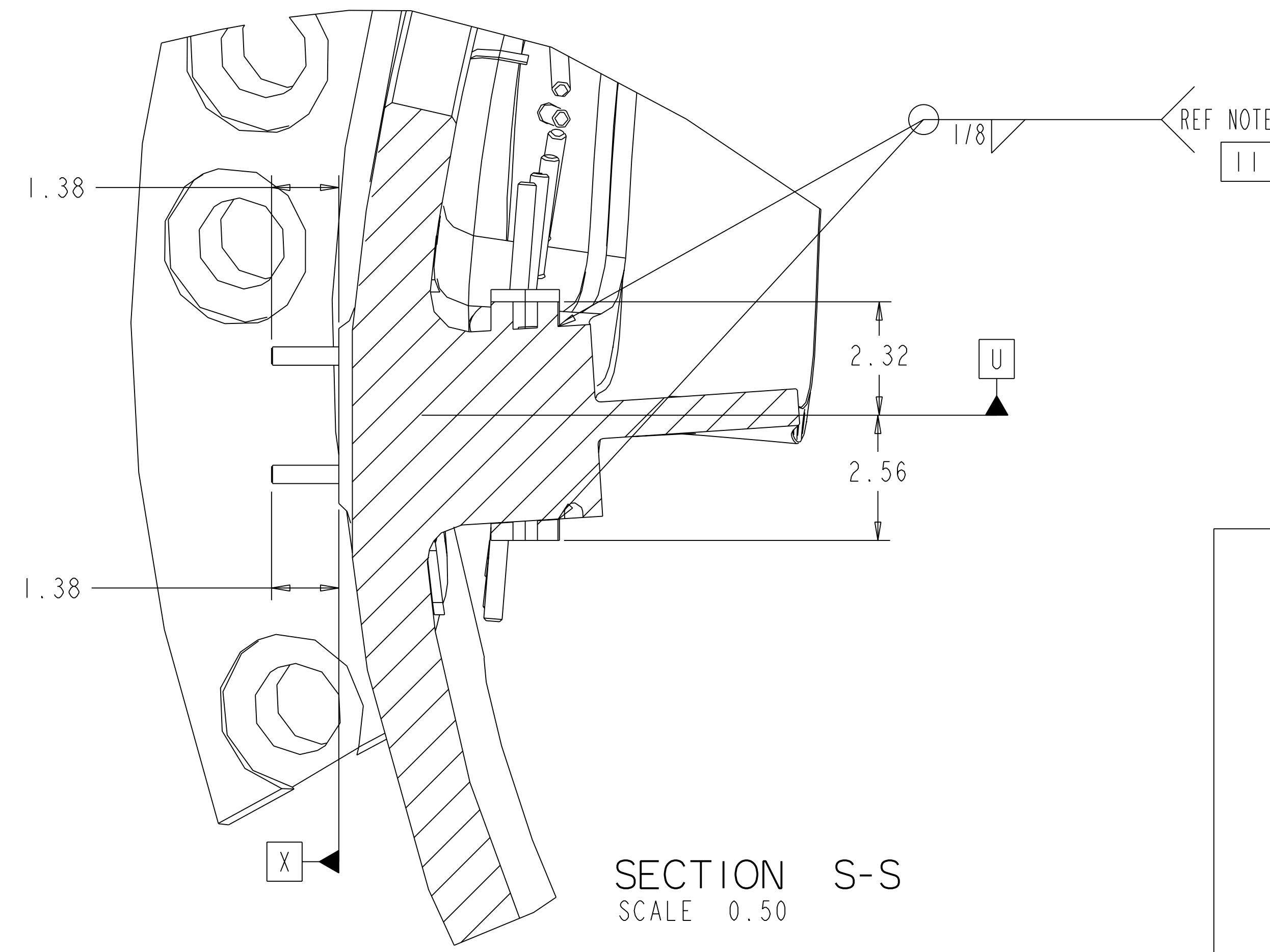
SCALE 0.13



SECTION K-K SCALE 0.50 LOCATION OF TEE STUDS

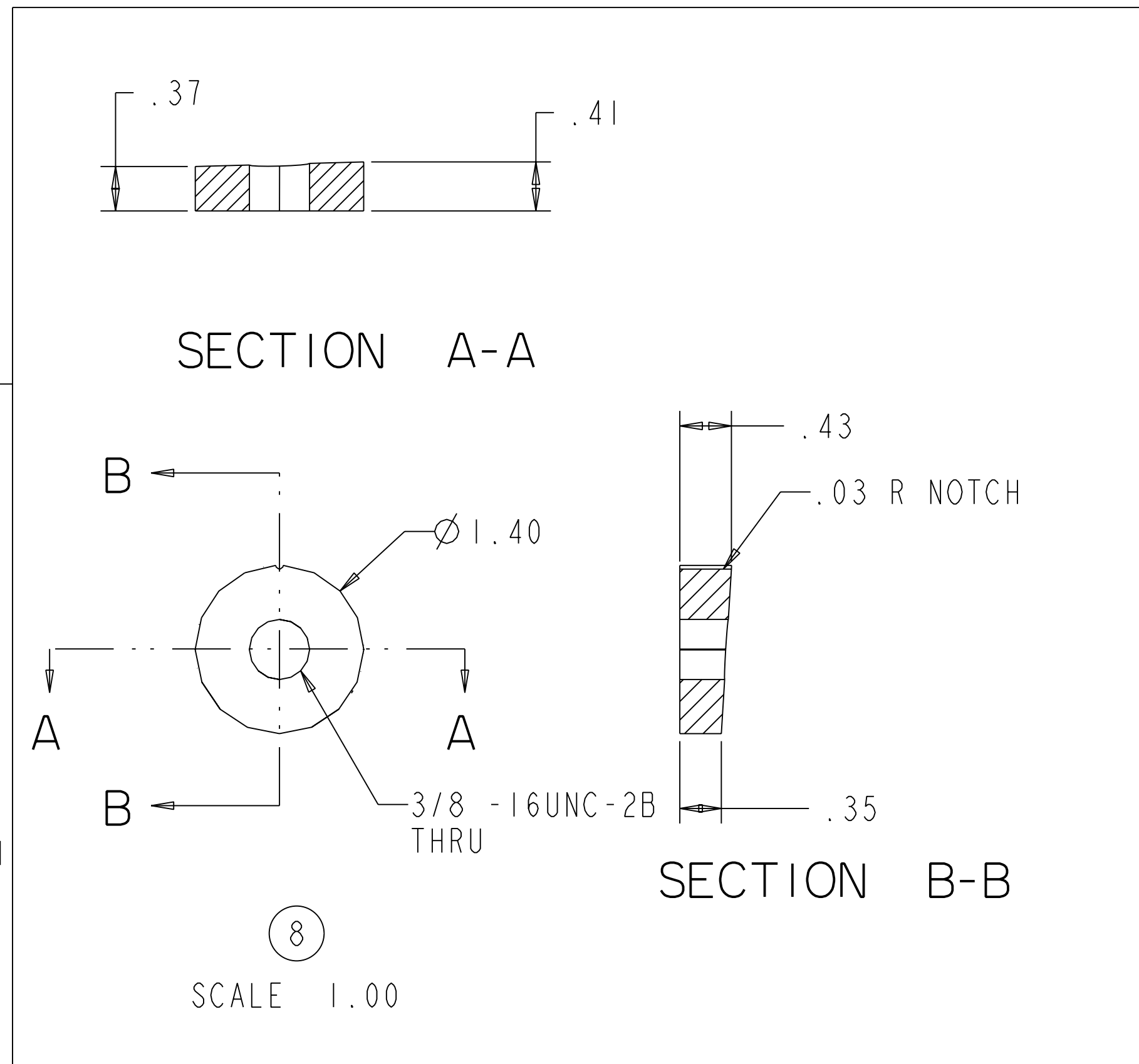


SECTION T-T

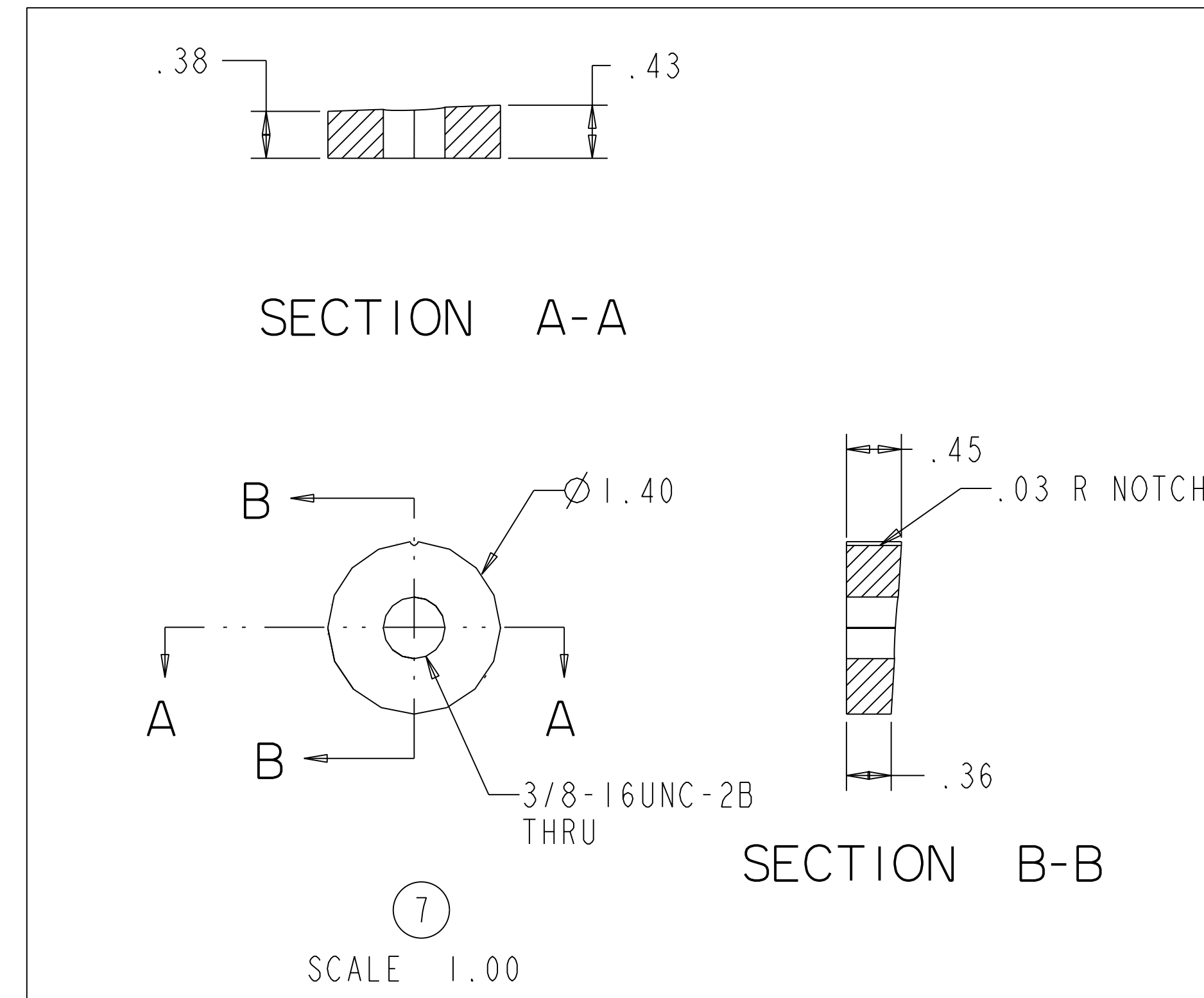


SECTION S-S SCALE 0.50

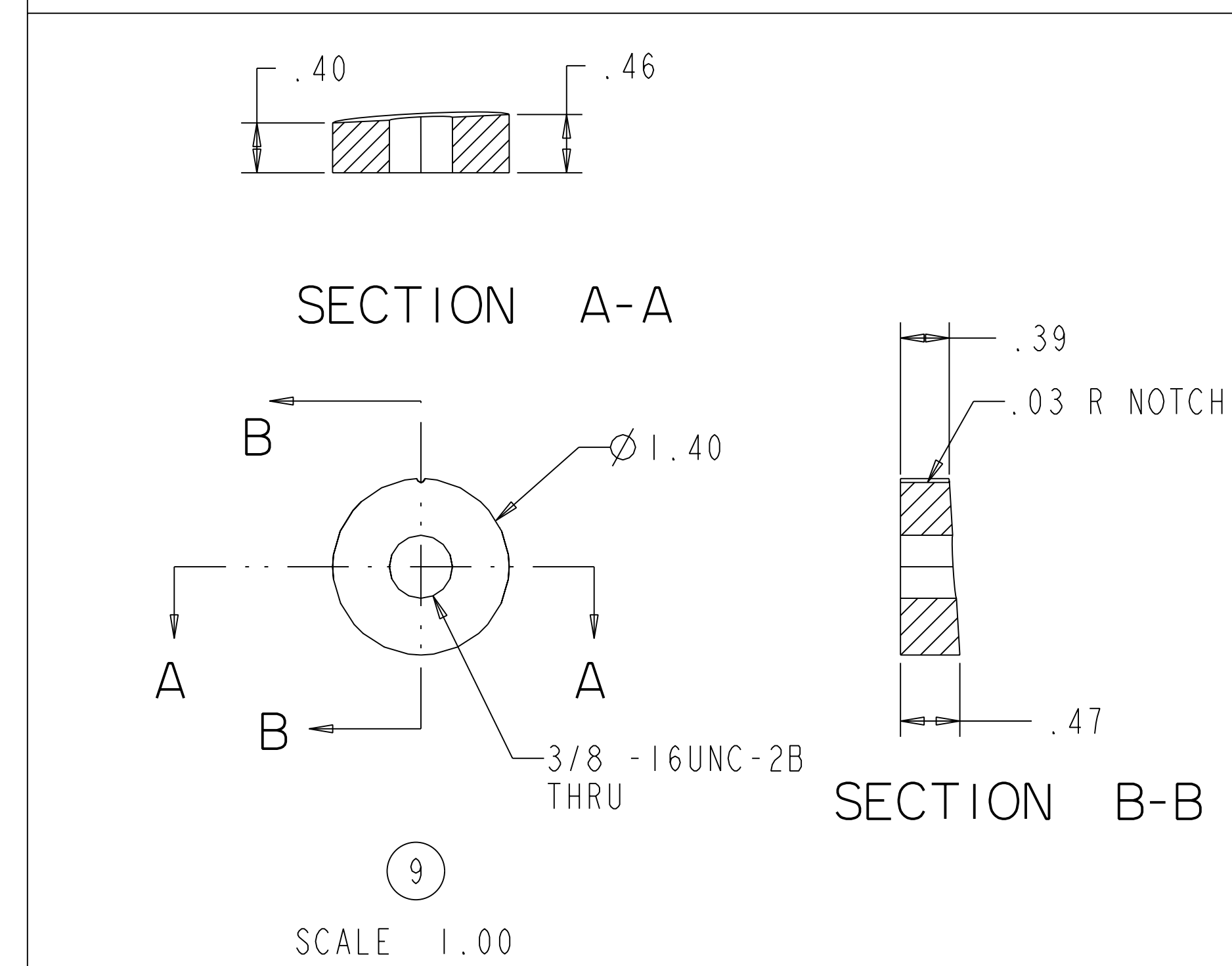
ECN PENDING



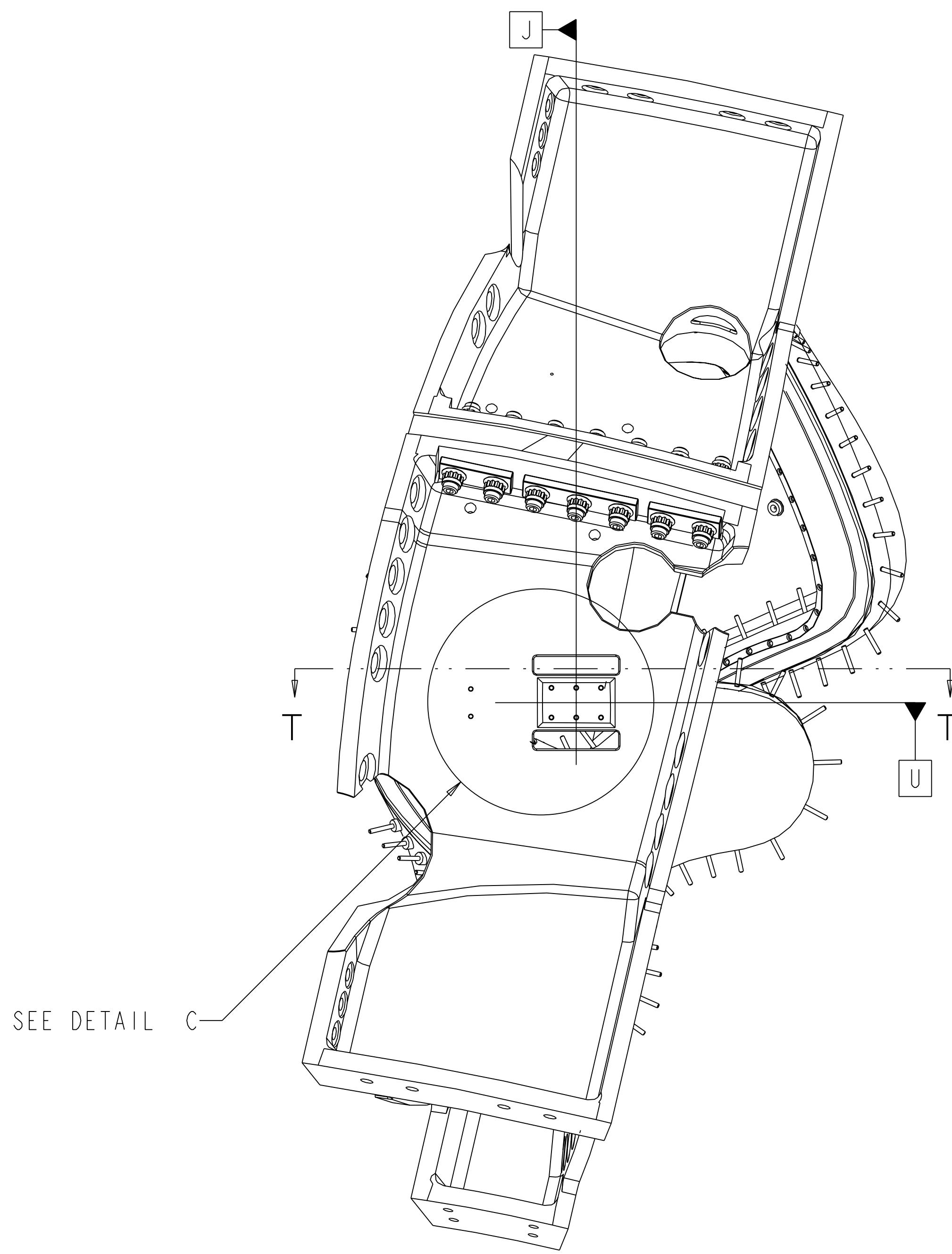
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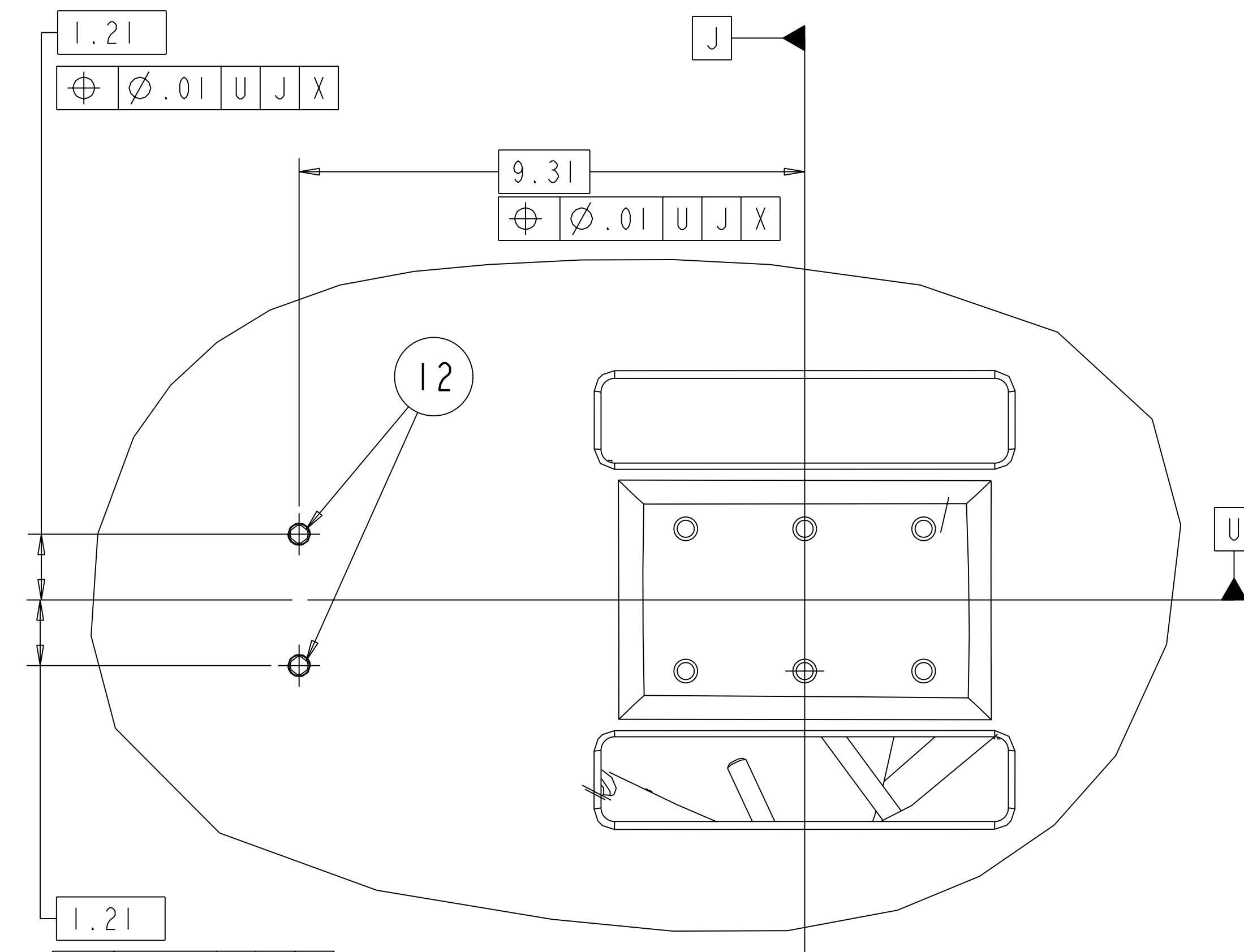
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SCALE 1.00

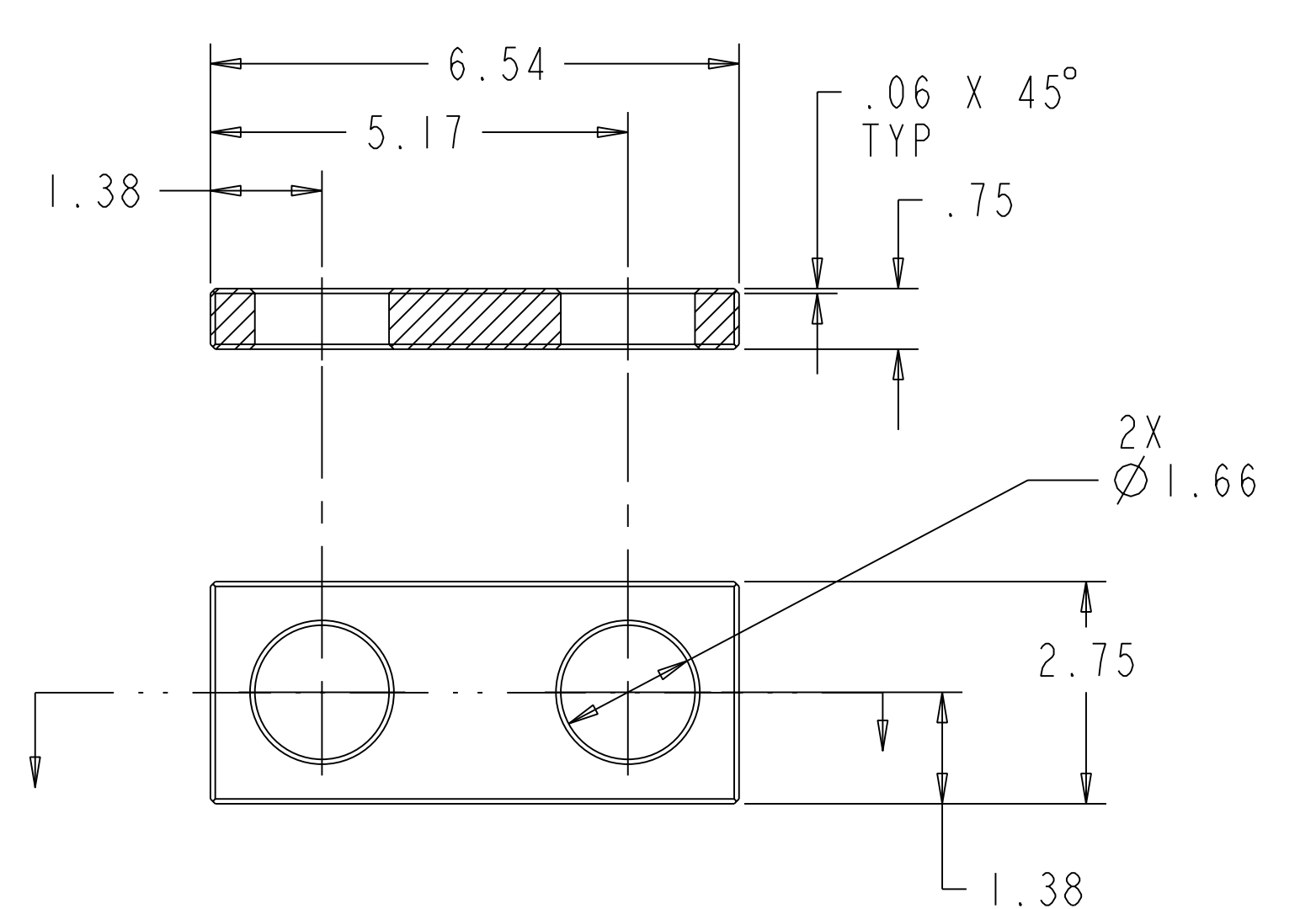


LOCATION OF LEAD BLOCK MOUNTS SCALE 0.13

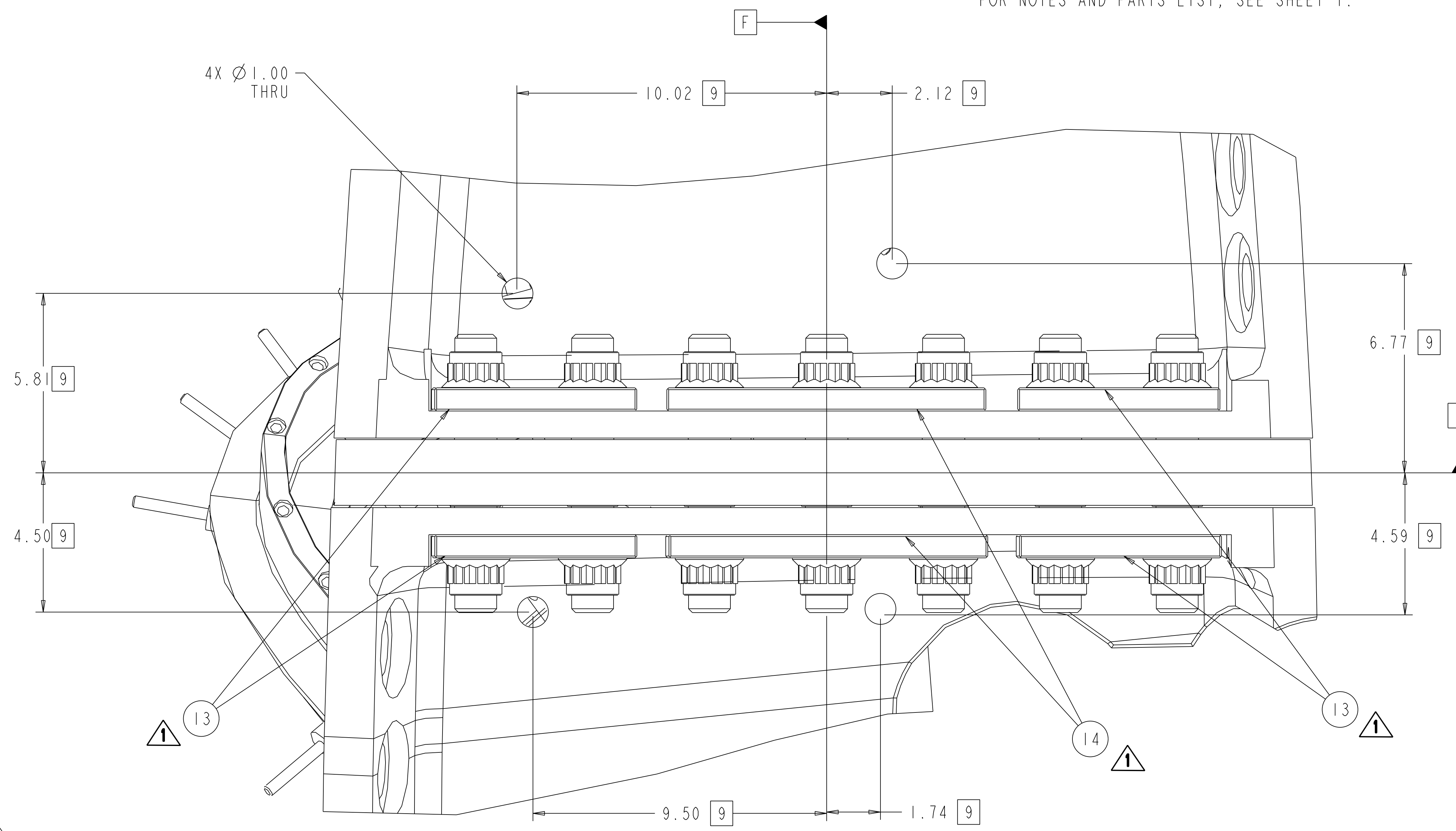


DETAIL C SCALE 0.50 LOCATION OF BASE BLOCK SUPPORT STUDS

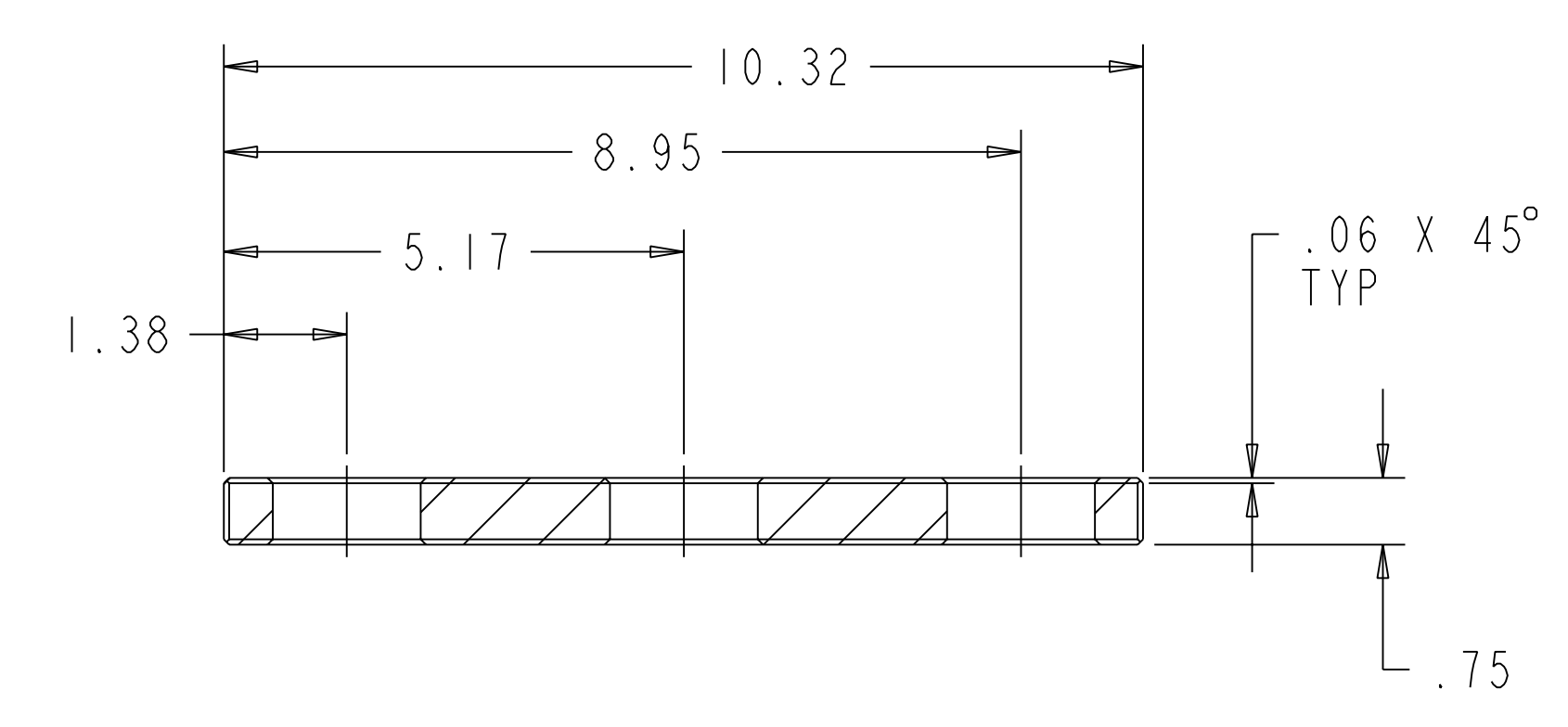
Oak Ridge National Laboratory managed for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT CONTRACT DE-AC05-00OR22725 UT-BATTELLE, LLC., Oak Ridge, Tennessee									
PROJECT NAME: NATIONAL COMPACT STELLARATOR EXPERIMENT									
MODULAR COIL TYPE-C WINDING FORM AND STUD WELDMENT									
VERSION NO.	PLANT	BLDG	FL	SHT	OF	TYPE	CLASS		
6	X-10	5700	3	2	4	S	U		
RELEASE LEVEL		SEI41-123						REV	
WIP									



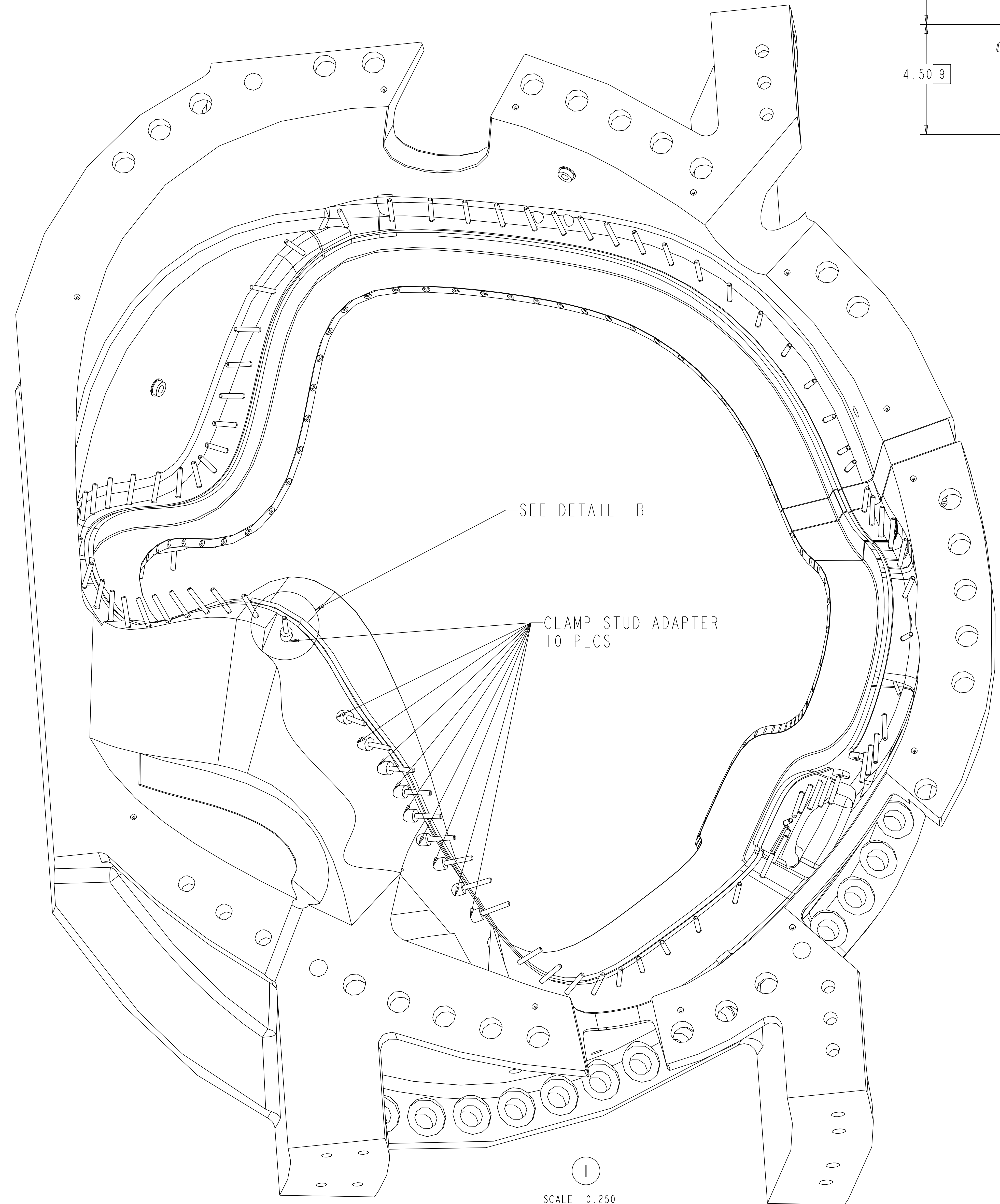
13 POLOIDAL BREAK BOLT SHIM "A"
SCALE 0.50



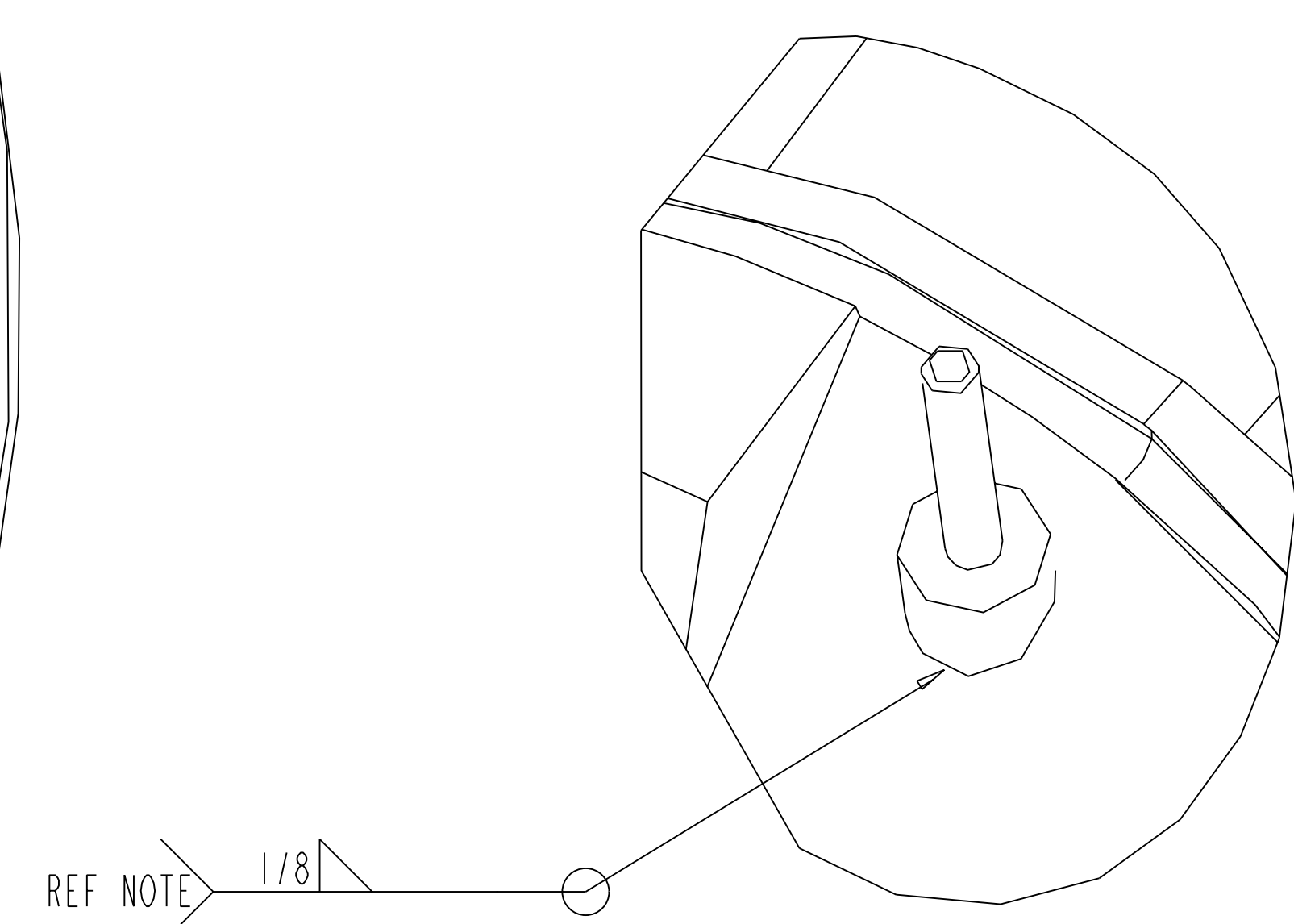
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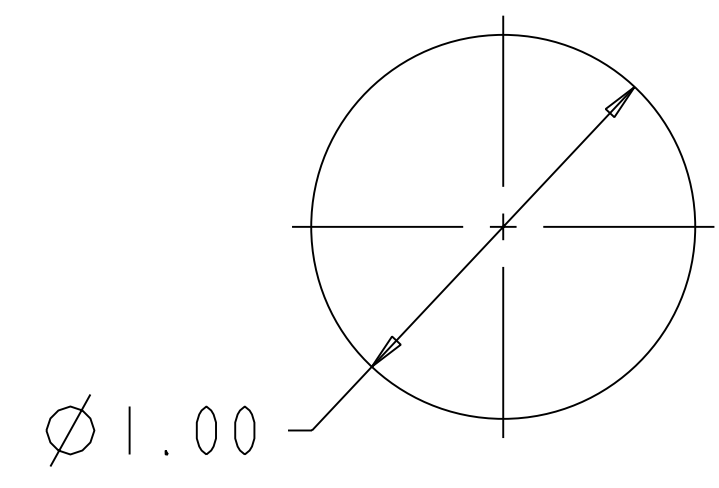
14 POLOIDAL BREAK BOLT SHIM "B"
SCALE 0.50



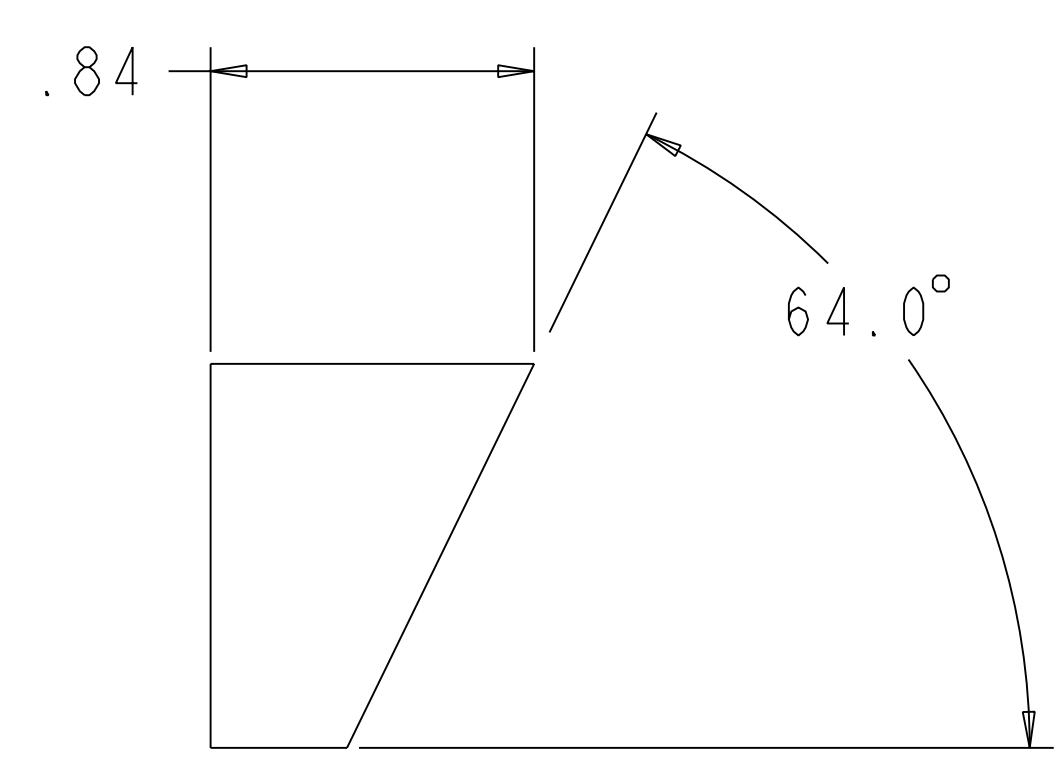
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SCALE 0.250



DETAIL B
(7X) SCALE 1.0



6 CLAMP STUD ADAPTER
SCALE 2.00

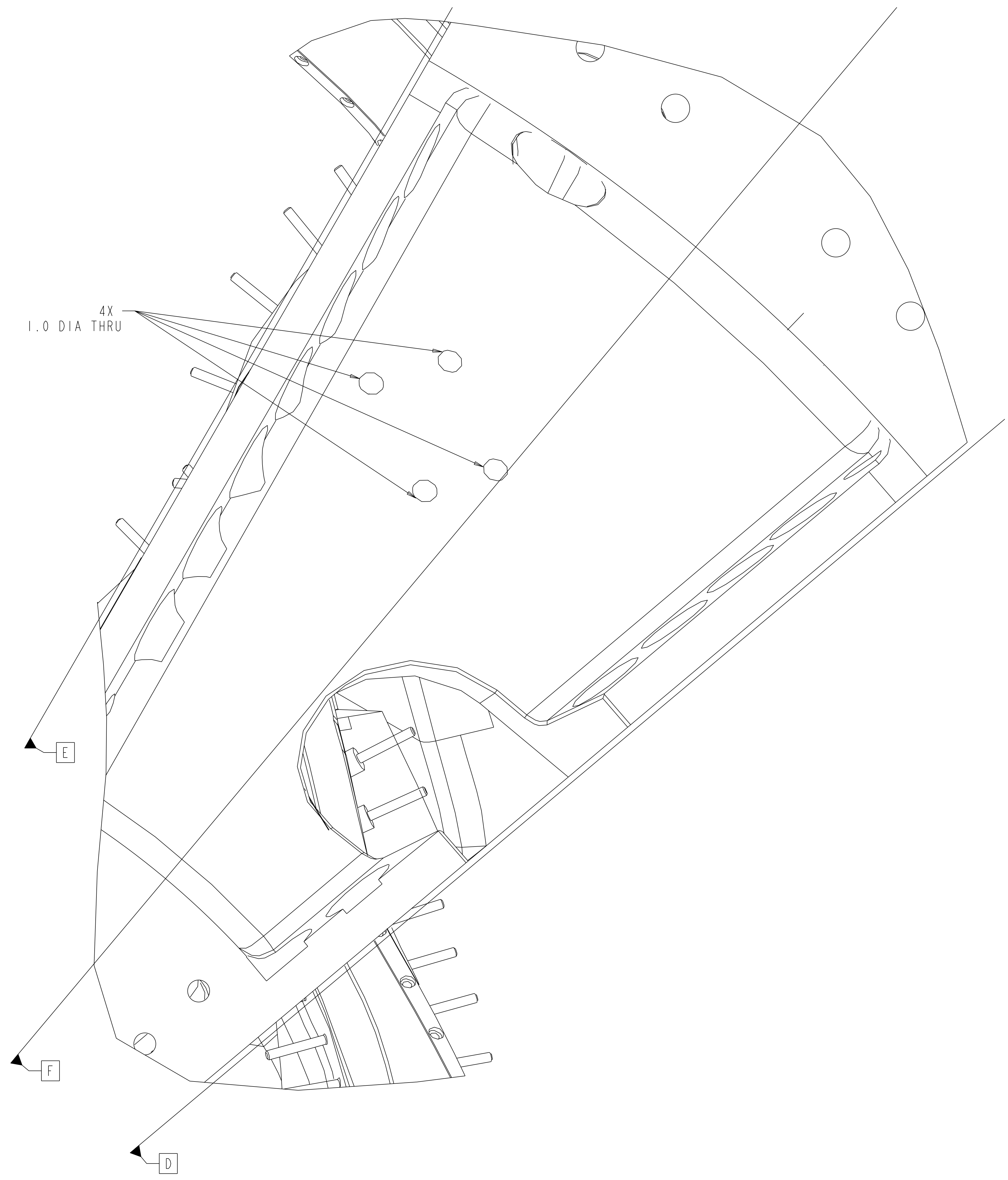


ECN PENDING

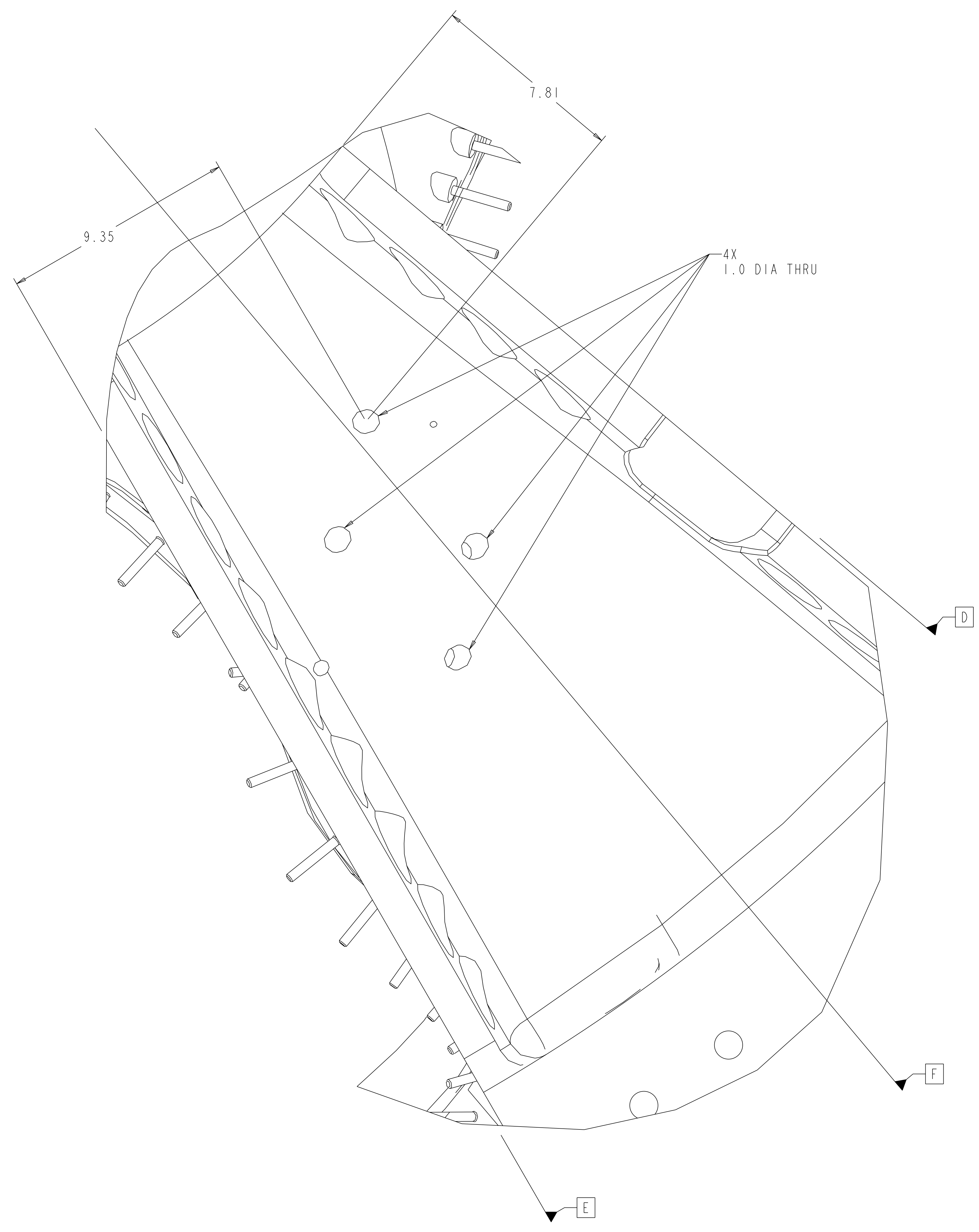
Oak Ridge National Laboratory managed for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT CONTRACT DE-AC05-00OR22725 UT-BATTELLE, LLC, Oak Ridge, Tennessee PROJECT NAME: NATIONAL COMPACT STELLARATOR EXPERIMENT									
MODULAR COIL TYPE-C WINDING FORM AND STUD WELDMENT									
VERSION NO.	PLANT	BLDG	FL	SHT	OF	TYPE	CLASS		
6	X-10	5700	3	3	4	S	U		
RELEASE LEVEL		SEI41-123							
WIP									

8 7 6 5 4 3 2 1 NEXT ASS'Y: 1 FINAL ASS'Y:

H G F E D C B A



TOP VIEW (PARTIAL)
SCALE 0.50



BOTTOM VIEW (PARTIAL)
SCALE 0.50

ECN PENDING

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									
MODULAR COIL TYPE-C WINDING FORM AND STUD WELDMENT									
VERSION NO.	PLANT	BLDG	FL	SHT	OF	TYPE	CLASS		
6	X-10	5700	3	4	4	S	U		
RELEASE LEVEL		SE141-123						REV	
Fabrication								0	

8 7 6 5 4 3 2 1

H G F E D C B A

SE141-123