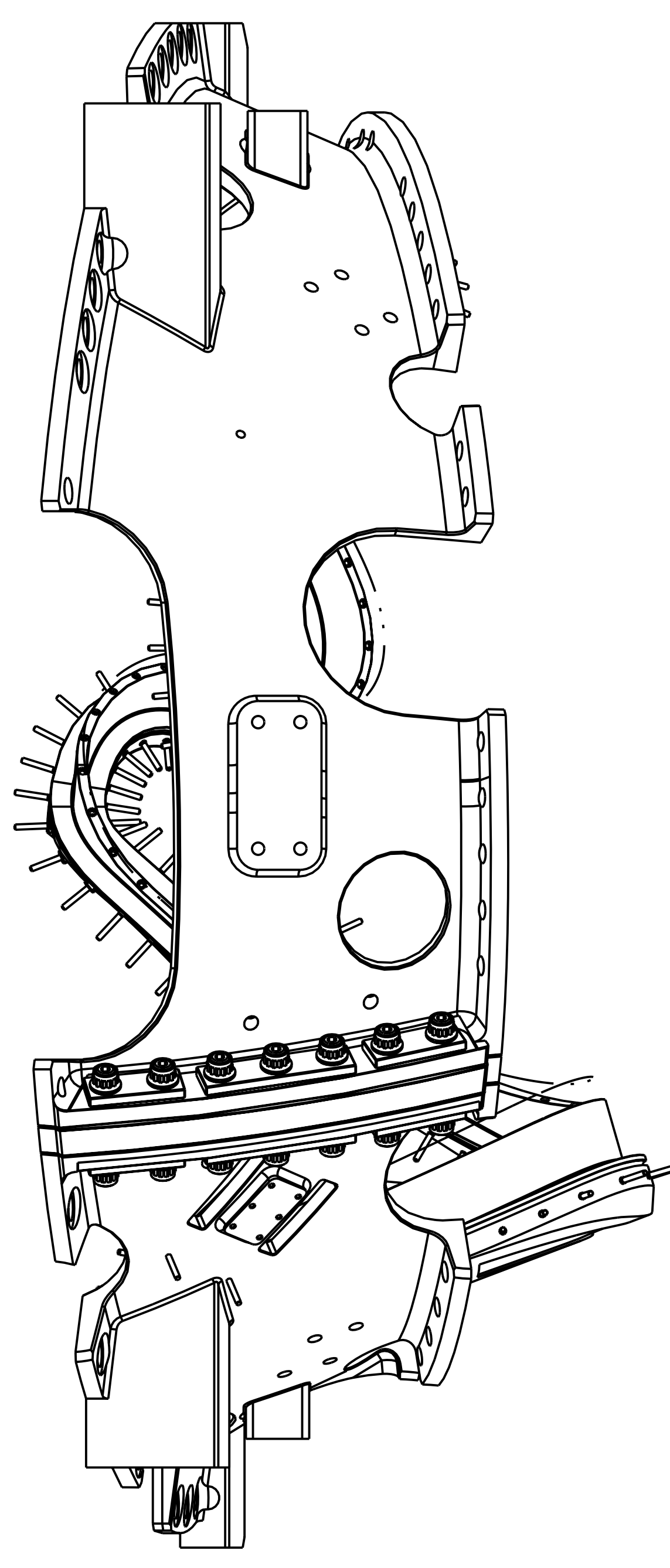
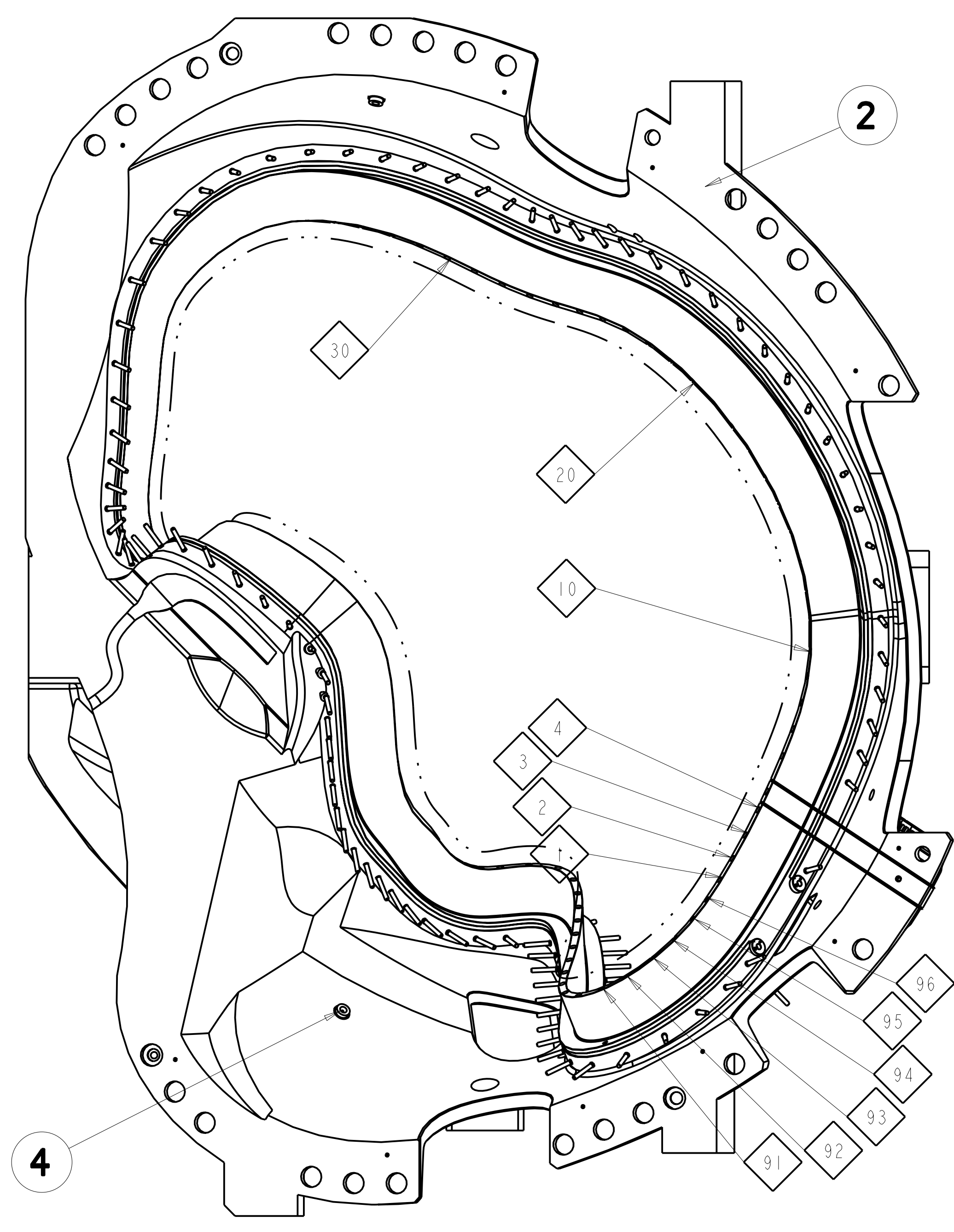


NOTES:

- 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-NC5X-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.



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PPPL Drafting:

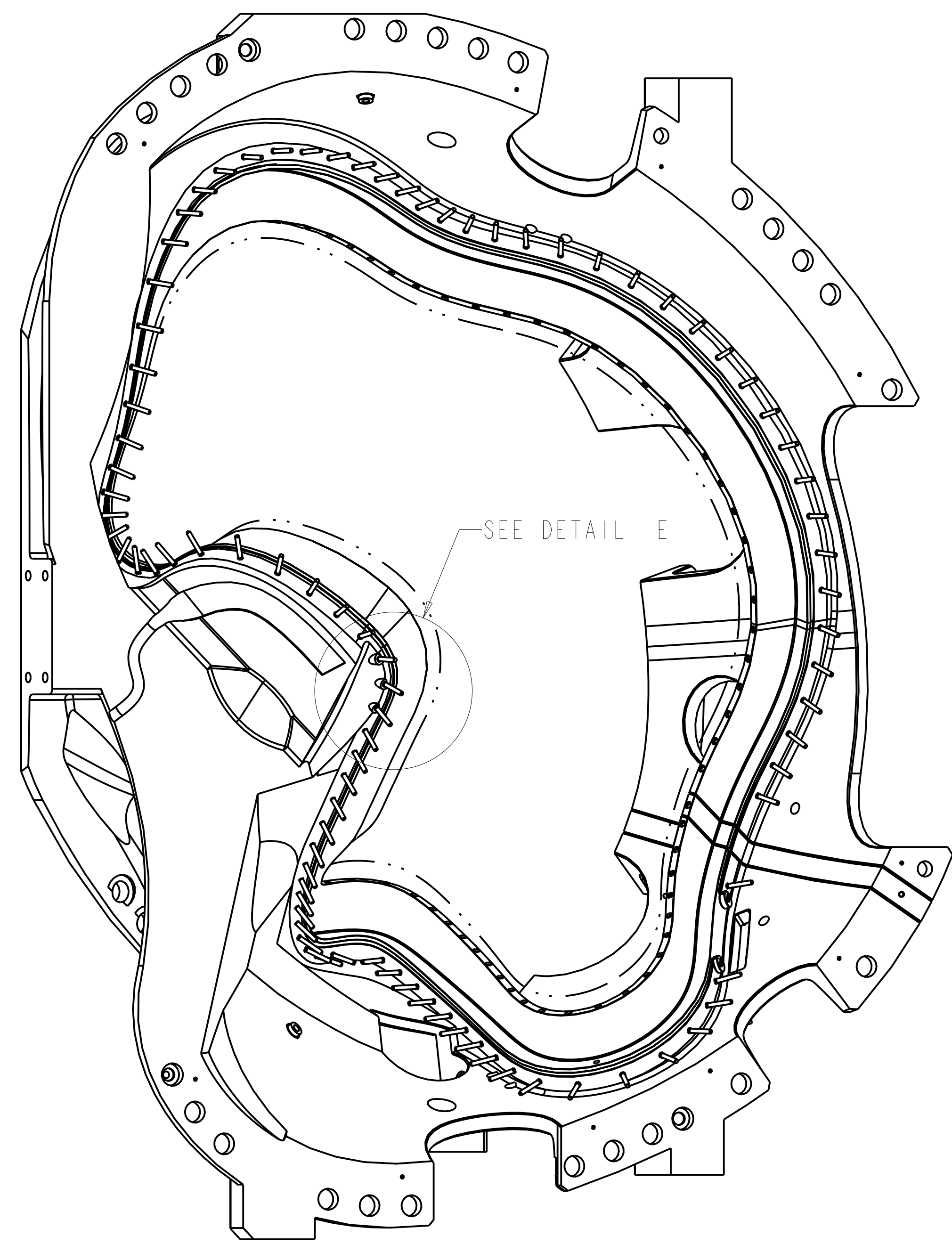
WELDING ENGINEER
APPROVED G. GETTLEFINGER DATE: 10/06

REV	CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
1		-17	1" Ø STUD EXTENSION SIDE "A" MOUNT	UNS 31600	N/A	16
1		-16	1" Ø STUD EXTENSION SIDE "A" MOUNT	UNS 31600	N/A	15
1		-15	1" Ø STUD EXTENSION SIDE "A" MOUNT	UNS 31600	N/A	14
1		-14	1" Ø STUD EXTENSION SIDE "B" MOUNT	UNS 31600	N/A	13
1		-13	1" Ø STUD EXTENSION SIDE "B" MOUNT	UNS 31600	N/A	12
1		-12	1" Ø STUD EXTENSION SIDE "B" MOUNT	UNS S31600	N/A	11
1		-10	LEAD BLOCK MOUNT #4 (SIDE B LEFT)	UNS S31600	N/A	10
1		-9	LEAD BLOCK MOUNT #3 (SIDE B RIGHT)	UNS S31600	N/A	9
1		-8	LEAD BLOCK MOUNT #2 (SIDE A LEFT)	UNS S31600	N/A	8
1		-7	LEAD BLOCK MOUNT #1 (SIDE A RIGHT)	UNS S31600	N/A	7
2		-6	STUD 3/8-16 UNC-2A X3.5 LG	UNS S31600	N/A	6
181		-5	STUD, 3/8-16UNC -2A X 2.5 LG	UNS S31600	N/A	5
7	AR	SE780-011	METROLOGY TARGET			4
1		SE141-149	TYPE-B VPI GROOVE FILLER PIECE			3
1		SE141-102	TYPE-B MCWF			2
AR	X	-1	MODULAR COIL TYPE-B WINDING FORM AND STUD ASSEMBLY			1
PARTS LIST						

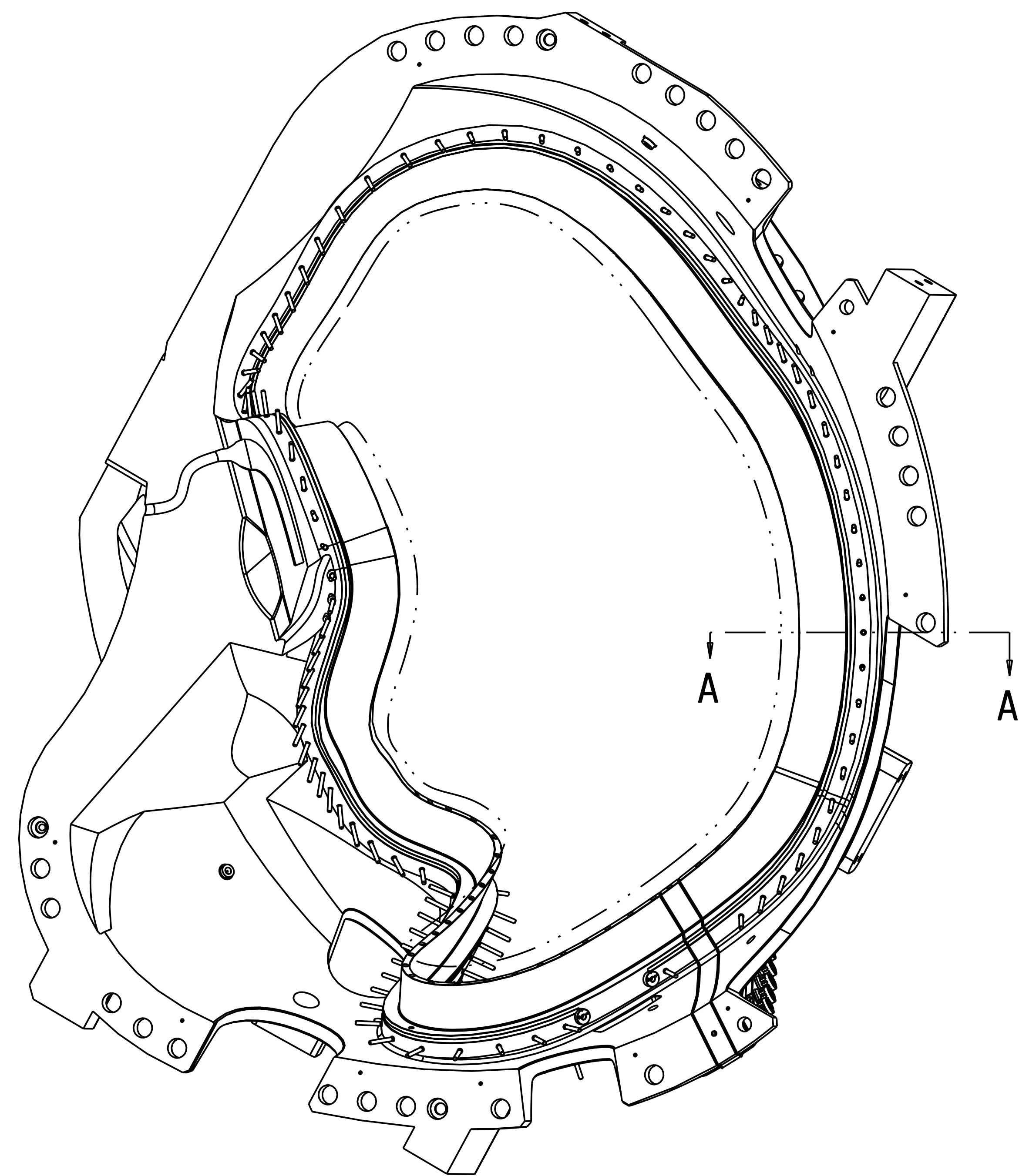
NO REPRESENTATION OR WARRANTY, EXPRESSED OR IMPLIED, IS MADE AS TO THE ACCURACY, COMPLETENESS OR USEFULNESS OF THE INFORMATION OR STATEMENTS CONTAINED IN THESE DRAWINGS, OR THAT THE USE OR DISCLOSURE OF ANY INFORMATION, APPARATUS, METHOD OR PROCESS DISCLOSED IN THESE DRAWINGS MAY NOT INFRINGE PRIVATE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

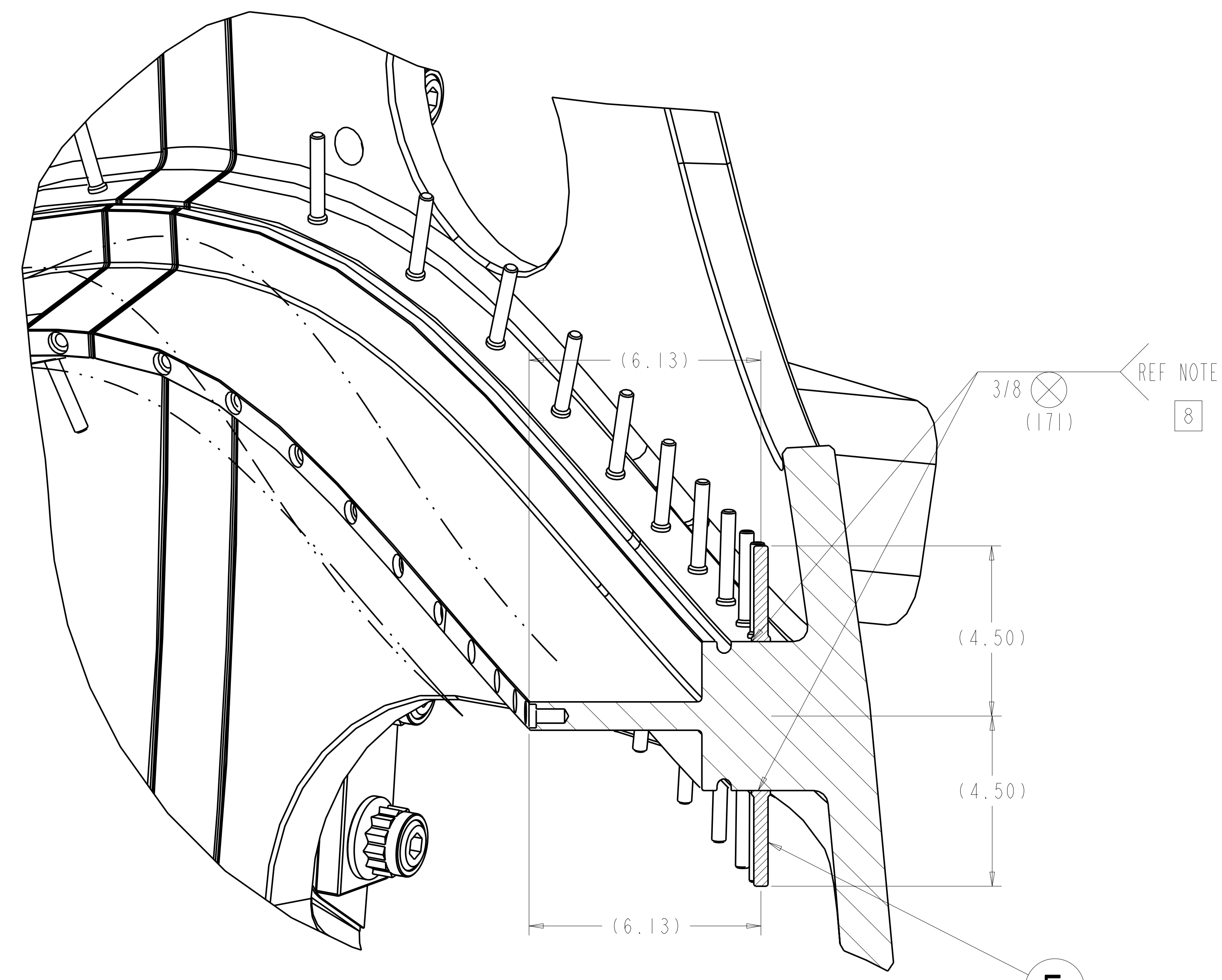
REV	DESCRIPTION	BY	DATE	CHK	DEPT	DATE	PE	REQ	DATE	ORNL	DOE	DATE																																																												
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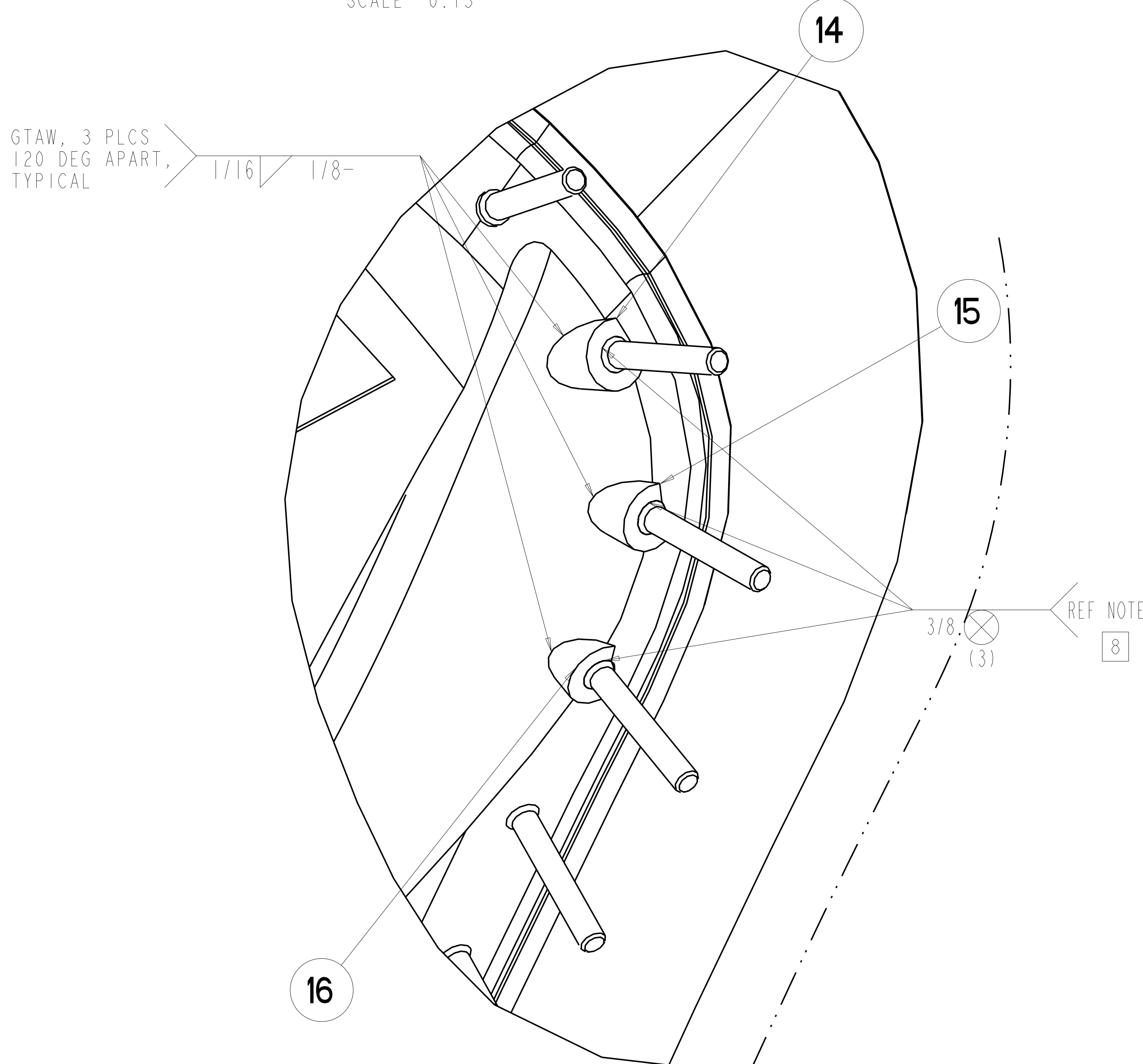
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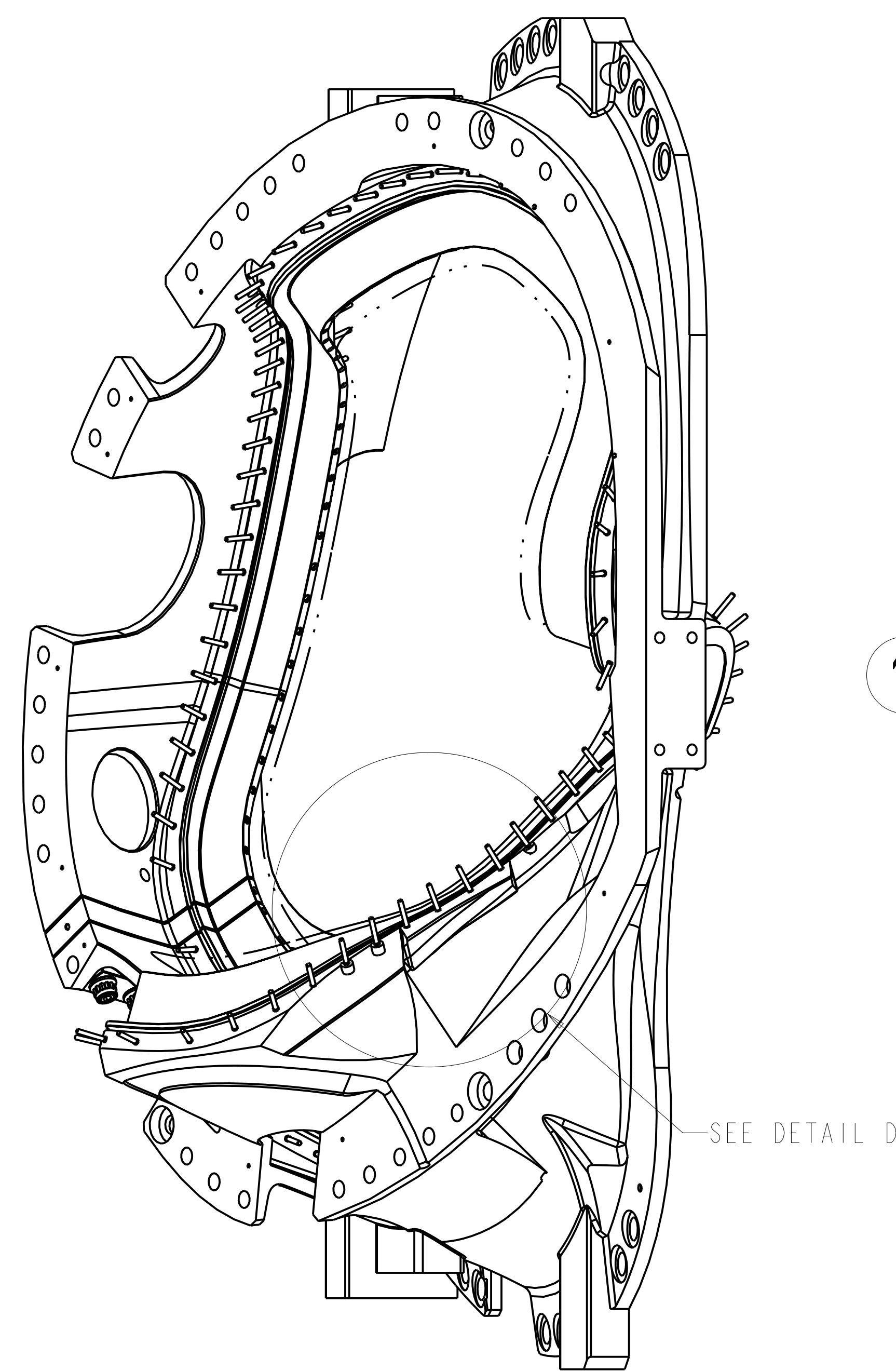
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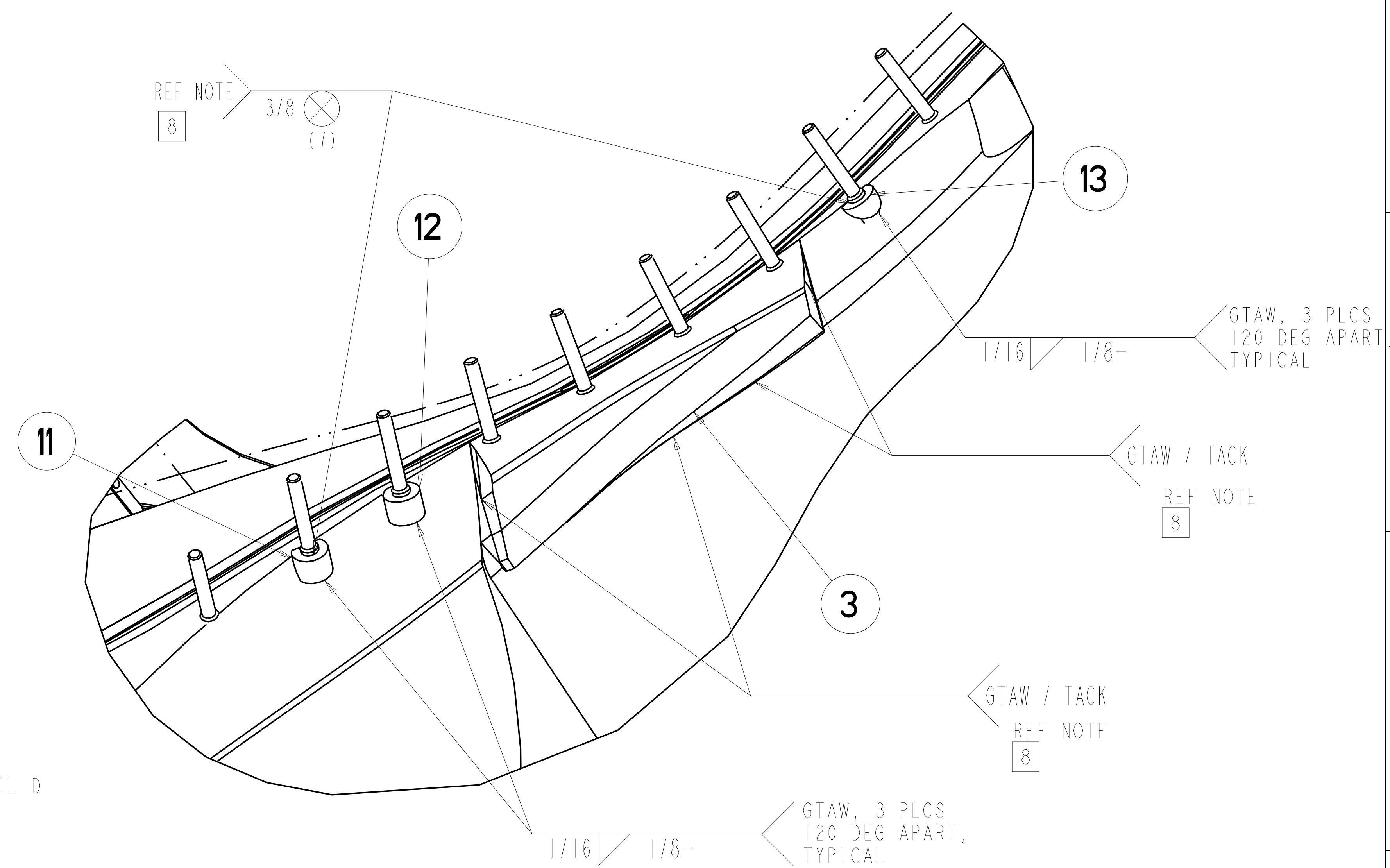
SECTION A-A
SCALE 0.50
STUDS NORMAL TO SECTION AT EACH LOCATION



DETAIL E
SCALE 1.00



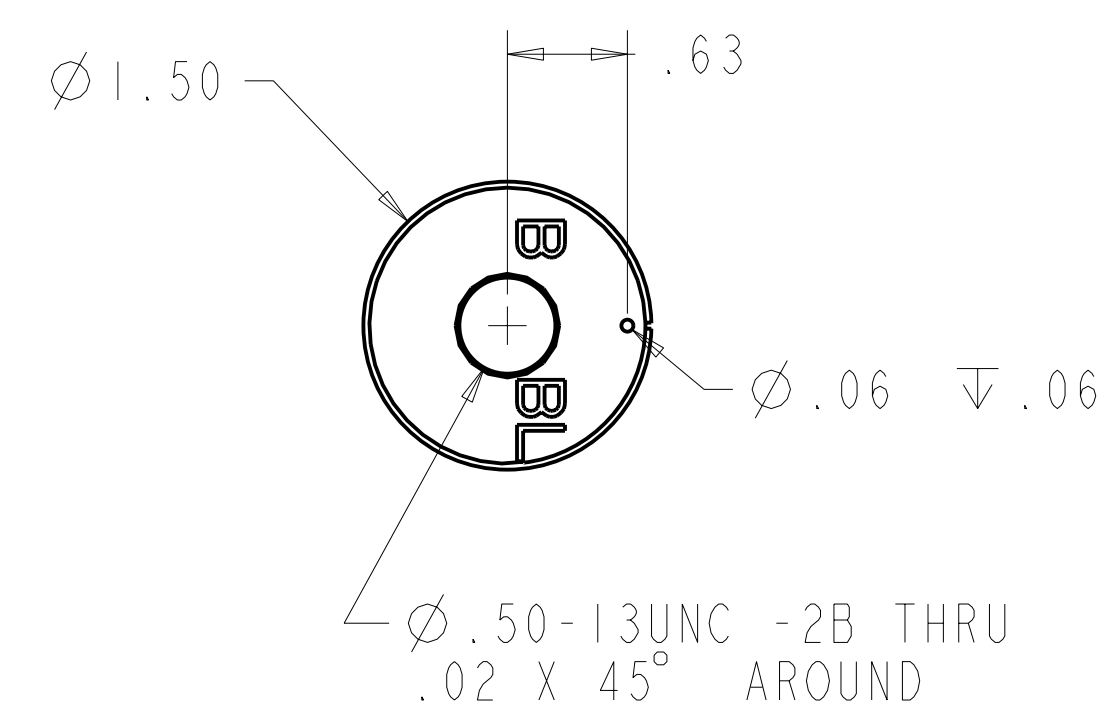
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DETAIL D
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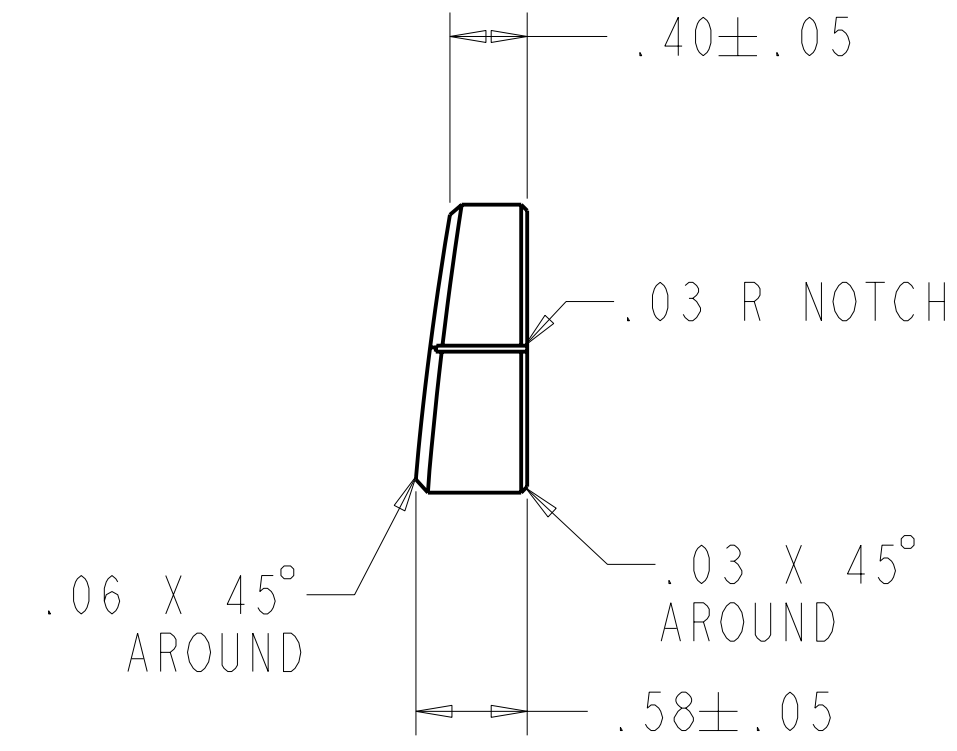
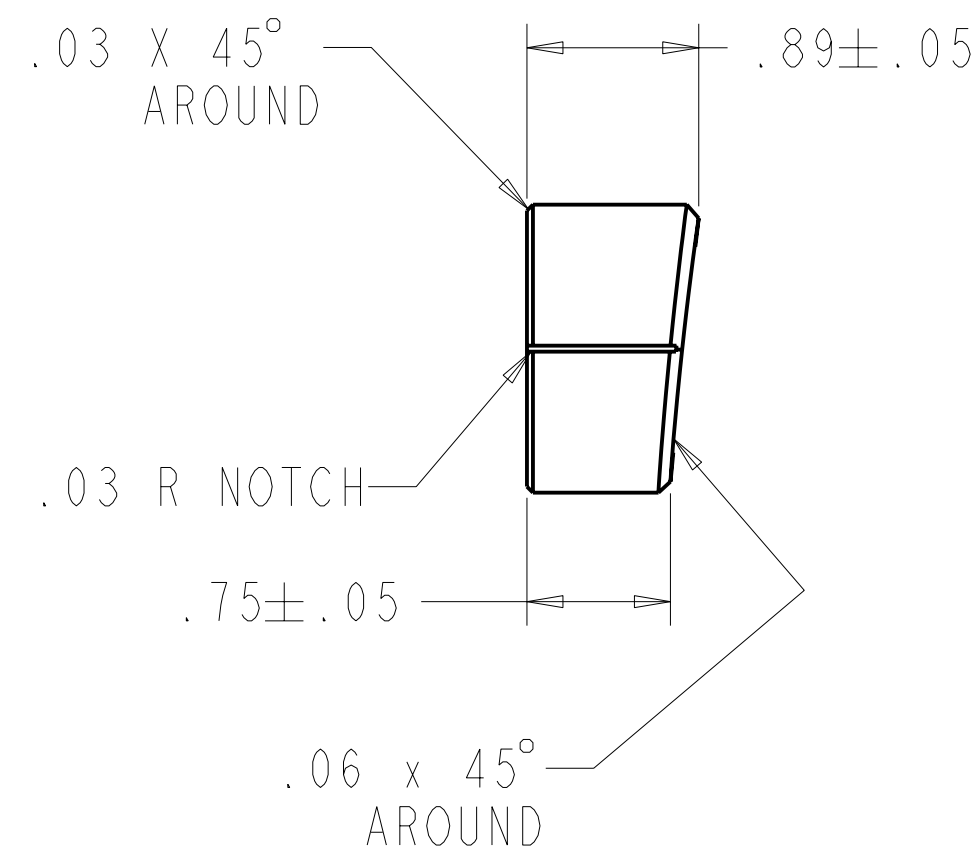
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Oak Ridge National Laboratory managed for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT contract DE-AC05-00OR22725 UT-BATTELLE, LLC, Oak Ridge, Tennessee PROJECT TITLE:						
UT-BATTELLE NATIONAL COMPACT STELLARATOR EXPERIMENT						
MODULAR COIL TYPE-B WINDING FORM AND STUD WELDMENT						
VERSION NO:	PLANT	BLDG	FL	SHT	OF	TYPE CLASS
29+	X-10	5700	3	2	4	S U
RELEASE LEVEL		SE141-122			REV	
Fabrication					I	

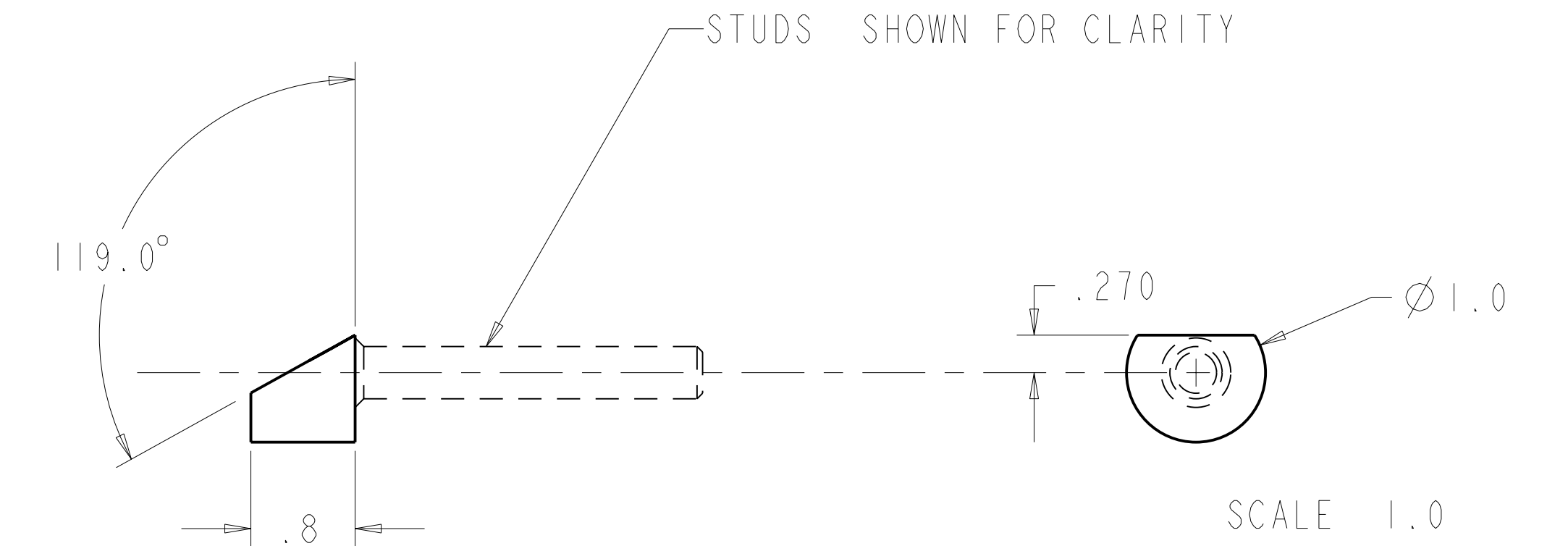
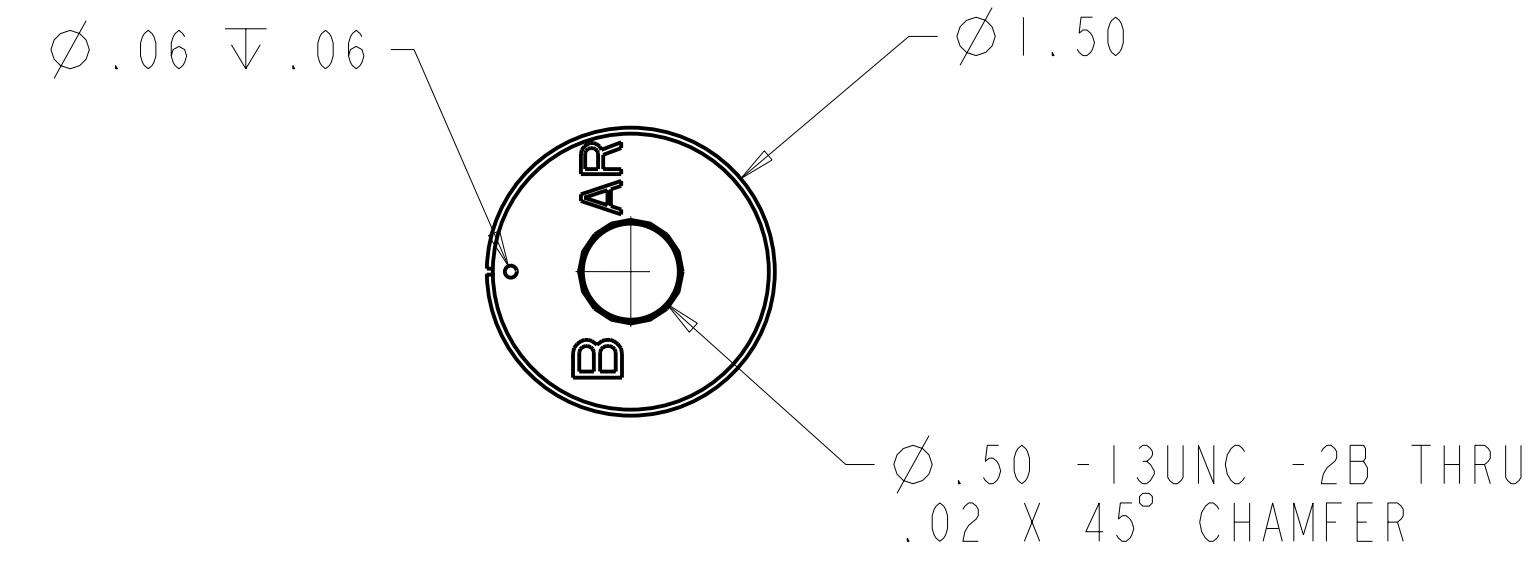


10 SIDE-B LEFT

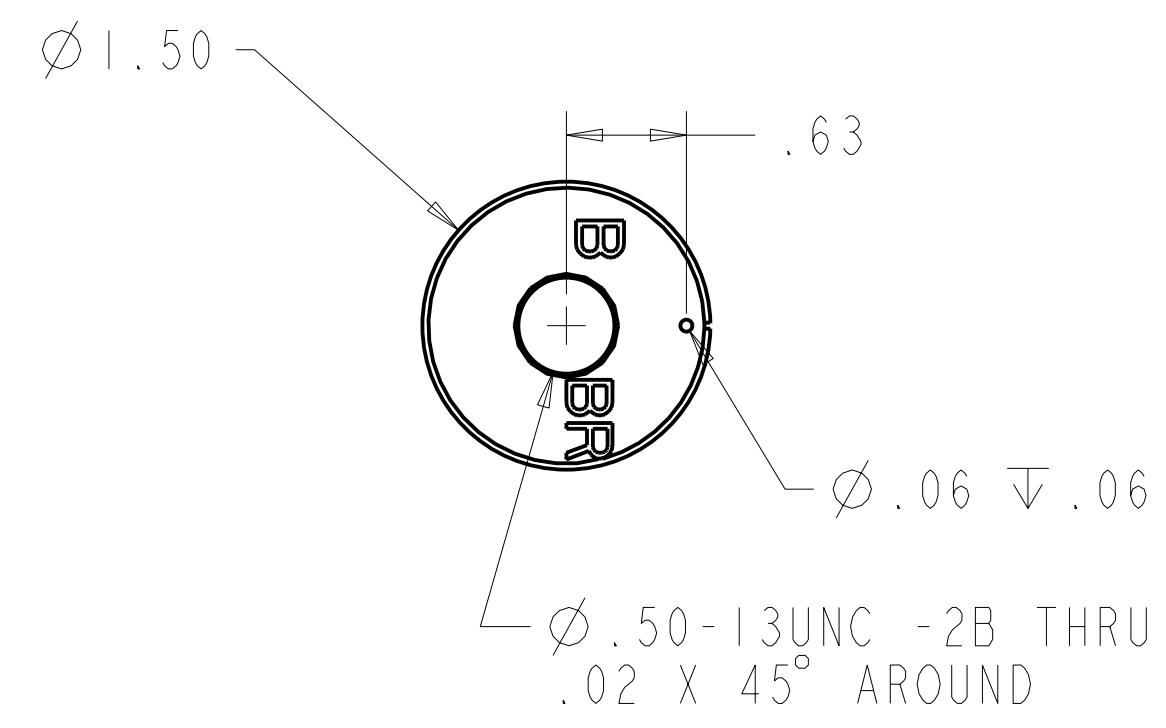
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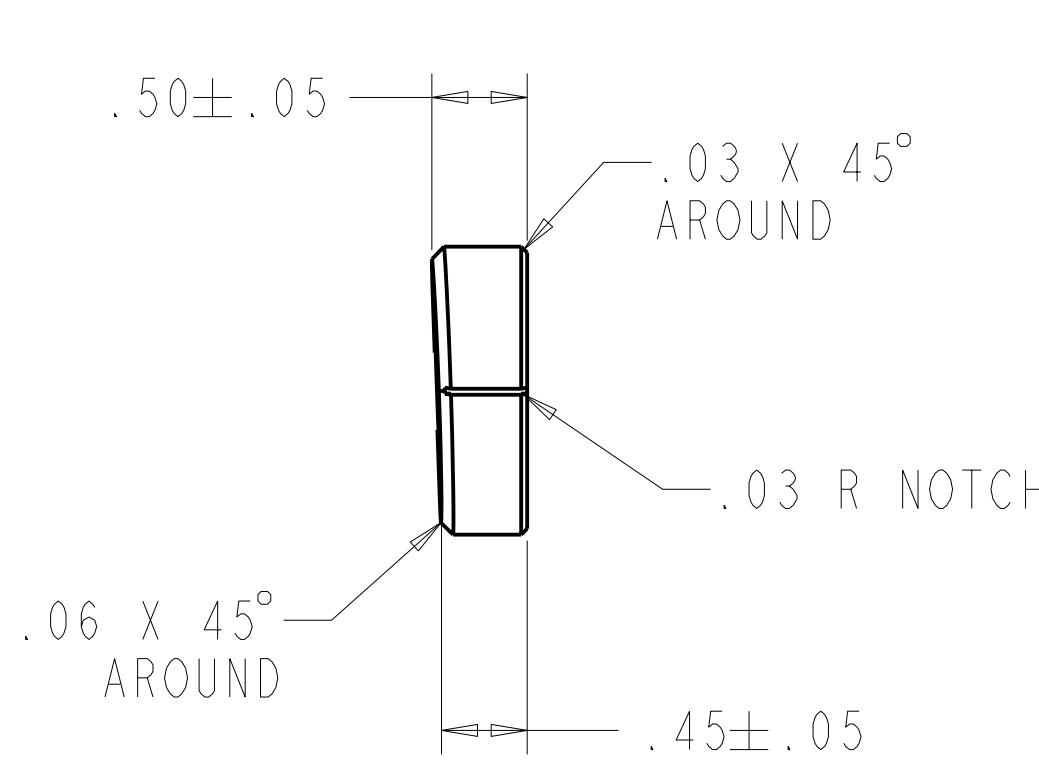
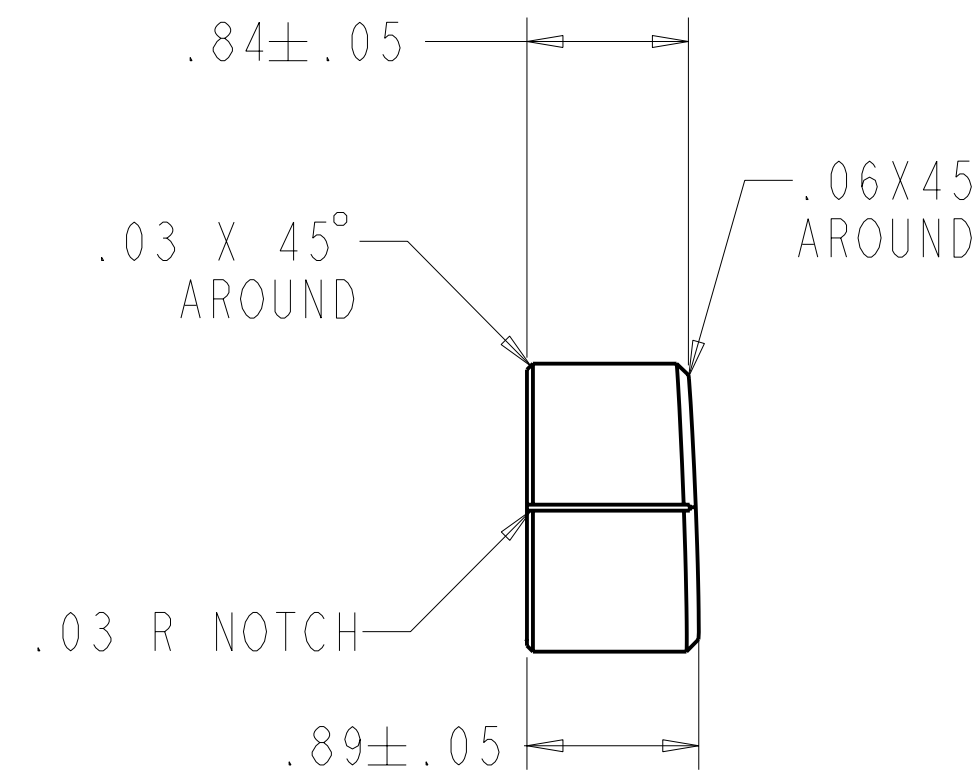
7 SIDE-A RIGHT



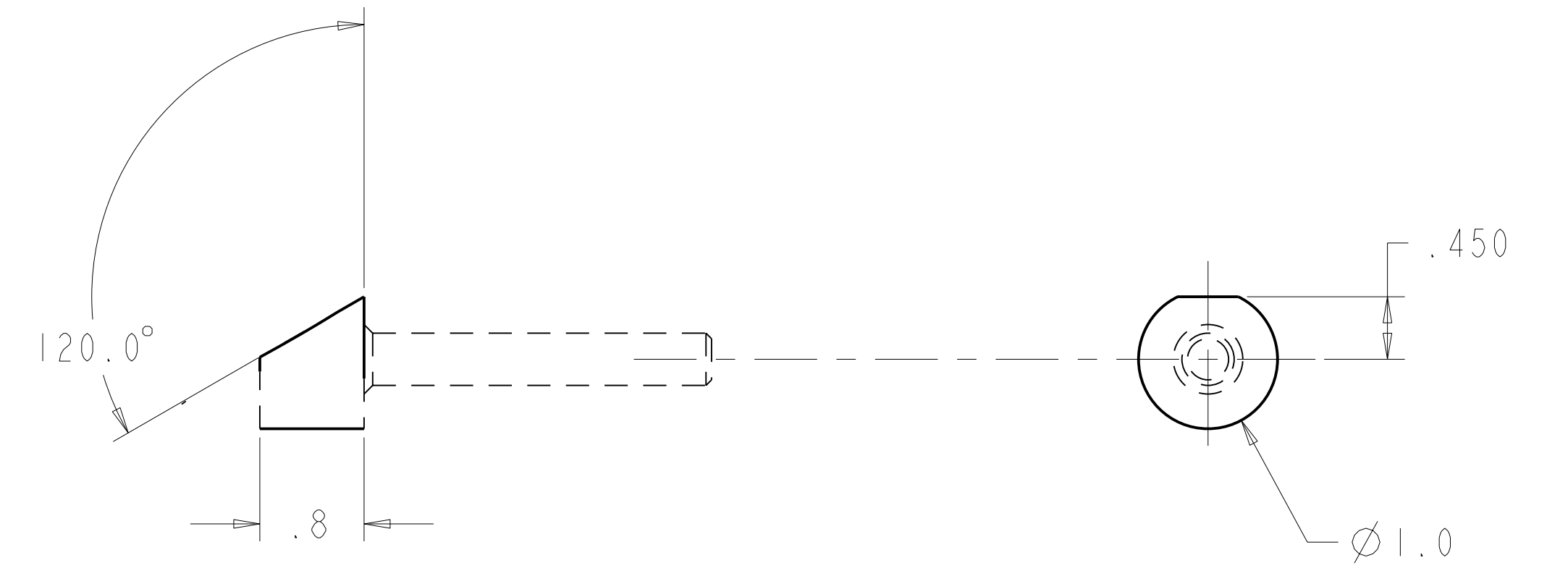
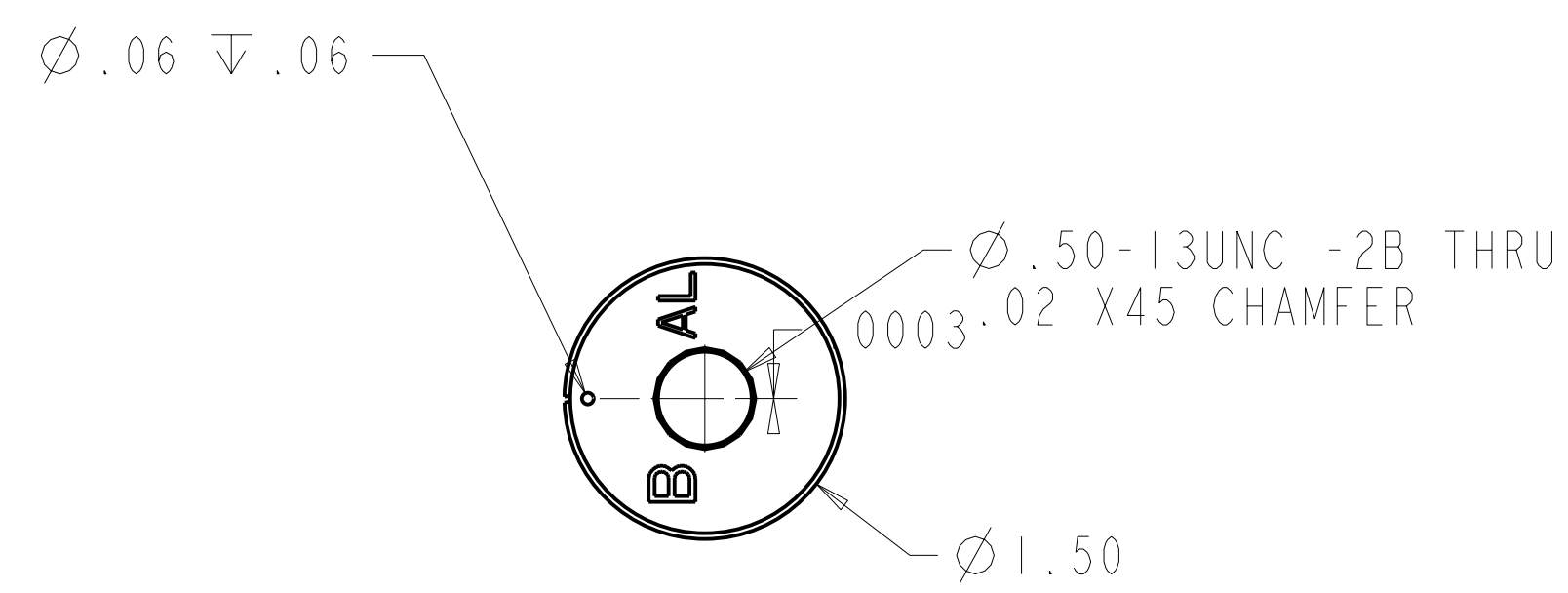
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9 SIDE-B RIGHT

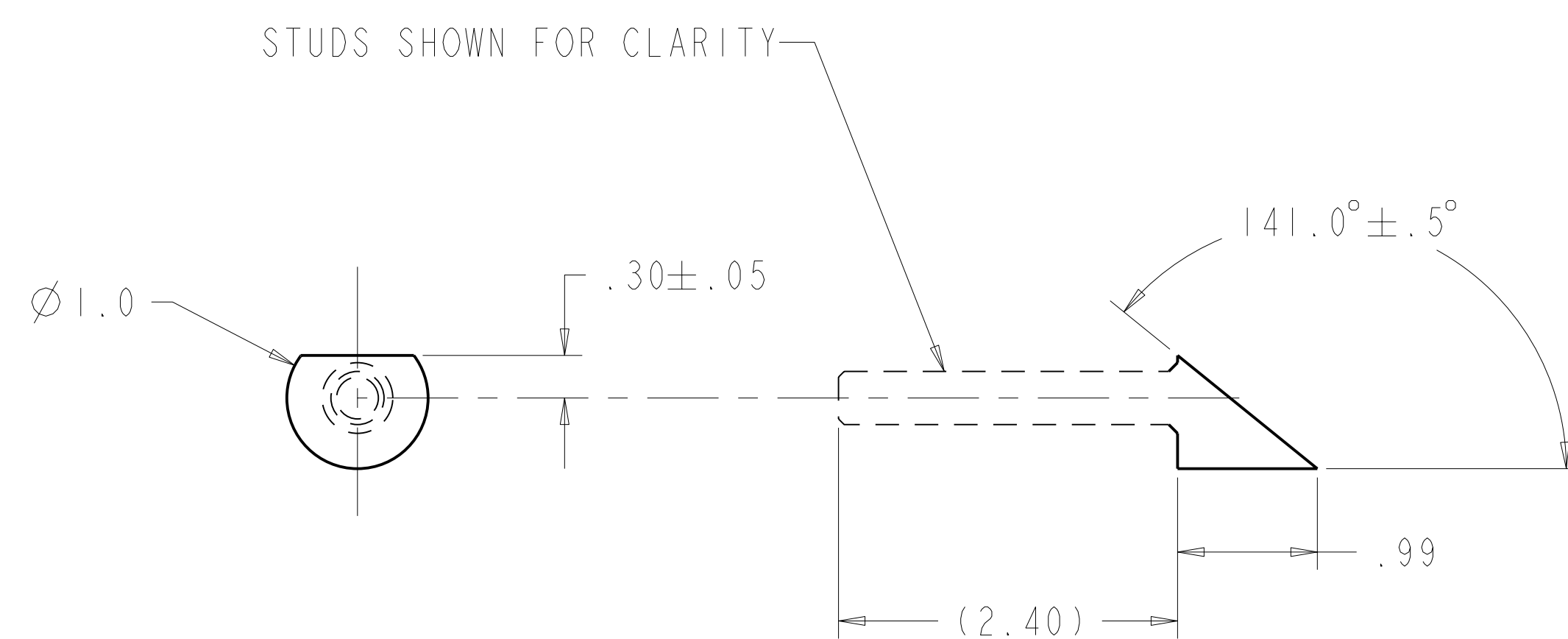


8 SIDE-A LEFT



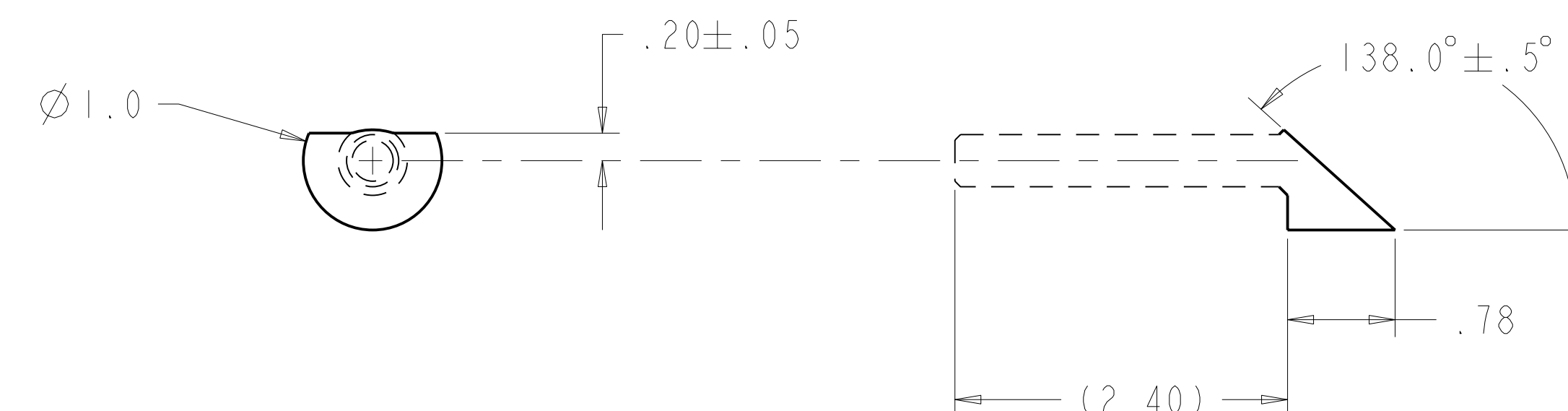
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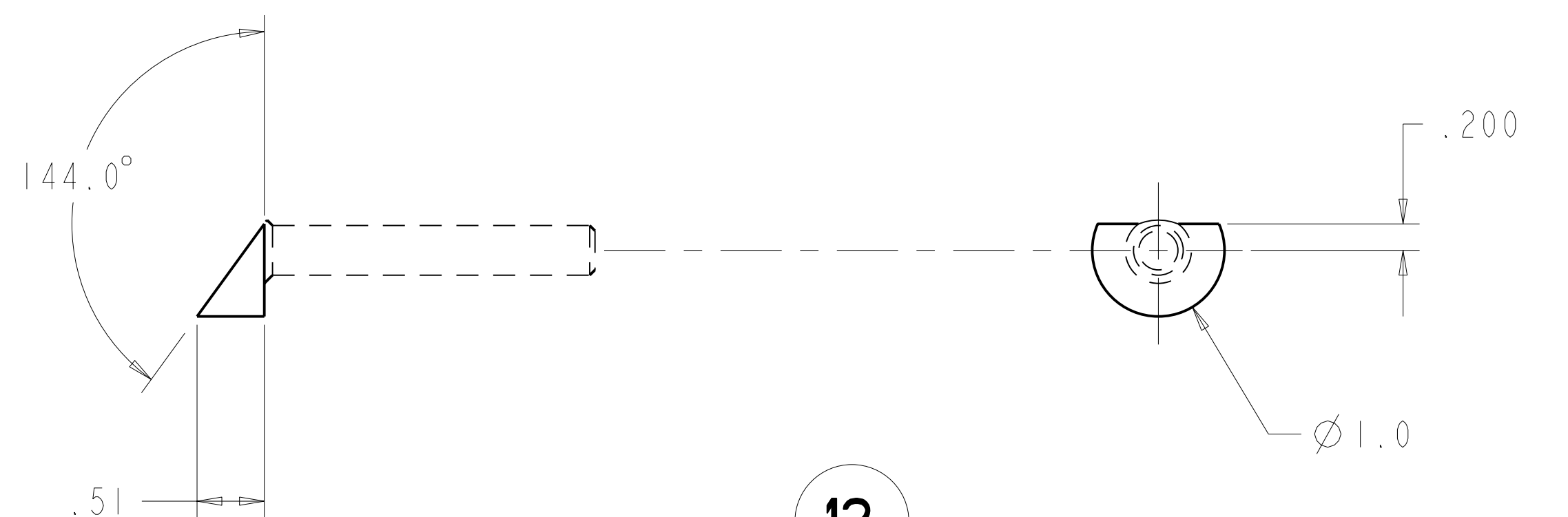
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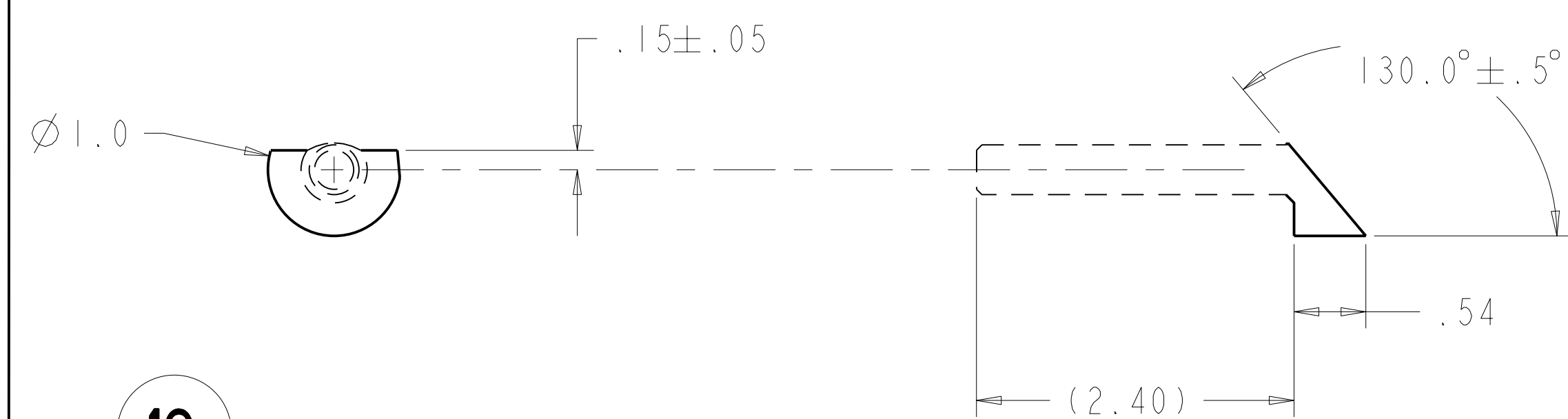
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SCALE 1.0



13

SCALE 1.0

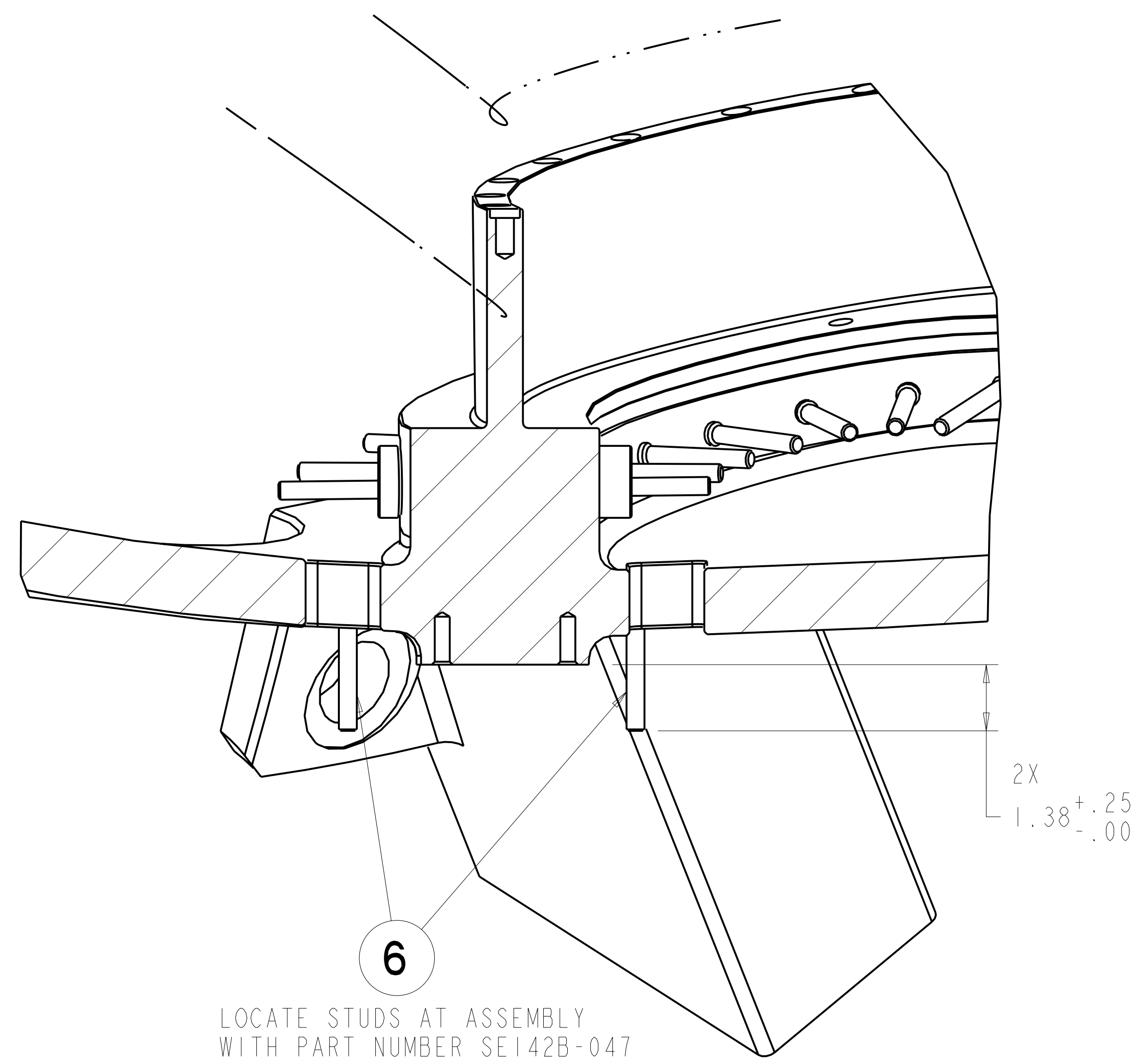


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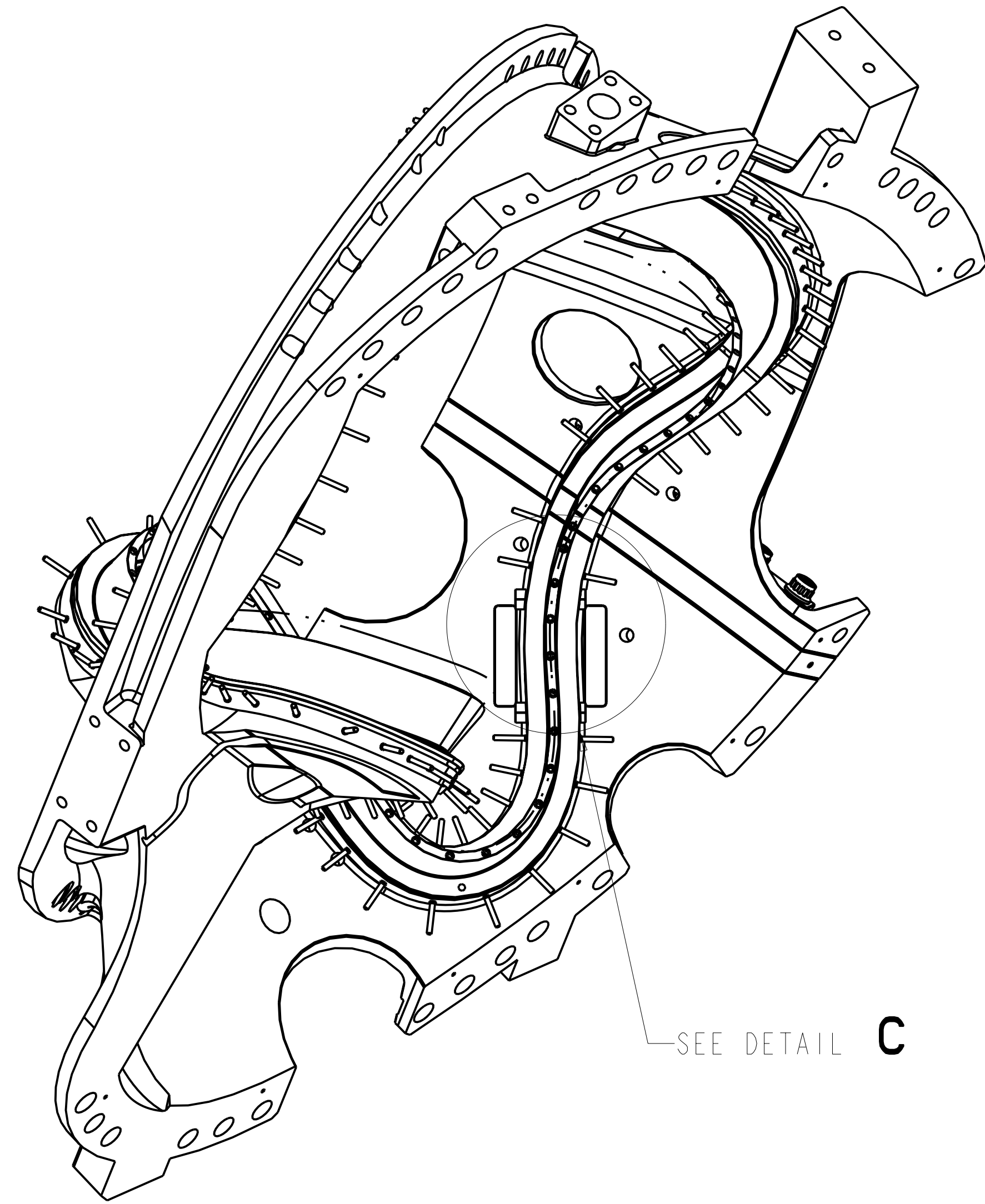
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UT-BATTELLE NATIONAL COMPACT STELLARATOR EXPERIMENT						
MODULAR COIL TYPE-B WINDING FORM AND STUD WELDMENT						
VERSION NO:	PLANT	BLDG	FL	SHT	OF	TYPE CLASS
29+	X-10	5700	3	3	4	S U
RELEASE LEVEL		SE141-122			REV I	
Fabrication						

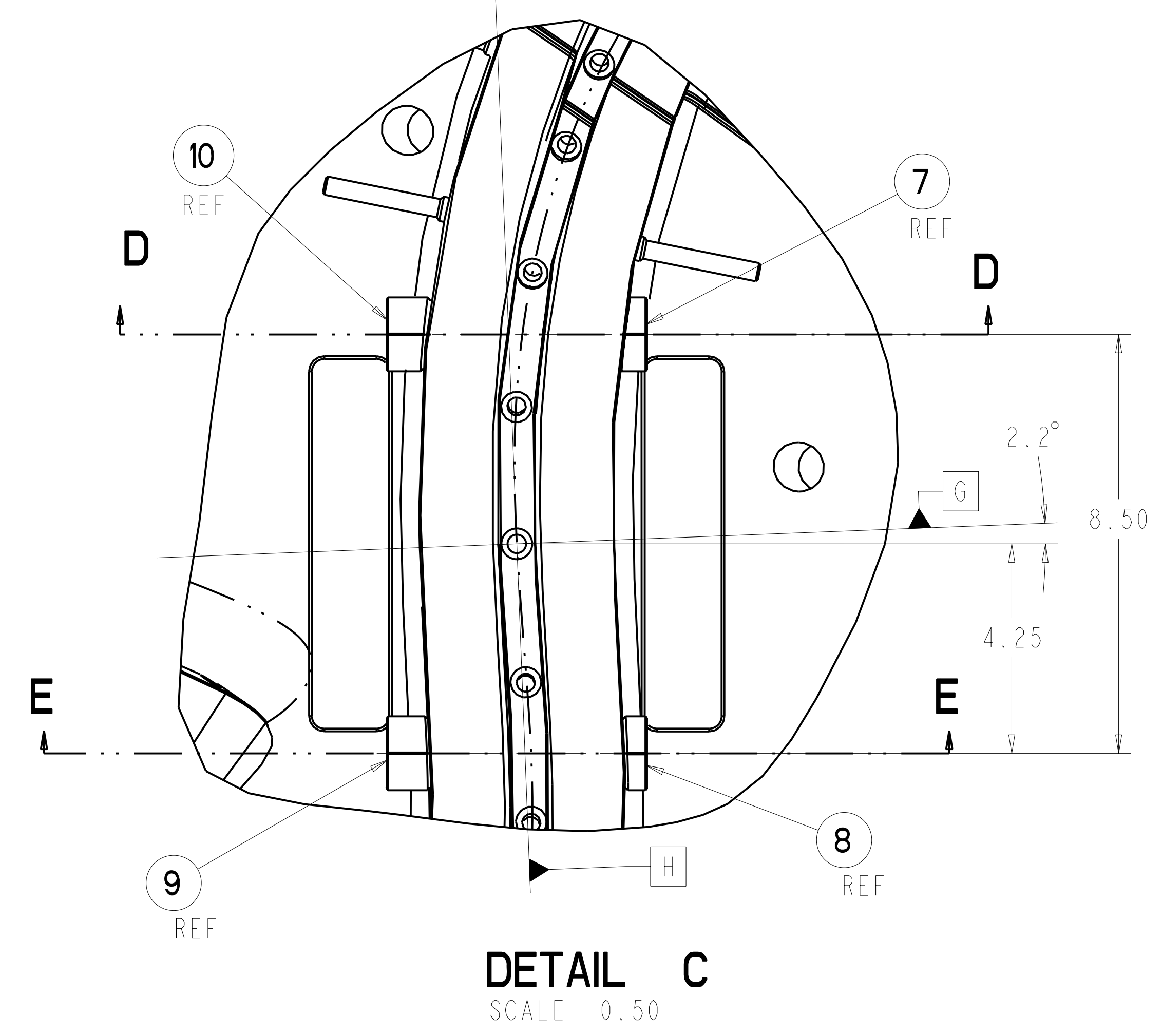


LOCATE STUDS AT ASSEMBLY WITH PART NUMBER SE142B-047

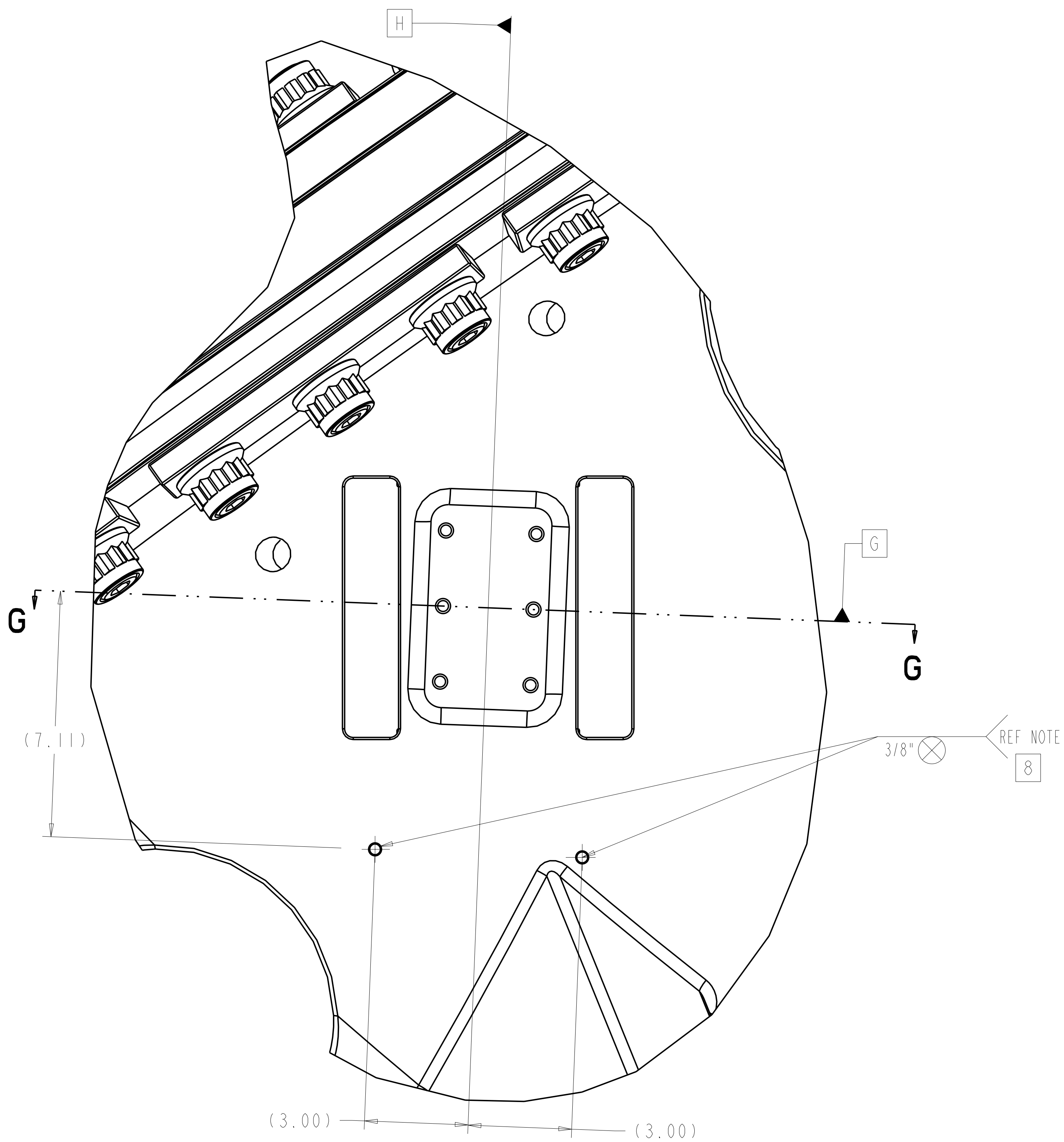
SECTION G-G



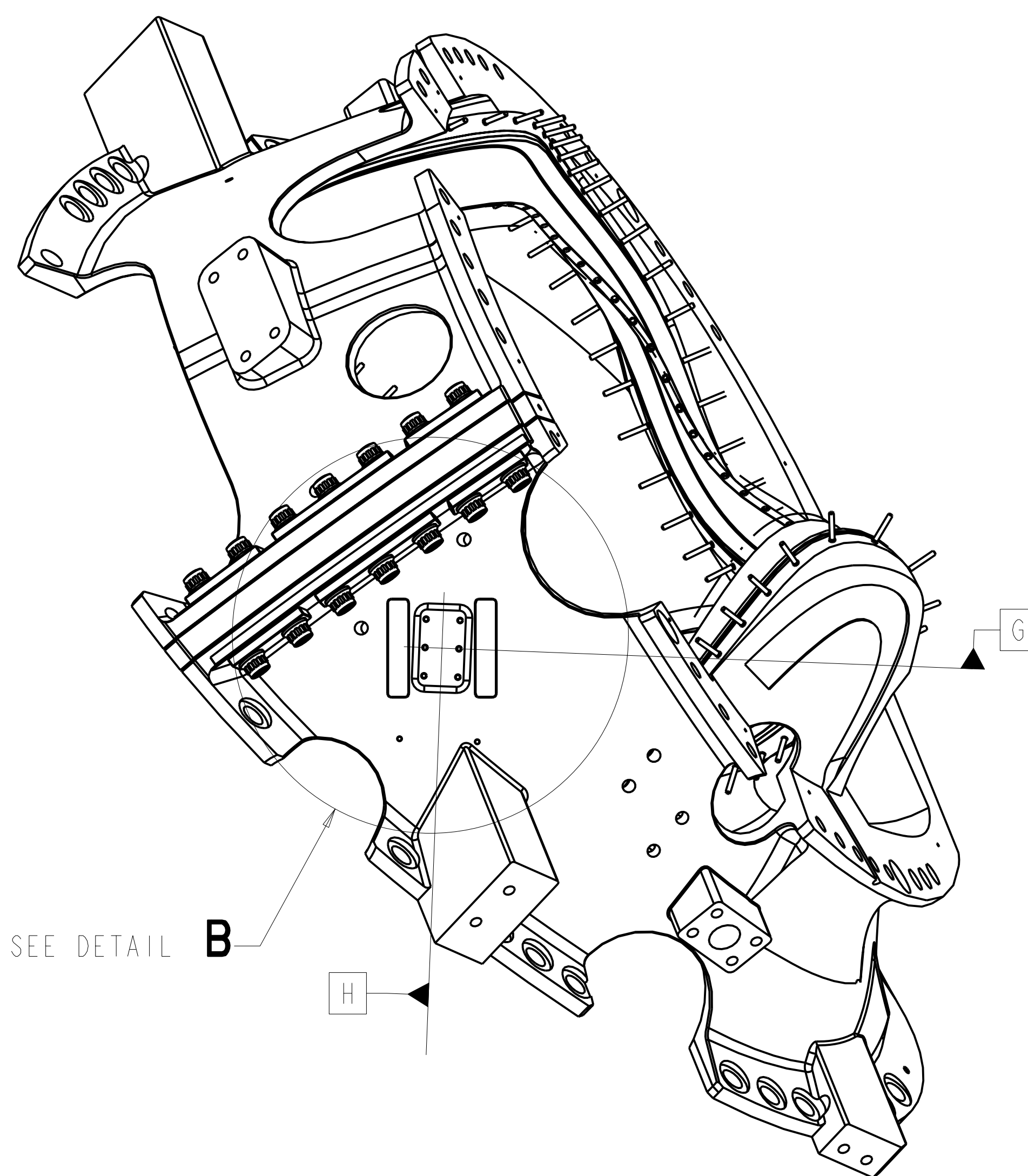
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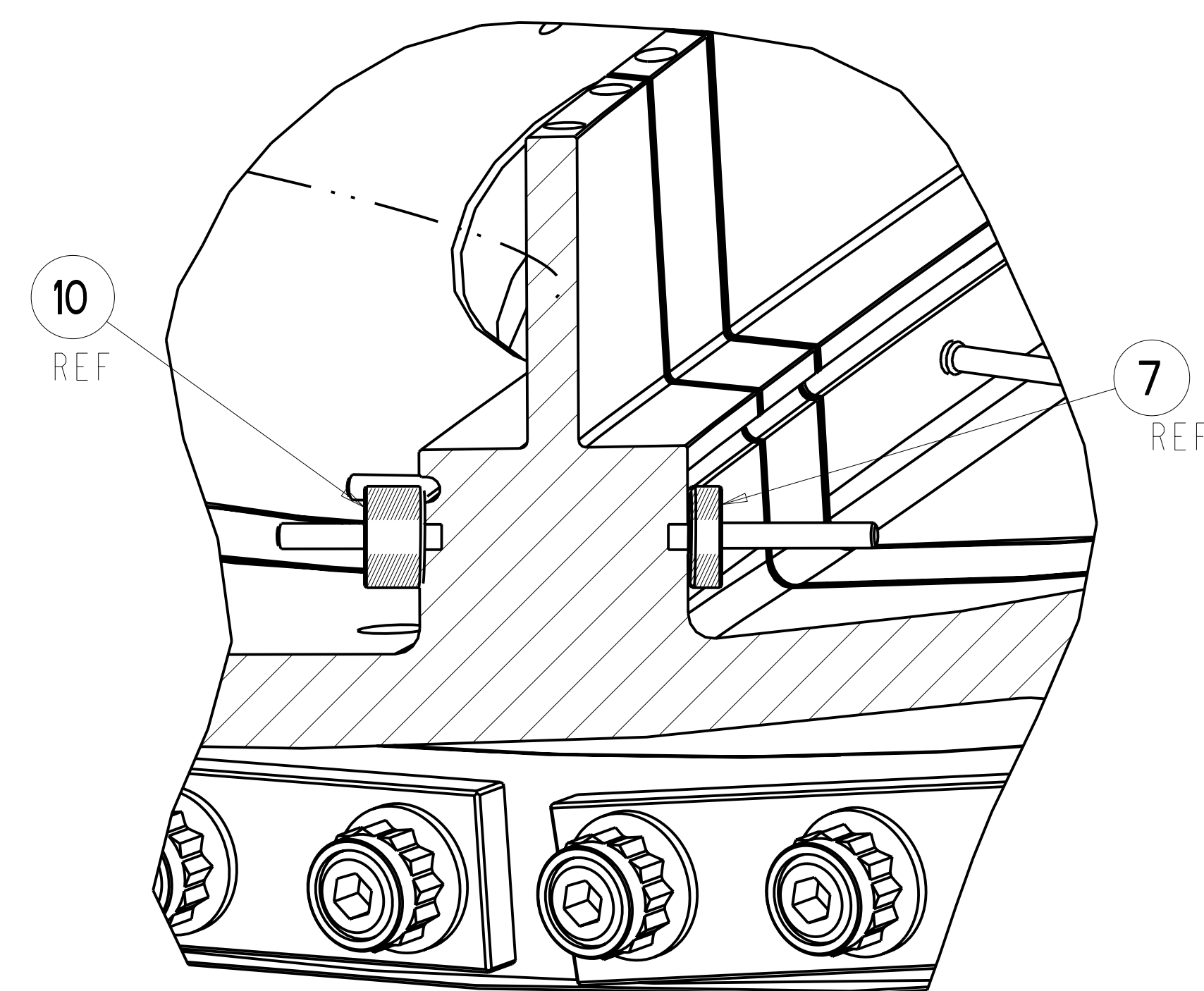
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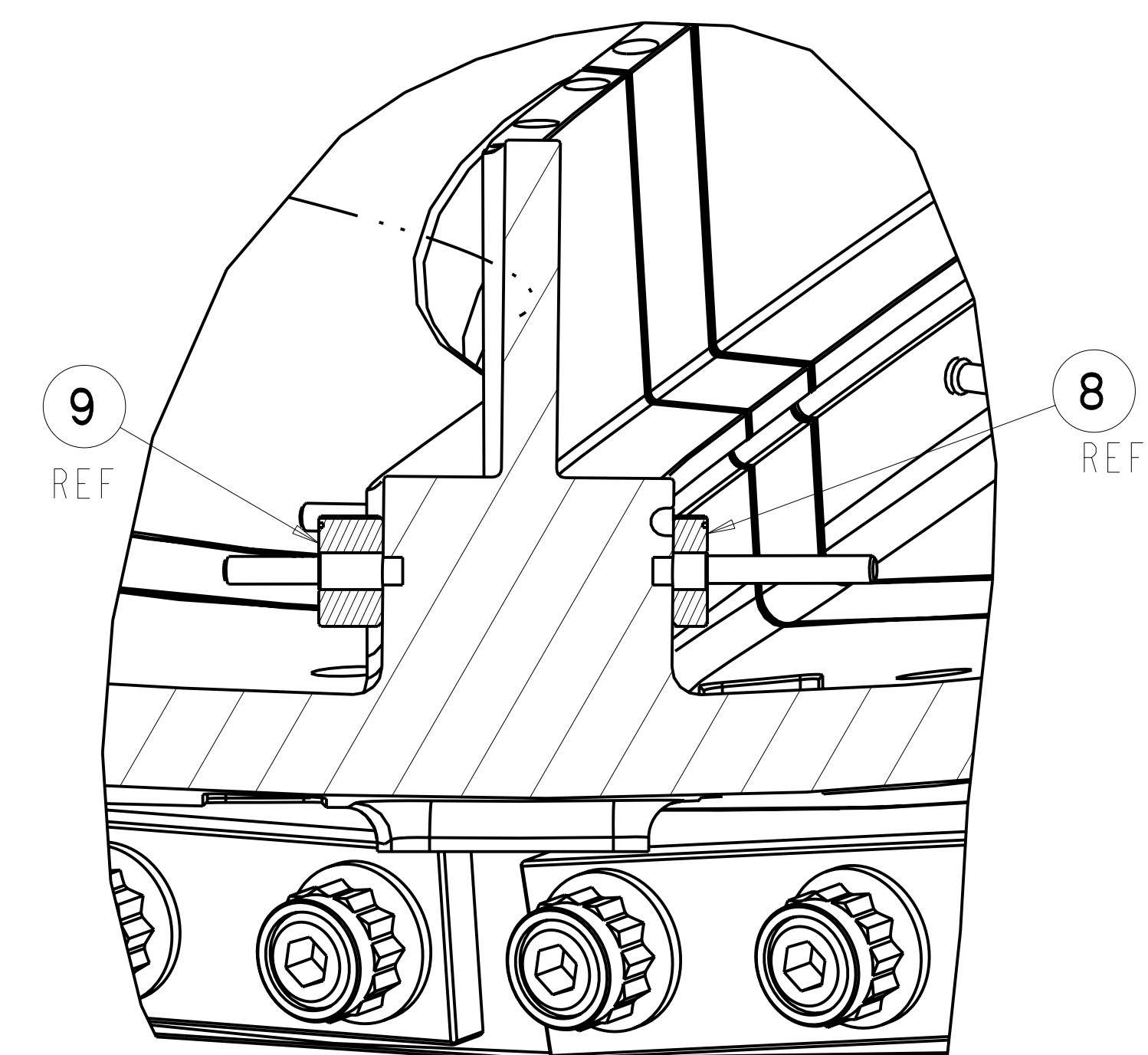
DETAIL B
SCALE 0.50



SCALE 0.13



SECTION D-D



SECTION E-E

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RELEASE LEVEL		SE141-122							
WIP									