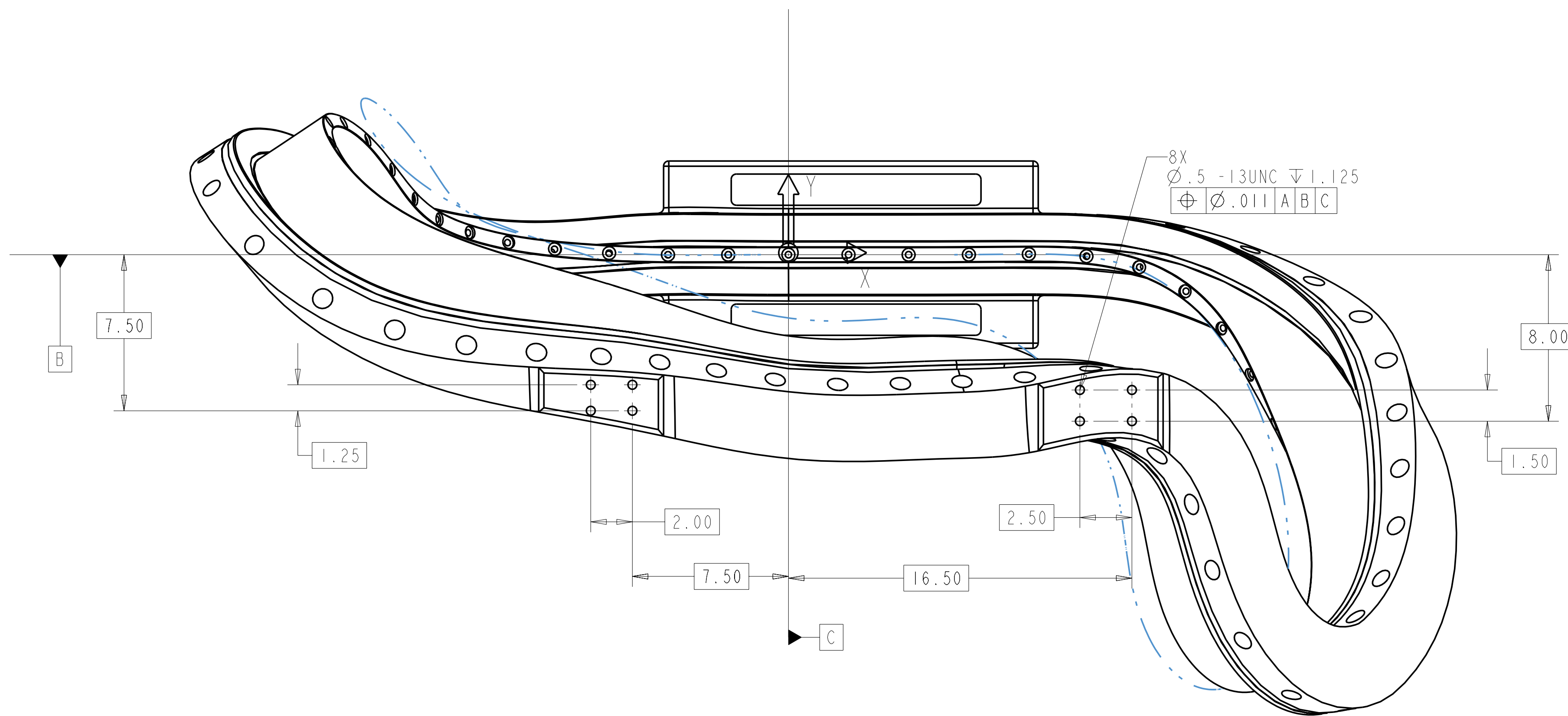
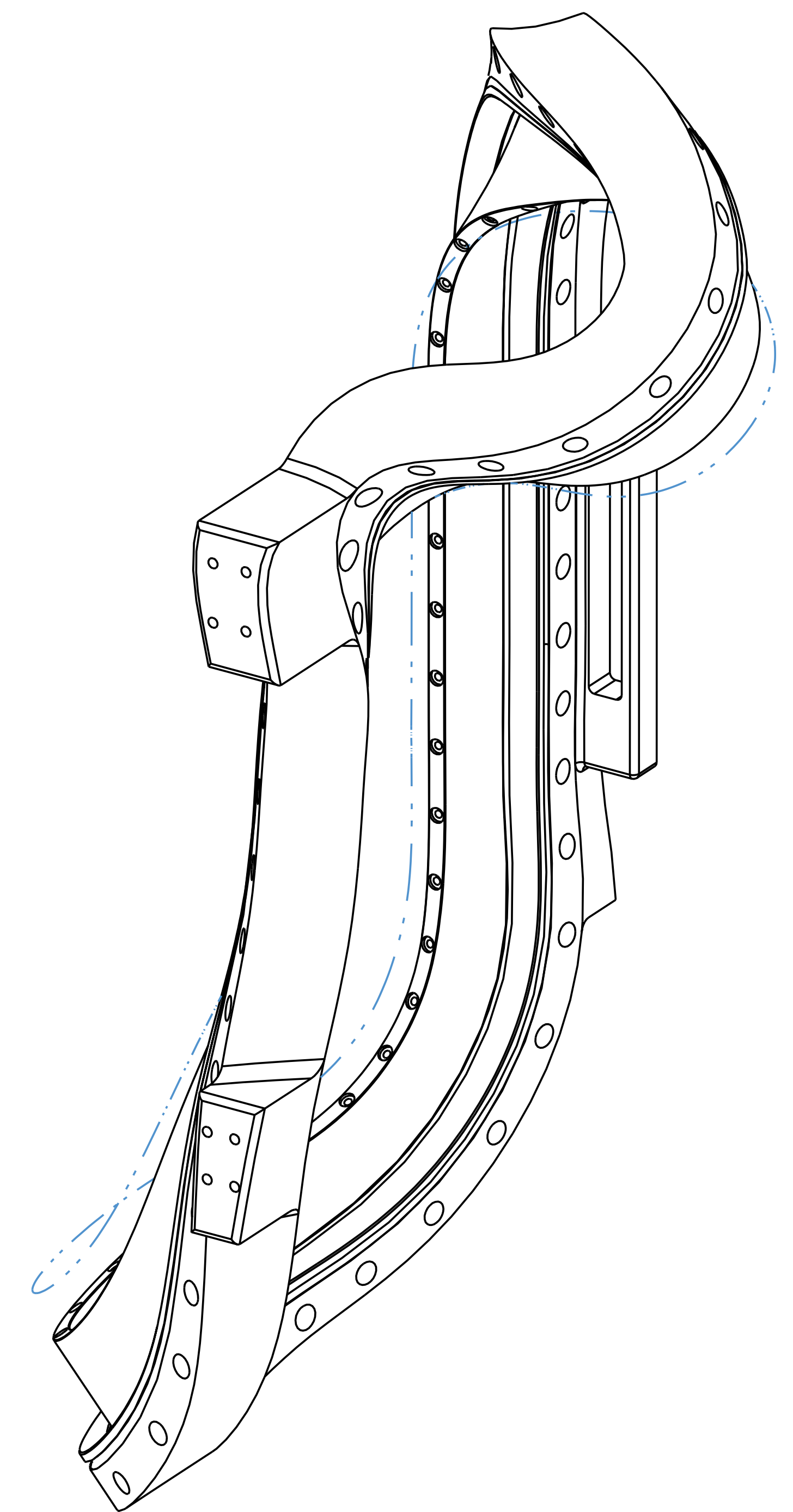


NOTES:

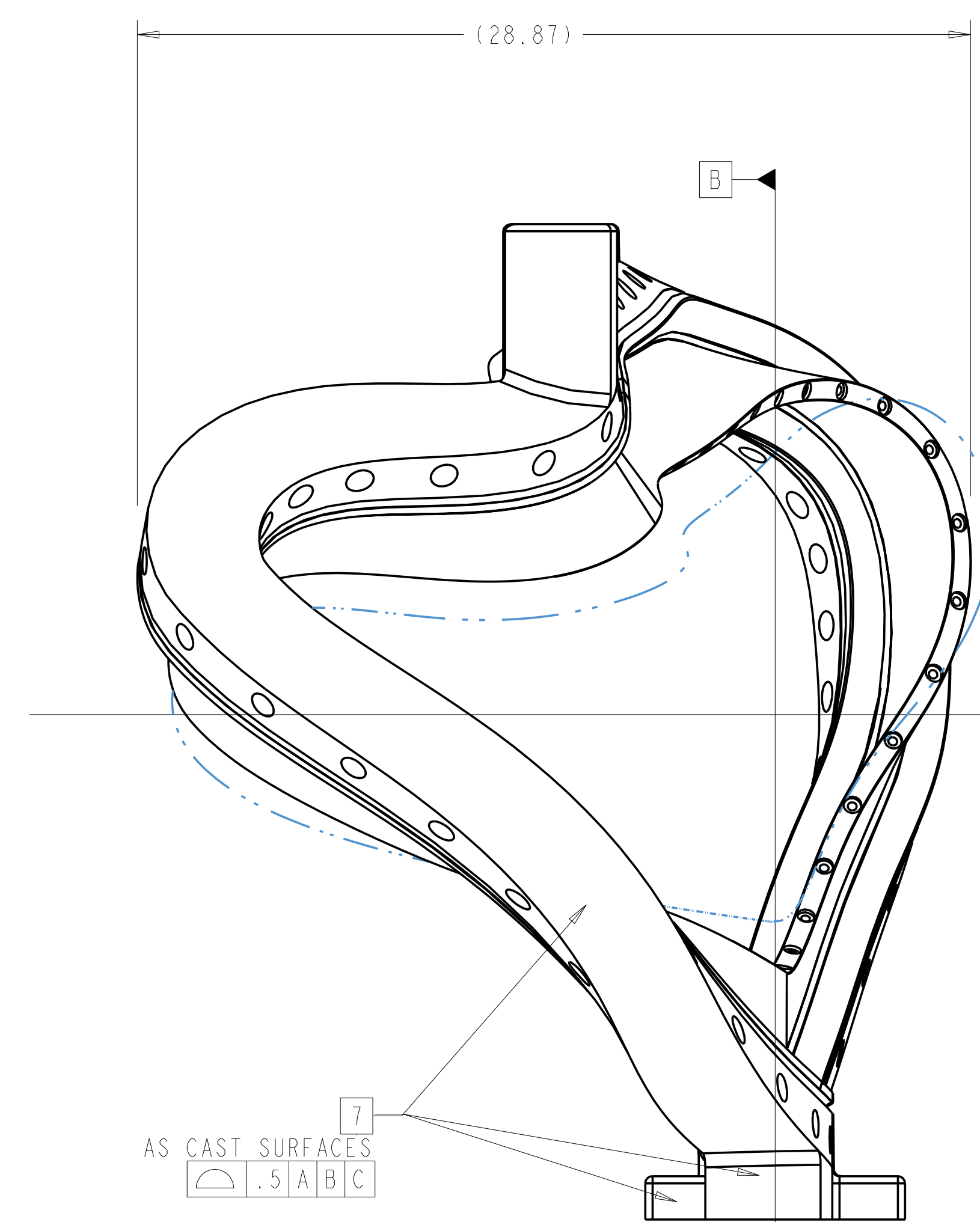
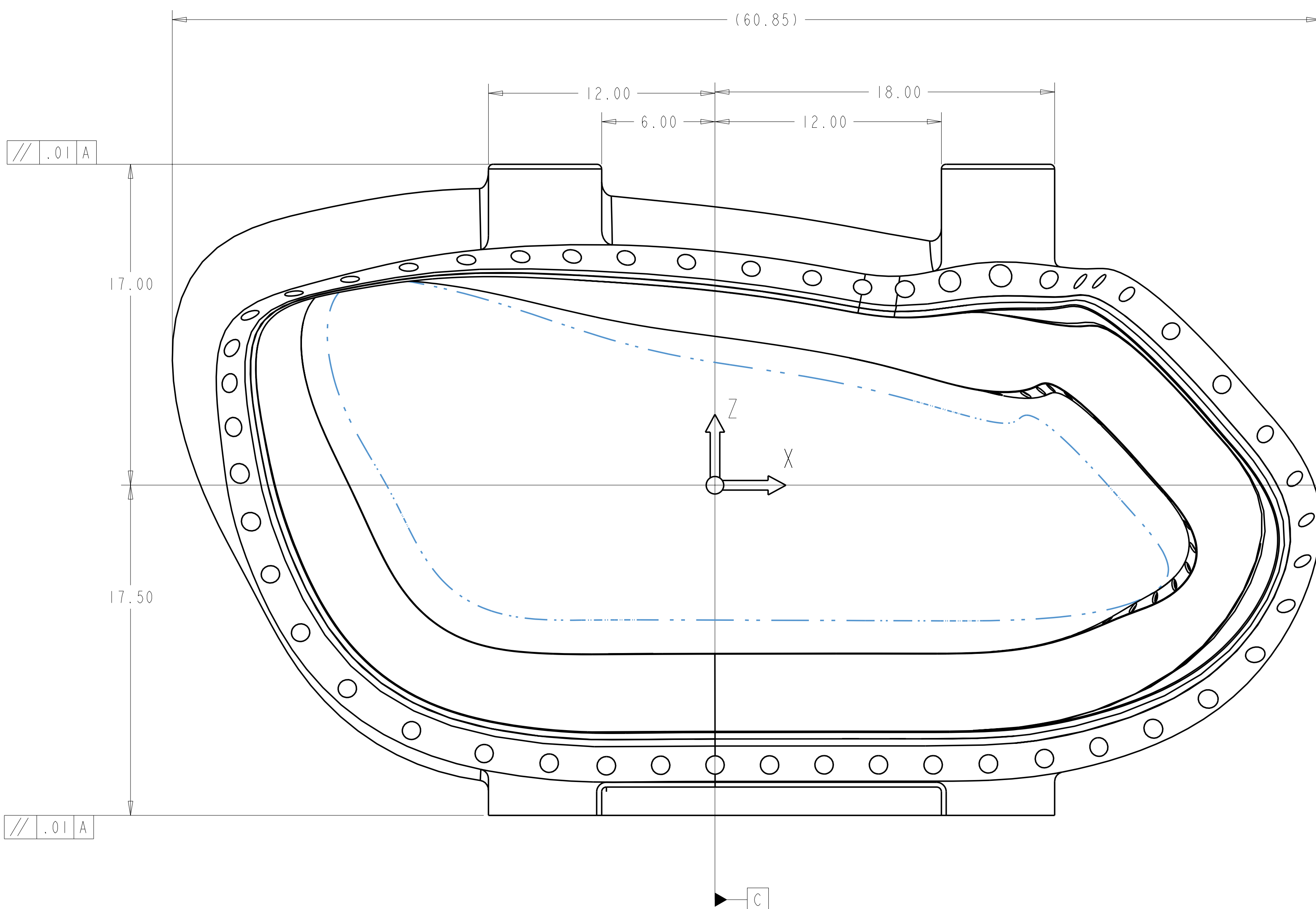
1. INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M
2. DIMENSIONS ARE IN INCHES
3. DIMENSIONS APPLY AT ROOM TEMPERATURE, OPERATING TEMP 80 K.
4. GEOMETRY IS DEFINED IN PRO ENGINEER CAD MODELS/FILES SE140-084.PRT
5. DRAWING AND MODELS COMBINED DEFINE FINISHED MACHINED PART.
6. MACHINE FINISHED SURFACES 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.
9. SEE SPECIFICATION NCSX-CSPEC 141-02-00 SECTION 3.2.1.1 FOR MATERIAL REQUIREMENTS.]



DATUM A = PLANE THRU "XY"
 DATUM B = PLANE THRU "XZ"
 DATUM C = PLANE THRU "YZ"



ISOMETRIC VIEW



X	AR	SE140-084	WINDING FORM	SEE NOTE 9	SEE NOTE 8	-1
next ass'y	CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
SE140-080		NEXT ASSEMBLY				

PARTS LIST

APPROXIMATE WEIGHT = 725 LBS

-1

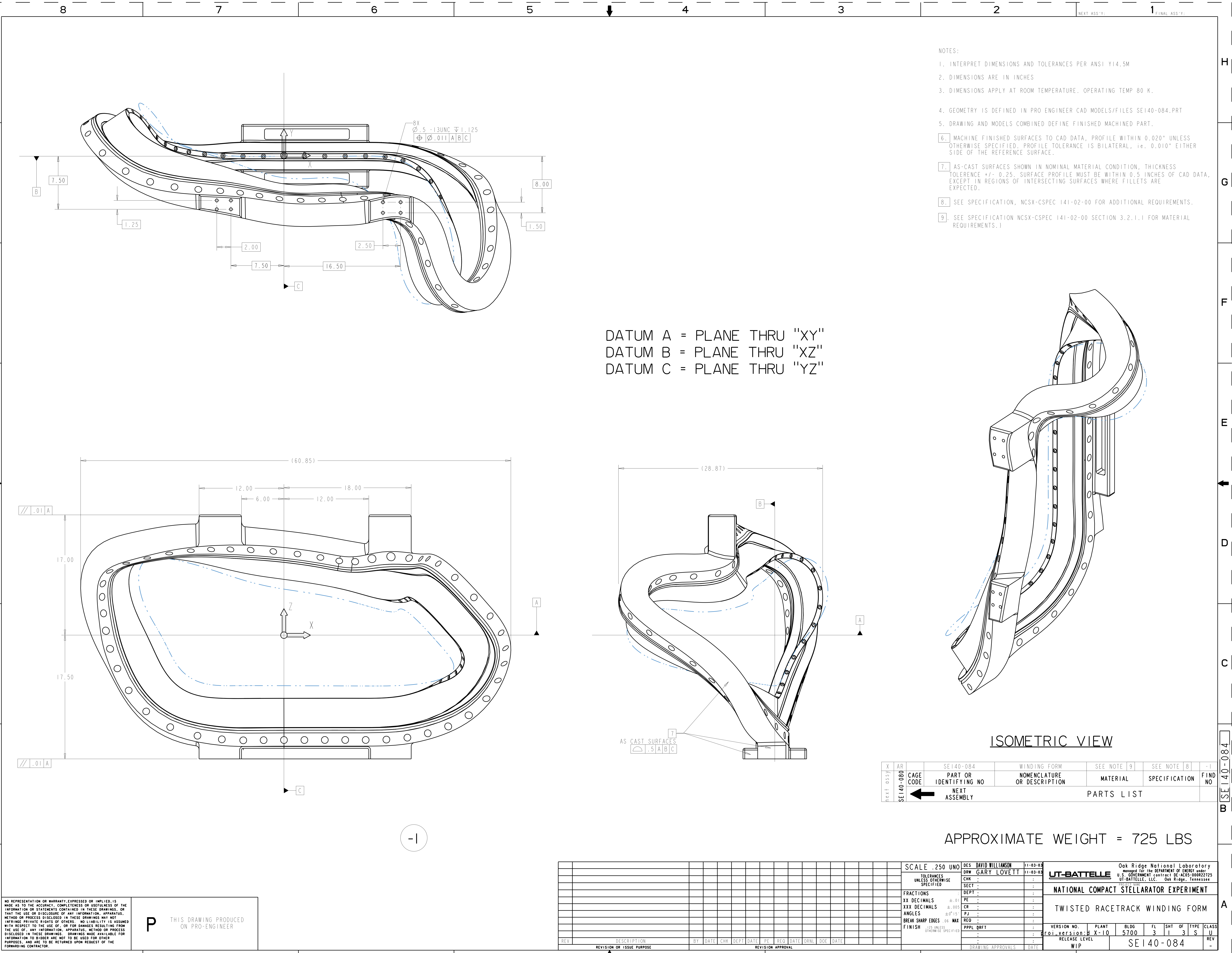
REV	DESCRIPTION	BY	DATE	CHK	DEPT	DATE	PE	REQ	DATE	ORNL	DOE	DATE

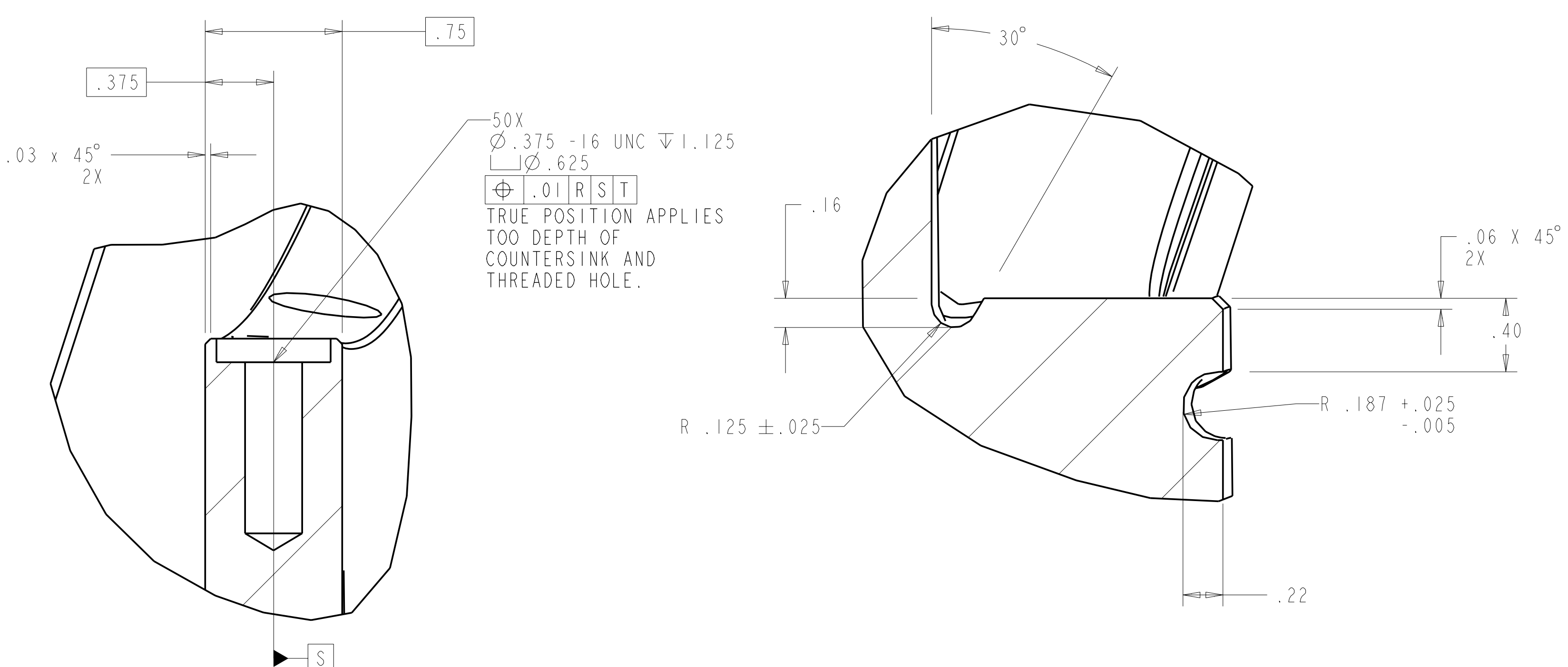
SCALE .250 UNO	DES DAVID WILLIAMSON	11-03-03
TOLERANCES UNLESS OTHERWISE SPECIFIED	DRW GARY LOVETT	11-03-03
FRACTIONS	CHK :	
XX DECIMALS ±.01	SECT :	
XXX DECIMALS ±.005	DEPT :	
ANGLES ±0°15'	PE :	
BREAK SHARP EDGES .06 MAX	CR :	
FINISH .125 UNLESS OTHERWISE SPECIFIED	PJ :	
	RD :	
	PPPL DRFT :	

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	
TWISTED RACETRACK WINDING FORM	
VERSION NO.	PLANT

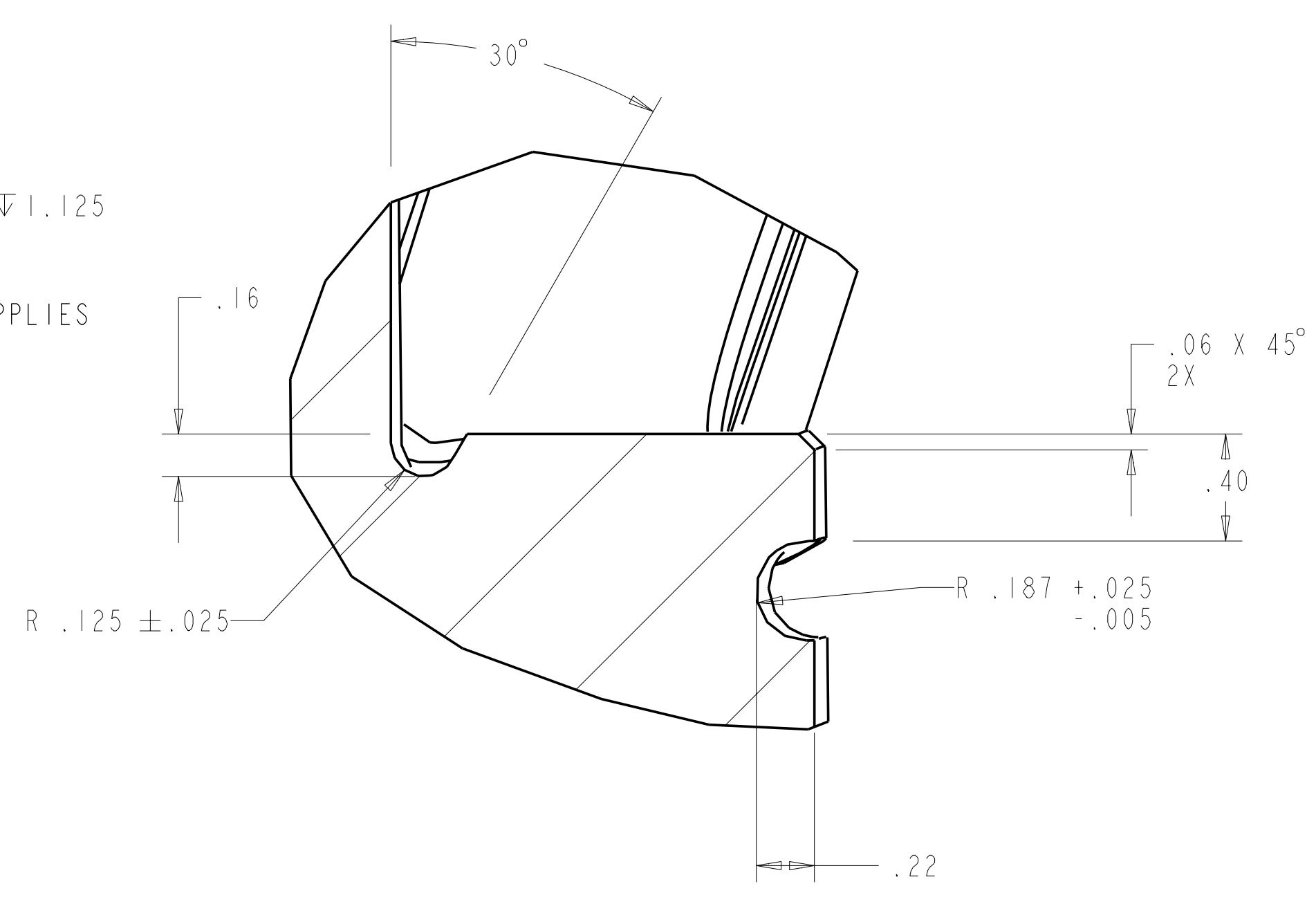
NO REPRESENTATION OR WARRANTY, EXPRESSED OR IMPLIED, IS MADE AS TO THE ACCURACY, COMPLETENESS OR USEFULNESS OF THE INFORMATION OR STATEMENTS CONTAINED IN THESE DRAWINGS, OR THAT THE USE OR DISCLOSURE OF ANY INFORMATION, APPARATUS, METHOD OR PROCESS DISCLOSED IN THESE DRAWINGS MAY NOT INFRINGE PRIVATE 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

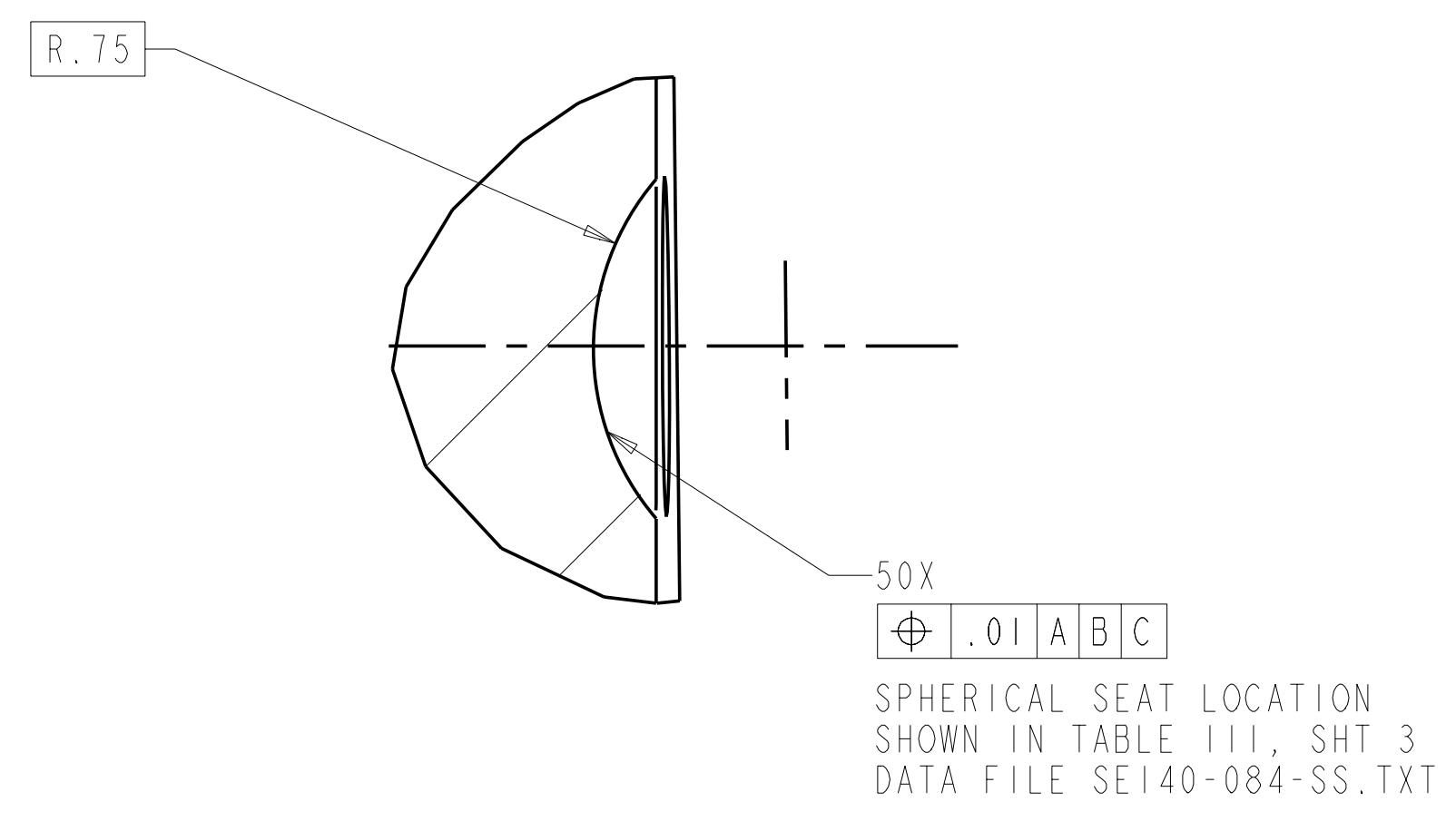




DETAIL 1
SCALE 2.0

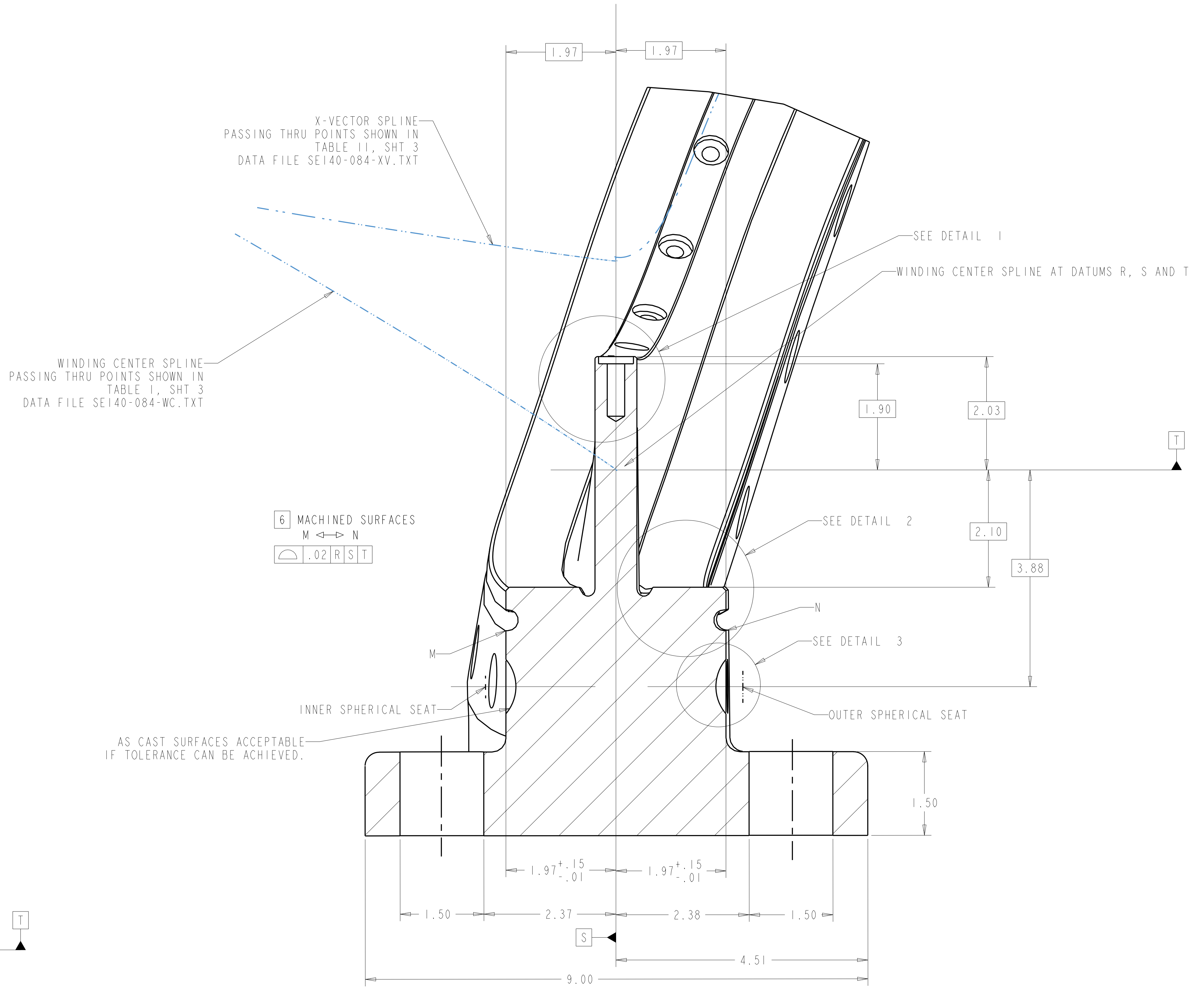
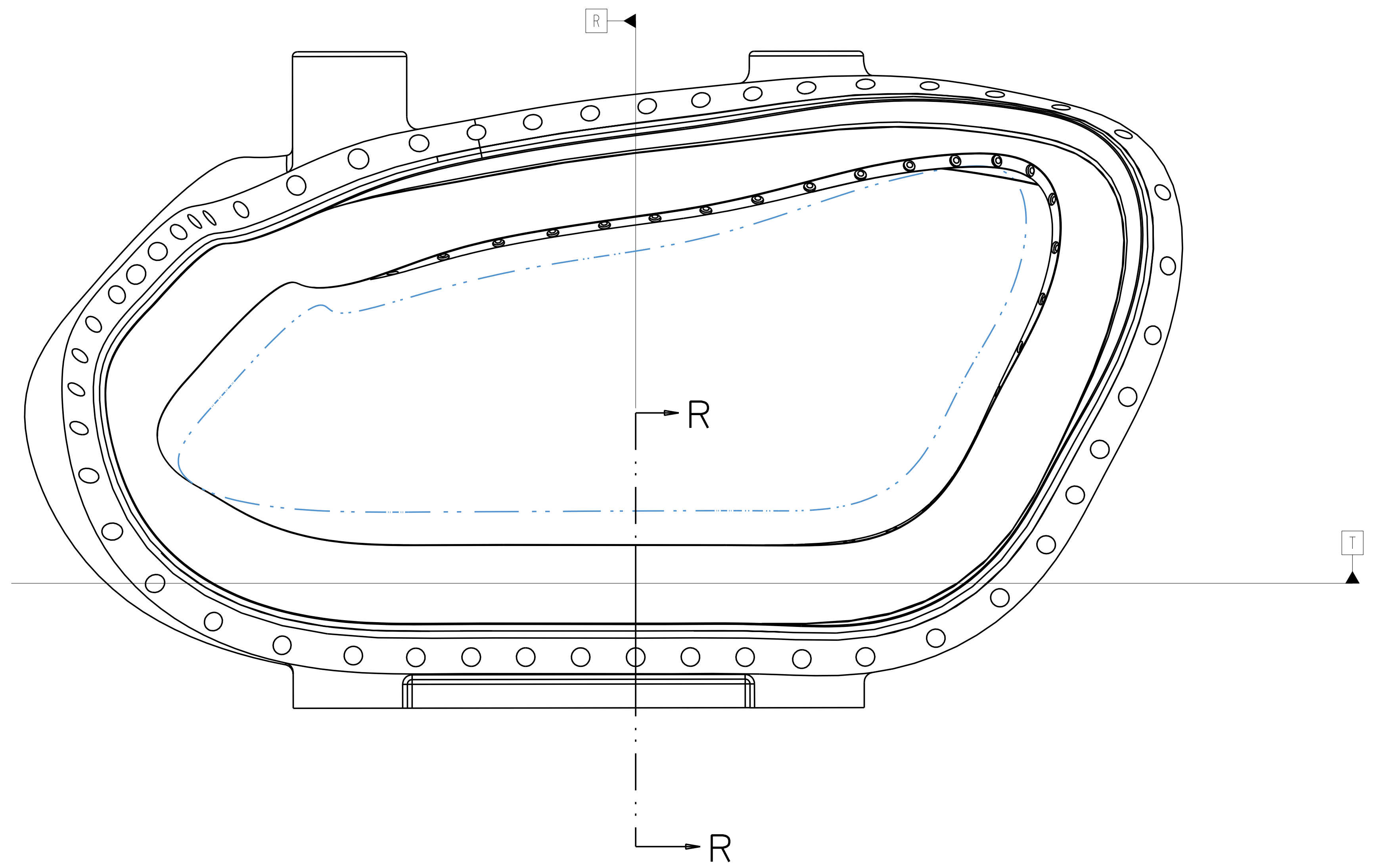


DETAIL 2
SCALE 2.0
VPI GROOVE TO BE MACHINED BY
BALL END MILL OR DISC CUTTER IF
SAME TOLERANCE CAN BE ACHIEVED.



DETAIL 3
SCALE 2.0

DATUM R = PLANE NORMAL TO WINDING CENTER
 DATUM S = PLANE PASSING THRU WINDING CENTER AND
 X-VECTOR AT DATUM R
 DATUM T = PLANE PASSING THRU WINDING CENTER ORTHOGONAL
 TO DATUM S



SECTION R-R
SCALE 1.0
APPLIES AT ALL POINTS
ALONG WINDING CENTER

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	
10	X-10	5700	3	2 3	S	U	
RELEASE LEVEL	SE140-084						REV
WIP							-

SE140-084

