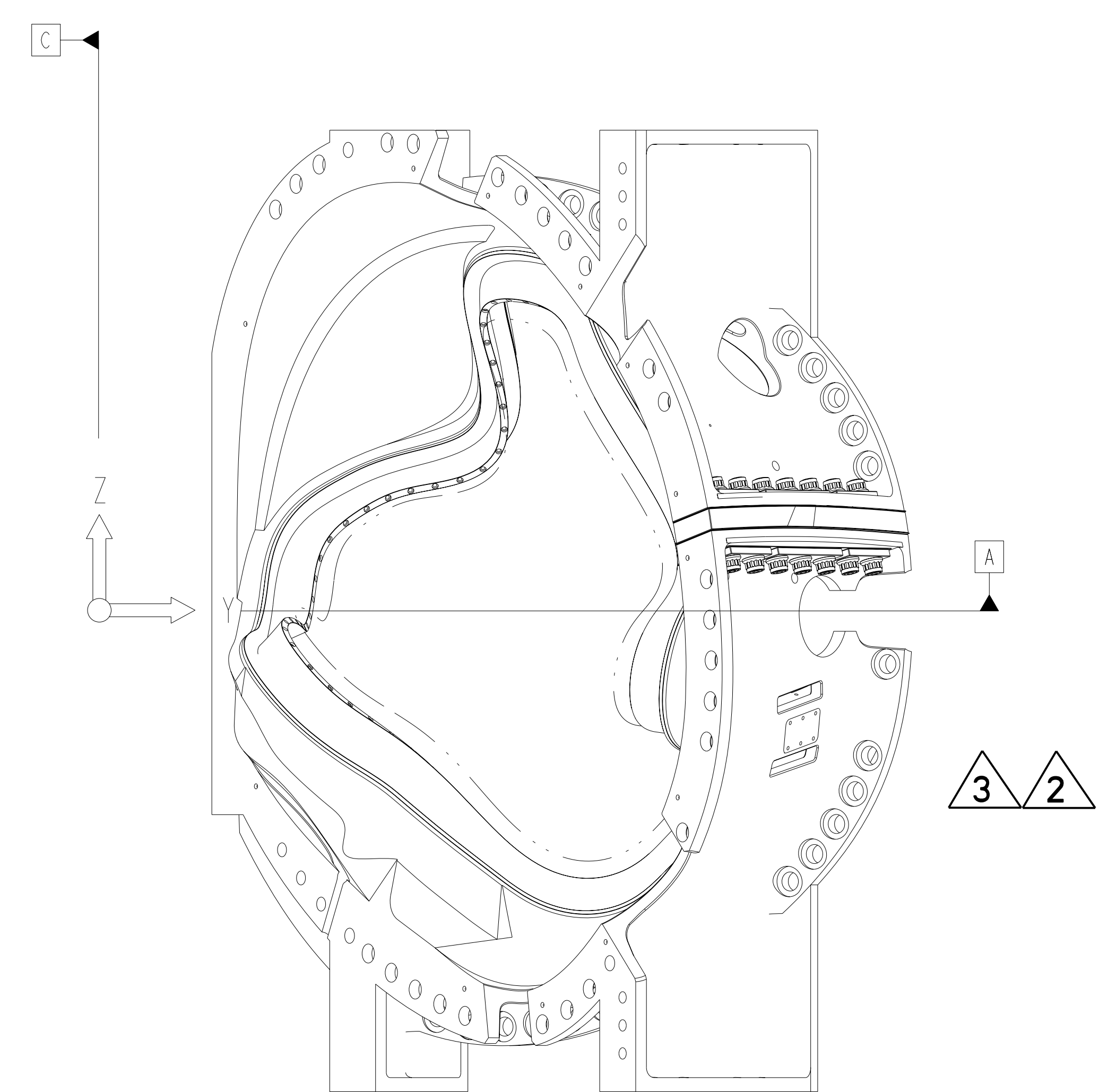
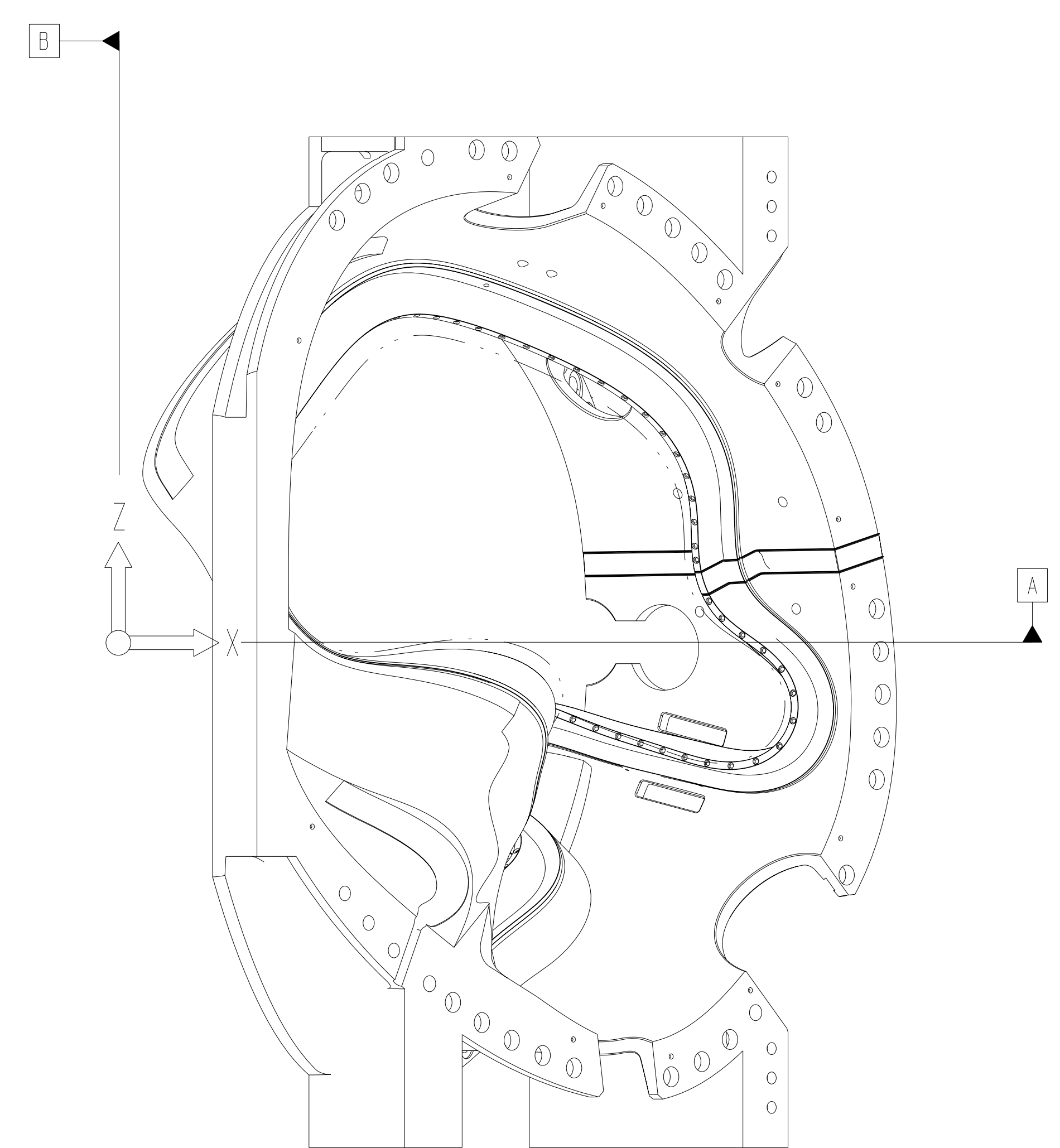
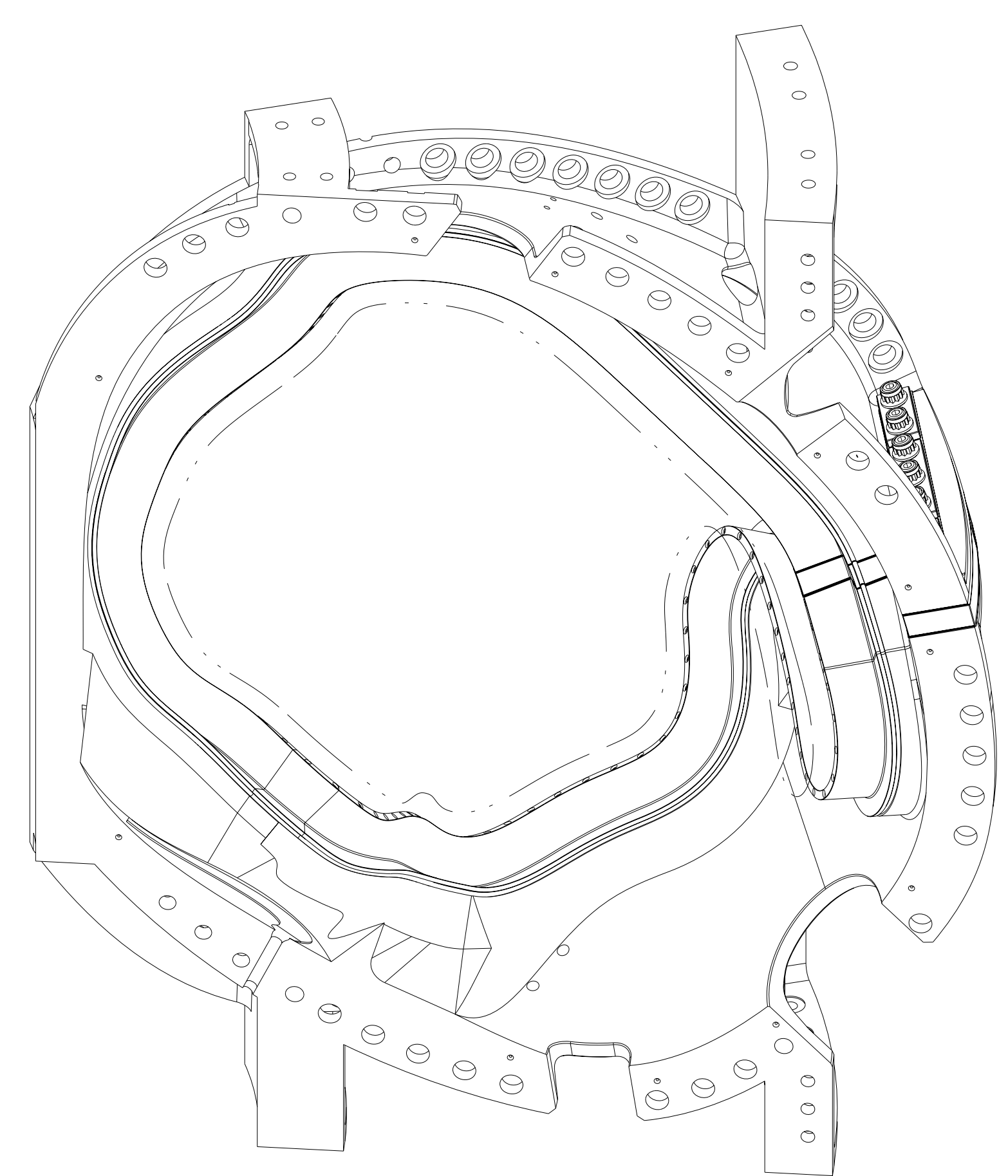
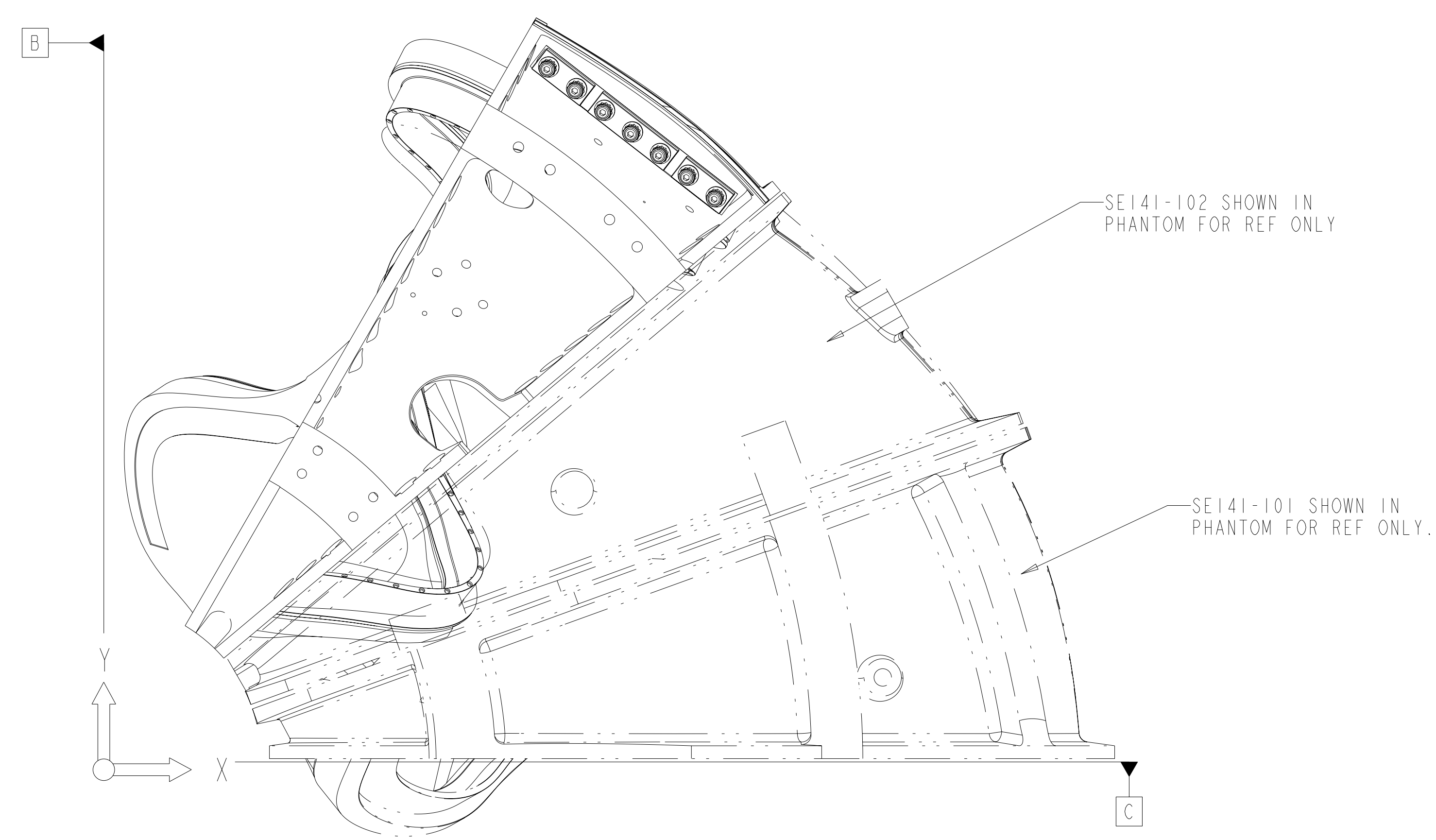


- NOTES:
- DRAWING PREPARED IN ACCORDANCE WITH ASME Y14.8M-1996.
 - INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M-1994.
 - DIMENSIONS ARE IN INCHES.
 - DRAWING DEPICTS FINAL MACHINED STATE OF ASSEMBLY DEFINED BY PRO/ENGINEER FILE SEI41-103.ASM.
 - UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE RELATED 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).
 - DIMENSIONS AND TOLERANCES EXCLUDE PROCESS MATERIAL ALLOWANCES WHICH MAY ADD MASS.
 - APPROXIMATE WEIGHT = 5080 LBS.
 - MATCH DRILL OR BEAM TO ACHIEVE RUNNING FIT BETWEEN PARTS AND ASSEMBLY.
 - LUBRICATE THREADED SURFACES WITH THRED-GARD ANTI-SEIZE COMPOUND FROM FEDERAL PROCESS CORP, CLEVELAND, OH
 - SEE LATEST REVISION OF SPECIFICATION NCSX-CSPEC-141-03 FOR ADDITIONAL REQUIREMENTS.
 - BOND INSULATING SLEEVE (F/N 5) TO WINDING FORM (F/N 2) USING LOCTITE 411 PER MANUFACTURER'S INSTRUCTIONS.
 - ITEM NO. 4 HOLE DIAMETERS TO MATCH OD OF ITEM NO. 6 PLUS .001 TO .002 FOR CLEARANCE FIT
 - ITEM NO. 7 MAY BE DIVIDED INTO TWO PARTS IF NECESSARY. HOLE DIAMETERS TO MATCH OUTER DIA OF ITEM NO. 5 PLUS .001 TO .002 FOR CLEARANCE FIT.
 - TORQUE ITEM NO. 8 TO 1500 +/-30 FT-LBS.



RELEASED FOR FABRICATION / INSTALLATION
PPPL Drafting:

REV	DESCRIPTION	BY	DATE	CHK	DEPT	DATE	PE	REQ	DATE	ORNL	DOE	DATE	REVISION APPROVAL
3	REVISED ASM AND DRAWING PER ECN-5026	GLL	10/05	MJC			DEW						
2	REVISED ASSEMBLY AND DRAWING PER ECN 5009	GLL	7/05	MJC			DEW						
1	REVISED F/N 2 PER ECN-4903	DW	9/04	MJC			DEW						

REV	DESCRIPTION	BY	DATE	CHK	DEPT	DATE	PE	REQ	DATE	ORNL	DOE	DATE	REVISION APPROVAL
2	BEARING PLATE, LONG												
4	BEARING PLATE, SHORT												
14	DSI41-060												
2	-7												
7	DSI41-036												
14	-5												
2	-4												
1	SEI41-078												
1	SEI41-116												
AR	X												

CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPECIFICATION	FIND NO
SEI41-103		MOD COIL WINDING FORM ASSEMBLY TYPE-C		

REV	DESCRIPTION	BY	DATE	CHK	DEPT	DATE	PE	REQ	DATE	ORNL	DOE	DATE	REVISION APPROVAL
3	REVISED ASM AND DRAWING PER ECN-5026	GLL	10/05	MJC			DEW						
2	REVISED ASSEMBLY AND DRAWING PER ECN 5009	GLL	7/05	MJC			DEW						
1	REVISED F/N 2 PER ECN-4903	DW	9/04	MJC			DEW						

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P THIS DRAWING PRODUCED ON PRO-ENGINEER

SCALE NOTED
TOLERANCES UNLESS OTHERWISE SPECIFIED

DES: T BROWN 6-30-04
DRW: G LOVETT 6-30-04
CHK: M COLE 6-30-04

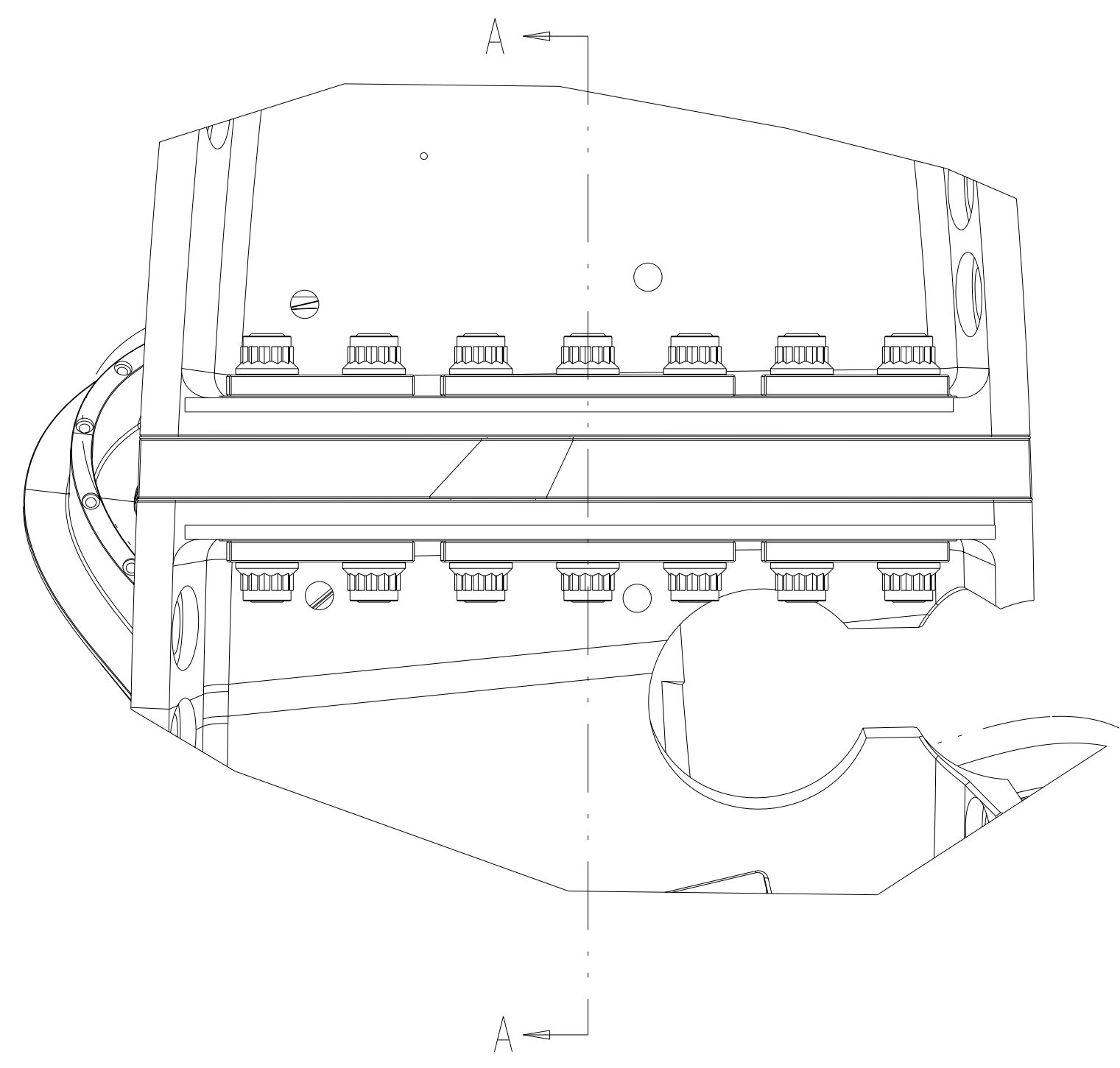
FRACTIONS: :
XX DECIMALS: ±.01
XXX DECIMALS: ±.005
ANGLES: ±0°15'
BREAK SHARP EDGES: 04 MAX
FINISH: .125 UNLESS OTHERWISE SPECIFIED

PPPL DRFT: J SIEGEL 6-30-04

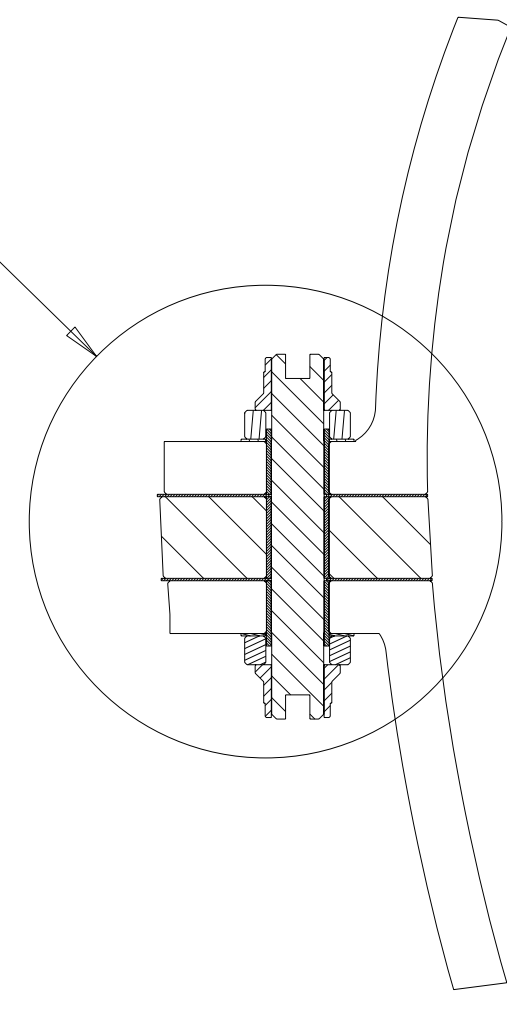
Oak Ridge National Laboratory managed for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT contract DE-AC05-00OR22725 UT-BATTELLE, LLC, Oak Ridge, Tennessee
PROJECT NAME: NATIONAL COMPACT STELLARATOR EXPERIMENT
MOD COIL WINDING FORM ASSEMBLY TYPE-C

VERSION NO.: B
PLANT: X-10
BLDG: 5700
FL: 3
SHT: 1
OF: 2
TYPE: S
CLASS: U
REV: 3

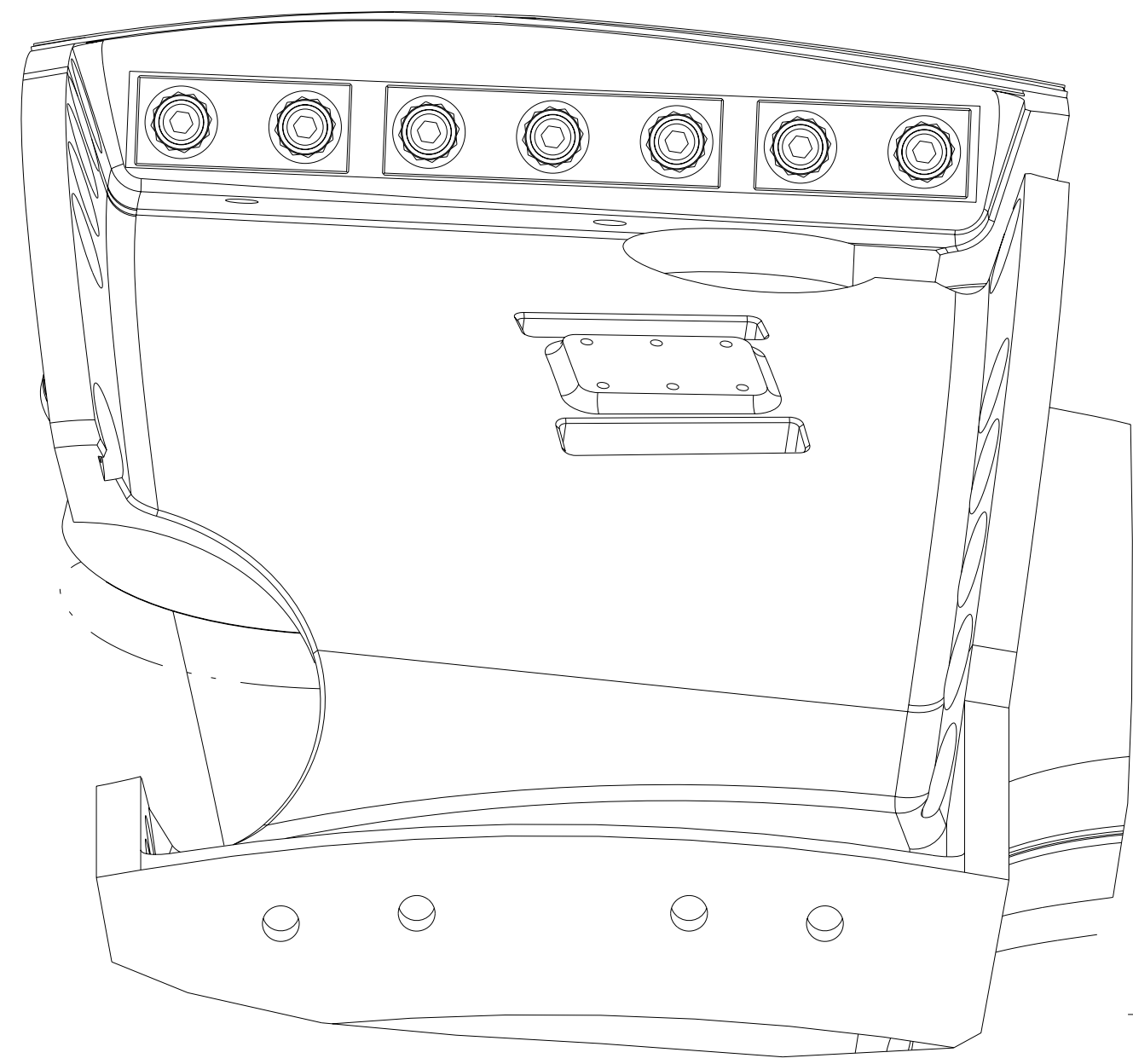
RELEASE LEVEL: SEI41-103
Fabrication



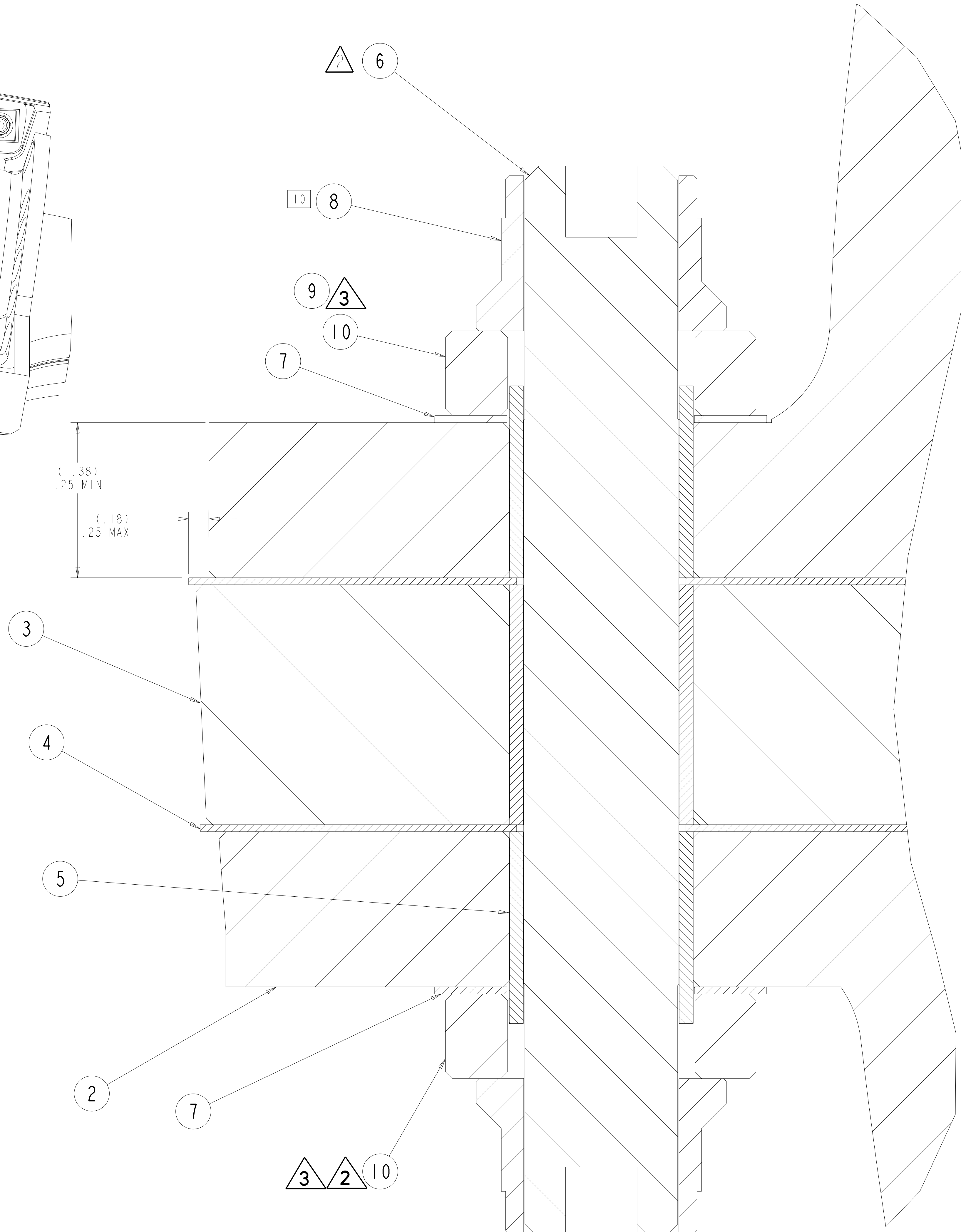
SEE DETAIL X



SECTION A-A
SCALE 0.20



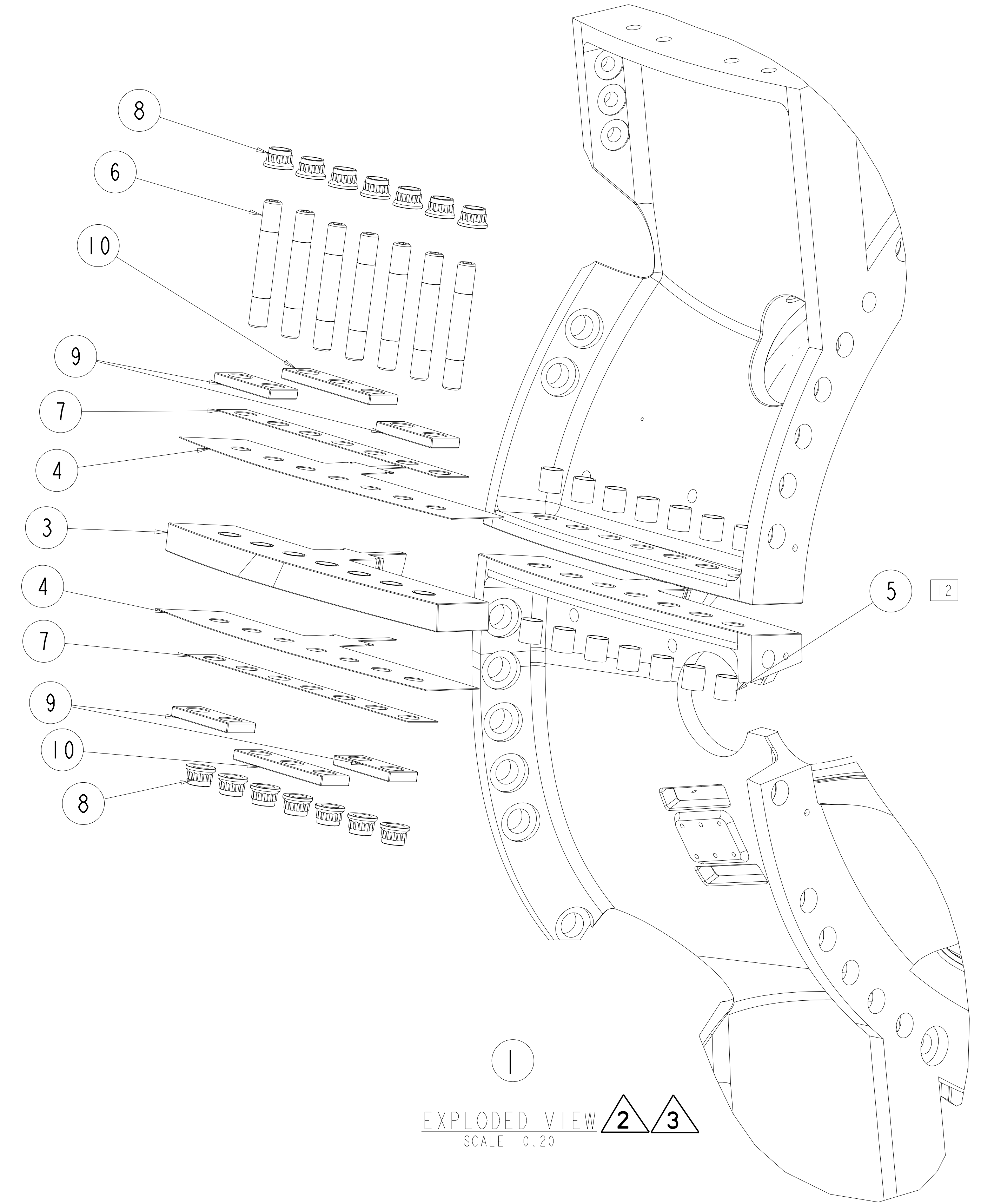
POLOIDAL BREAK DETAIL



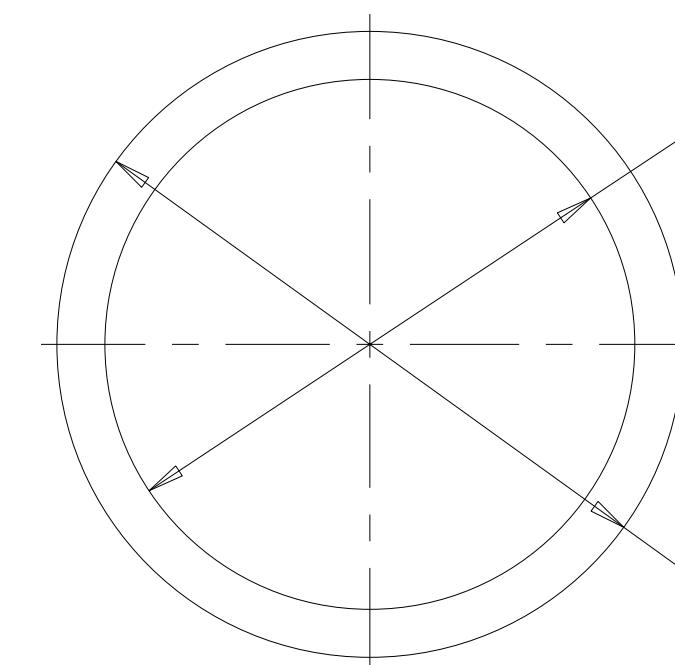
(1.38)
.25 MIN

(.18)
.25 MAX

DETAIL X
SCALE 2.00

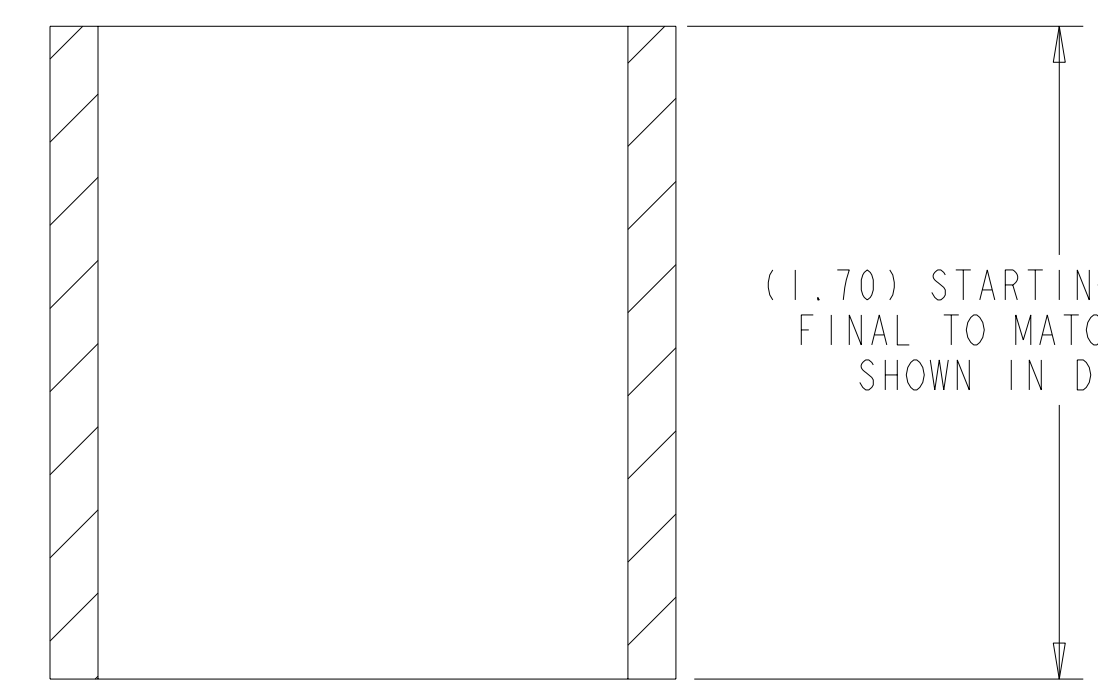
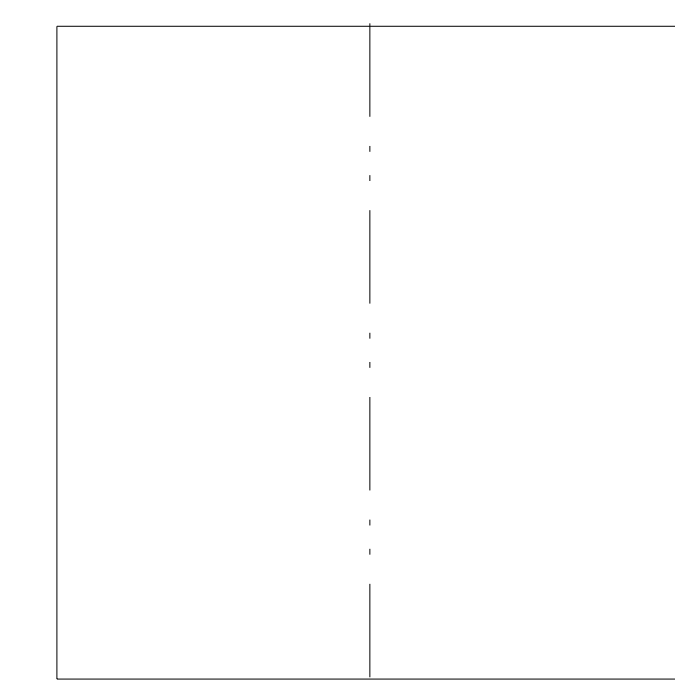


EXPLODED VIEW
SCALE 0.20



Ø1.38 REAM AT ASSEMBLY FOR
.001 TO .002 DIA CLEARANCE
WITH ITEM 6

Ø1.63 TO MATCH HOLE DIA
MINUS .001 TO .002 FOR
CLEARANCE FIT



(1.70) STARTING DIMENSION
FINAL TO MATCH OVERLAP
SHOWN IN DETAIL-X

SECTION B-B
SCALE 2.00

**RELEASED FOR
FABRICATION / INSTALLATION**
PPPL Drafting:

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	
PROJECT NAME NATIONAL COMPACT STELLARATOR EXPERIMENT			
MOD COIL WINDING FORM ASSEMBLY TYPE-C			
VERSION NO. 8	PLANT X-10	BLDG 5700	FL SHT OF TYPE CLASS 3 2 2 S U
RELEASE LEVEL Fabrication		SE141-103	
		REV 3	

01-103