

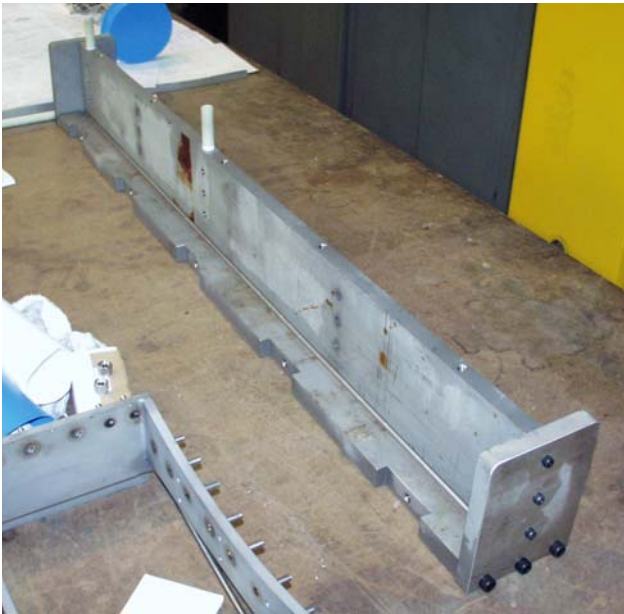
***NCSX***

**Photo Gallery  
Modular Coil R&D Activities**

**Straight Tee Section  
Preparation and VPI**

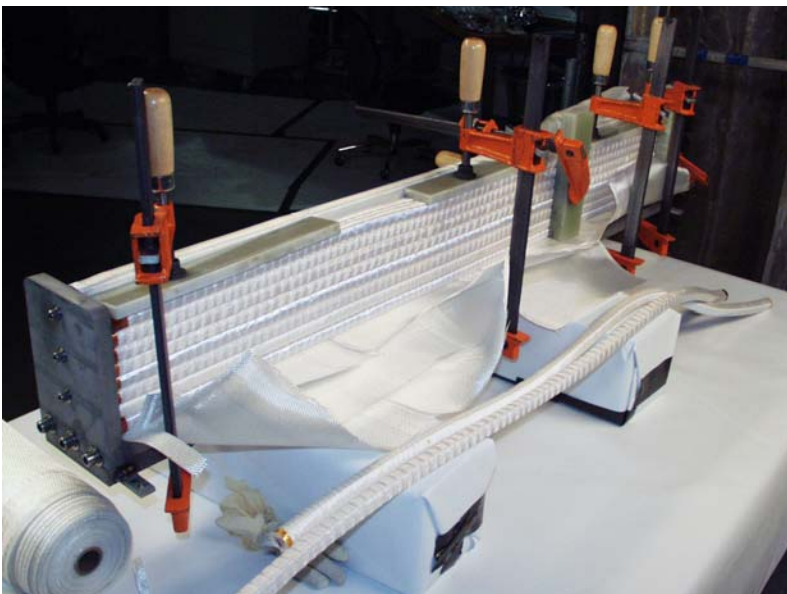
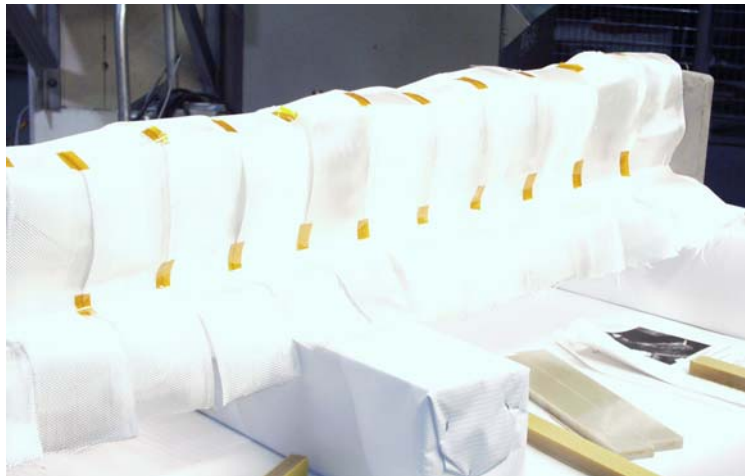
James H. Chrzanowski  
March 11, 2003

**NCSX- Photo Gallery of Straight Tee Section VPI**



**Straight Tee Section Winding Form Ready for Ground Wrap Insulation- Figure 1**

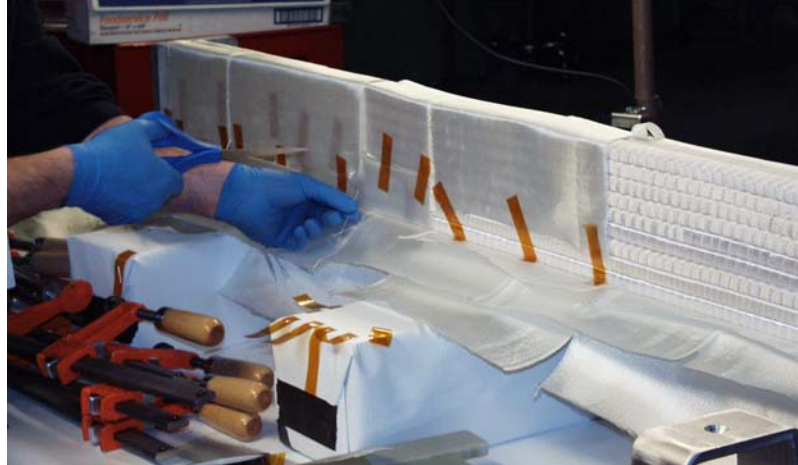
**Ground Wrap Placed onto Tee Section- Figure 2**



**(18) Individually Insulated Copper Rope Conductors placed onto each side of Tee Section Figure 3**

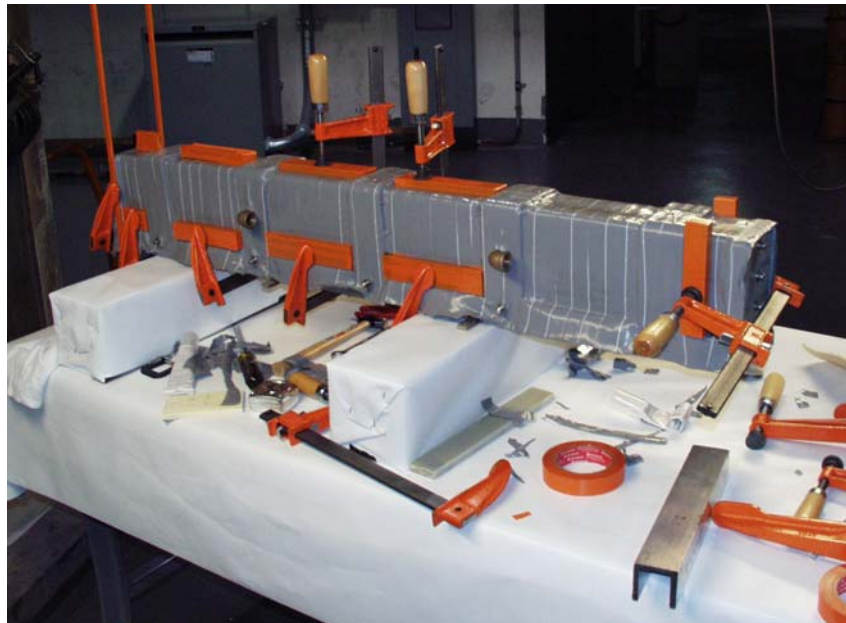
**NCSX- Photo Gallery of Straight Tee Section VPI**

Outer Ground Wrap  
Insulation Wrapped  
Over Turns Bundle –  
**Figure 4**

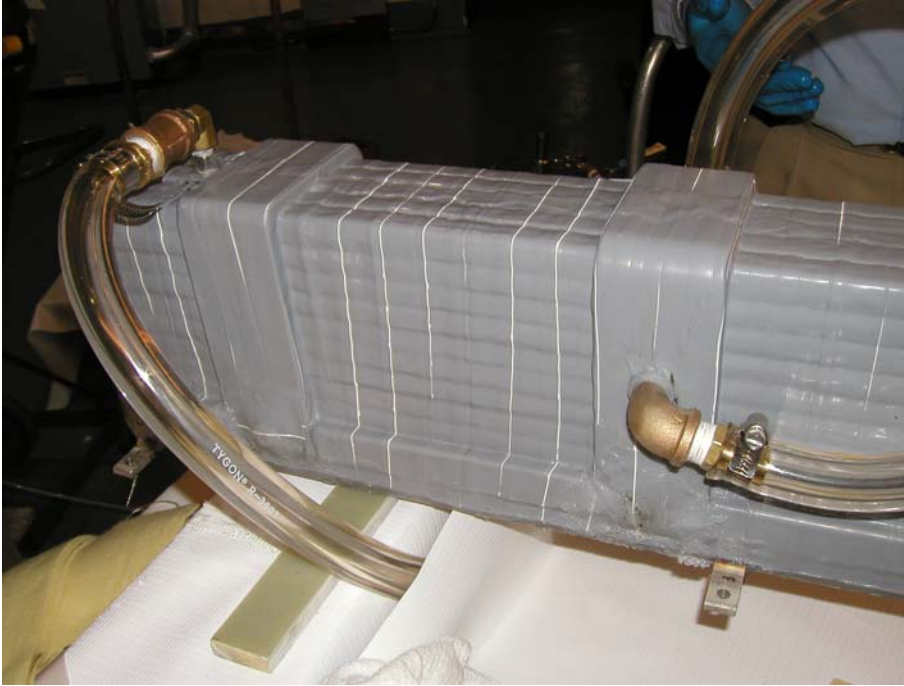


18 Insulated Turns in  
Position on Tee Section  
–**Figure 5**

Silicone Rubber  
Tape (Bag Mold)  
placed over  
Ground Wrap and  
Coil Clamps. –  
**Figure 6**

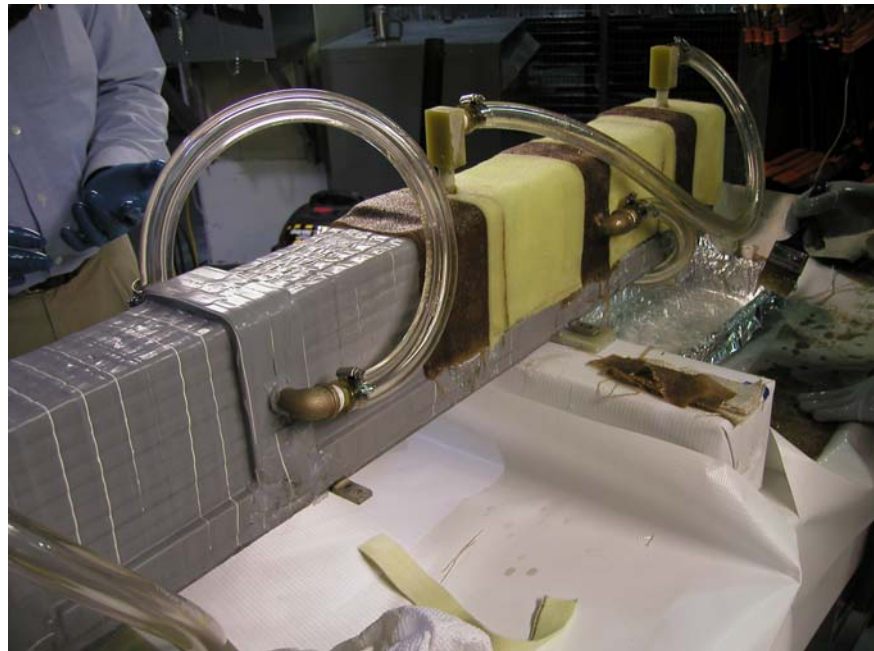


**NCSX- Photo Gallery of Straight Tee Section VPI**



Epoxy Feed Spues  
installed and Bag Mold  
Pumped Down-  
**Figure 7**

Begin  
Installation of  
Outer  
Epoxy/Glass  
Shell- **Figure 8**



**NCSX- Photo Gallery of Straight Tee Section VPI**



Installation of Outer Epoxy Shell (Strong back) is complete. Reinforcement bars placed on edge of mold to secure seams  
**Figure 9**

Edge View of Mold Ready for Oven and VPI  
**Figure 10**



*NCSX- Photo Gallery of Straight Tee Section VPI*

Vacuum Impregnated  
Bundle (18) turns from  
Tee Section- March 11,  
2003  
**Figure 11**

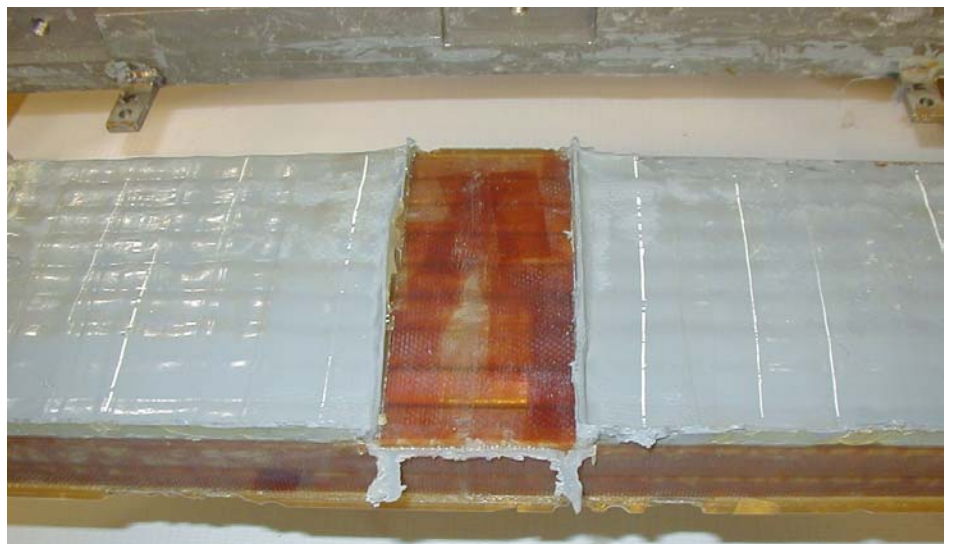


**NCSX- Photo Gallery of Straight Tee Section VPI**

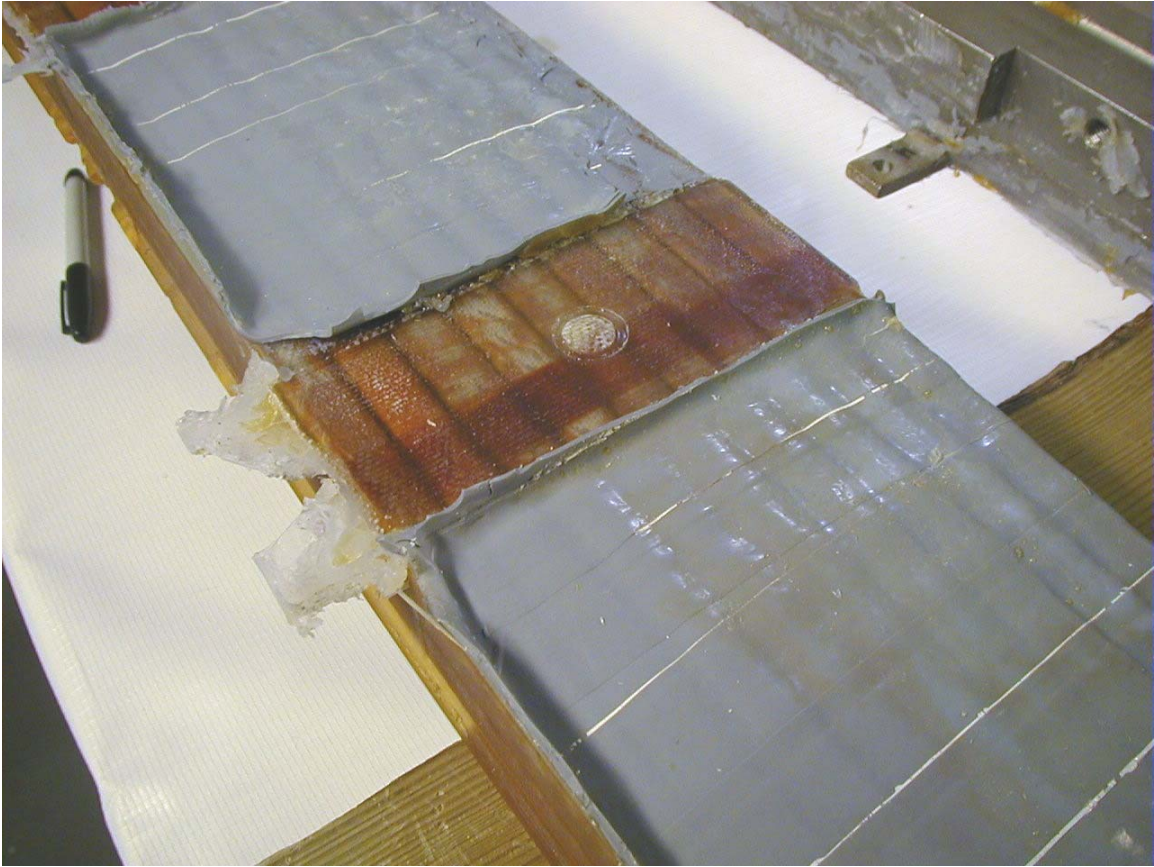


Vacuum Impregnated  
Bundle (18) turns from  
Tee Section- March 11,  
2003  
**Figure 12**

Impregnated Tee Section  
Area under Coil Clamp  
with partial bag mold in  
place **Figure 13**



**NCSX- Photo Gallery of Straight Tee Section VPI**



Impregnated Tee Section -Area under Coil Clamp with partial bag mold in place - **Figure 14**