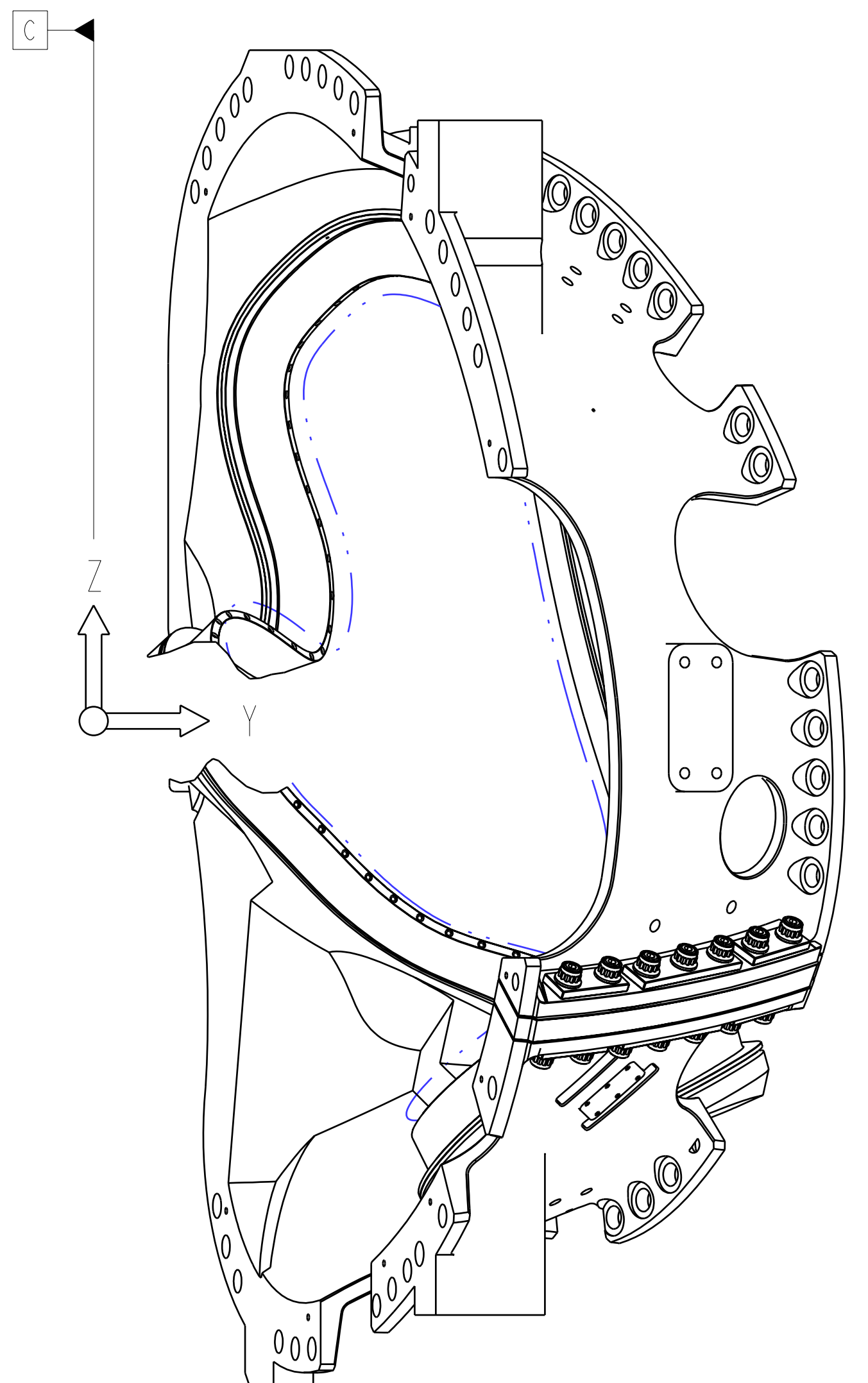


ISOMETRIC VIEW
 SCALE 0.10

- 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 PART DEFINED BY PRO/ENGINEER FILE SE141-102.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 = 4950-LBS
 - MATCH DRILL OR REAM AS REQUIRED TO ACHIEVE RUNNING FIT BETWEEN PARTS AT 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) INTO 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 CLEARANCE FIT.
 - TORQUE ITEM NO.8 TO 1500 +/- 30 FT-LBS.



SCALE 0.10



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REV	DESCRIPTION	BY	DATE	CHK	DEPT	DATE	PE	REQ	DATE	ORNL	DOE	DATE
3	REVISED ASM AND DRAWING PER ECN 5059	GLL	12/08	MJC			DEW					
2	REVISED ASSEMBLY AND DRAWING PER ECN 5009	GLL	7/08	MJC			DEW					
1	REVISED F/N 2 PER ECN-4903	DW	9/04	MJC			DEW					

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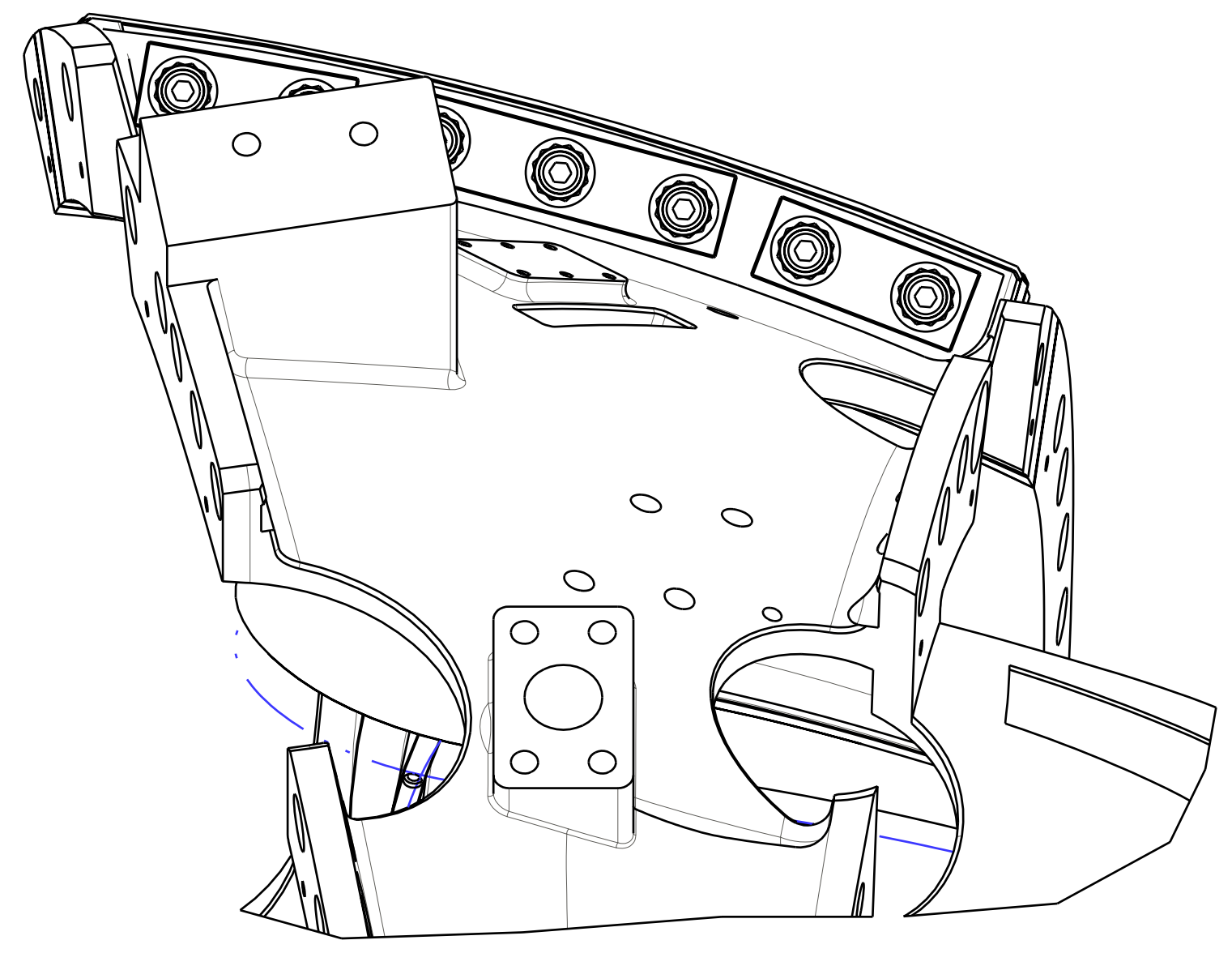
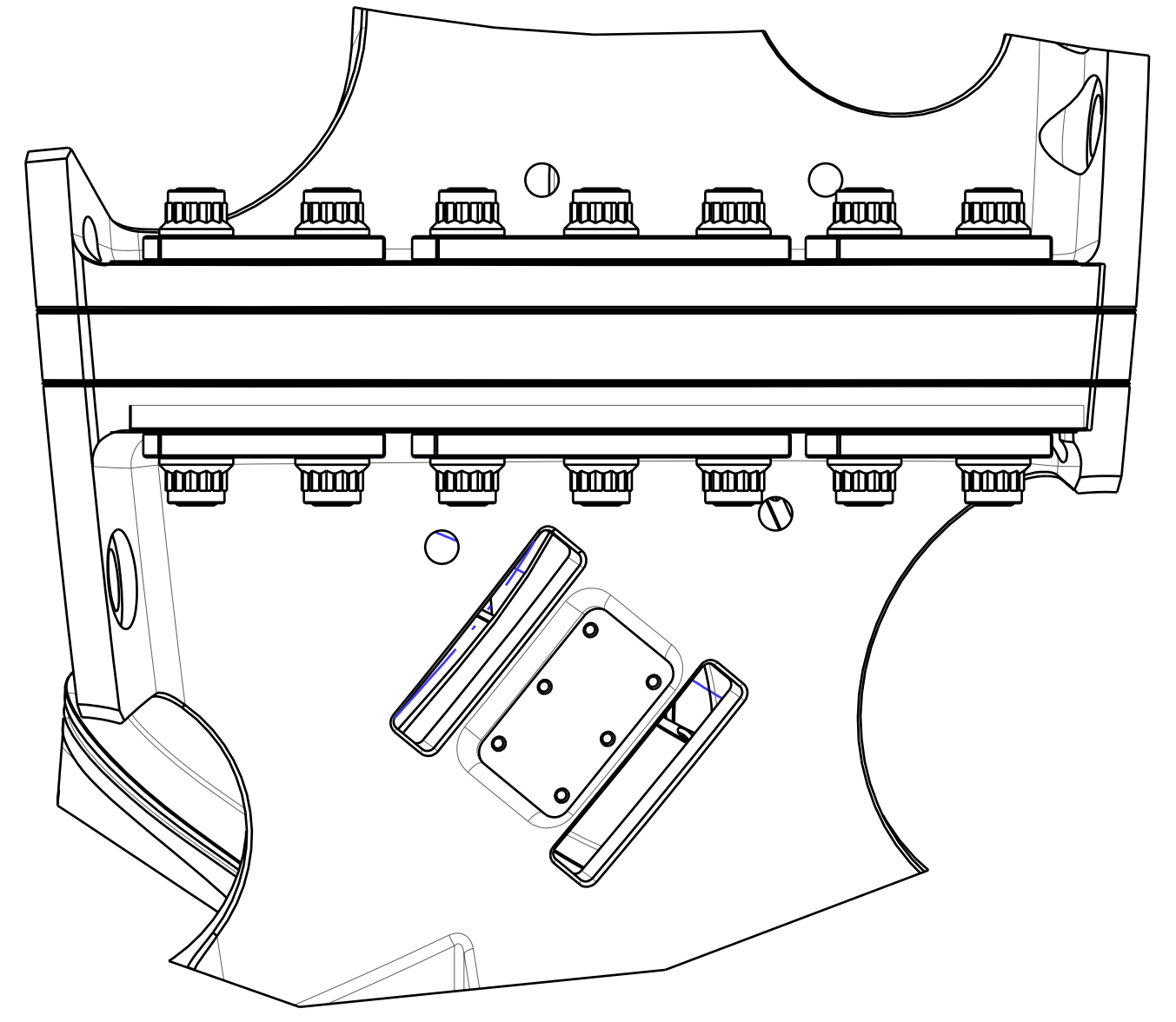
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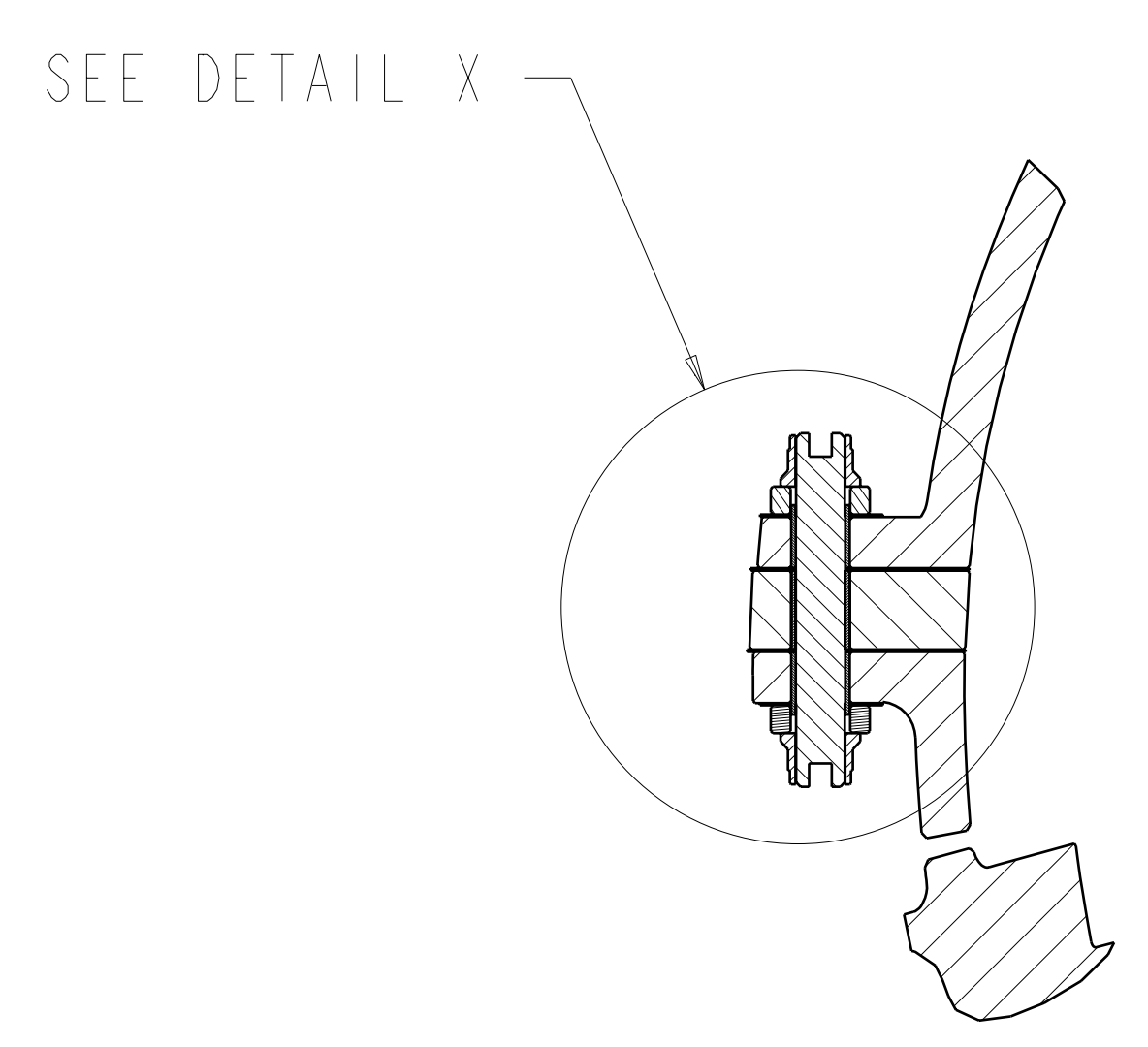
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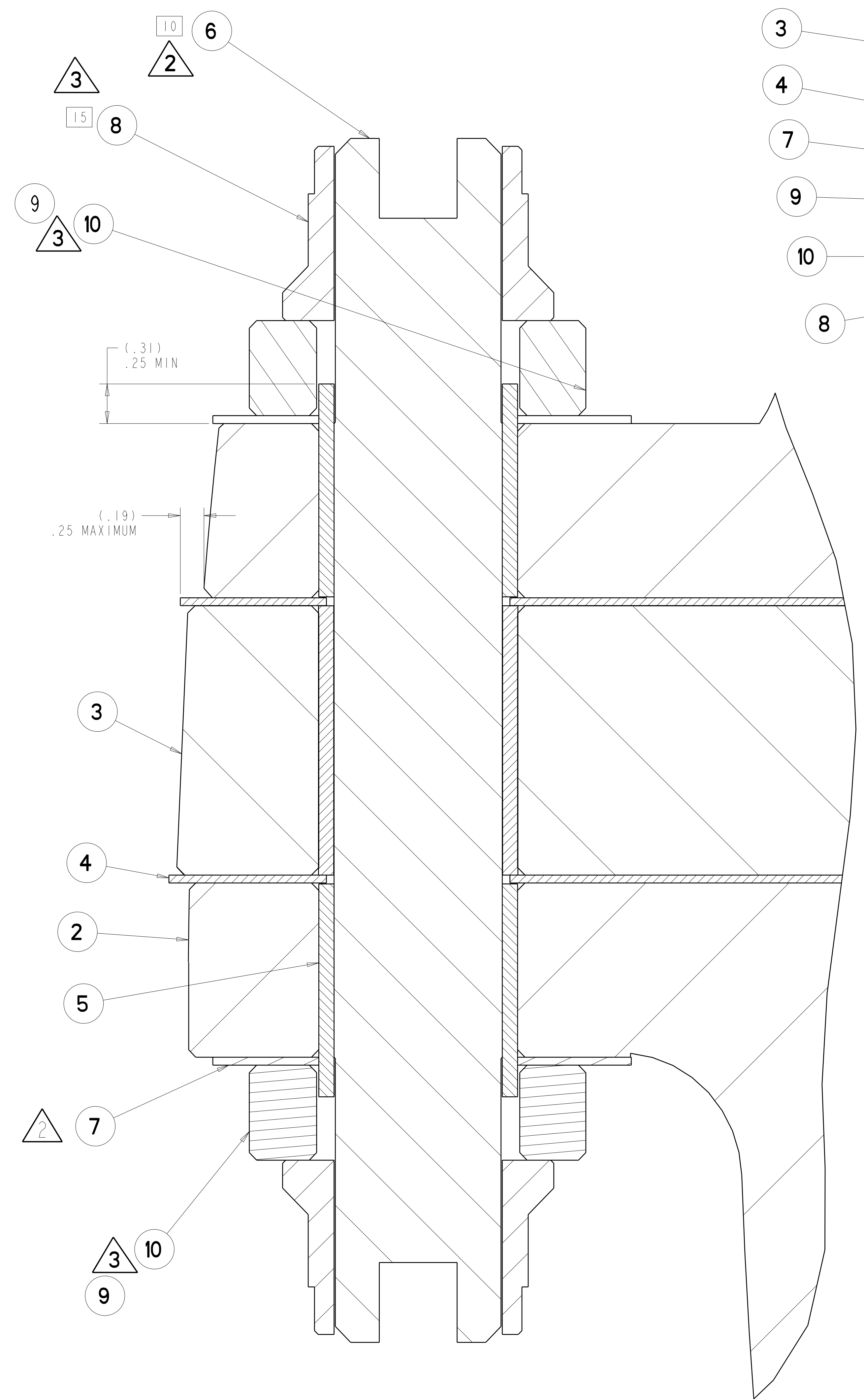
FOR NOTES AND PARTS LIST SEE SHEET 1



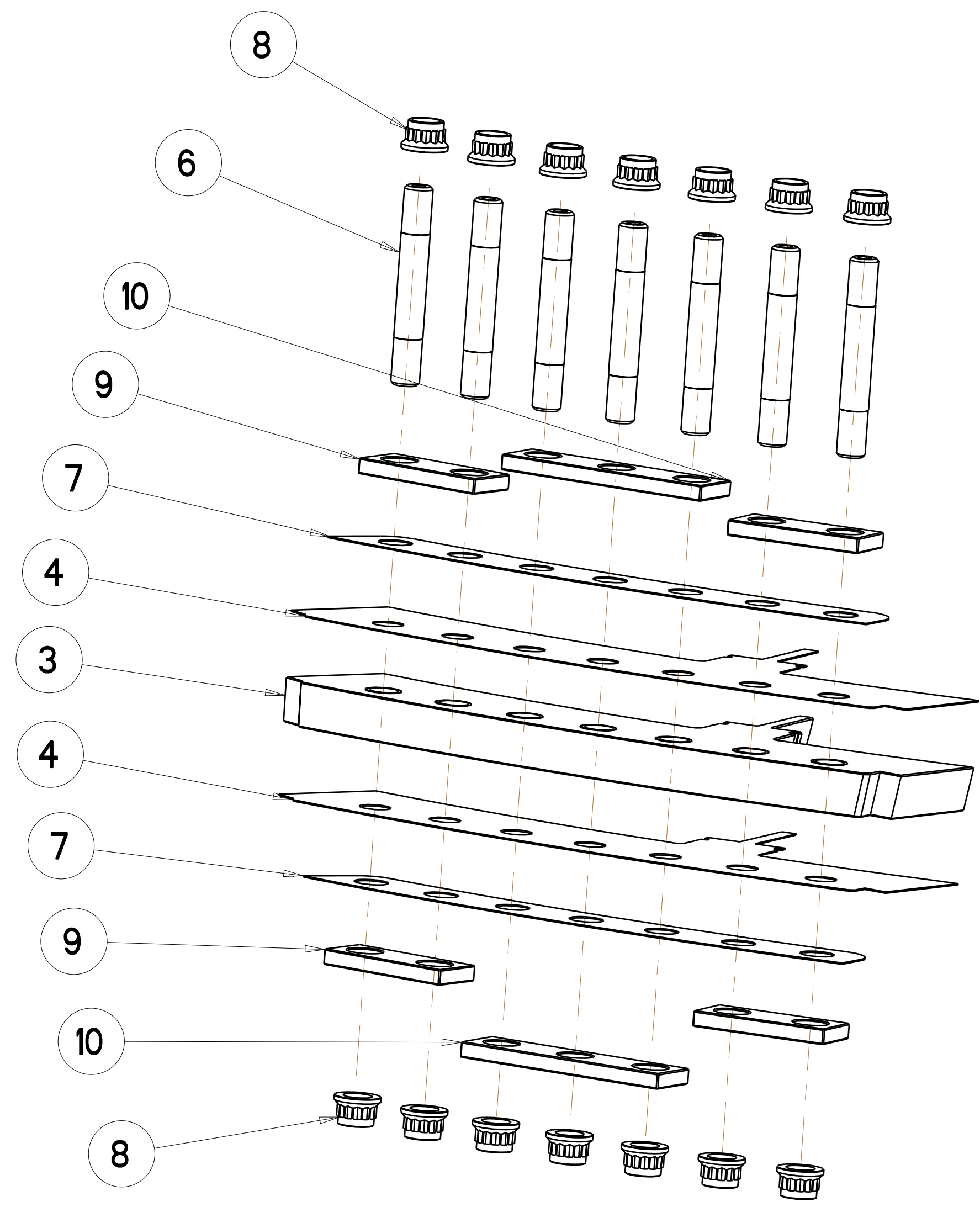
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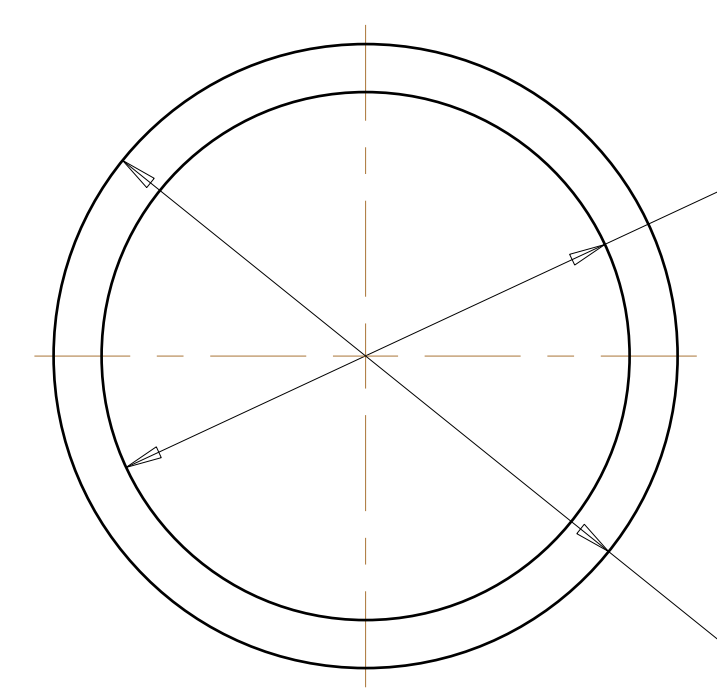
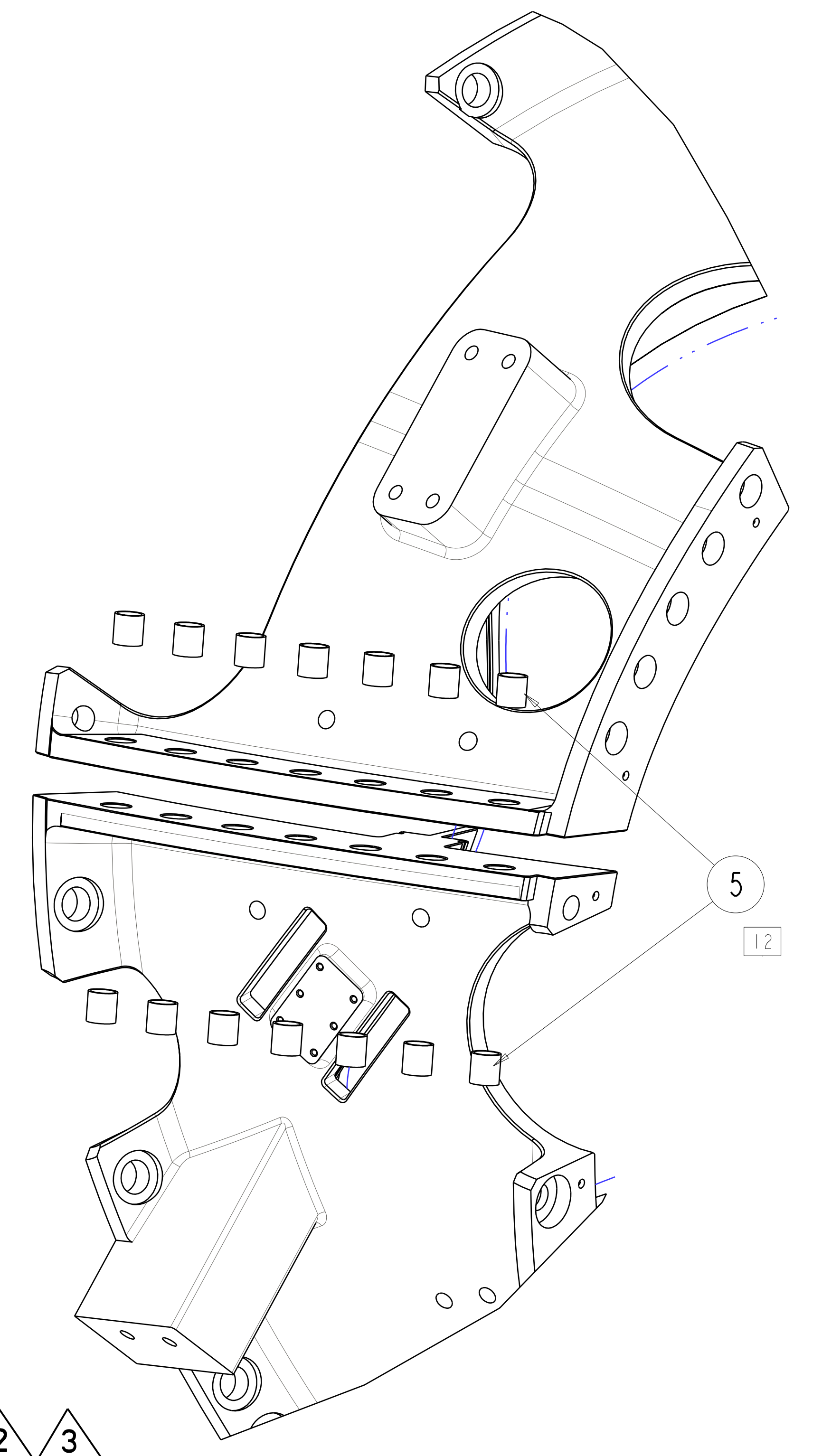
SECTION A-A
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DETAIL X
 SCALE 2.00

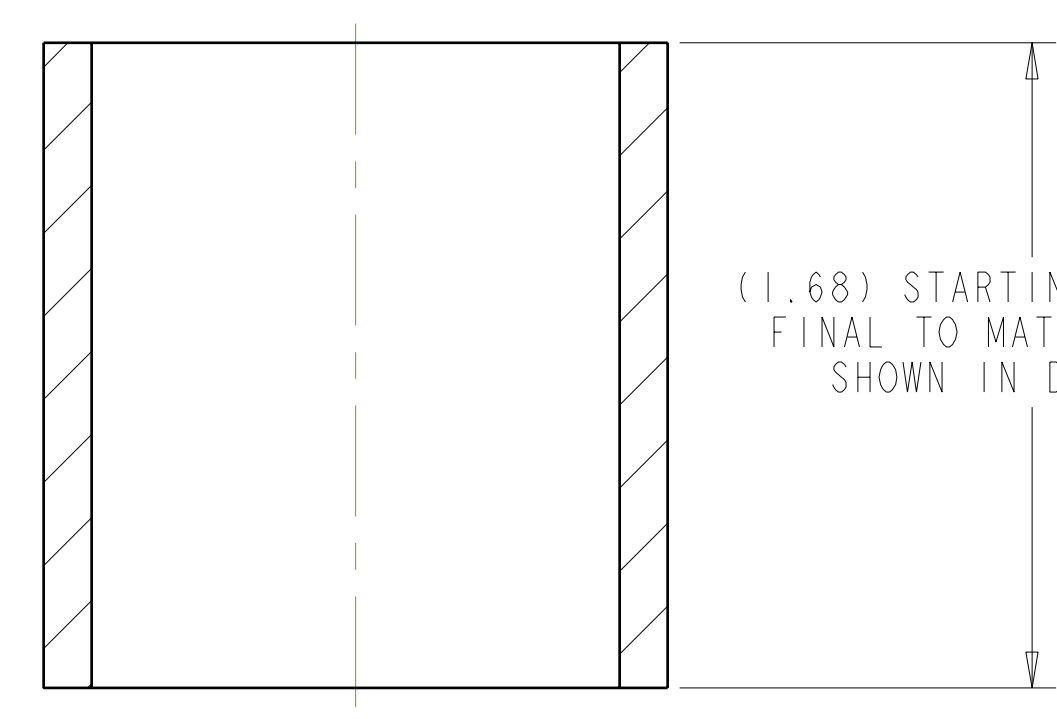
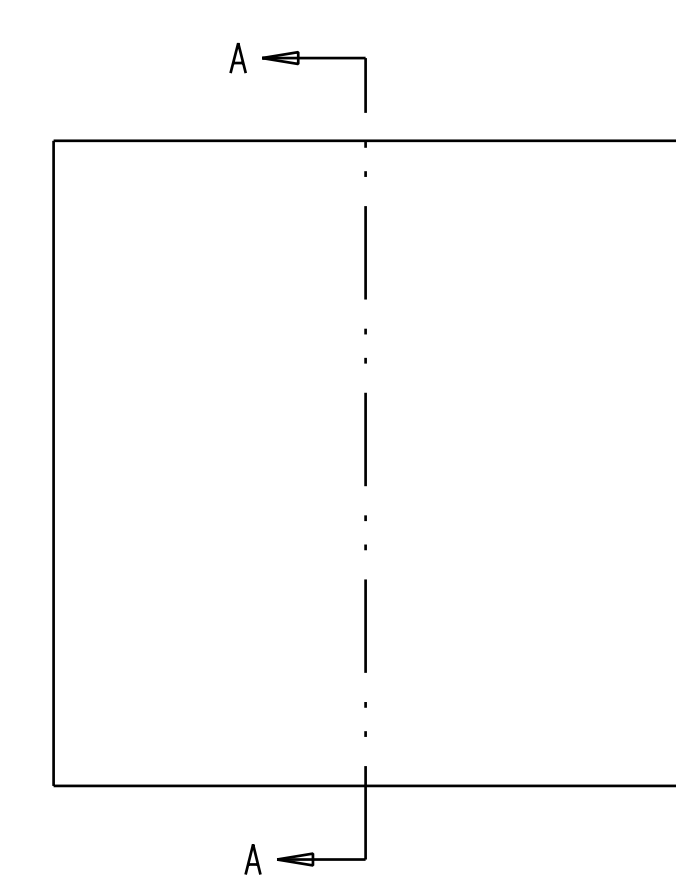


EXPLODED VIEW 2 3
 SCALE 0.200



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

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



SECTION A-A
 SCALE 200

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

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							
MOD COIL WINDING FORM ASSEMBLY TYPE-B							
VERSION NO.	PLANT	BLDG	FL	SHT OF	TYPE	CLASS	
4	X-10	5700	3	2	S	U	
RELEASE LEVEL	SEI41-102						REV
Fabrication							3

H
G
F
E
D
C
B
A

SEI41-102