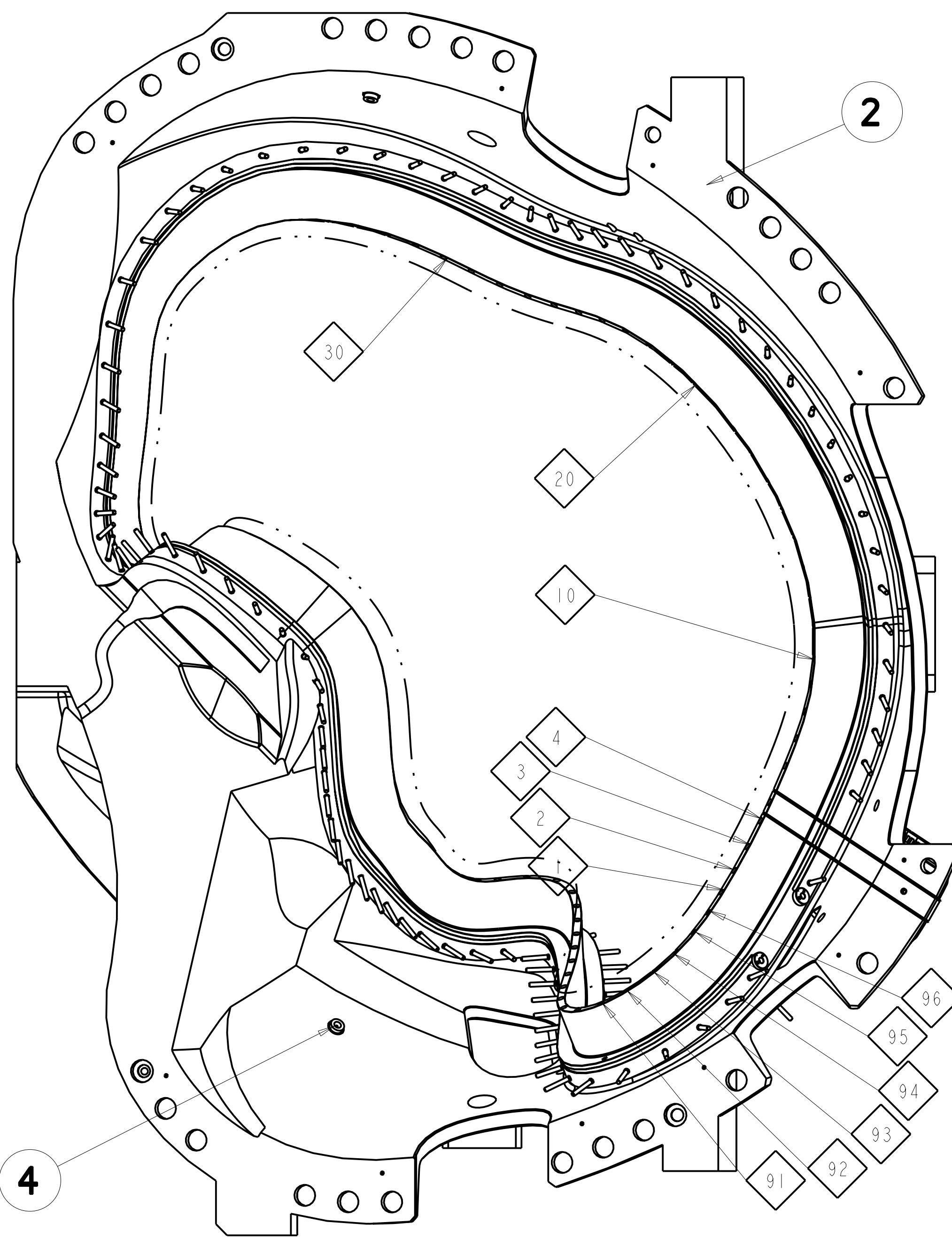
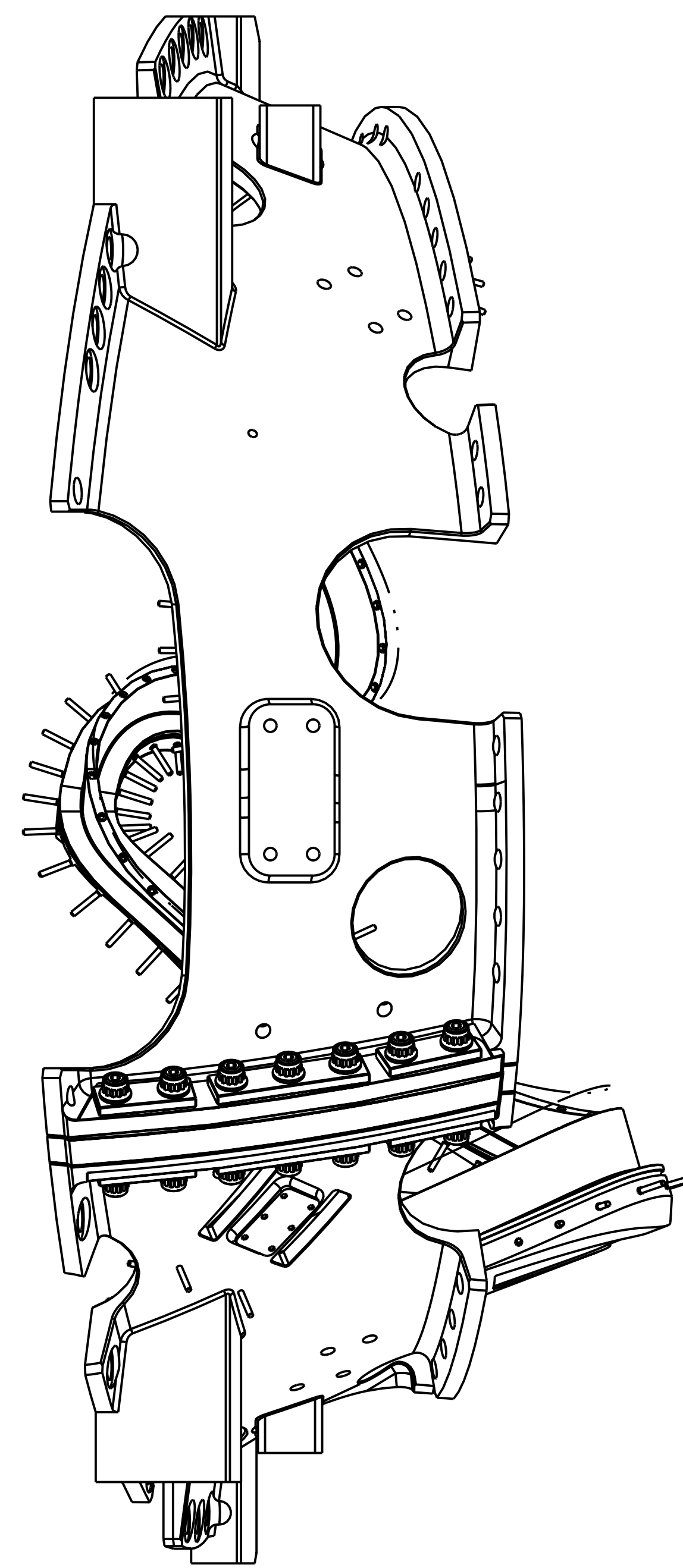


HOLE NUMBERING SEQUENCE
LEAD BLOCK AREA (TOP VIEW)
SCALE 0.38



1 WINDING FORM AND STUD ASM

SCALE 0.13



WELDING ENGINEER
APPROVED L. DUDEK DATE: 08/06

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 SE141-122.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)
- SEE LATEST REVISION OF PROCEDURE D-NCSX-MCF-001 FOR ADDITIONAL REQUIREMENTS.
- WELDING SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF PPPL PROCEDURE NO. ENG-037. VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH THE ACCEPTANCE CRITERIA OF AWS D1.6.

REV	DESCRIPTION	BY	DATE	CHK	DEPT	DATE	PE	REQ	DATE	ORNL	DOE	DATE
1												
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36												

7

SE141-102

CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
	-17	1" Ø STUD EXTENSION SIDE "A" MOUNT	UNS 31600	N/A	16
	-16	1" Ø STUD EXTENSION SIDE "A" MOUNT	UNS 31600	N/A	15
	-15	1" Ø STUD EXTENSION SIDE "A" MOUNT	UNS 31600	N/A	14
	-14	1" Ø STUD EXTENSION SIDE "B" MOUNT	UNS 31600	N/A	13
	-13	1" Ø STUD EXTENSION SIDE "B" MOUNT	UNS 31600	N/A	12
	-12	1" Ø STUD EXTENSION SIDE "B" MOUNT	UNS S31600	N/A	11
	-10	LEAD BLOCK MOUNT #4 (SIDE B LEFT)	UNS S31600	N/A	10
	-9	LEAD BLOCK MOUNT #3 (SIDE B RIGHT)	UNS S31600	N/A	9
	-8	LEAD BLOCK MOUNT #2 (SIDE A LEFT)	UNS S31600	N/A	8
	-7	LEAD BLOCK MOUNT #1 (SIDE A RIGHT)	UNS S31600	N/A	7
	-6	STUD 3/8-16 UNC-2A X3.5 LG	UNS S31600	N/A	6
	-5	STUD, 3/8-16UNC -2A X 2.5 LG	UNS S31600	N/A	5
AR	SE780-011	METROLOGY TARGET			4
	SE141-149	TYPE-B VPI GROOVE FILLER PIECE			3
	SE141-102	TYPE-B MCWF			2
AR	X	MODULAR COIL TYPE-B WINDING FORM AND STUD ASSEMBLY			1

PARTS LIST

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.

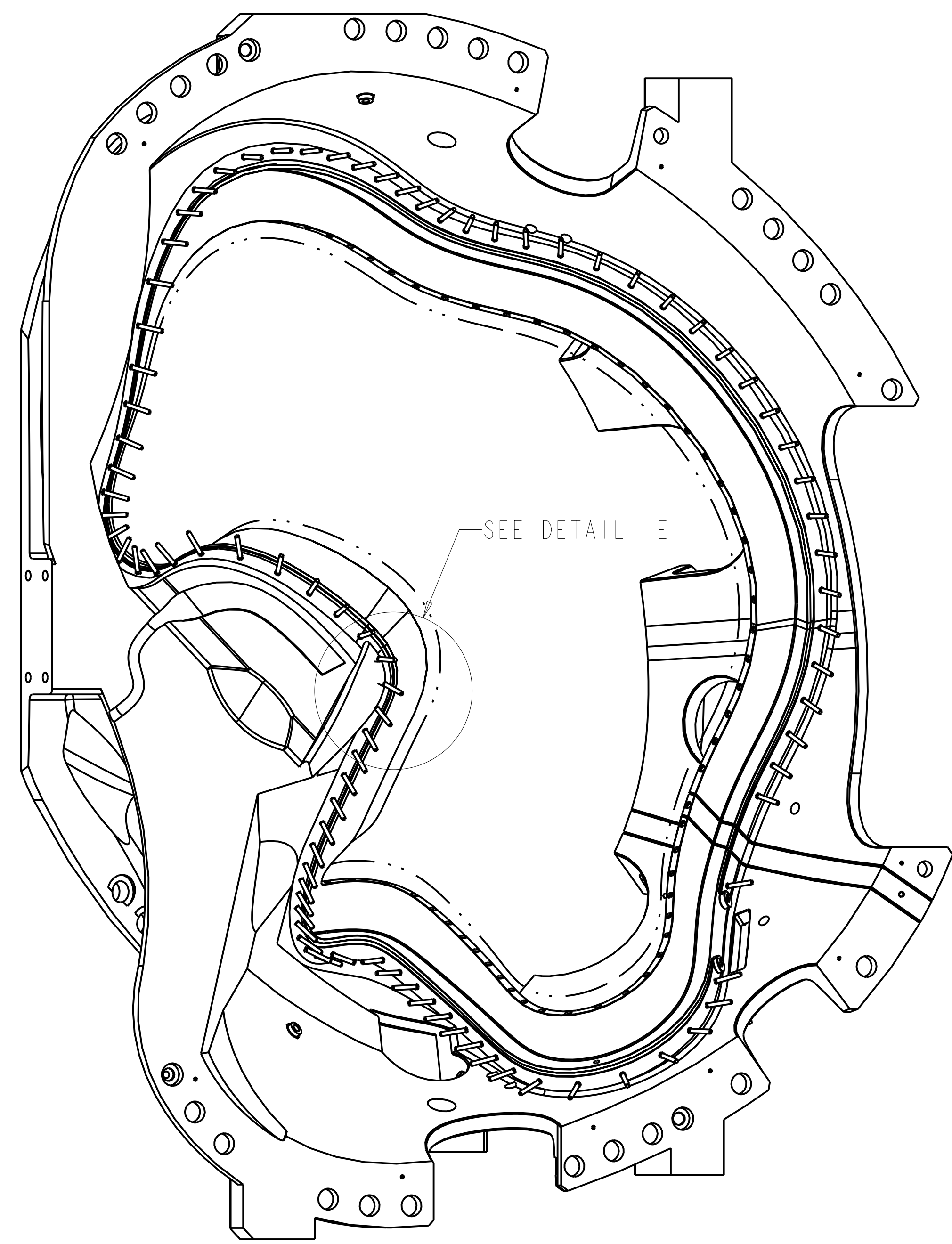
P THIS DRAWING PRODUCED ON PRO-ENGINEER

SCALE NOTED

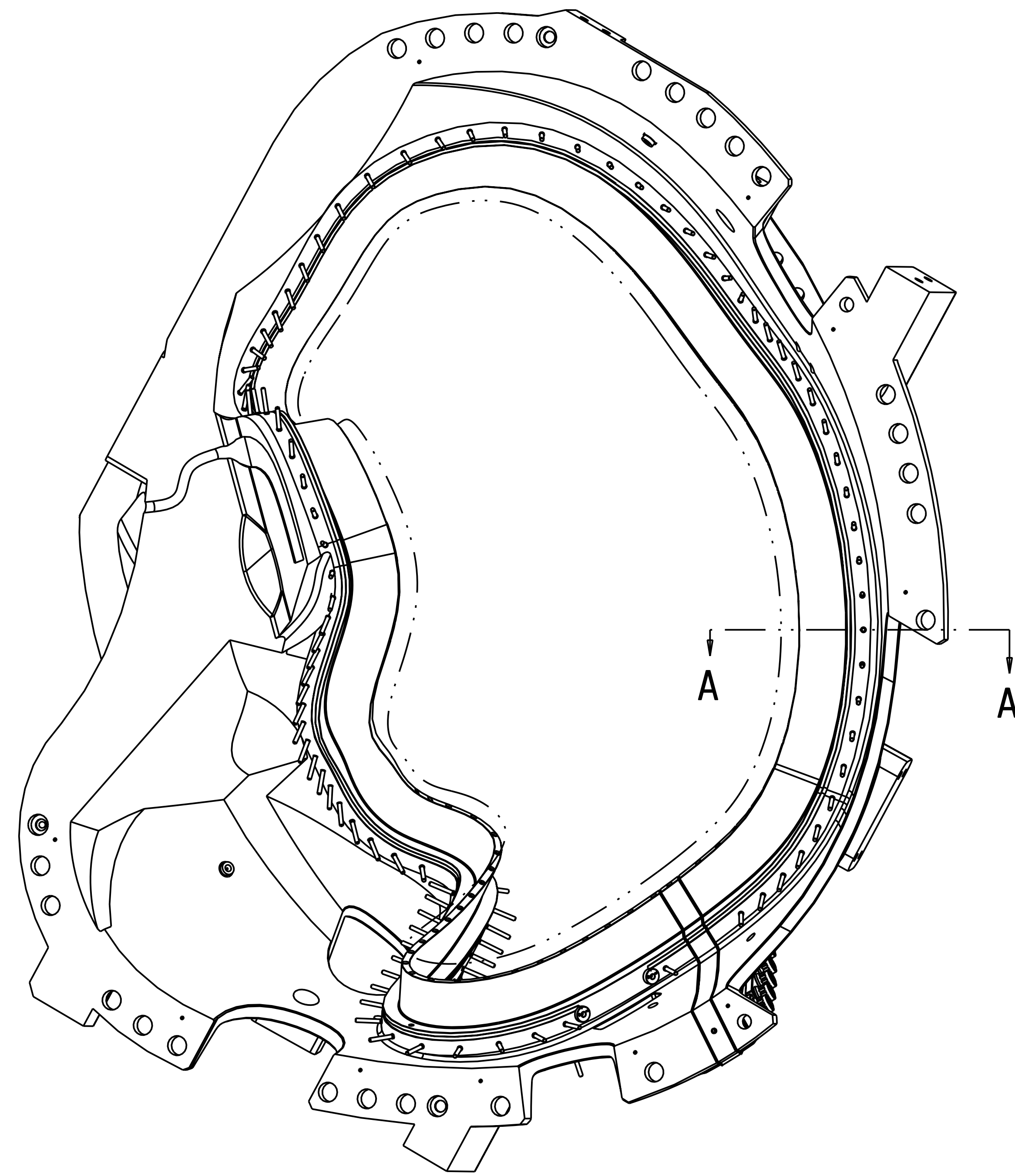
TOLERANCES UNLESS OTHERWISE SPECIFIED
FRACTIONS
XX DECIMALS ±.01
XXX DECIMALS ±.005
ANGLES ±0'15"
BREAK SHARP EDGES 06 MAX
FINISH .125 UNLESS OTHERWISE SPECIFIED

DES D WILLIAMSON 03/06
DRW G LOVETT 03/06
CHK MIKE COLE 03/06
DEPT :
PE D WILLIAMSON 03/06
CR :
PJ :
RD :
PPPL DRFT J SIEGEL 03/06
DRAWING APPROVALS DATE

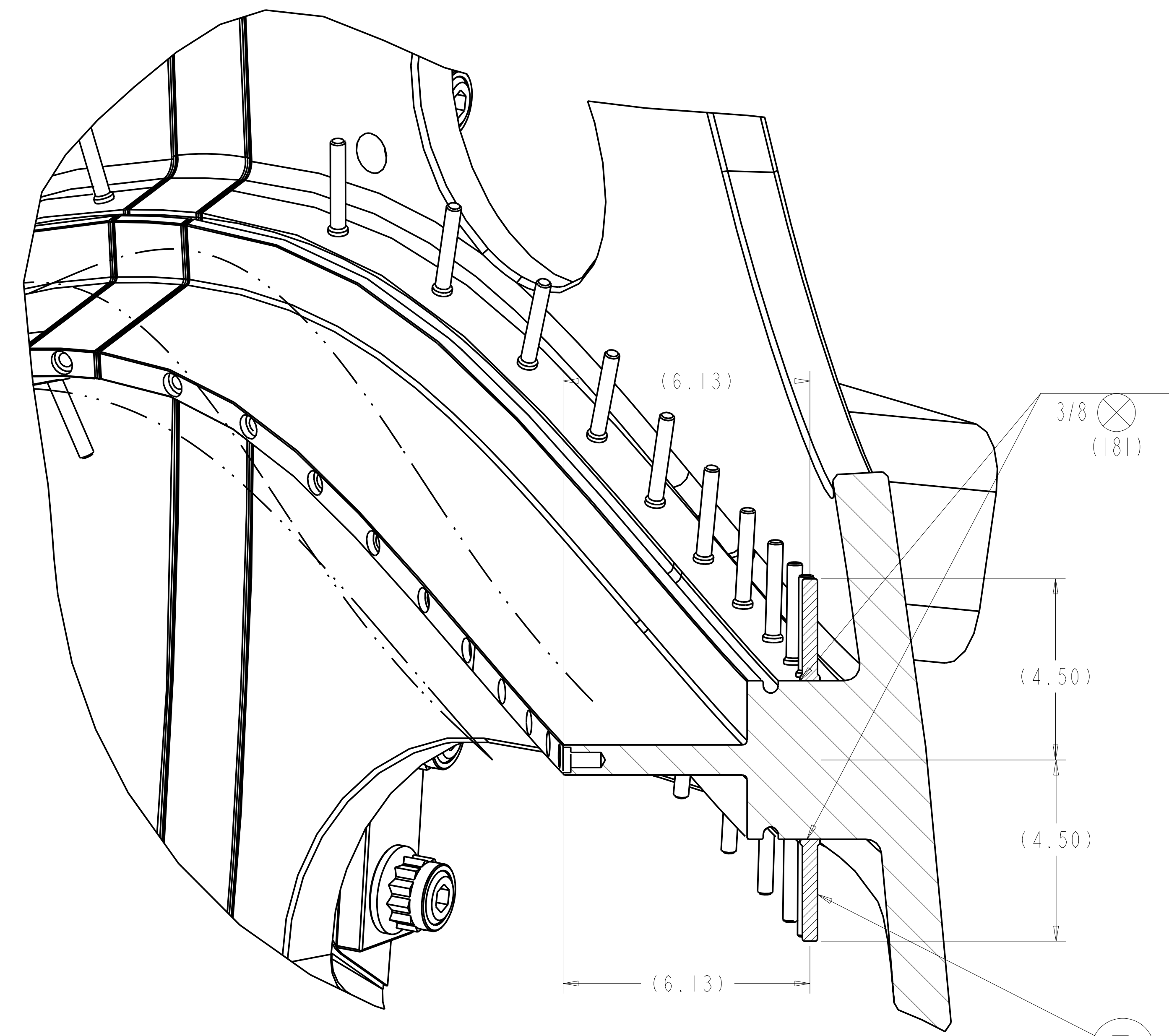
Oak Ridge National Laboratory managed for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT contract DE-AC05-00OR22725 UT-BATTELLE, LLC. Oak Ridge, Tennessee
PROJECT NAME
NATIONAL COMPACT STELLARATOR EXPERIMENT
MODULAR COIL TYPE-B WINDING FORM AND STUD WELDMENT
VERSION NO. 24+
PLANT X-10
BLDG 5700
FL 3
SHT 1
OF 4
TYPE S
CLASS U
REV 0
RELEASE LEVEL WIP
SE141-122



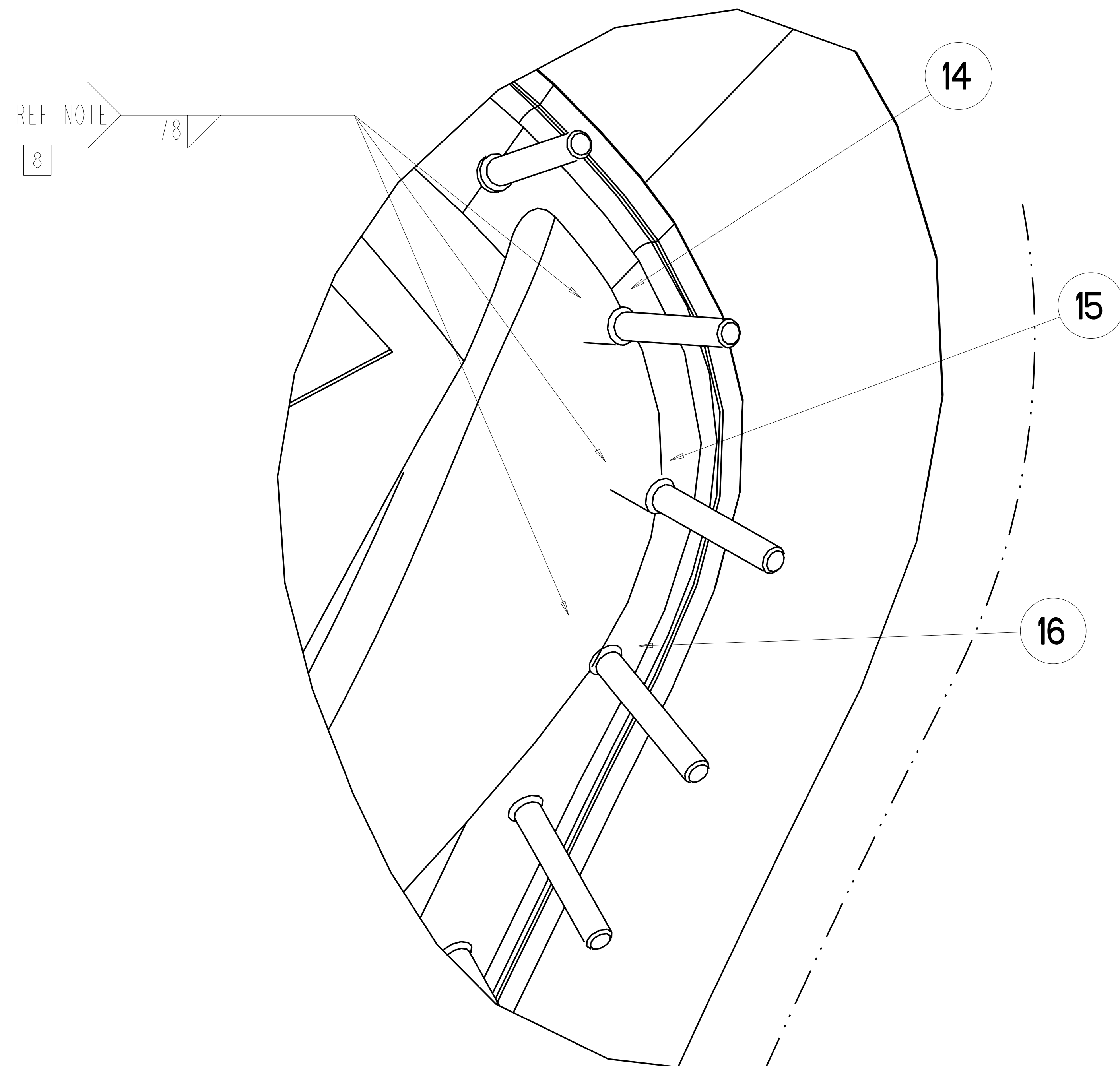
SIDE-A VIEW
SCALE 0.13



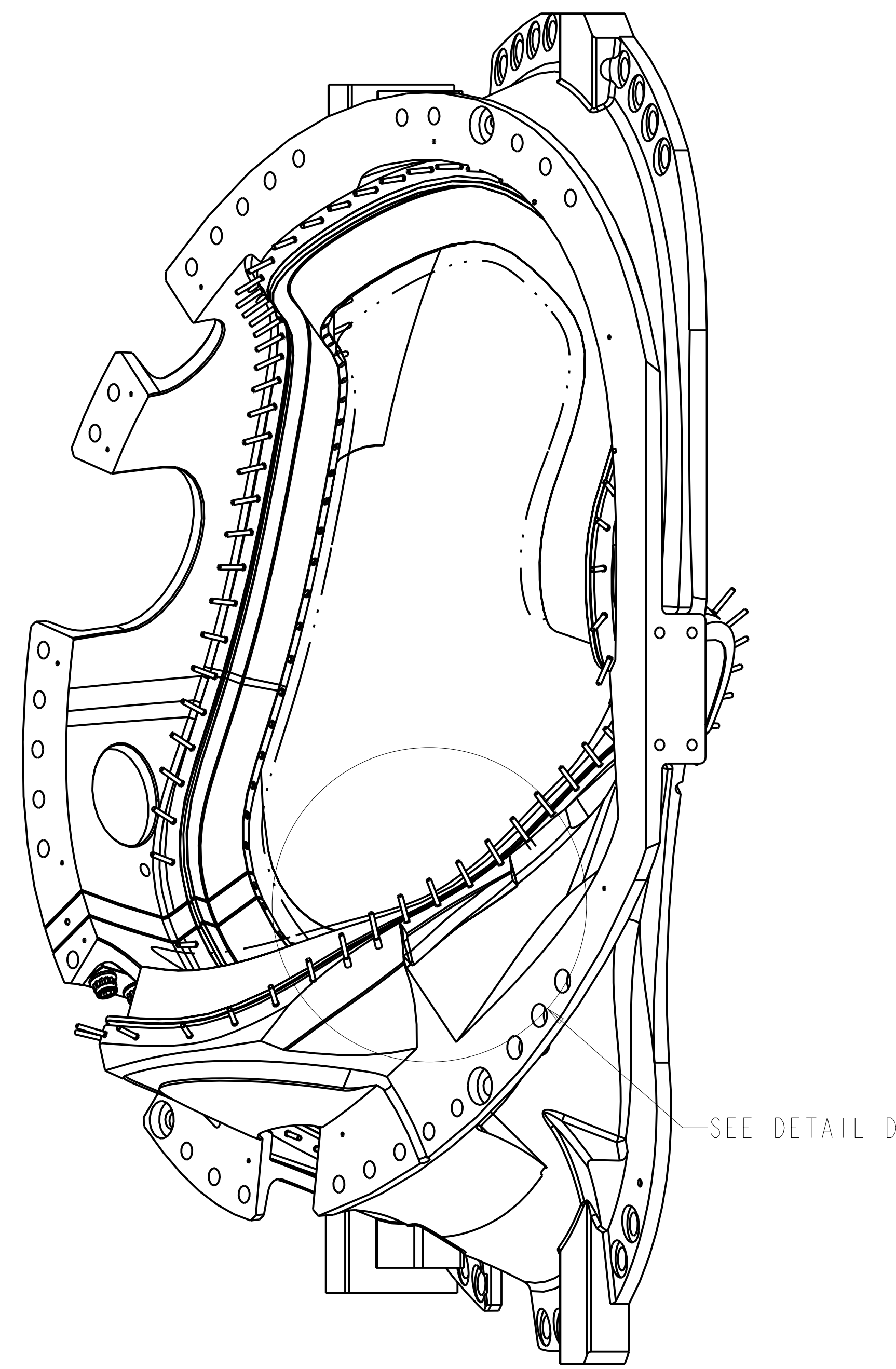
SIDE-A VIEW
SCALE 0.13



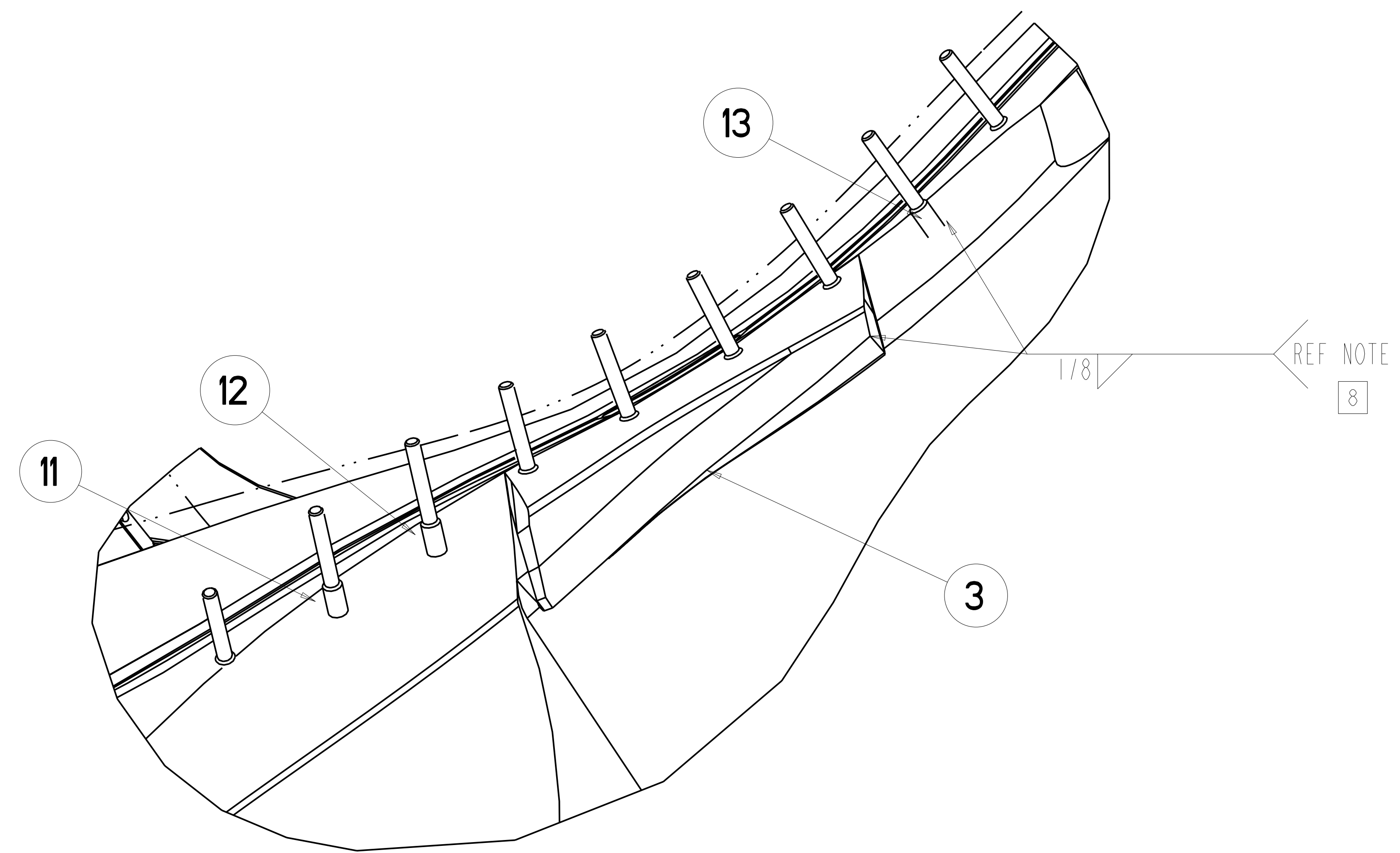
SECTION A-A
SCALE 0.50



DETAIL E
SCALE 1.00

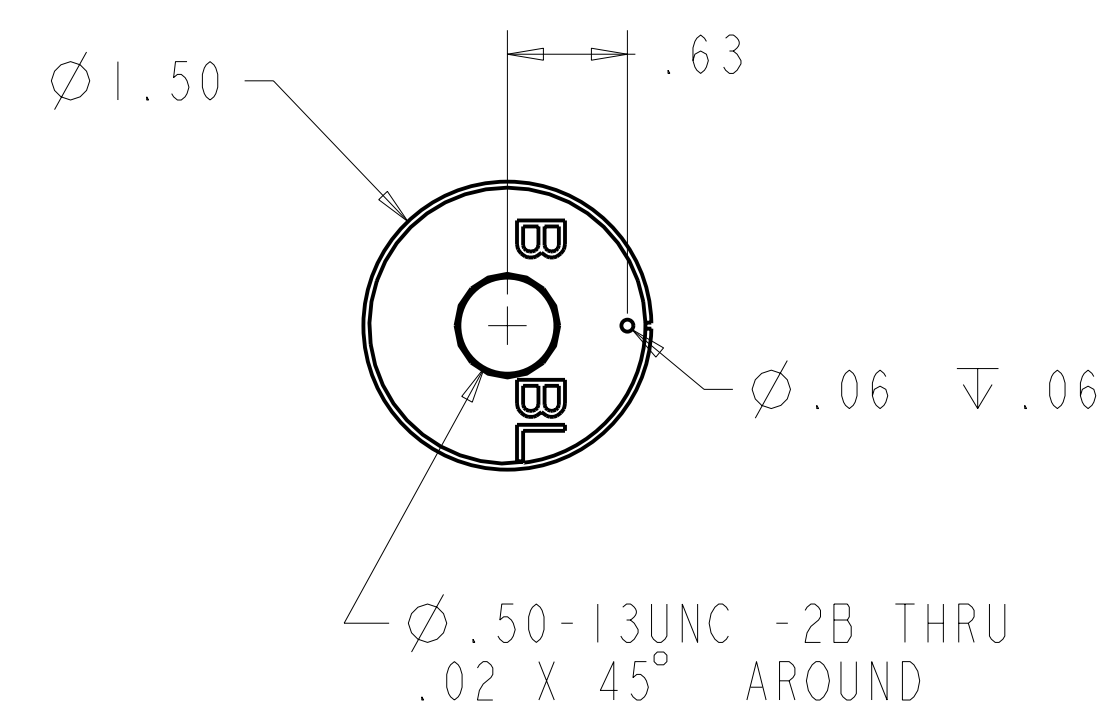


SIDE-B VIEW
SCALE 0.13



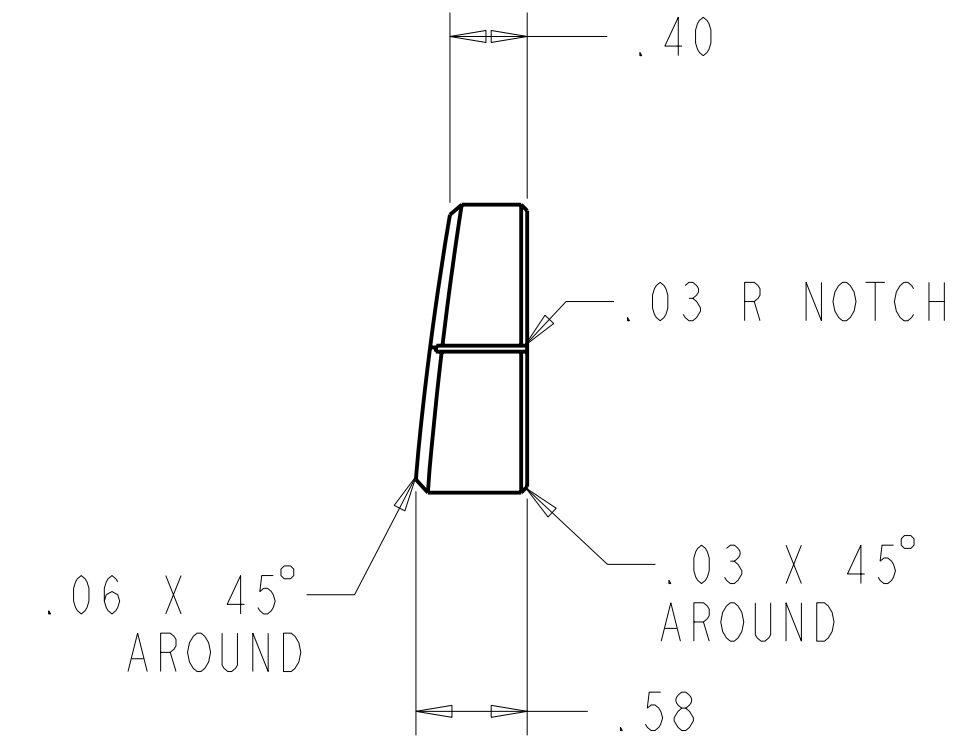
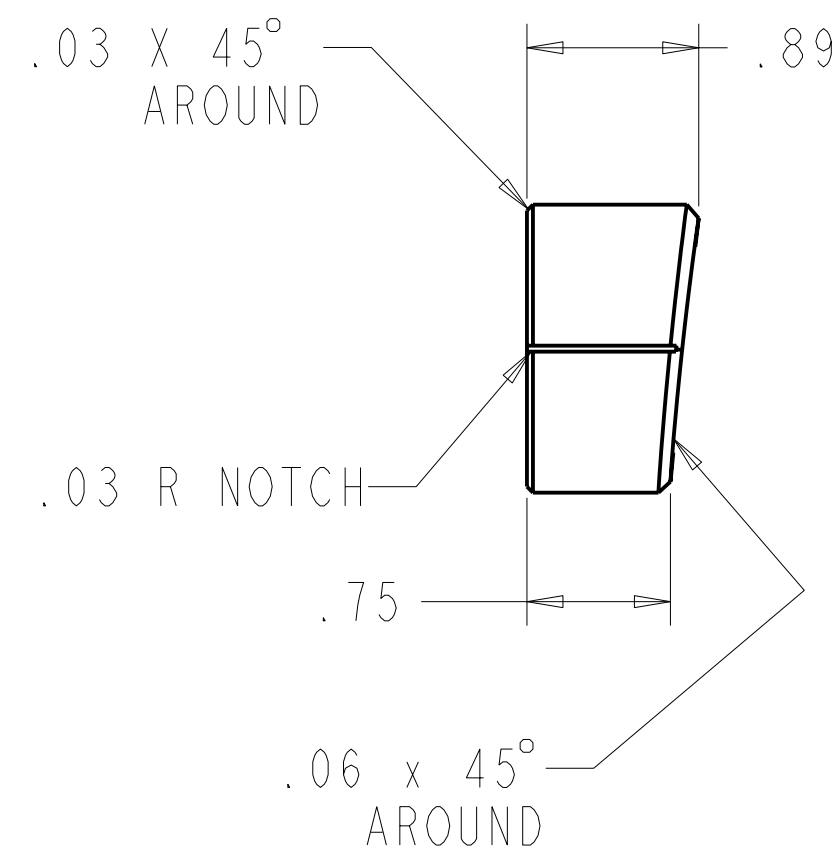
DETAIL D
SCALE 0.50

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 TITLE:									
UT-BATTELLE NATIONAL COMPACT STELLARATOR EXPERIMENT									
MODULAR COIL TYPE-B WINDING FORM AND STUD WELDMENT									
VERSION NO:	PLANT	BLDG	FL	SHT	OF	TYPE	CLASS		
24+	X-10	5700	3	2	4	S	U		
RELEASE LEVEL		SE141-122						REV	
WIP								I	

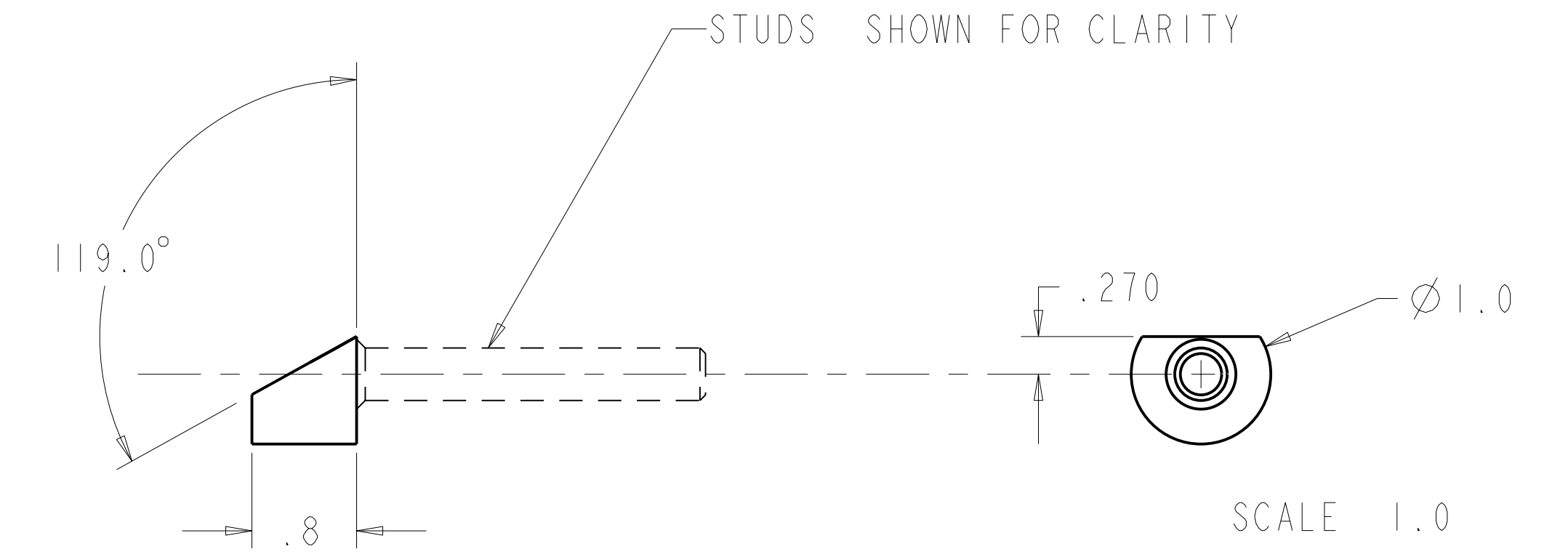
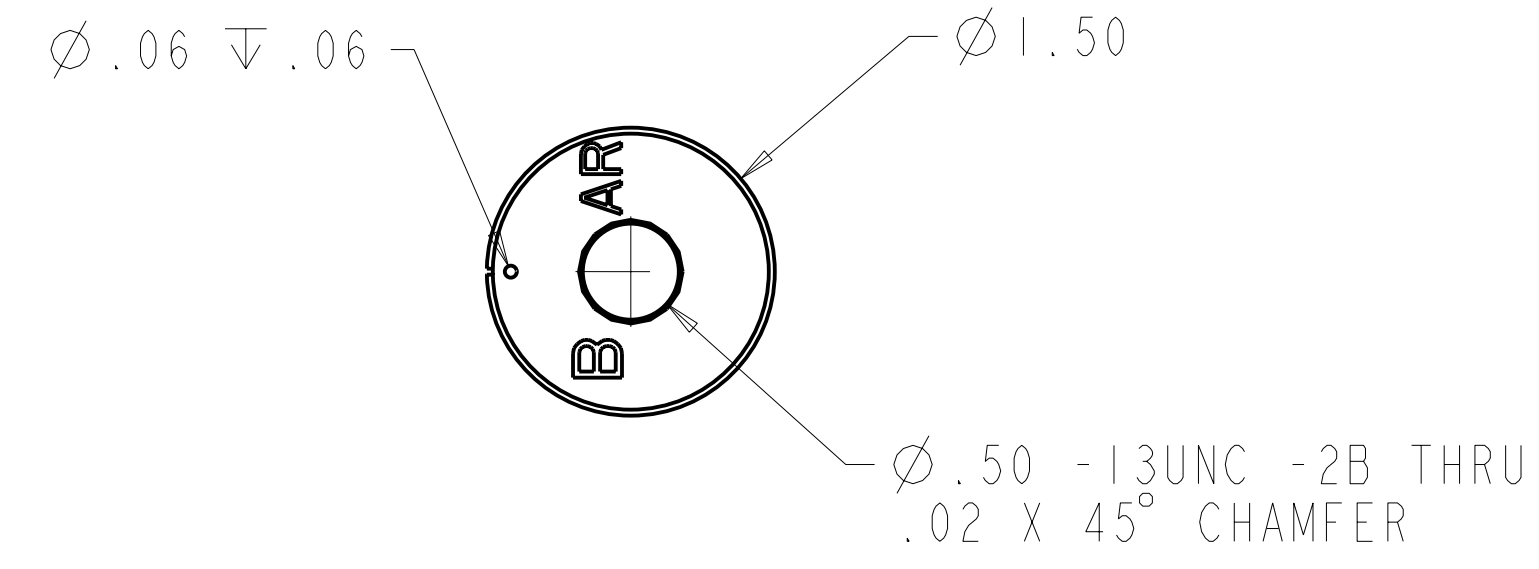


10 SIDE-B LEFT

SCALE 1.0

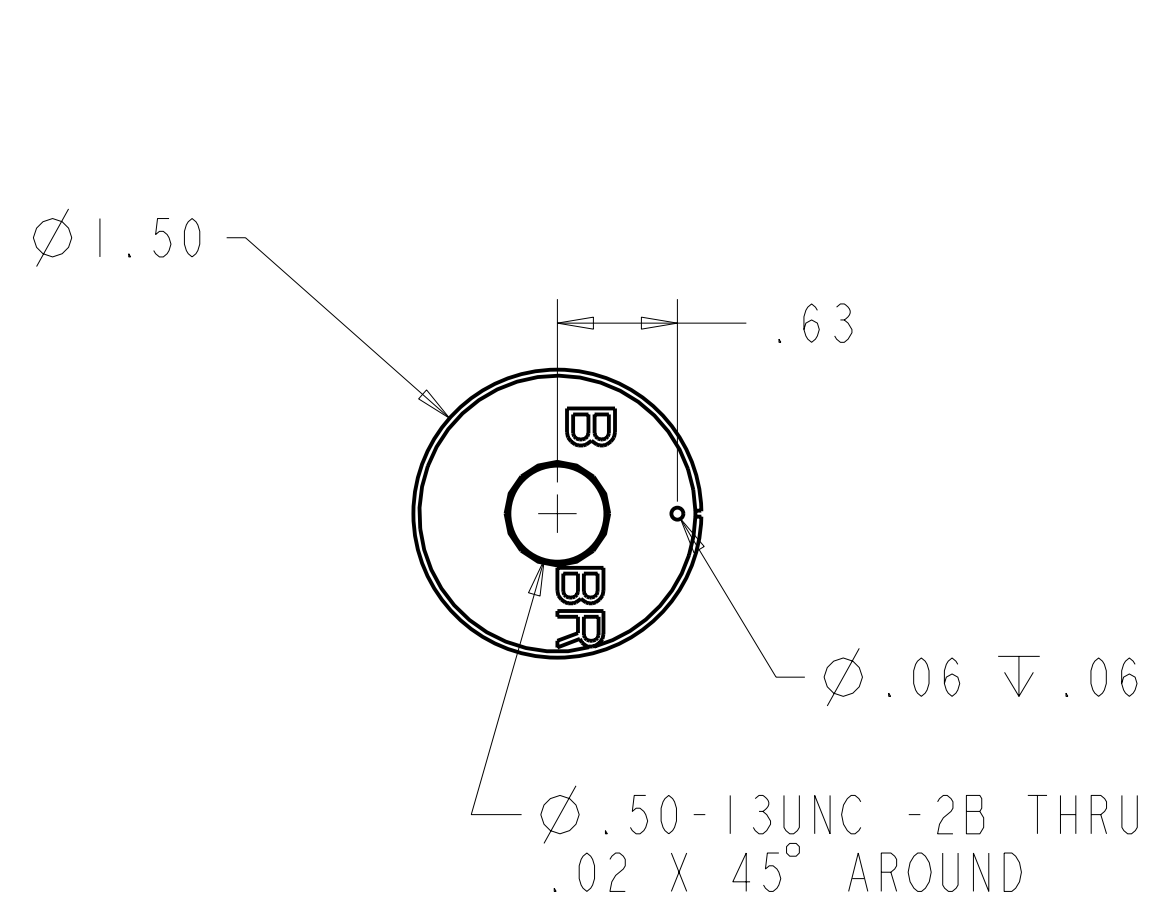


7 SIDE-A RIGHT

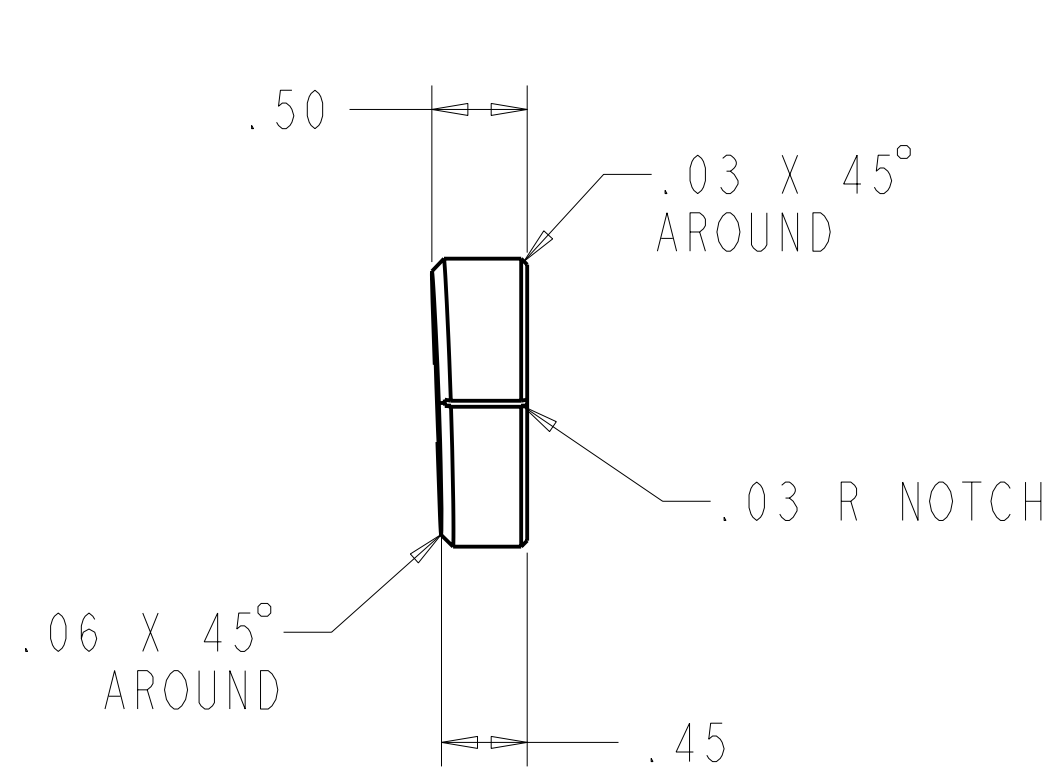
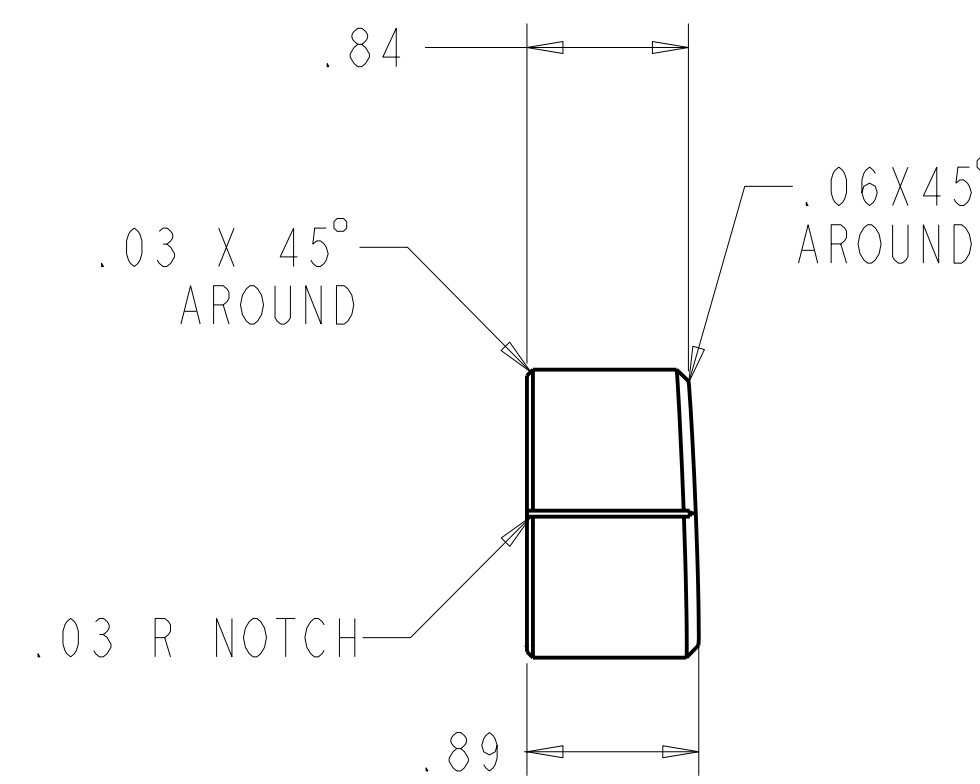


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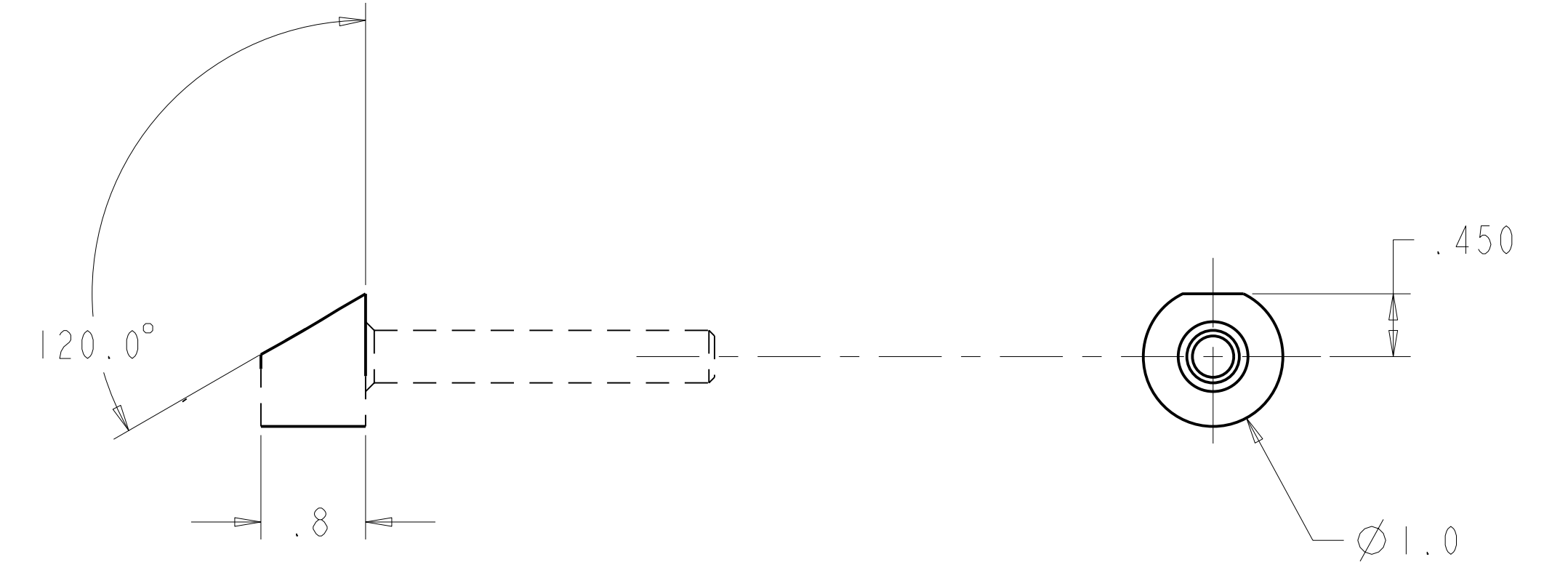
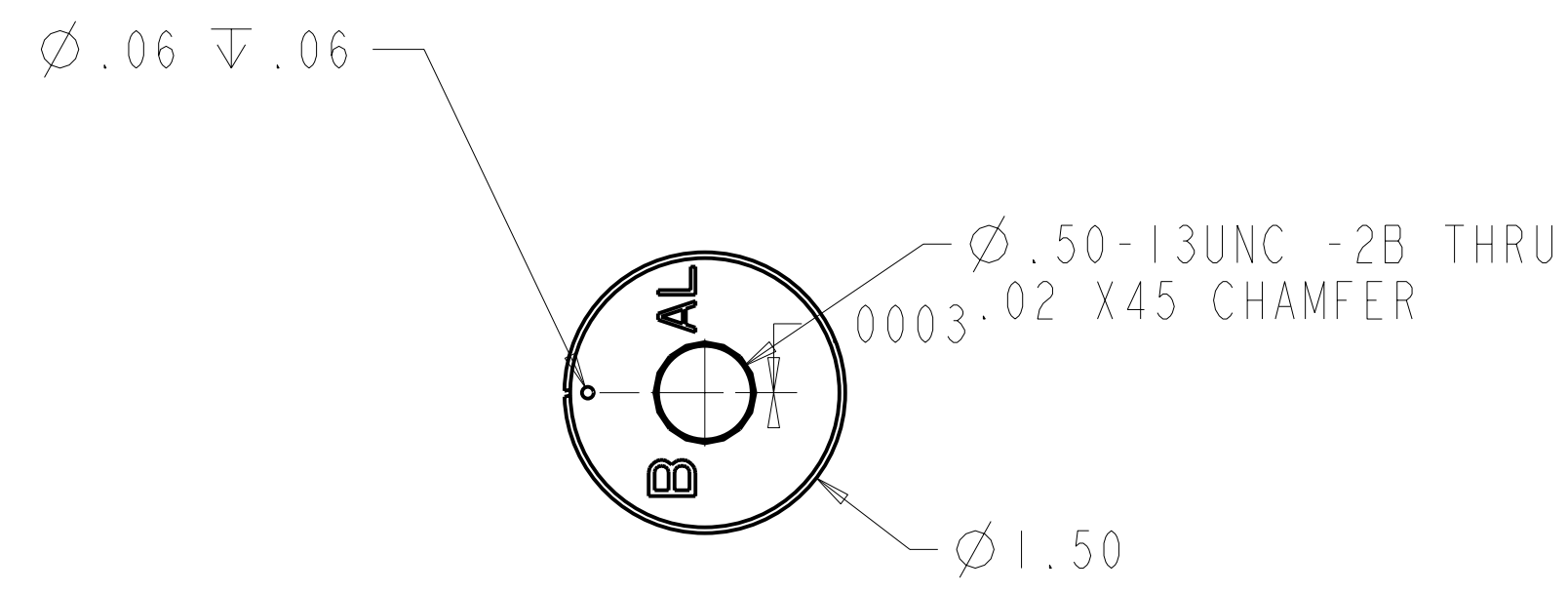
SCALE 1.0



9 SIDE-B RIGHT

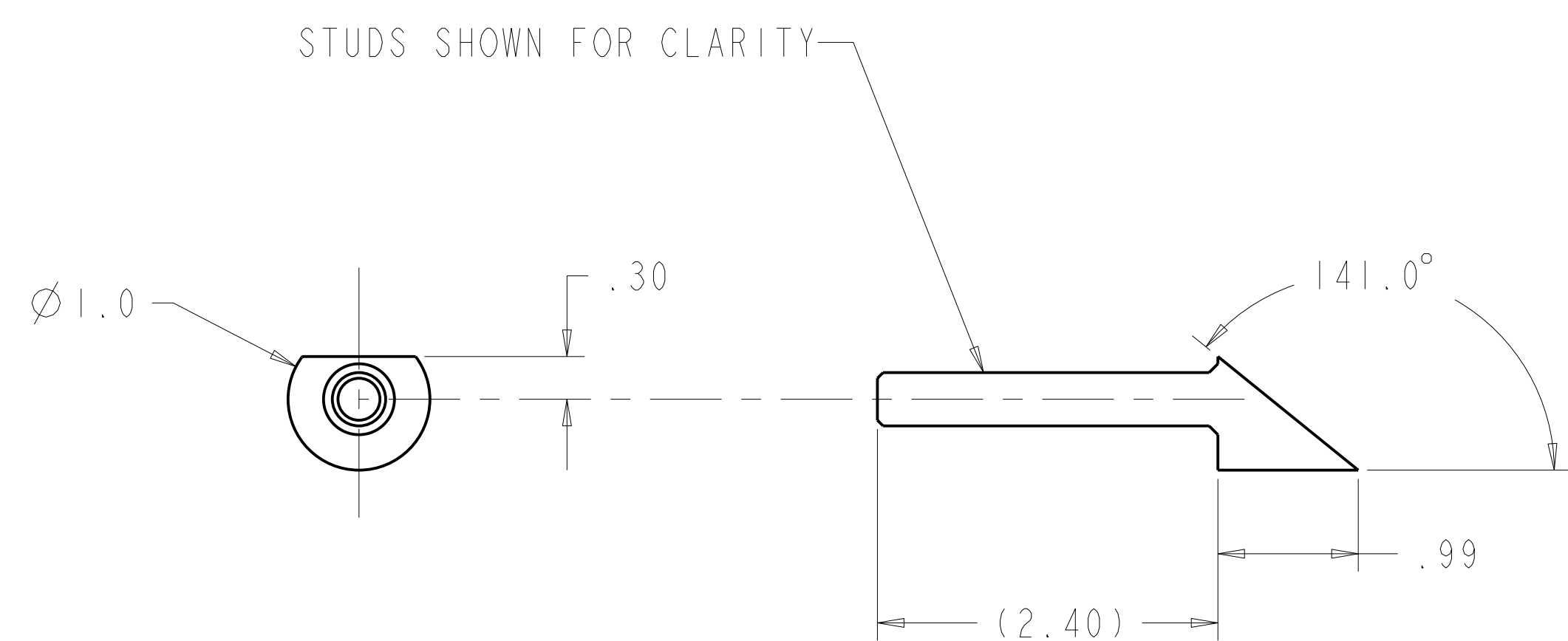


8 SIDE-A LEFT



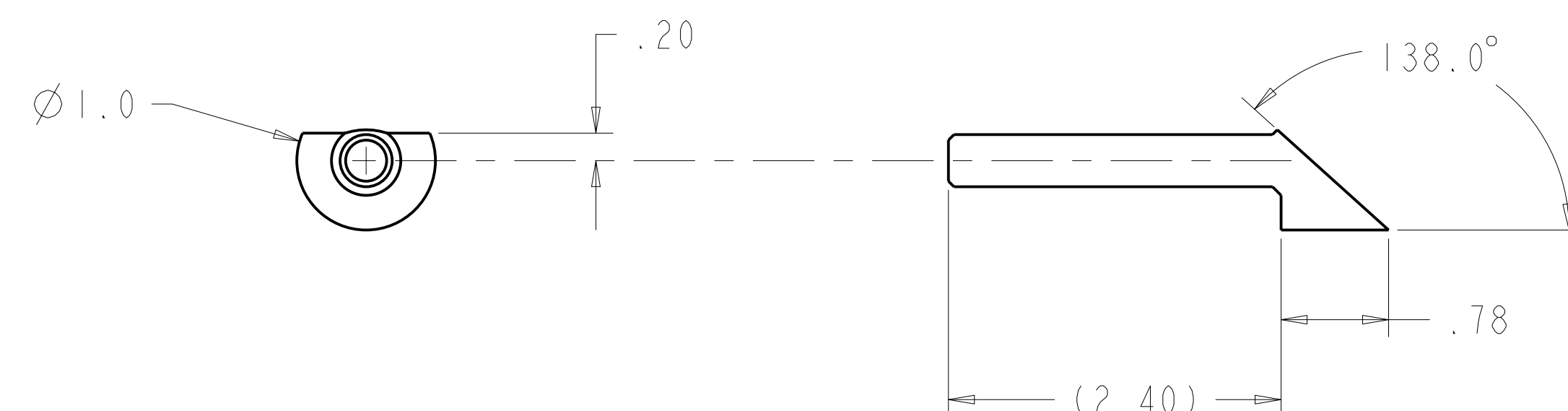
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SCALE 1.0



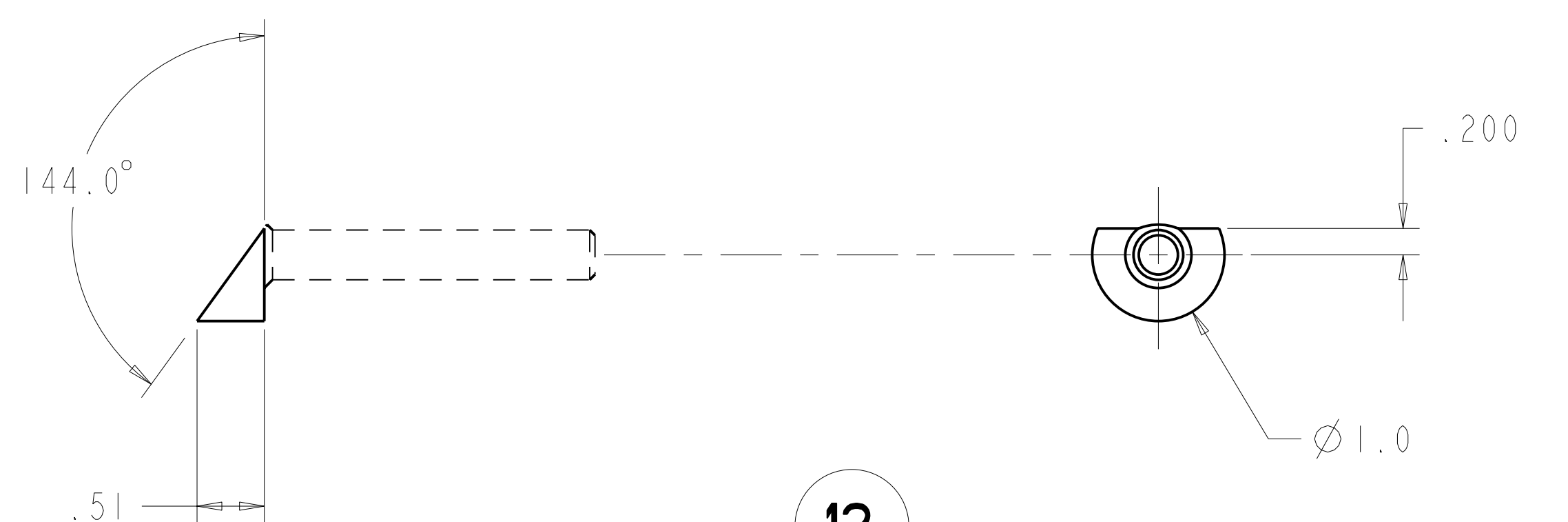
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SCALE 1.0



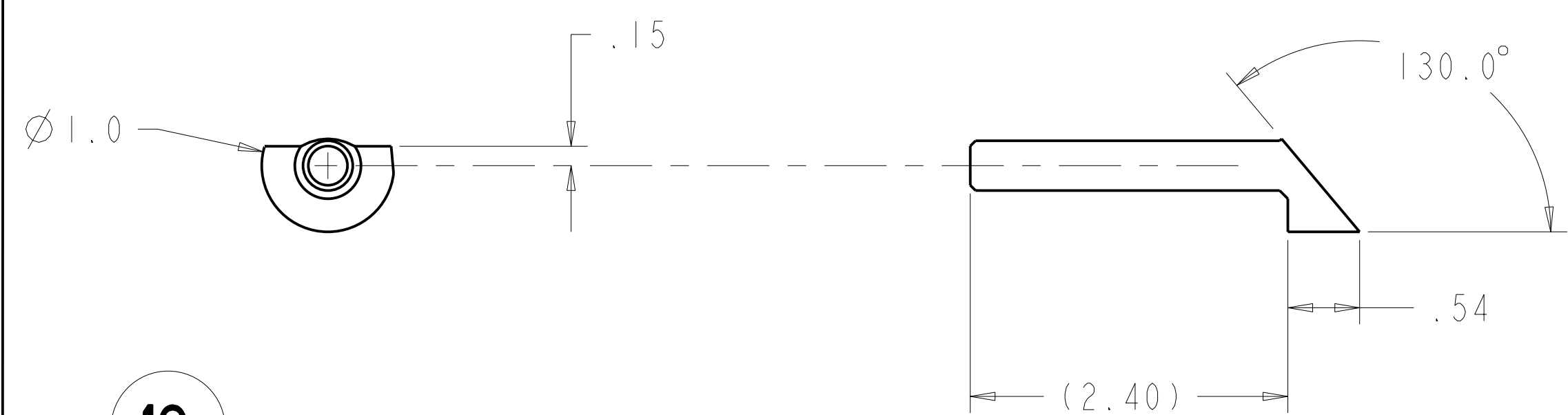
15

SCALE 1.0



13

SCALE 1.0

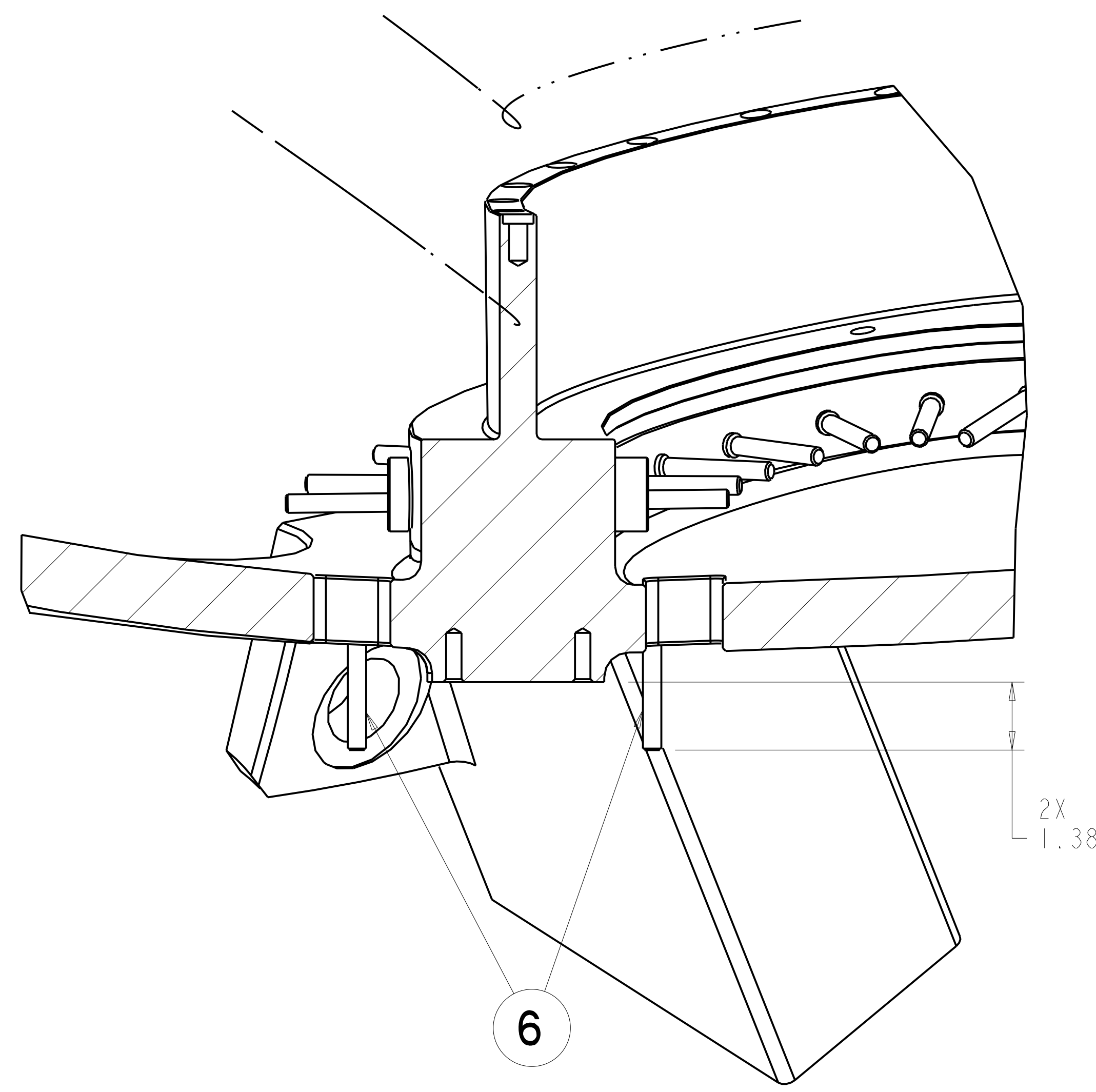


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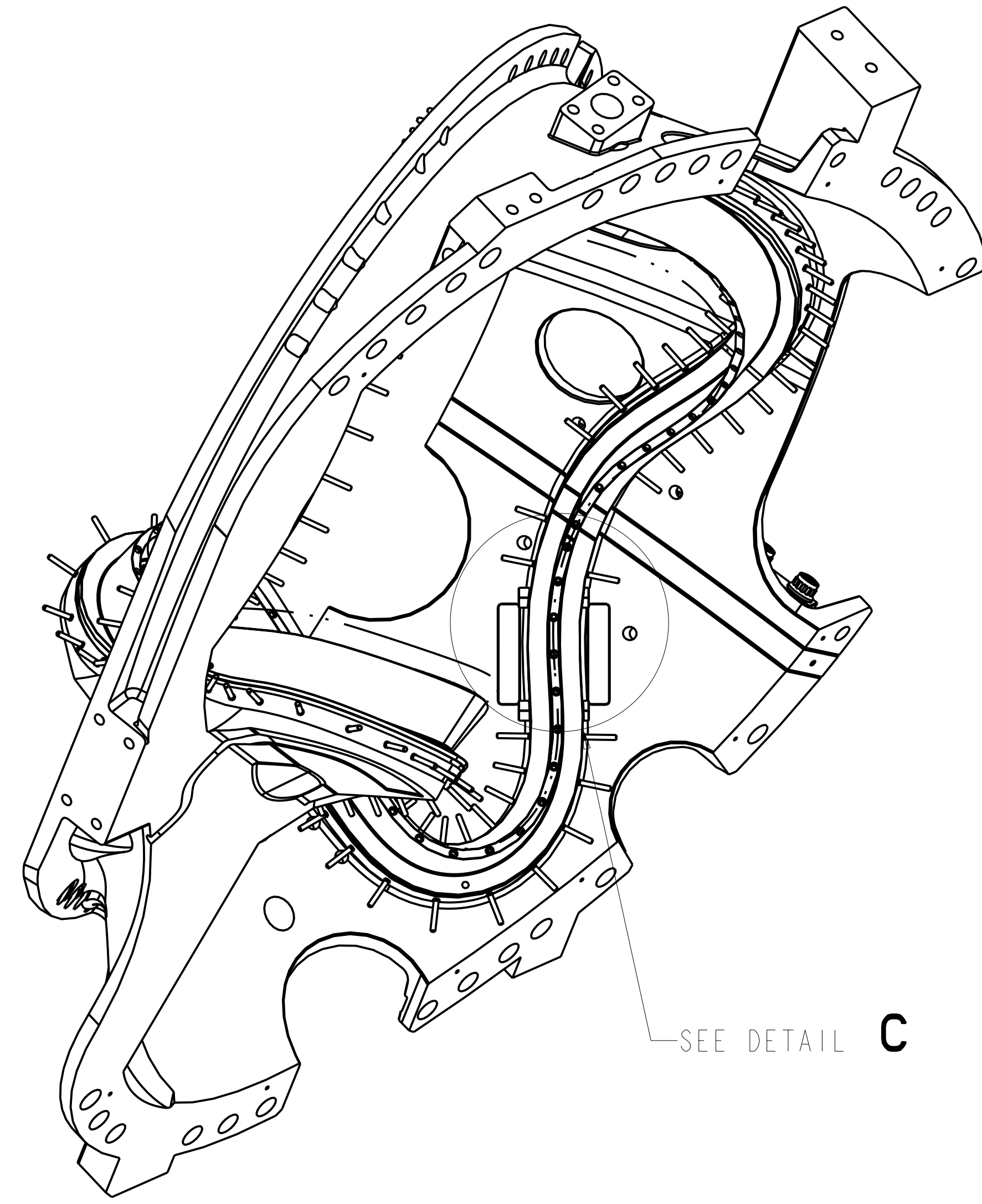
SCALE 1.0

Oak Ridge National Laboratory managed for the DEPARTMENT OF ENERGY under UT-BATTELLE U.S. GOVERNMENT CONTRACT DE-AC05-00OR22725 UT-BATTELLE, LLC. Oak Ridge, Tennessee PROJECT NAME:						
NATIONAL COMPACT STELLARATOR EXPERIMENT						
MODULAR COIL TYPE-B WINDING FORM AND STUD WELDMENT						
VERSION NO:	PLANT	BLDG	FL	SHT OF	TYPE	CLASS
24+	X-10	5700	3	3 4	S	U
RELEASE LEVEL		SEI41-122			REV	
WIP						

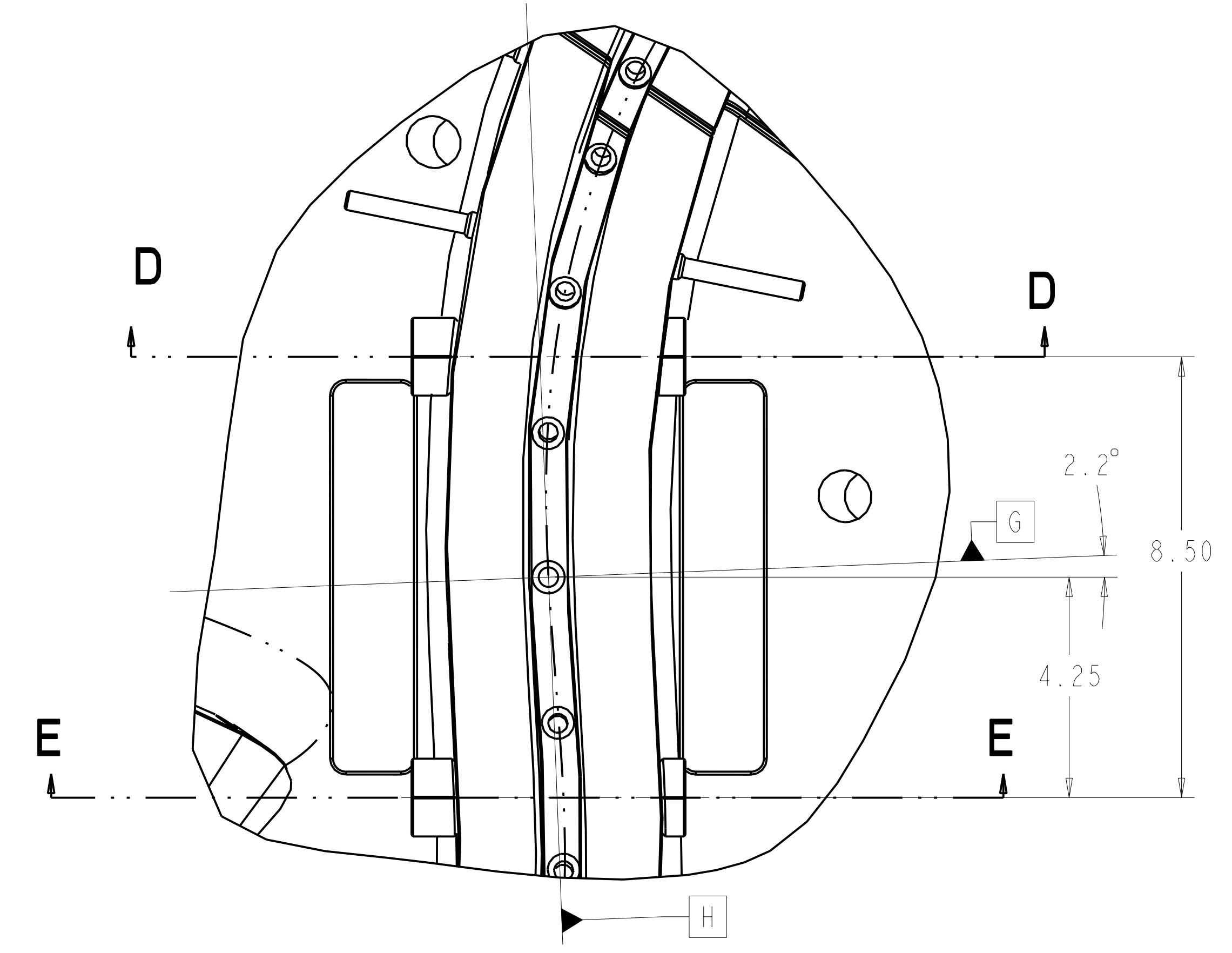
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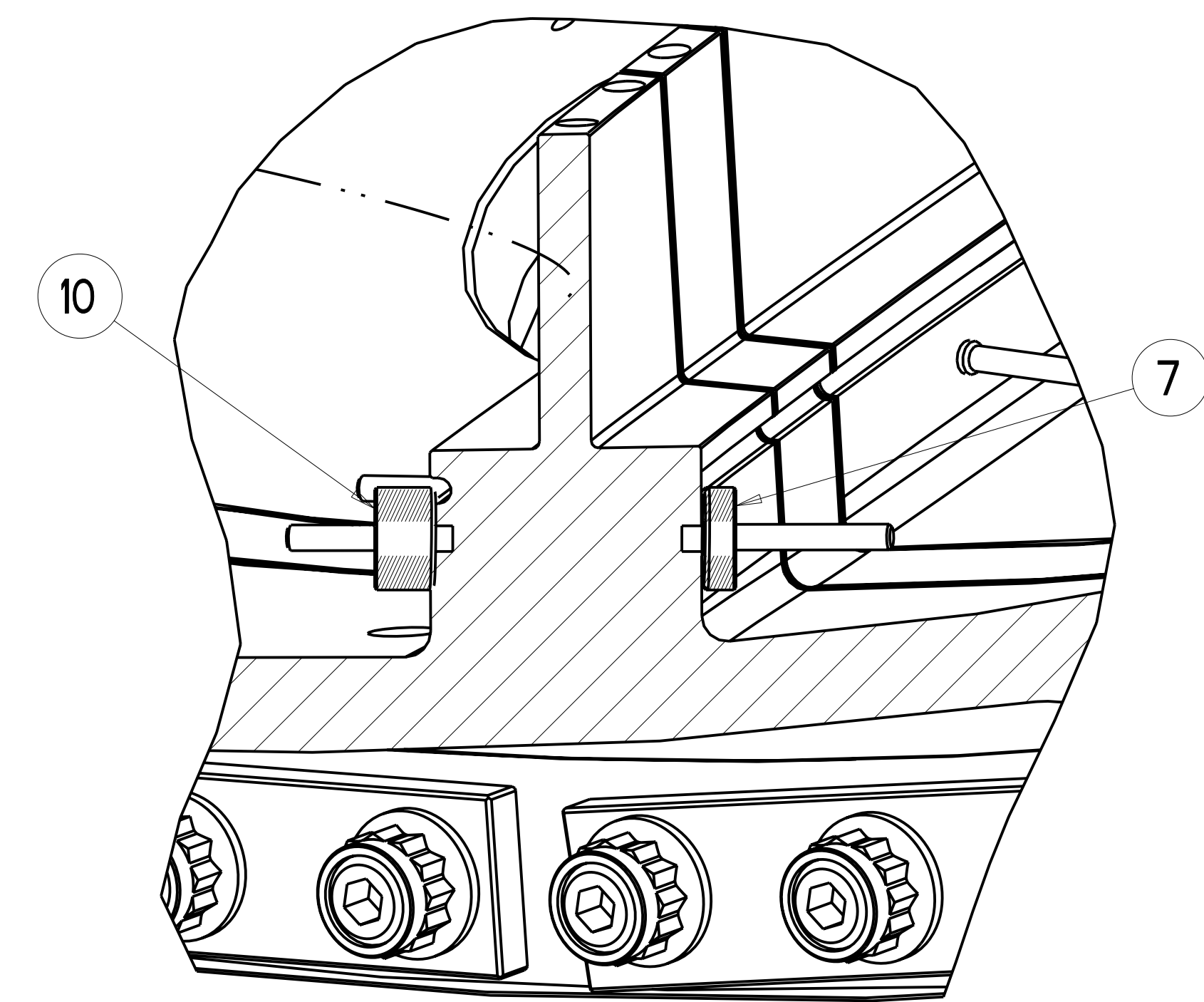
SECTION G-G



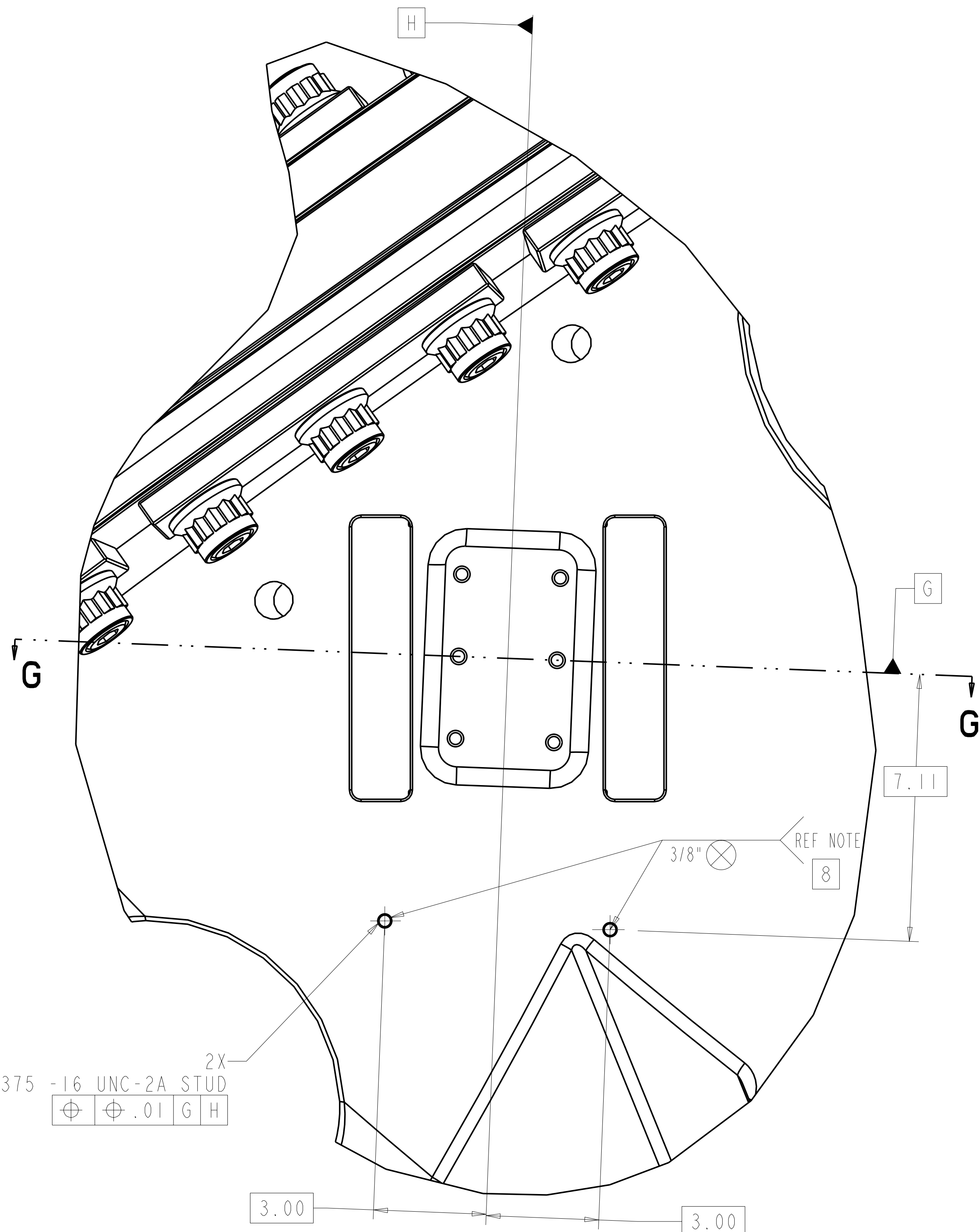
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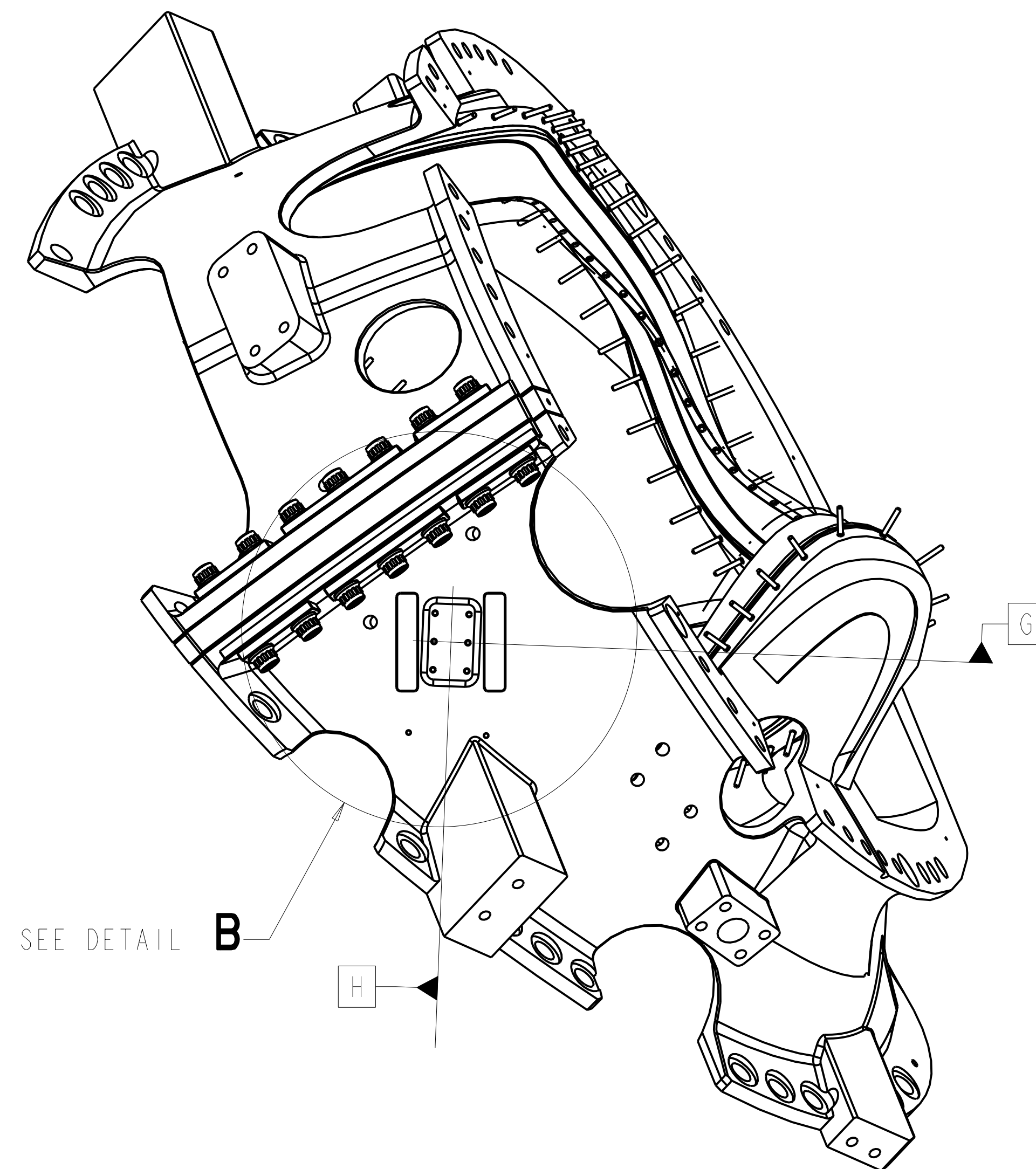
DETAIL C
SCALE 0.50



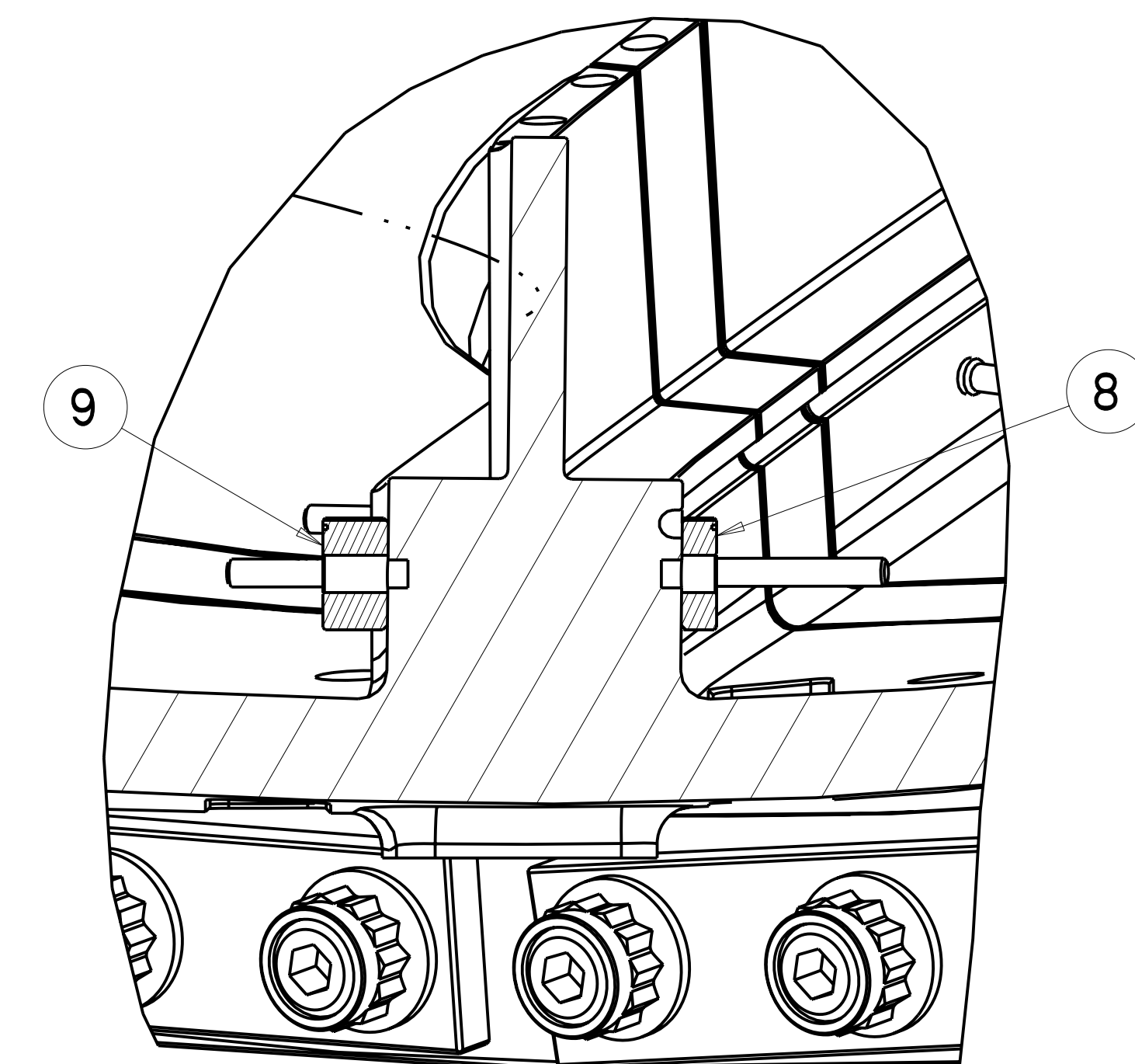
SECTION D-D



DETAIL B
SCALE 0.50



SCALE 0.13



SECTION E-E

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 5042									
UT-BATTELLE NATIONAL COMPACT STELLARATOR EXPERIMENT									
MODULAR COIL TYPE-B WINDING FORM AND STUD WELDMENT									
VERSION NO:	PLANT	BLDG	FL	SHT	OF	TYPE	CLASS		
24+	X-10	5700	3	4	4	S	U		
RELEASE LEVEL		SE141-122						REV	
WIP									