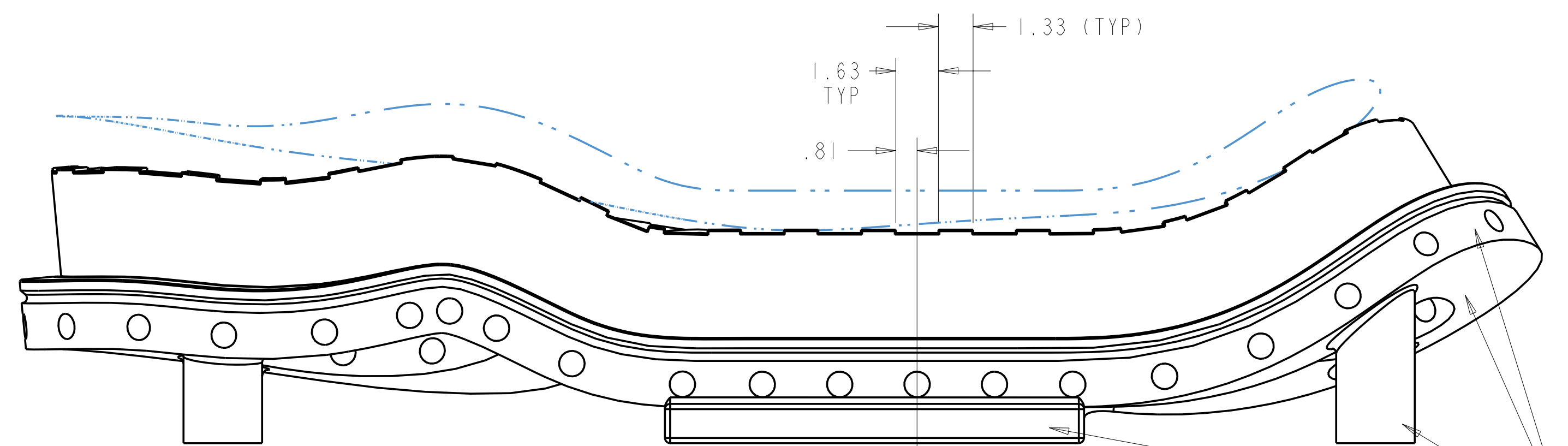
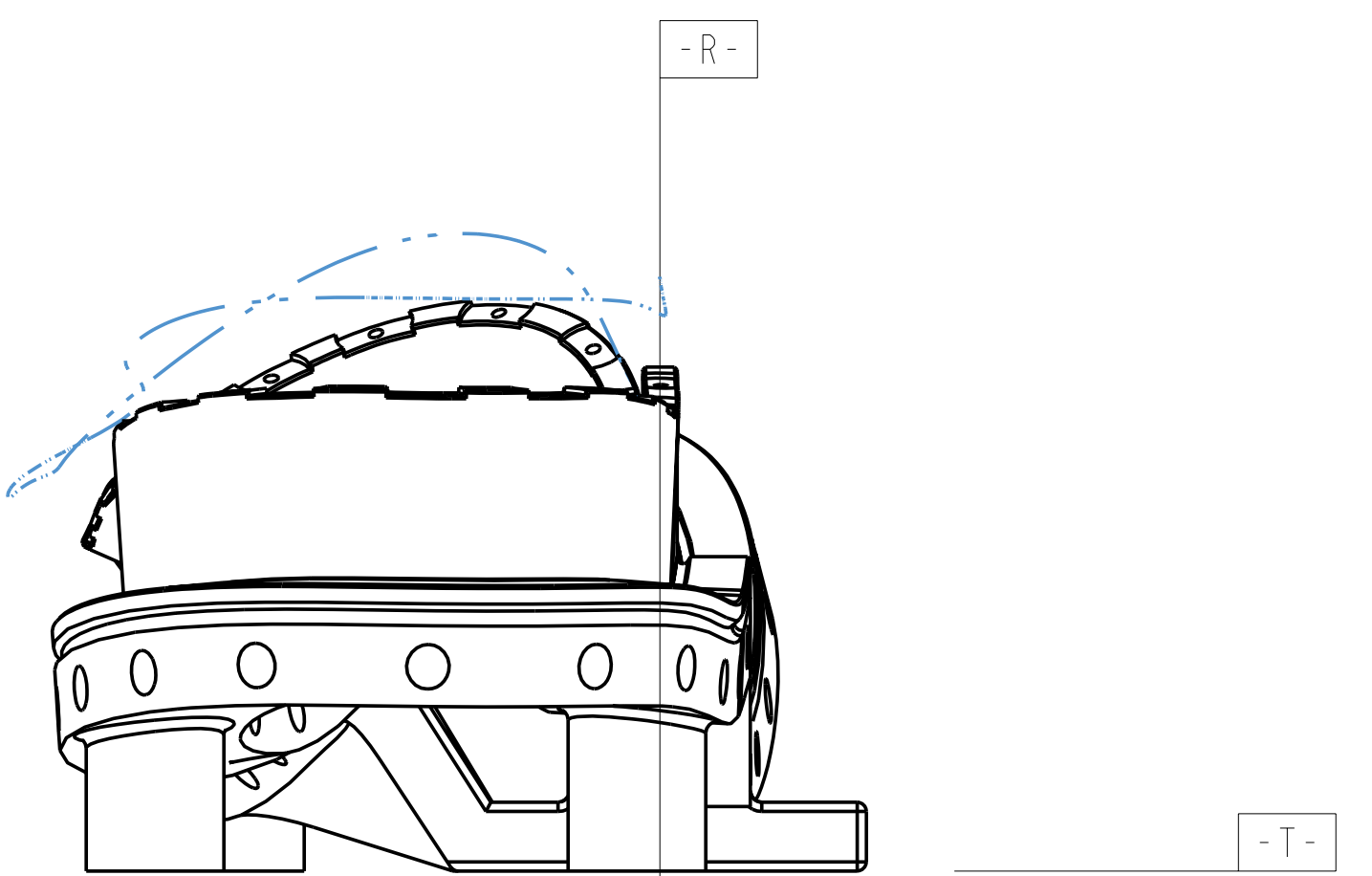
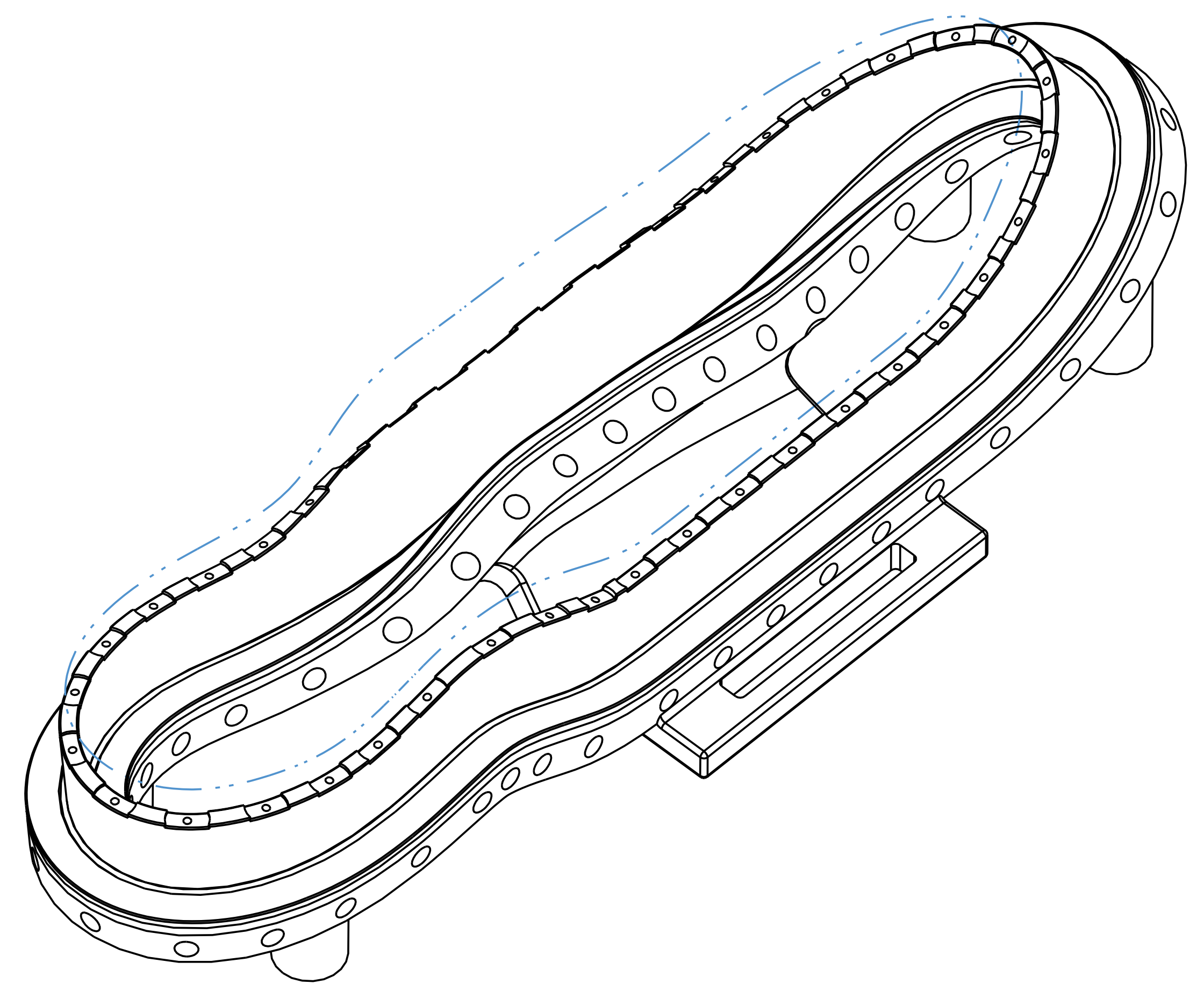
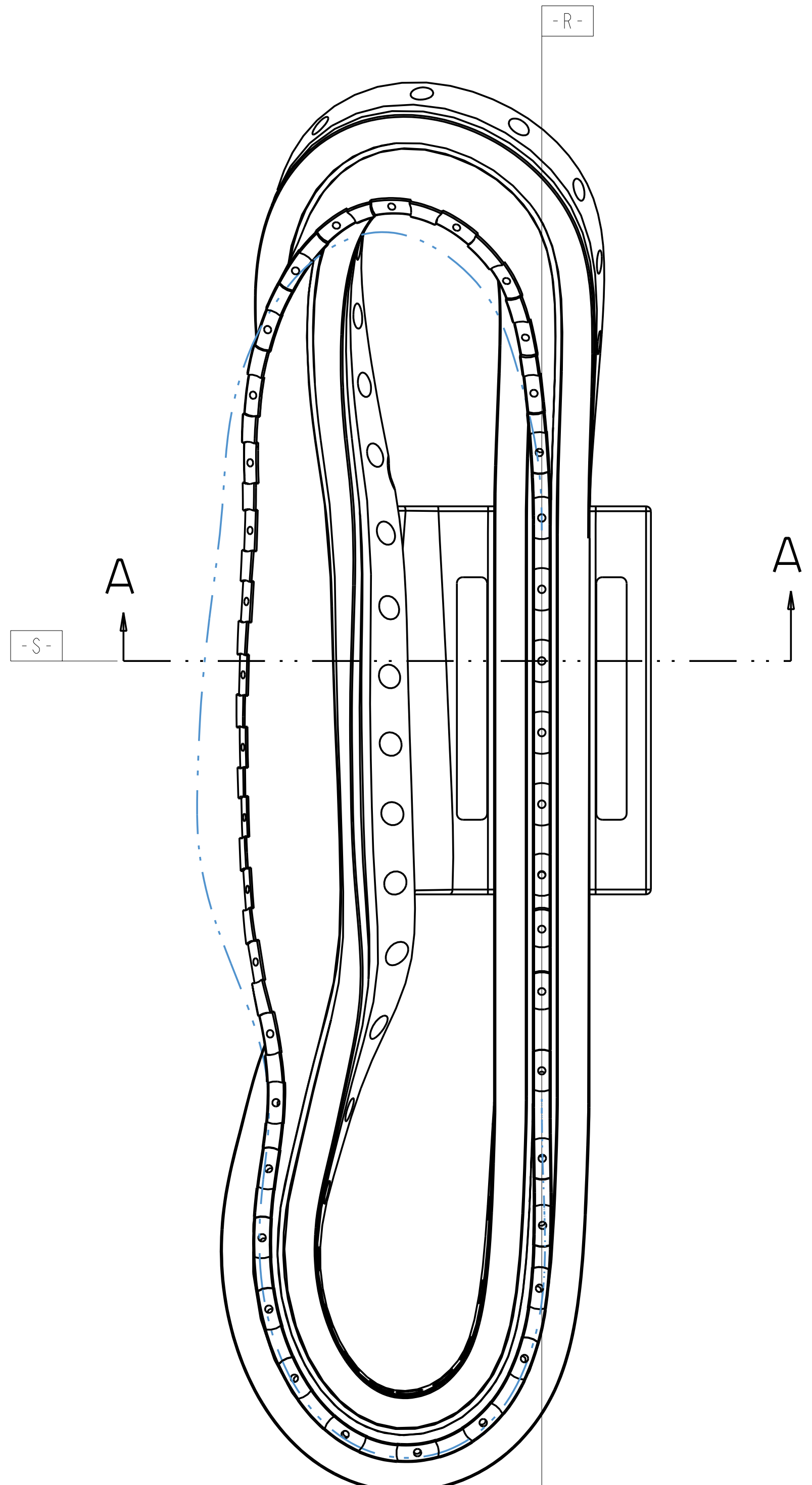


- NOTES:
1. INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M
 2. DIMENSIONS ARE IN INCHES
 3. DIMENSIONS APPLY AT ROOM TEMPERATURE, OPERATING TEMP 80 K.
 4. GEOMETRY IS DEFINED IN PRO ENGINEER CAD MODELS/FILES SE140-081.PRT.
 5. DRAWING AND MODELS COMBINED DEFINE FINISHED MACHINED PART.
 6. MACHINE FINISHED SURFACES TO CAD DATA, PROFILE WITHIN 0.020" UNLESS OTHERWISE SPECIFIED. PROFILE TOLERANCE IS BILATERAL, i.e. 0.010" EITHER SIDE OF THE REFERENCE SURFACE.
 7. AS-CAST SURFACES SHOWN IN NOMINAL MATERIAL CONDITION, THICKNESS TOLERANCE +/- 0.25. SURFACE PROFILE MUST BE WITHIN 0.5 INCHES OF CAD DATA, EXCEPT IN REGIONS OF INTERSECTING SURFACES WHERE FILLETS ARE EXPECTED.
 8. SEE SPECIFICATION, NCSX-CSPEC 141-02-00 FOR ADDITIONAL REQUIREMENTS.



CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SEE NOTE	8	1
NEXT ASSEMBLY			PARTS LIST			

QUALITY VERIFICATION		
MECHANICAL AND STRUCTURAL REFERENCE ORNL QA-685		
QV CLAUSE	DOCUMENTS REQUIRED	APPLICABLE TO PART NO.
30.3	MATERIAL MILL TEST REPORT	:
32.5	MATERIAL SELLER CERT	:
32.6	SPECIAL MATERIAL INSPECTION REPORT	:
20.5	MANUFACTURING, INSPECTION AND TEST PLAN	:
31.2	FITTED INSPECTION AND TEST PLAN	:
32.1	WELD AND BRAZE INSPECTION REPORT	:
32.2	HEAT TREAT REPORT (M/CERT)	:
31.0	CLEAN TEST REPORT	:
31.5	CLEANING CERT	:
31.8	DEVIATION REQUEST	:
31.9	NONCONFORMANCE REPORT	:
32.3	DIMENSIONAL REPORT	:
33.0	FUNCTIONAL TEST REPORT	:
...
...
...
...
100	DOCUMENTATION	DATE
...
* SYMBOL # INDICATES APPLICABLE TO ALL PARTS OR ITEMS		

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

REV	DATE	BY	APP'D	DESCRIPTION

SCALE NOTED

TOLERANCES UNLESS OTHERWISE SPECIFIED:

FRACTIONS: ±.001
 XX DECIMALS: ±.01
 XXX DECIMALS: ±.005
 ANGLES: ±0°15'

BREAK SHARP EDGES: .06 MAX
 FINISH: .125 UNLESS OTHERWISE SPECIFIED

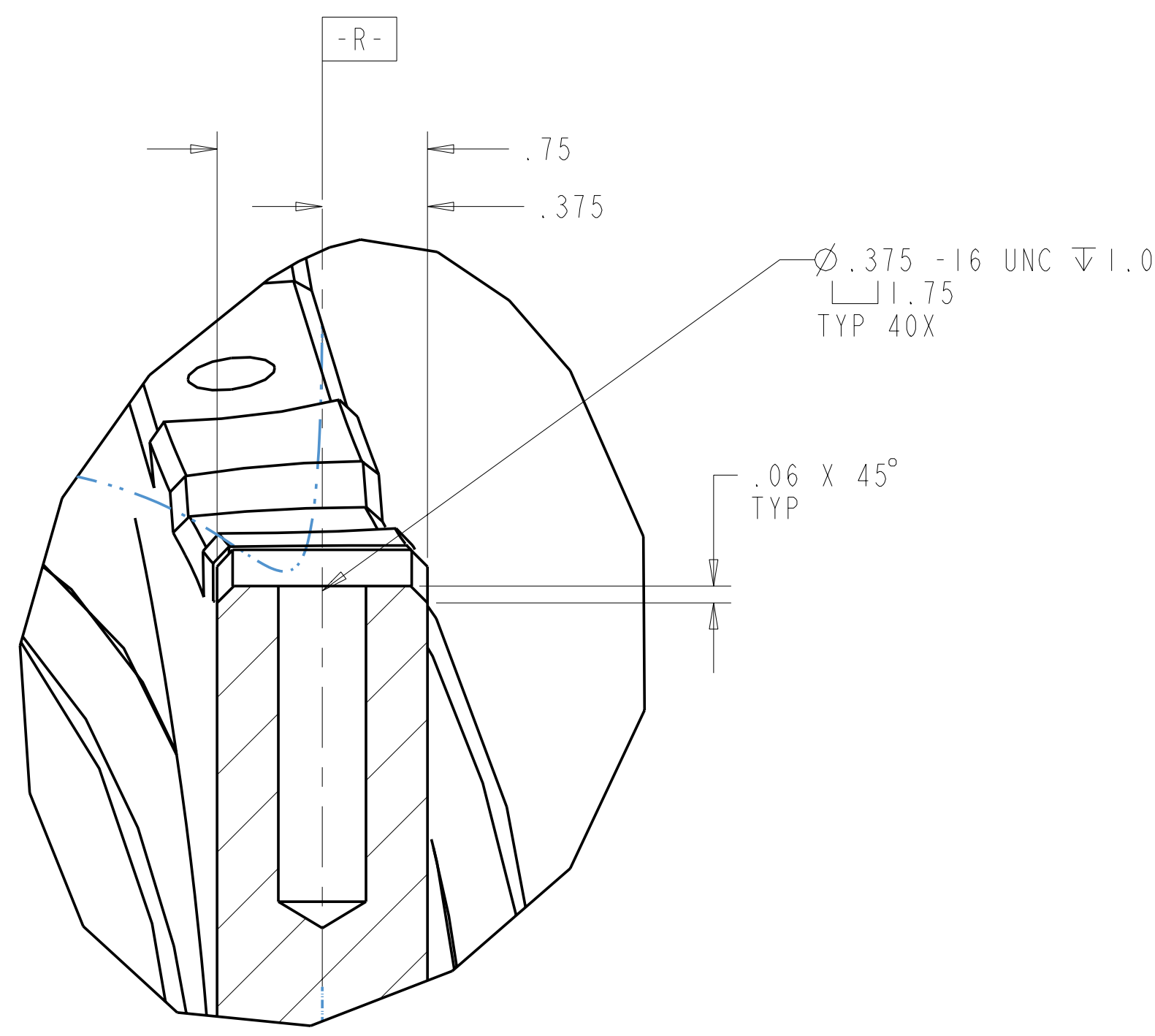
DES: PAUL FOGARTY 10-14-03
 DRW: GARY LOVETT 10-14-03

UT-BATTELLE
 NATIONAL COMPACT STELLERATOR EXPERIMENT
 TWISTED RACETRACK WINDING FORM

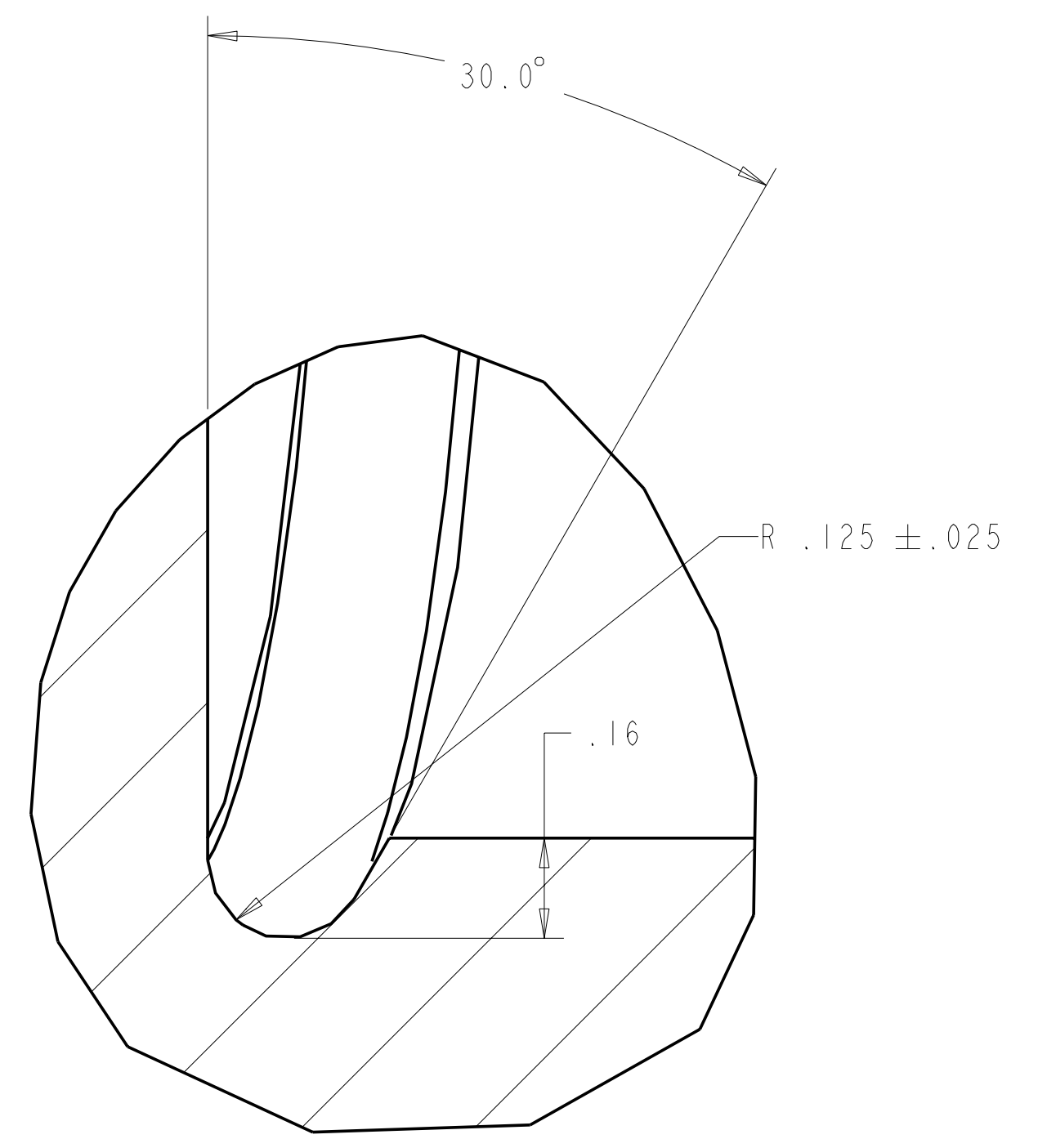
VERSION NO.: X-10
 PLANT: CSB
 BLDG: 3
 FL: 1
 SHT OF: 3
 TYPE: S
 CLASS: U
 RELEASE LEVEL: ■■■
 SEI40-081

H
G
F
E
D
C
B
A

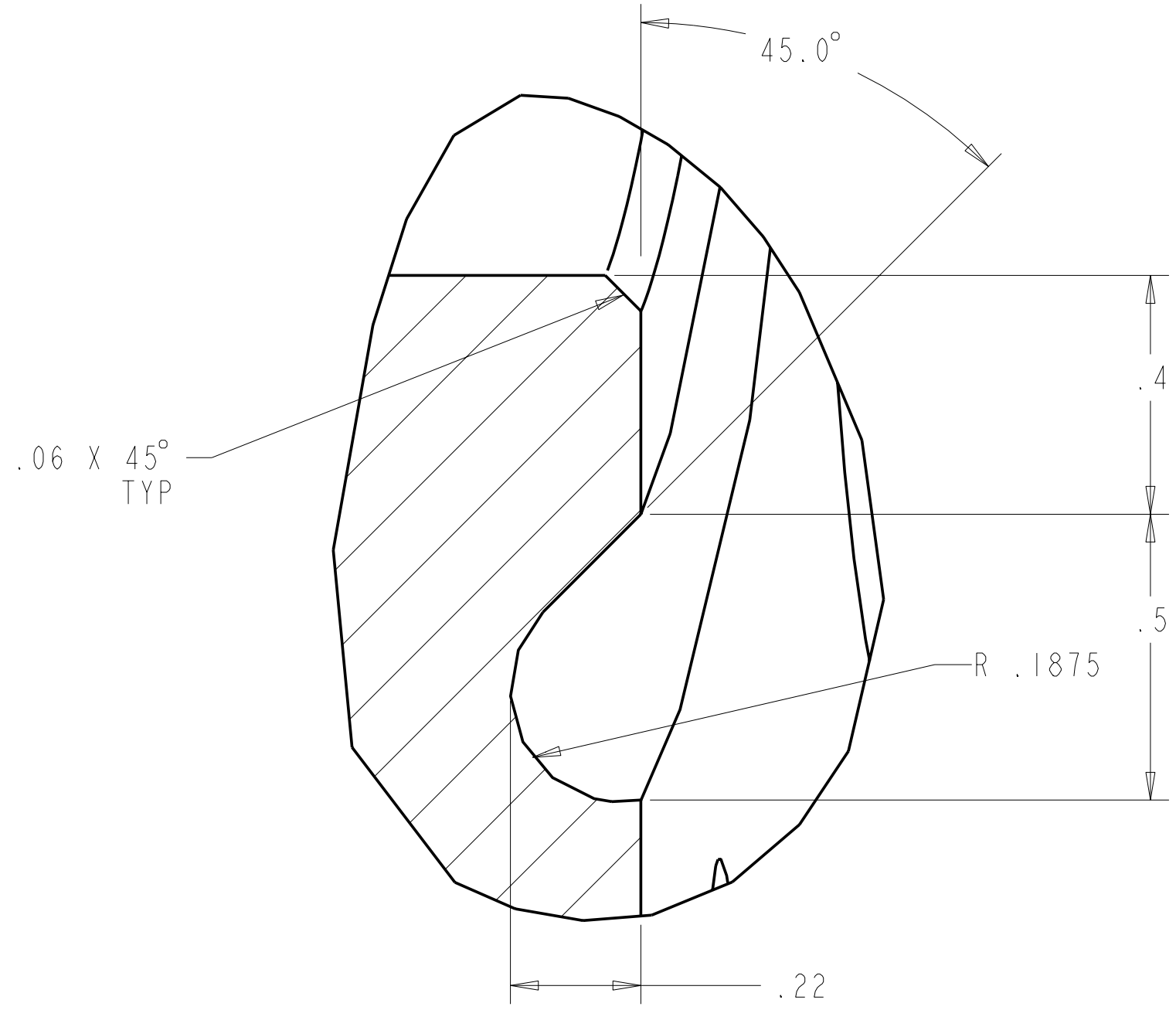
H
G
F
E
D
C
B
A



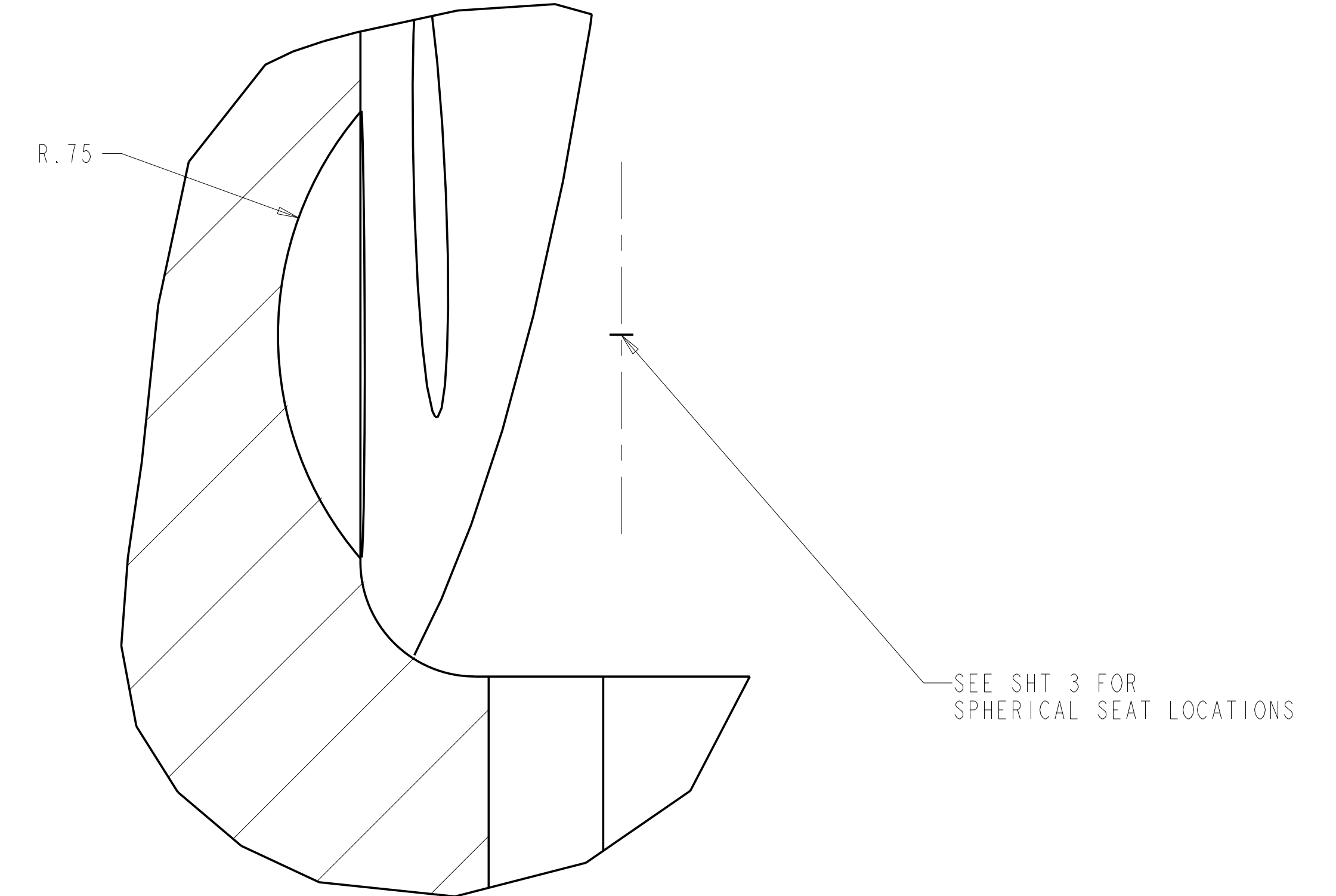
DETAIL 1
 SCALE 2.0



DETAIL 2
 SCALE 4.0

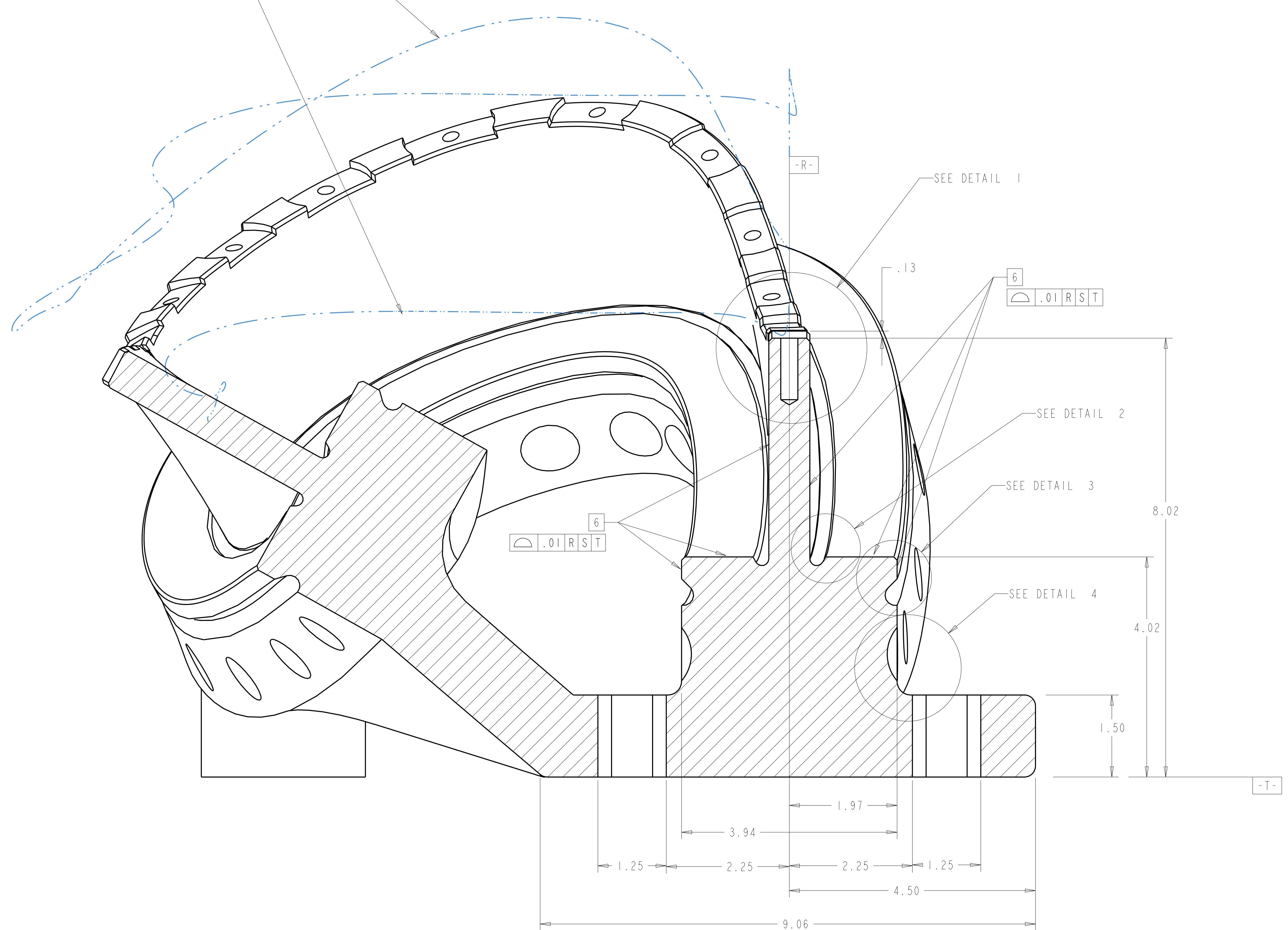


DETAIL 3
 SCALE 4.0

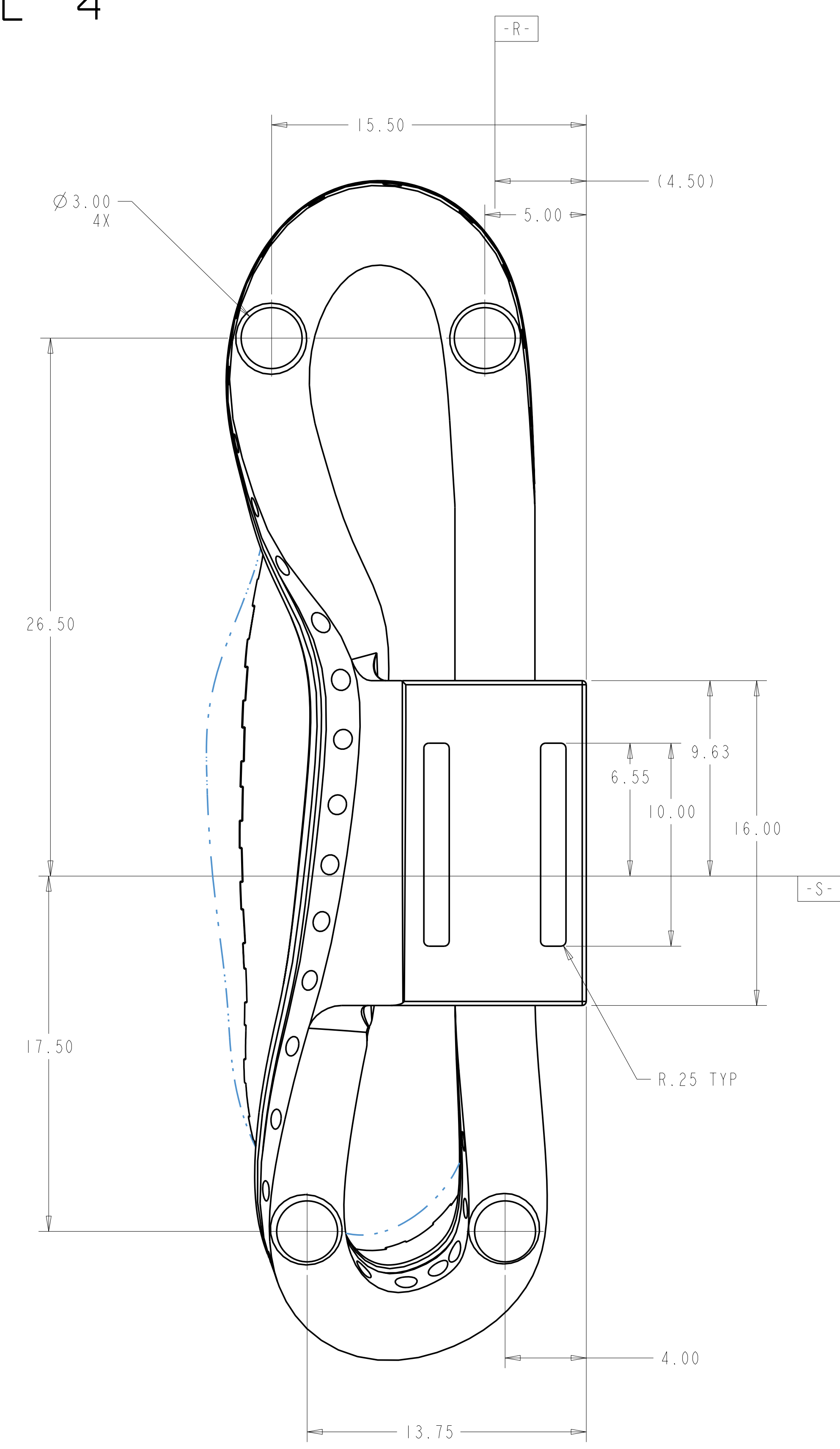


DETAIL 4
 SCALE 4.0

X-VECTOR CURVE
 SEE SHT 3 FOR CO-ORDINATE DATA FILE
 WINDING CENTER CURVE
 SEE SHEET 3 FOR CO-ORDINATE DATA FILE



SECTION A-A
 SCALE 1.000



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							
TWISTED RACETRACK WINDING FORM							
VERSION NO.	PLANT	BLDG	FL	SHT OF	TYPE	CLASS	
8	X-10	CSB	3	2 3	S	U	
RELEASE LEVEL	SEI40-081						REV
WIP							-

H
 G
 F
 E
 D
 C
 B
 A

SEI40-081

