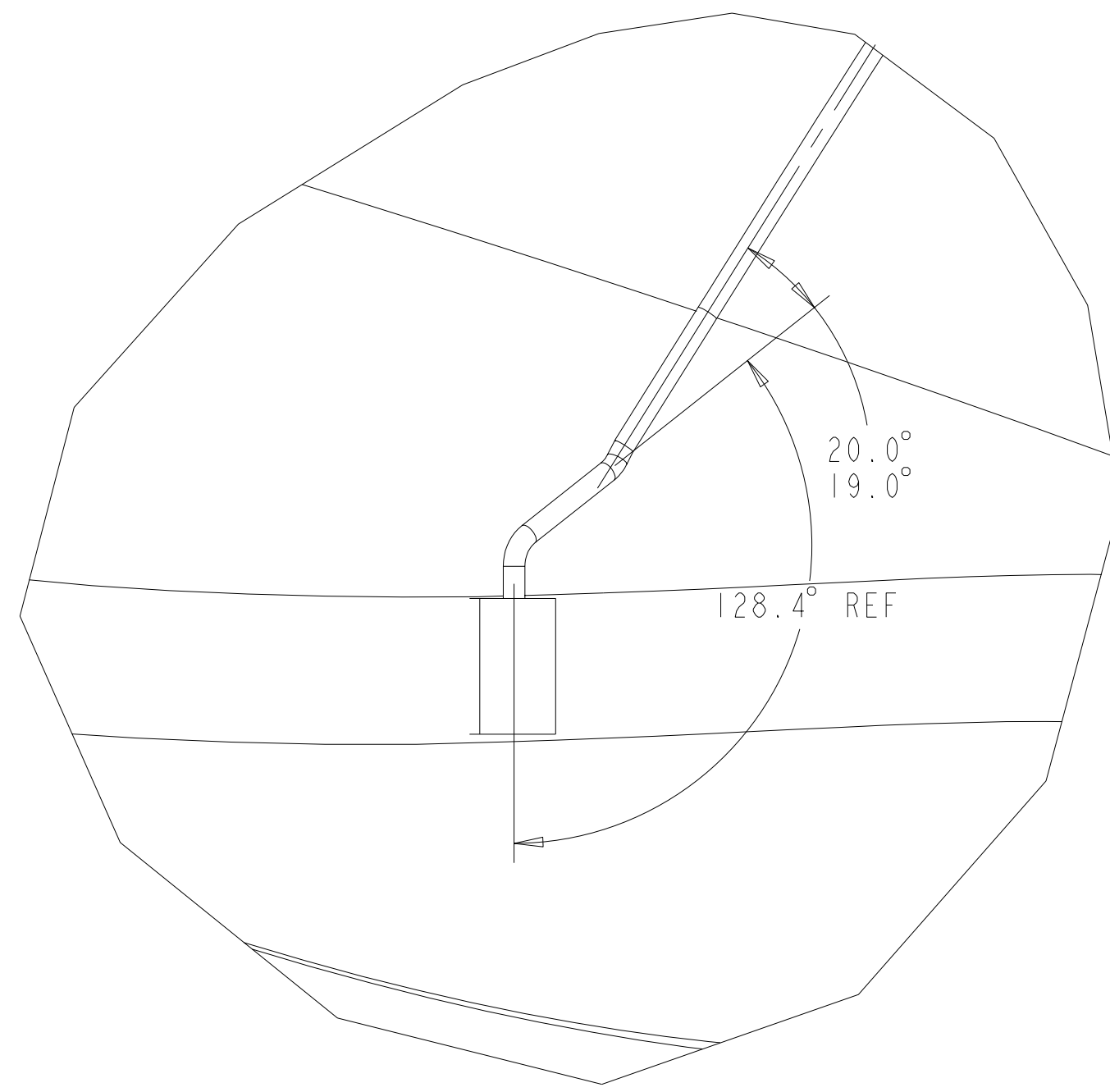
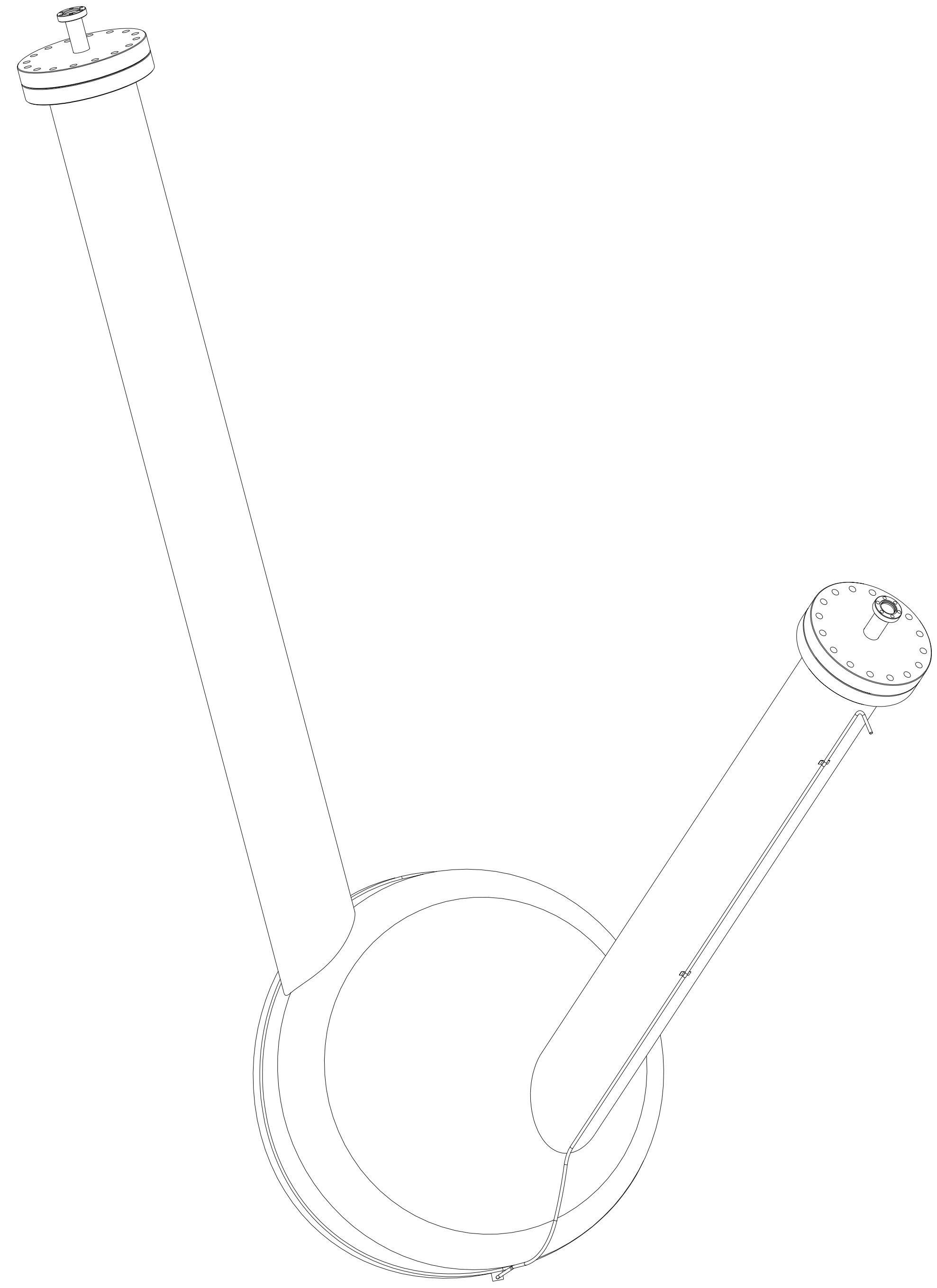


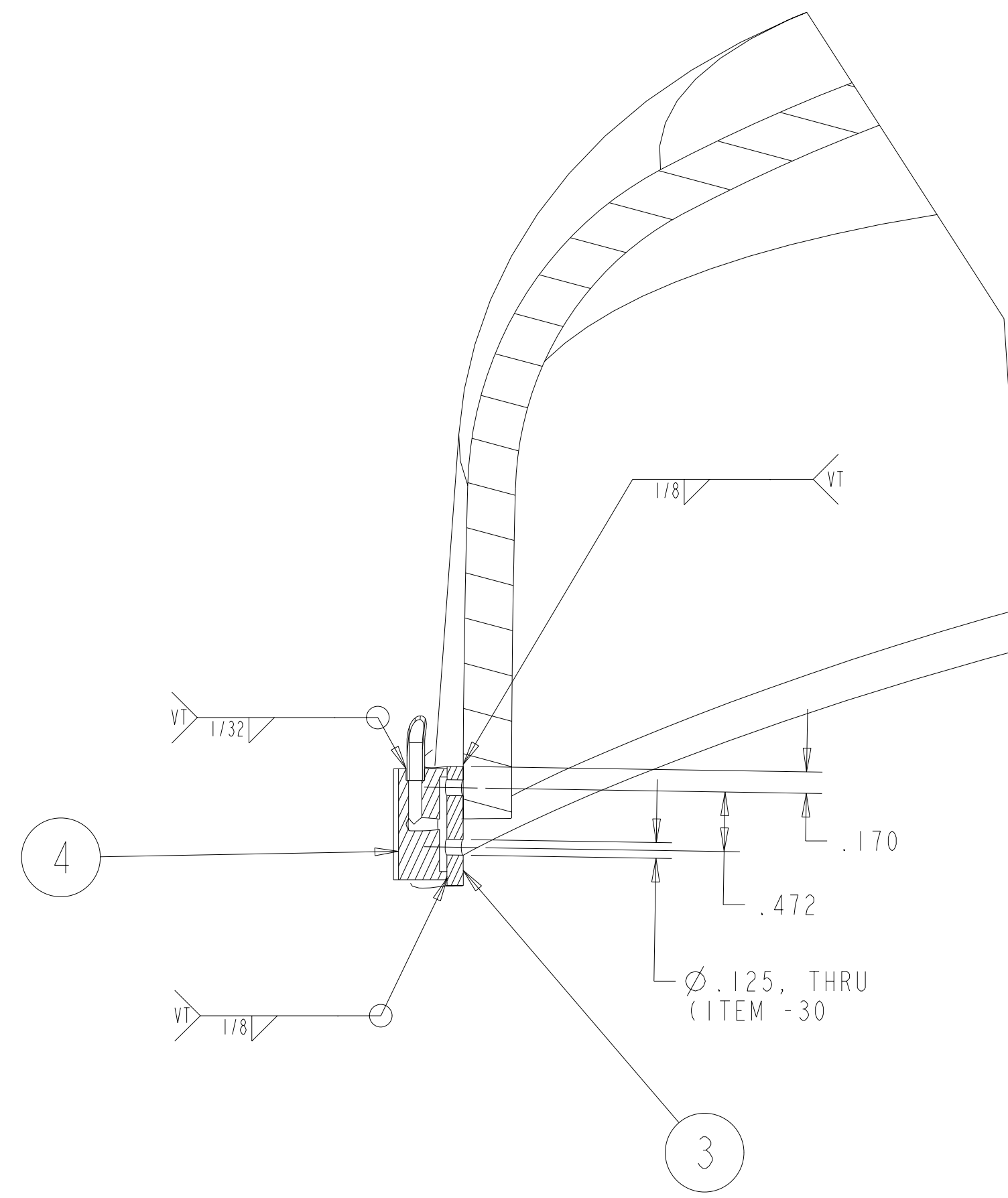
NCSX-RFD-12-004

NOTES:

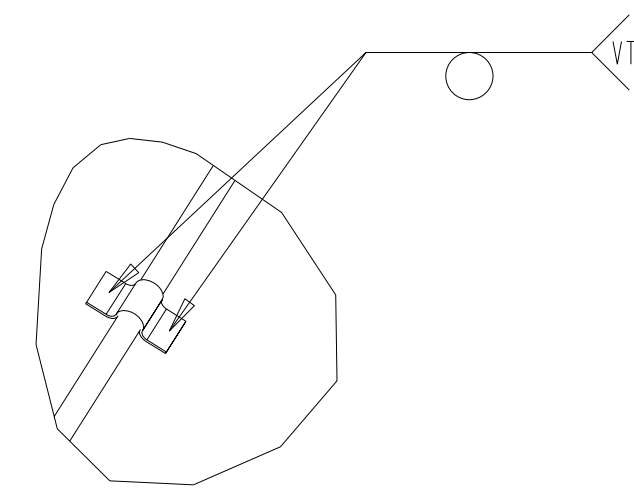
1. INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M
2. DIMENSIONS ARE IN INCHES.
3. DOME "A" WELDMENT AND DOME "B" WELDMENT CREATED AT SE120-003, AS A RESULT OF MATCH MARKING FOR RE-ASSEMBLY.
4. BACKING RING PROFILE OFFSET 1/2" FROM VACUUM VESSEL. CUT NORMAL TO PORT \perp .
5. FABRICATION, INSPECTION, AND TESTING SHALL BE PERFORMED IN ACCORDANCE WITH SPECIFICATION NCSX-CSPEC-121-02 AND STATEMENT OF WORK NCSX-SOW-121-03.



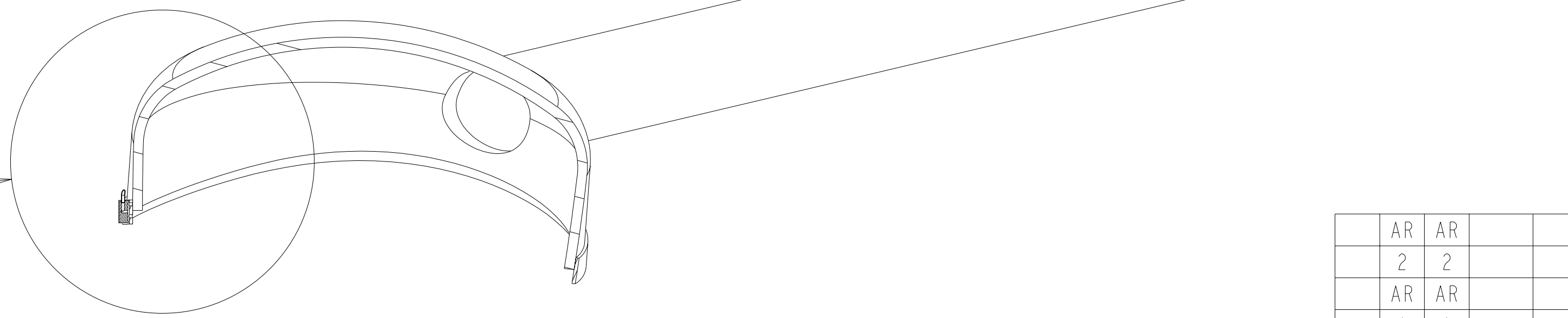
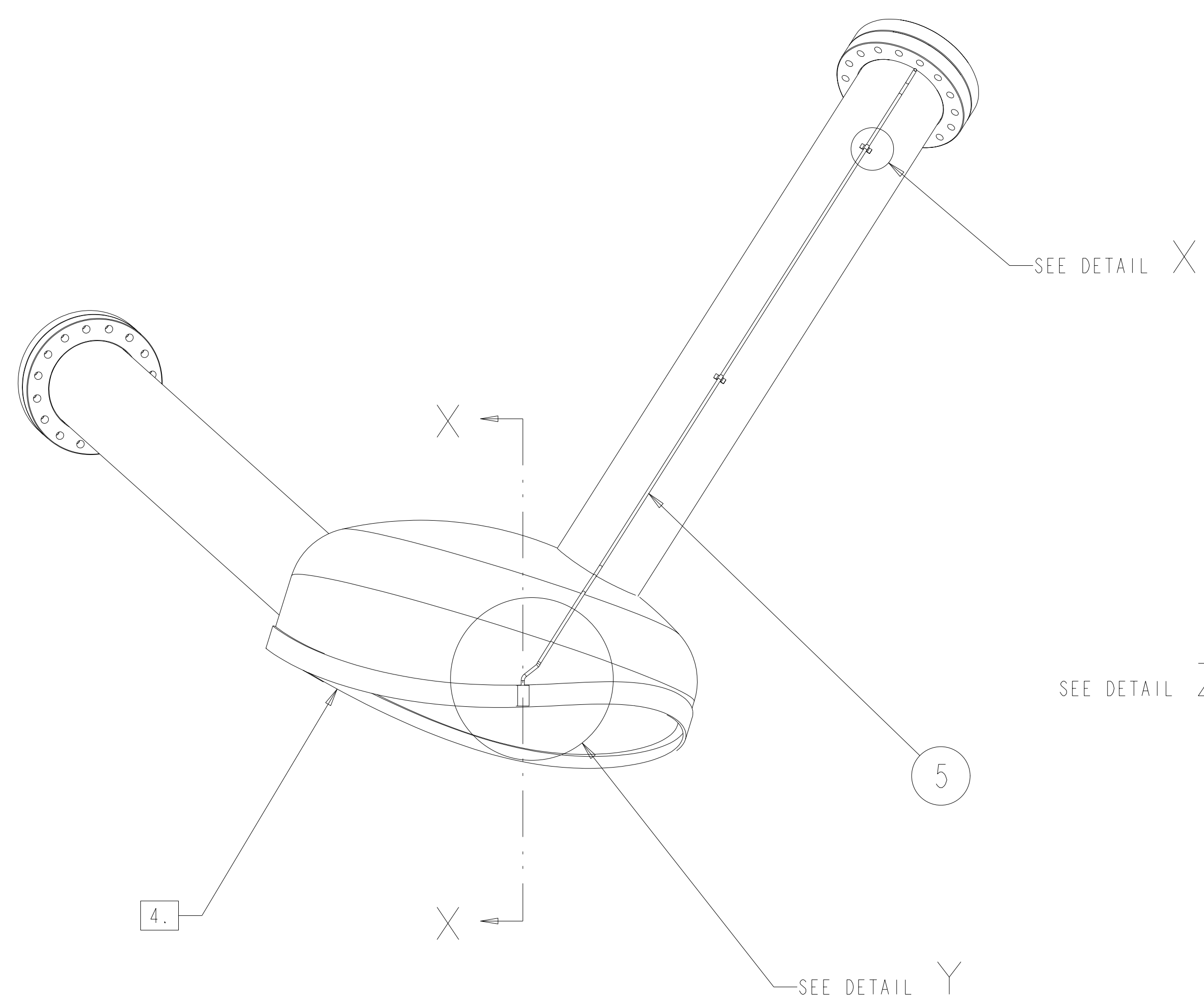
DETAIL Y
SCALE 1.00



DETAIL Z
SCALE 1.00



DETAIL X
SCALE 1.00
SEE SHT 2 FOR CLIP LOCATIONS



SECTION X-X

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

REV	AR	AR	DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
2	2		SE122-005-39	WELD FILLER METAL		7
2	2				CLIP	6
1	1		SE122-105	TUBING 1/8 X .035 WALL	316L SST	5
1	1				BLOCK	4
1	1		-3	DOMES 18 BACKING RING	UNS N06625	3
3	AR		-2	DOMES "B" WELDMENT		2
3	AR		-1	DOMES "A" WELDMENT		1

CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
SE122-003	-2	BACKING RING			
	-1	WELDMENT			

PARTS LIST

WELDING ENGINEER
APPROVED R PARSELLS DATE: 6/04

1 2

SCALE .25

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 BIDDERS ARE NOT TO BE USED FOR OTHER PURPOSES, AND ARE TO BE RETURNED UPON REQUEST OF THE FORWARDING CONTRACTOR.

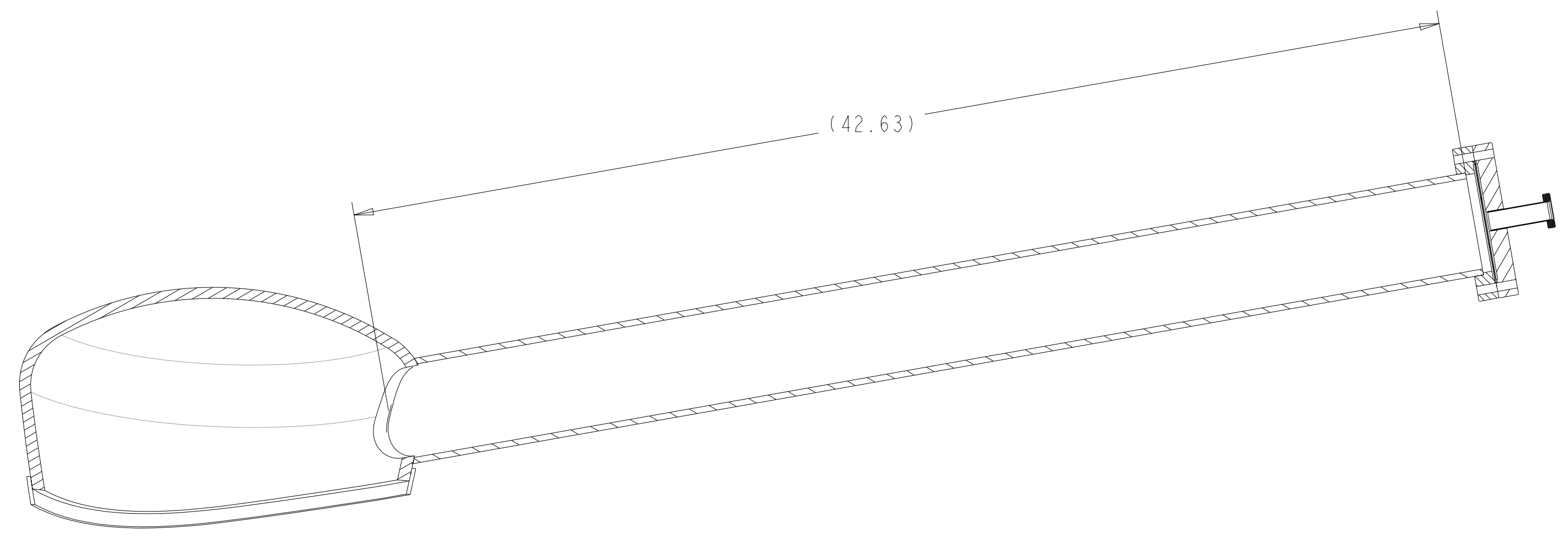
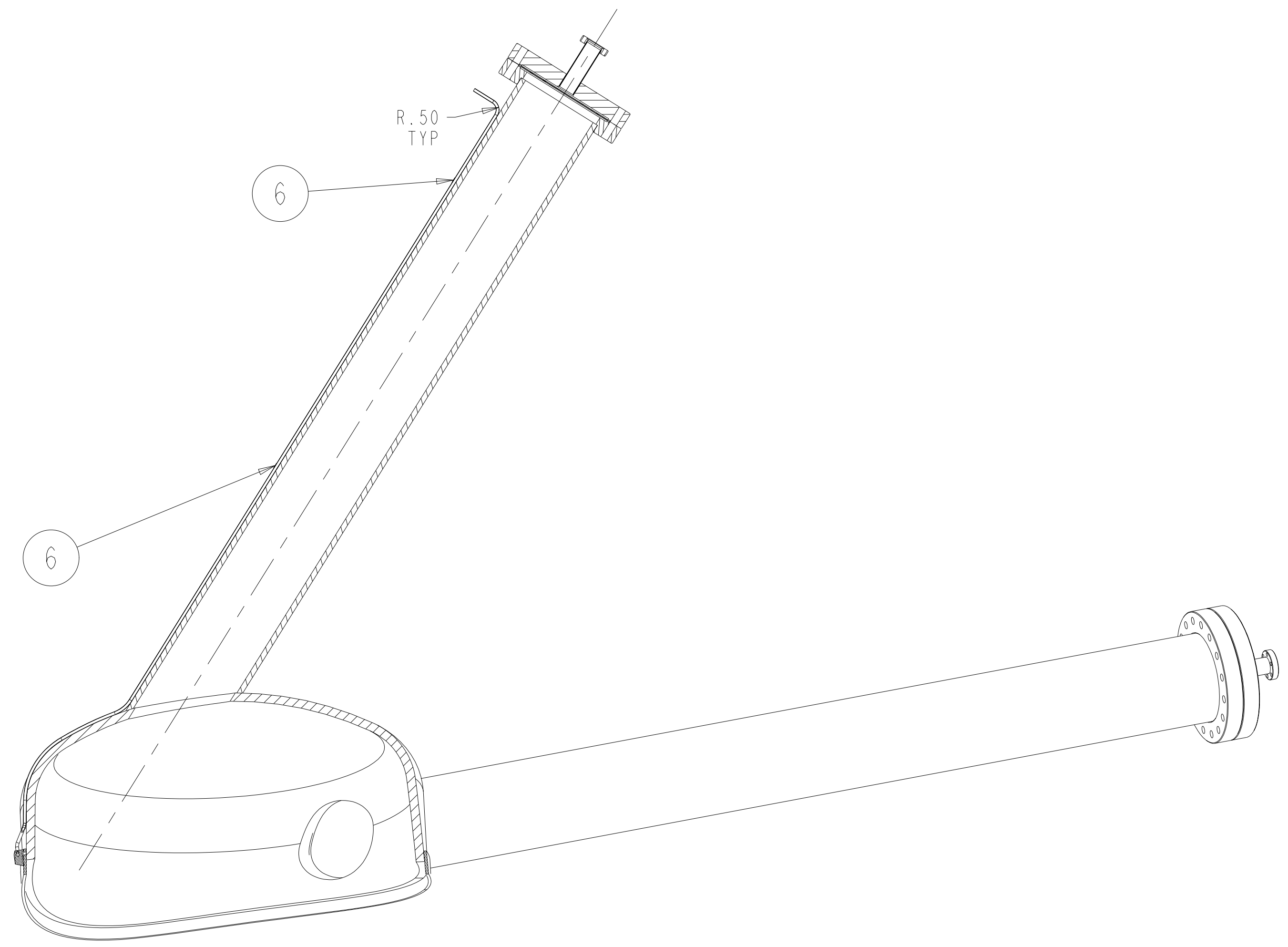
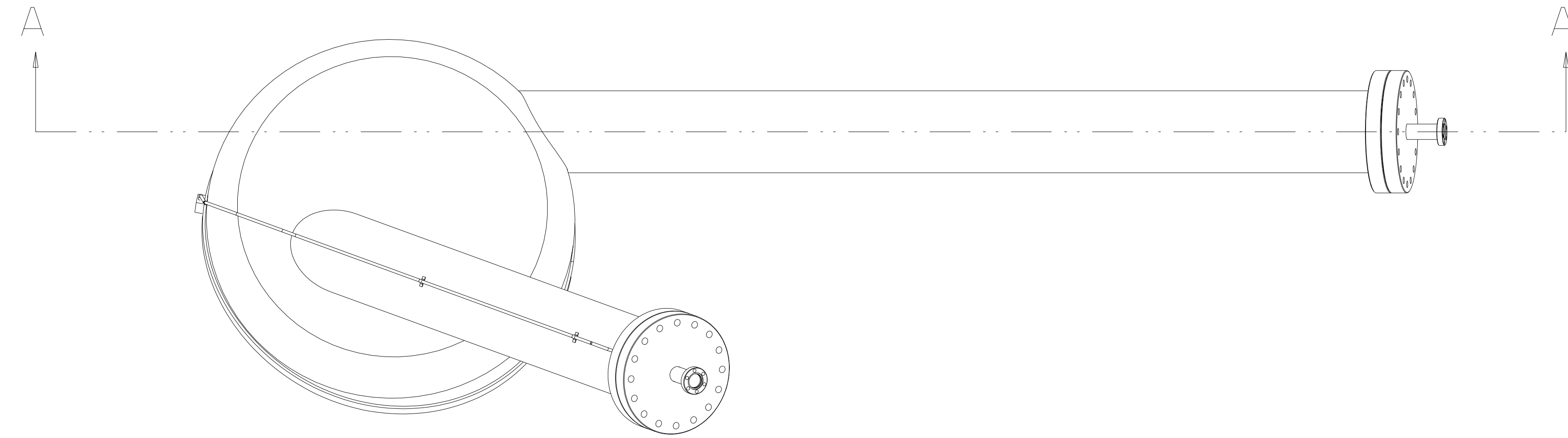
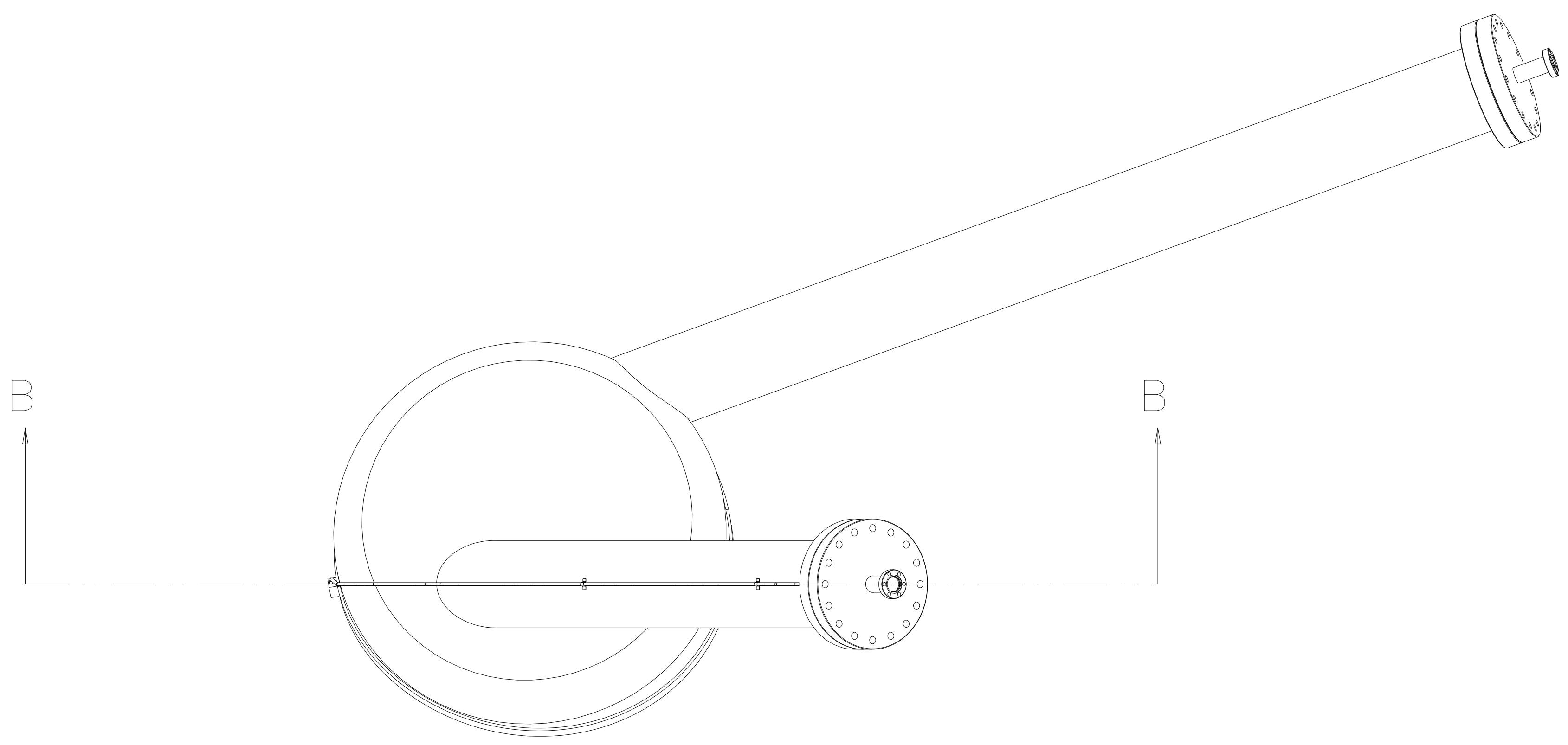
P

THIS DRAWING PRODUCED ON PRO-ENGINEER

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

SCALE NOTED	DES. P.L. GORANSON 8/03	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 VACUUM VESSEL PORT 17 & 18 WELDMENT
TOLERANCES UNLESS OTHERWISE SPECIFIED	DRW. G.H. JONES 8/03	
FRACTIONS	CHK. MIKE COLE 6/04	
XX DECIMALS ±.01	DEPT. :	
XXX DECIMALS ±.005	PE. :	
ANGLES ±0°15'	CR. :	
BREAK SHARP EDGES .06 MAX	FJ. :	
FINISH .125 UNLESS OTHERWISE SPECIFIED	REQ. :	
	PPPL DRFT J SIEGEL 6/04	VERSION NO. 24
		PLANT X-10
		BLDG 5700
		FL 3
		SHT 1
		OF 2
		TYPE S
		CLASS U
		REV 0
		RELEASE LEVEL Fabrication
		SE122-007

FOR NOTES AND PARTS LIST, SEE SHEET 1.



SECTION B-B

SECTION A-A

**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							
VACUUM VESSEL PORT 17 & 18 WELDMENT							
VERSION NO. 24	PLANT X-10	BLDG 5700	FL 3	SHT OF 2	TYPE S	CLASS U	REV 0
RELEASE LEVEL Fabrication		SE122-007					

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SE122-007