

[5] MANPORT FLANGE TO BE MARKED USING STRAP, F/N 3, AS TEMPLATE AND DRILLED AND TAPPED FOR BOLTS. (OPTION TO USE WELD STUDS, F/N 6, AND NUTS IN PLACE OF BOLTS)

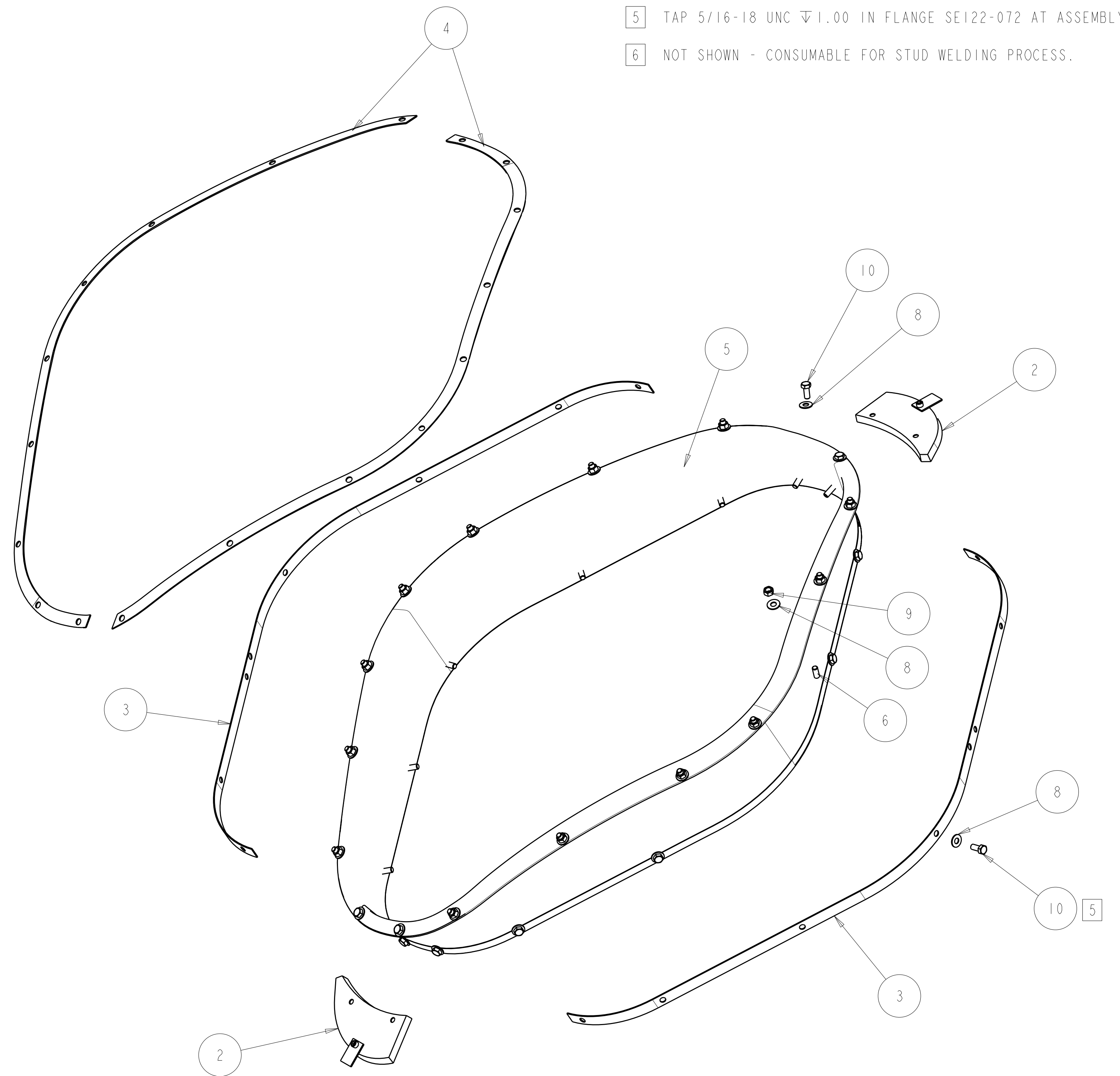
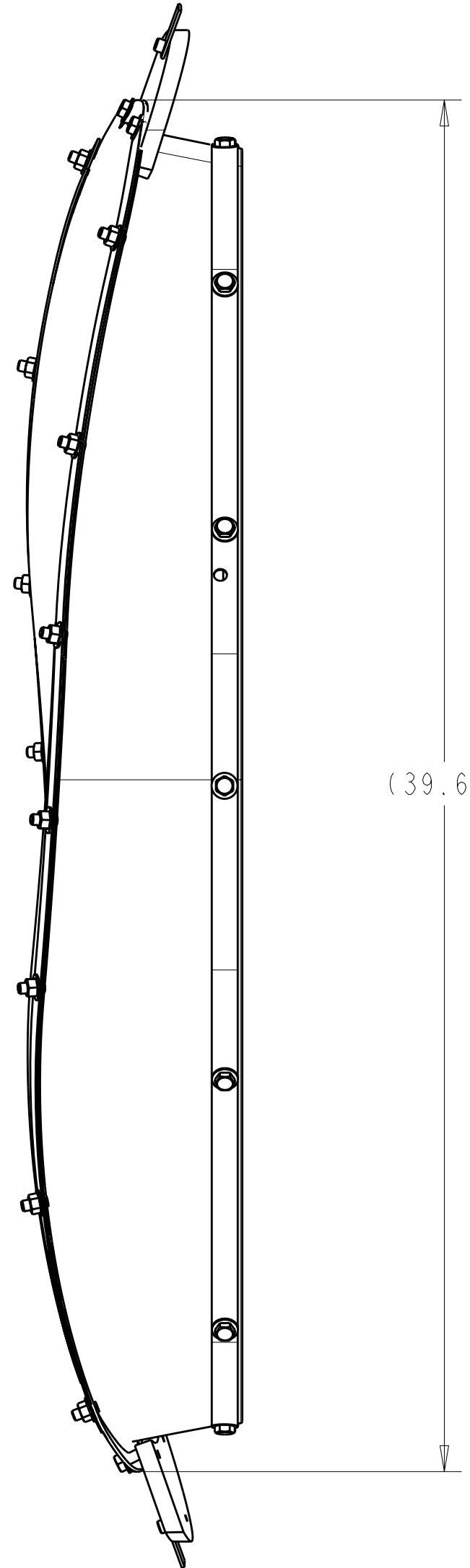
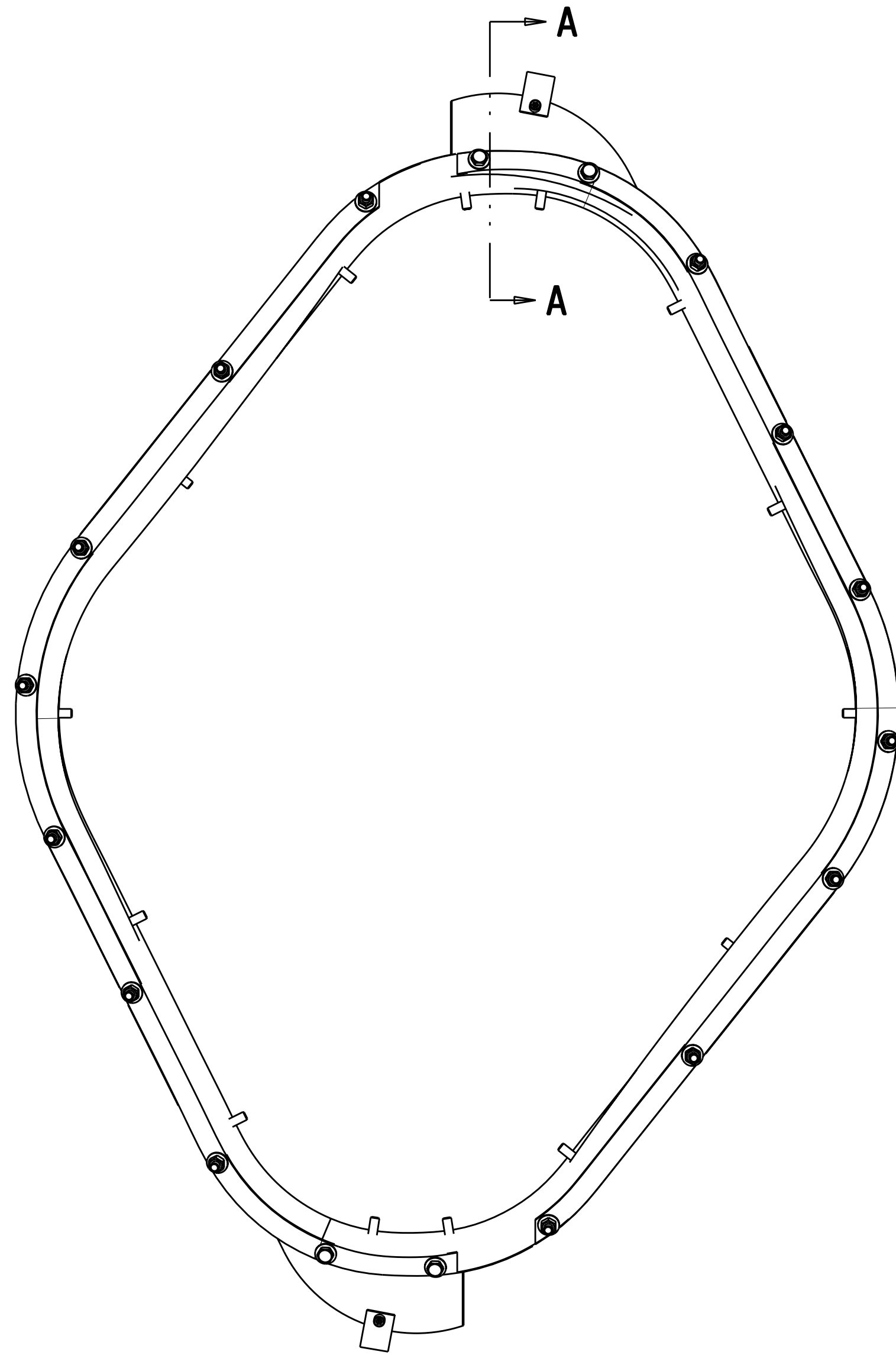
REF MODULAR COIL WALL

FILLER PLATE CLIPS TO BE FORMED AND TACK WELDED AFTER SEAL INSTALLATION

FLANGE COVER OR MANPORT (NOT SHOWN) MAY BE INSTALLED WITH SEAL IN PLACE.

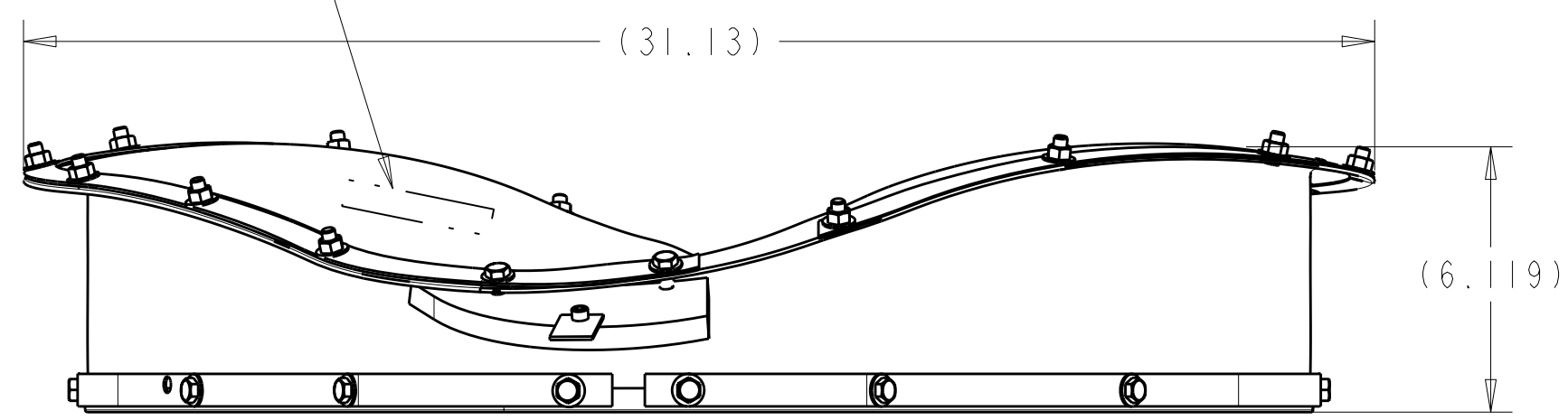
REF VVSA MANPORT FLANGE

SECTION A-A
SCALE .50



EXPLODED ISOMETRIC VIEW

LABEL PART NUMBER AND REVISION USING PERMANENT INK



-1 NEUTRAL BEAM PORT SEAL ASSEMBLY [4]

SCALE .25

NOTES

1. DRAWING PREPARED IN ACCORDANCE WITH ASME Y14.100-2004.
2. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M-1994.
3. DIMENSIONS ARE IN INCHES.
- 4 THIS DRAWING FOR PROCUREMENT OF PARTS. FOR INSTALLATION SEE DRAWING SE100-002.
- 5 TAP 5/16-18 UNC ±.001 IN FLANGE SE122-072 AT ASSEMBLY, 14 PLACES.
- 6 NOT SHOWN - CONSUMABLE FOR STUD WELDING PROCESS.

REV	DESCRIPTION	BY	DATE	CHK	DEPT	DATE	PE	REQ	DATE	ORNL	DOE	DATE
0	ORIGINAL ISSUE	MTR	01/07	SP		01/07						
1	REVISION OR ISSUE PURPOSE											

CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
18	93190A581	5/16-18 UNC X .75 LG HEX BOLT	316 SST	MCMaster-CARR ATLANTA, GA 30374-0100 (404) 346-7000 WWW.MCMaster.COM	10
14	90545A030	5/16-18 UNC HEX NUT	TITANIUM		9
32	93490A017	5/16 ID X .75 OD FLAT WASHER	BRONZE		8
14	009-689	5/16 FERRULE	CERAMIC	STUD WELDING COMPANY MOORESTOWN, NJ 08057 (800) 523-5092	7
14	006-932	5/16-18 UNC X .75 CD WELD STUD	SST		6
1	SE122-396-1	NEUTRAL BEAM SEAL BOOT			5
2	SE122-395-1	NEUTRAL BEAM PORT BOOT RETAINER STRAP AT WINDING FORM			4
2	SE122-394-1	NEUTRAL BEAM PORT BOOT RETAINER STRAP AT MAN PORT			3
2	SE122-356-1	NEUTRAL BEAM PORT BOOT FILL PLATE ASSY			2
AR		-1		NEUTRAL BEAM PORT SEAL ASSEMBLY	1

SCALE NOTED
TOLERANCES UNLESS OTHERWISE SPECIFIED

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

DES PL GORANSON 01/07
DRW MT BROWN 01/07
CHK S PARSON 01/07

DEPT :
SECT :
PE :
CR :
PJ :
REQ :
PPPL DRFT J SIEGEL 01/07DRAWING APPROVALS DATE

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

NEUTRAL BEAM PORT INSULATION SEAL ASSEMBLY

VERSION NO.	PLANT	BLDG	FL	SHT	OF	TYPE	CLASS
11+	ORNL	5700	3	1	1	A	U

RELEASE LEVEL
WIP

SE122-392

REV 0

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