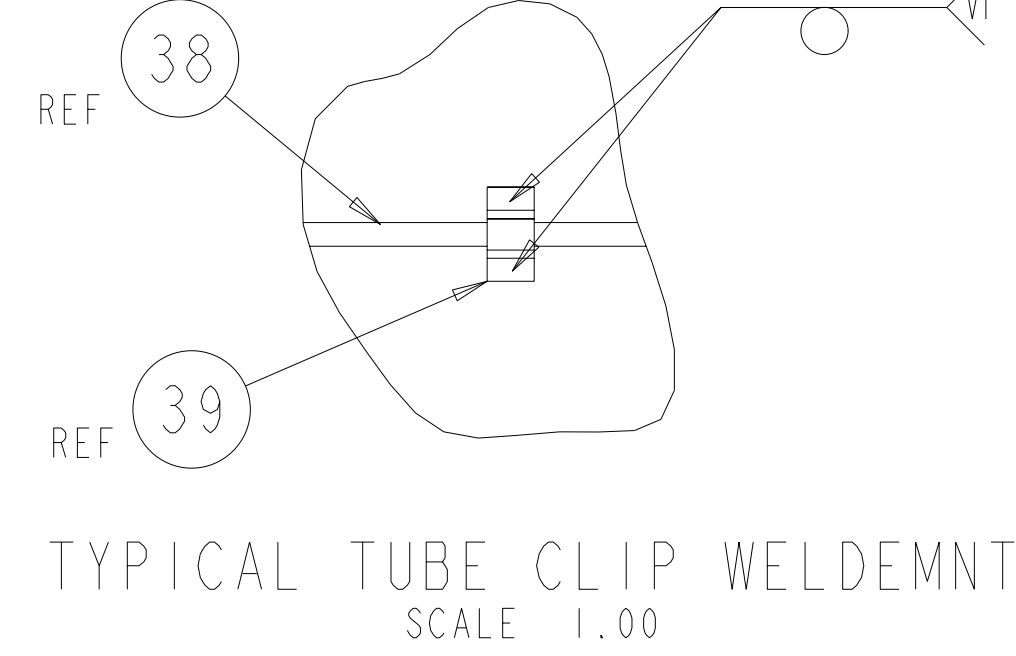
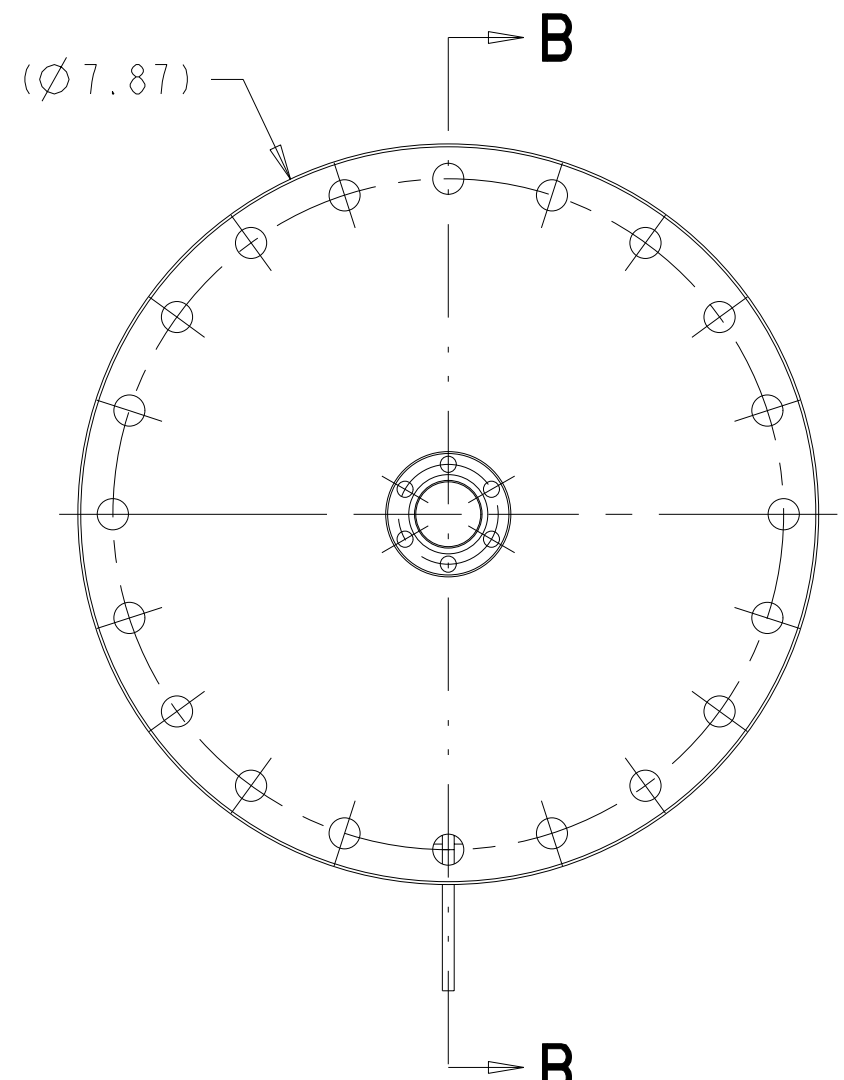
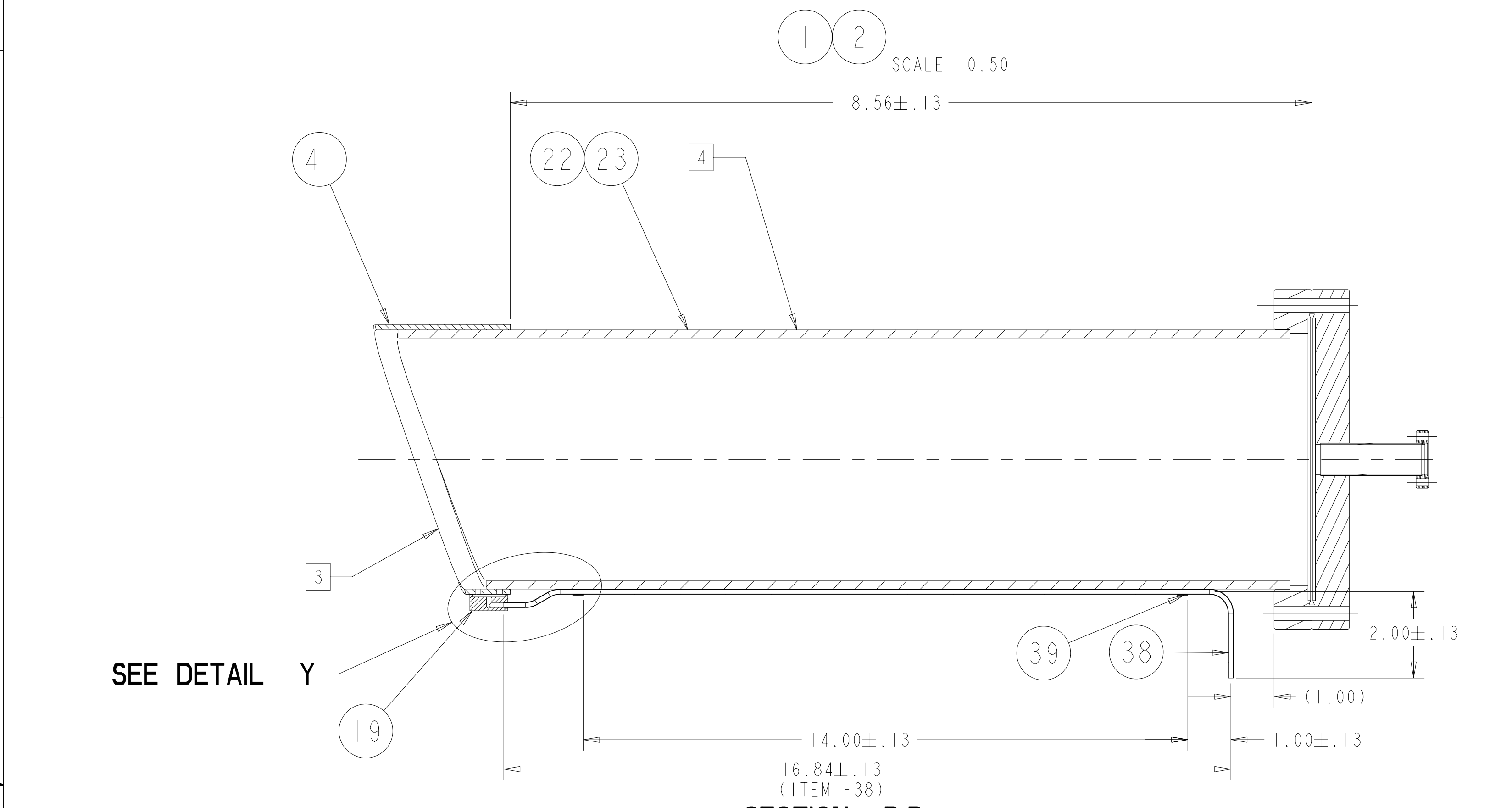


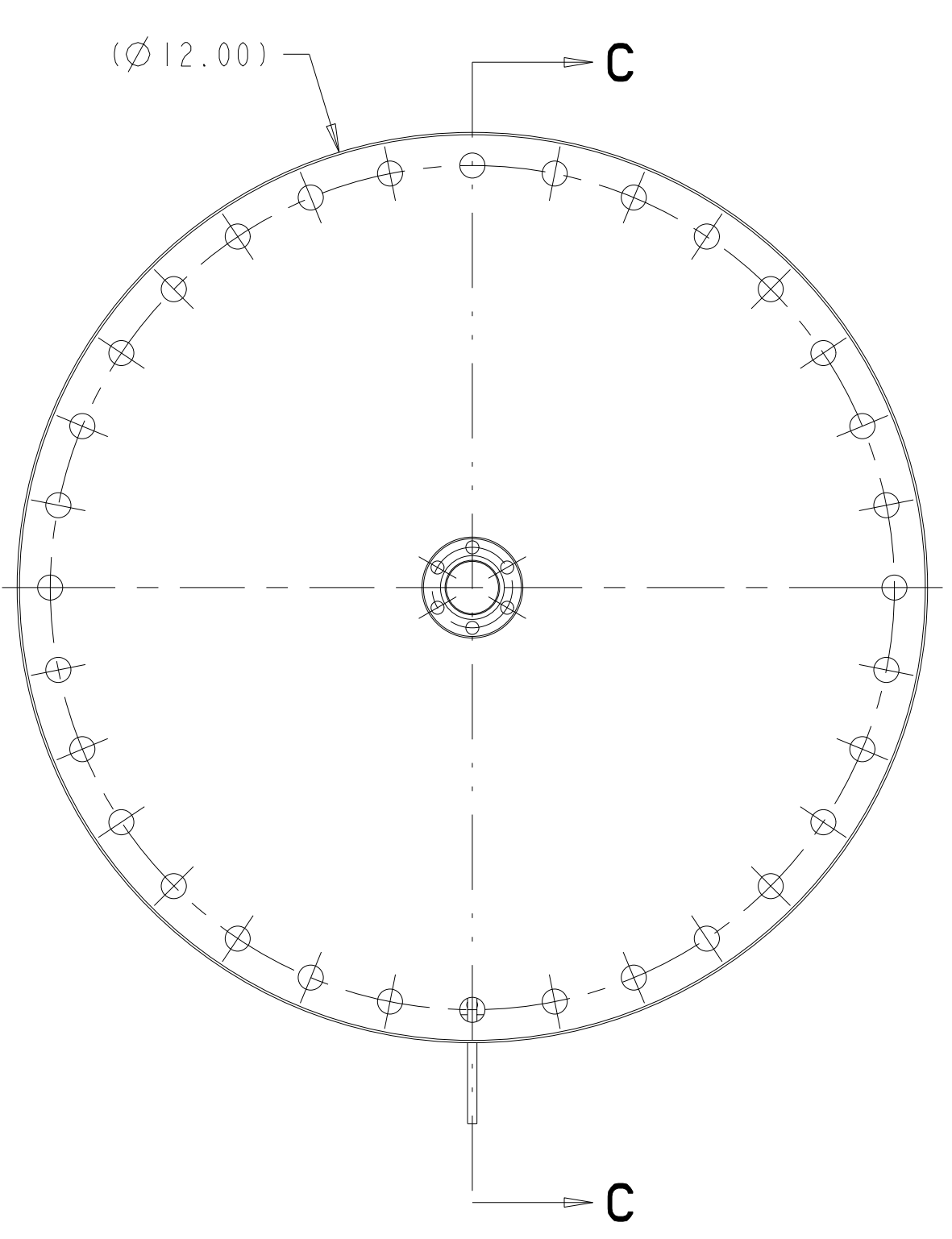
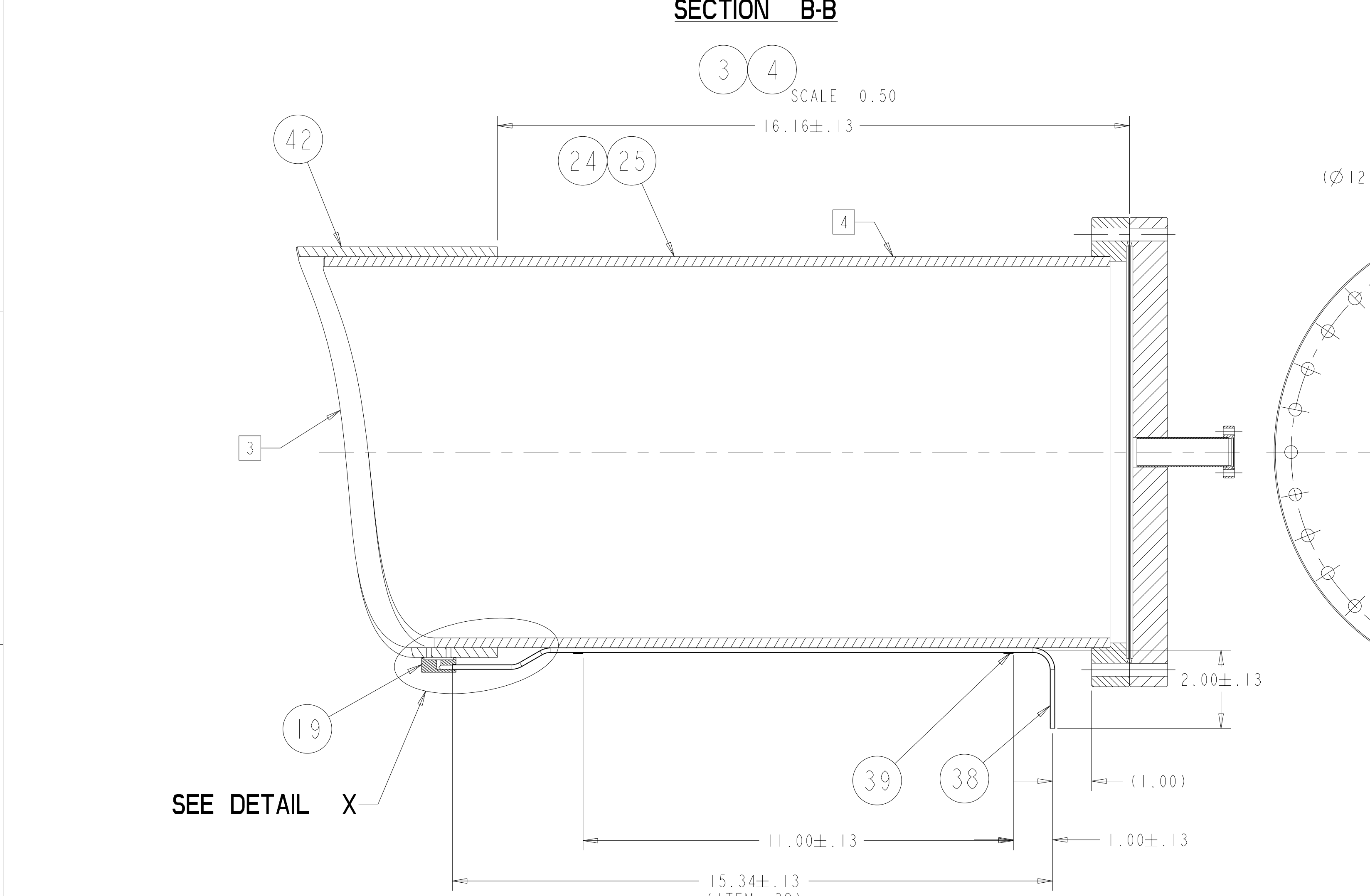
- NOTES:
- INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M.
 - DIMENSION ARE IN INCHES.
 - BACKING RING PROFILE OFFSET 1/2" BEYOND CUTOFF END OF PORT EXTENSIONS.
 - PORT TAKEN FROM DRAWING SEI20-003
 - FABRICATION, INSPECTION, AND TESTING SHALL BE PERFORMED IN ACCORDANCE WITH SPECIFICATION NCSX-CSPEC-121-02 AND STATEMENT OF WORK NCSX-SOW-121-03.



NCSX-RFD-12-003
NCSX-RFD-12-004



REV	DESCRIPTION	BY	DATE	CHK	DEPT	DATE	PE	REQ	DATE	ORNL	DOE	DATE
AR	AR	AR	AR	AR	AR	AR	AR	AR	AR	AR	AR	AR
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AR	AR	AR	AR	AR	AR	AR	AR	AR	AR	AR	AR	AR
SEI20-003-22	PORT 15B EXTENSION											
SEI20-003-21	PORT 15A EXTENSION											
SEI20-003-20	PORT 11B EXTENSION											
SEI20-003-19	PORT 11A EXTENSION											
SEI20-003-18	PORT 10B EXTENSION											
SEI20-003-17	PORT 10A EXTENSION											
SEI20-003-16	PORT 9B EXTENSION											
SEI20-003-15	PORT 9A EXTENSION											
SEI20-003-14	PORT 8B EXTENSION											
SEI20-003-13	PORT 8A EXTENSION											
SEI20-003-12	PORT 7B EXTENSION											
SEI20-003-11	PORT 7A EXTENSION											
SEI20-003-10	PORT 6B EXTENSION											
SEI20-003-9	PORT 6A EXTENSION											
SEI20-003-8	PORT 5B EXTENSION											
SEI20-003-7	PORT 5A EXTENSION											
SEI20-003-4	PORT 2B EXTENSION											
SEI20-003-3	PORT 2A EXTENSION											
SEI22-105	LEAK TEST BLOCK											
-18	PORT 15B WELDMNT											
-17	PORT 15A WELDMNT											
-16	PORT 11B WELDMNT											
-15	PORT 11A WELDMNT											
-14	PORT 10B WELDMNT											
-13	PORT 10A WELDMNT											
-12	PORT 9B WELDMNT											
-11	PORT 9A WELDMNT											
-10	PORT 8B WELDMNT											
-9	PORT 8A WELDMNT											
-8	PORT 7B WELDMNT											
-7	PORT 7A WELDMNT											
-6	PORT 6B WELDMNT											
-5	PORT 6A WELDMNT											
-4	PORT 5B WELDMNT											
-3	PORT 5A WELDMNT											
-2	PORT 2B WELDMNT											
-1	PORT 2A WELDMNT											



WELDING ENGINEER
APPROVED R PARSELLS DATE: 6/04

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P THIS DRAWING PRODUCED ON PRO-ENGINEER

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PPPL Drafting:

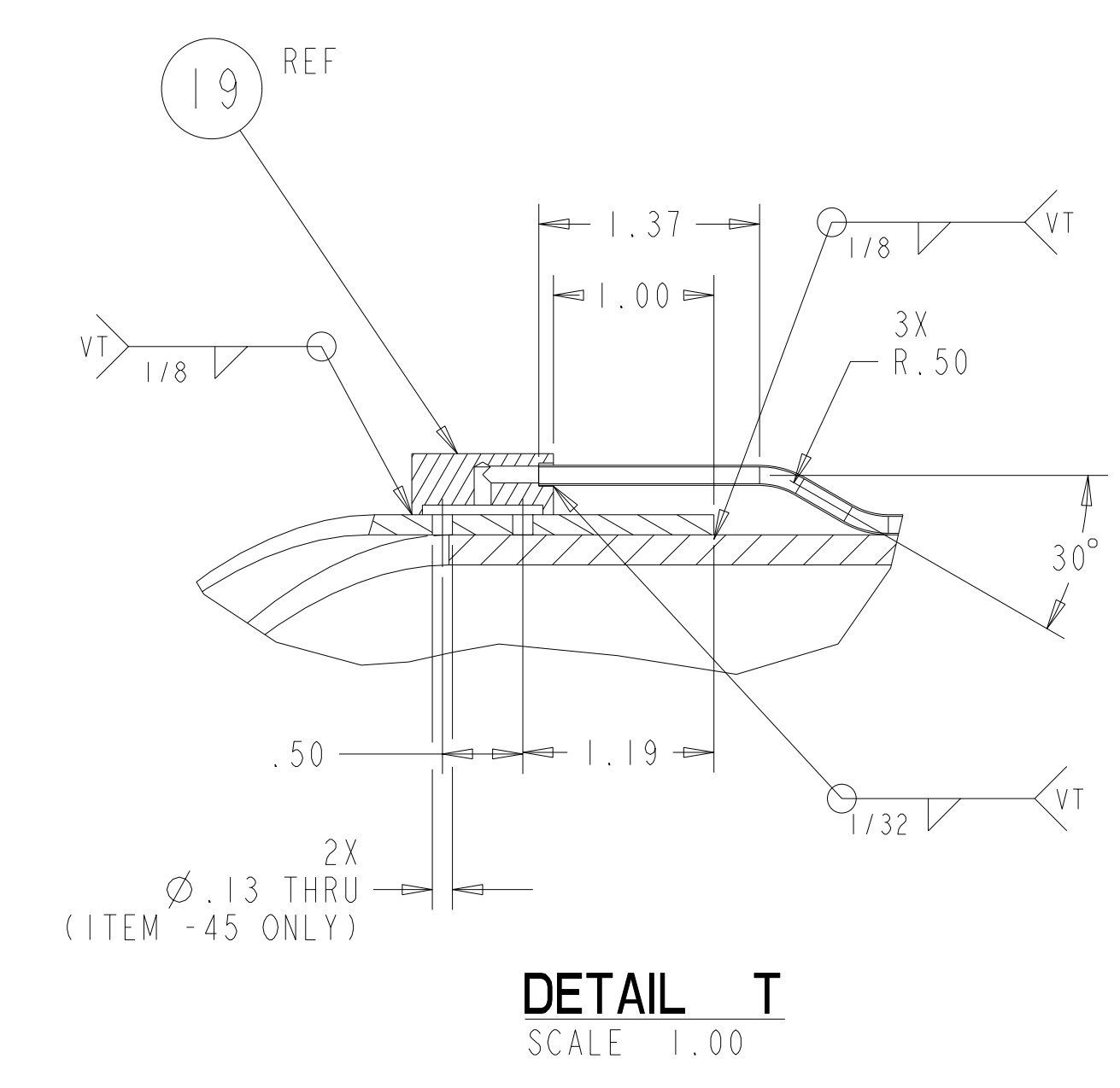
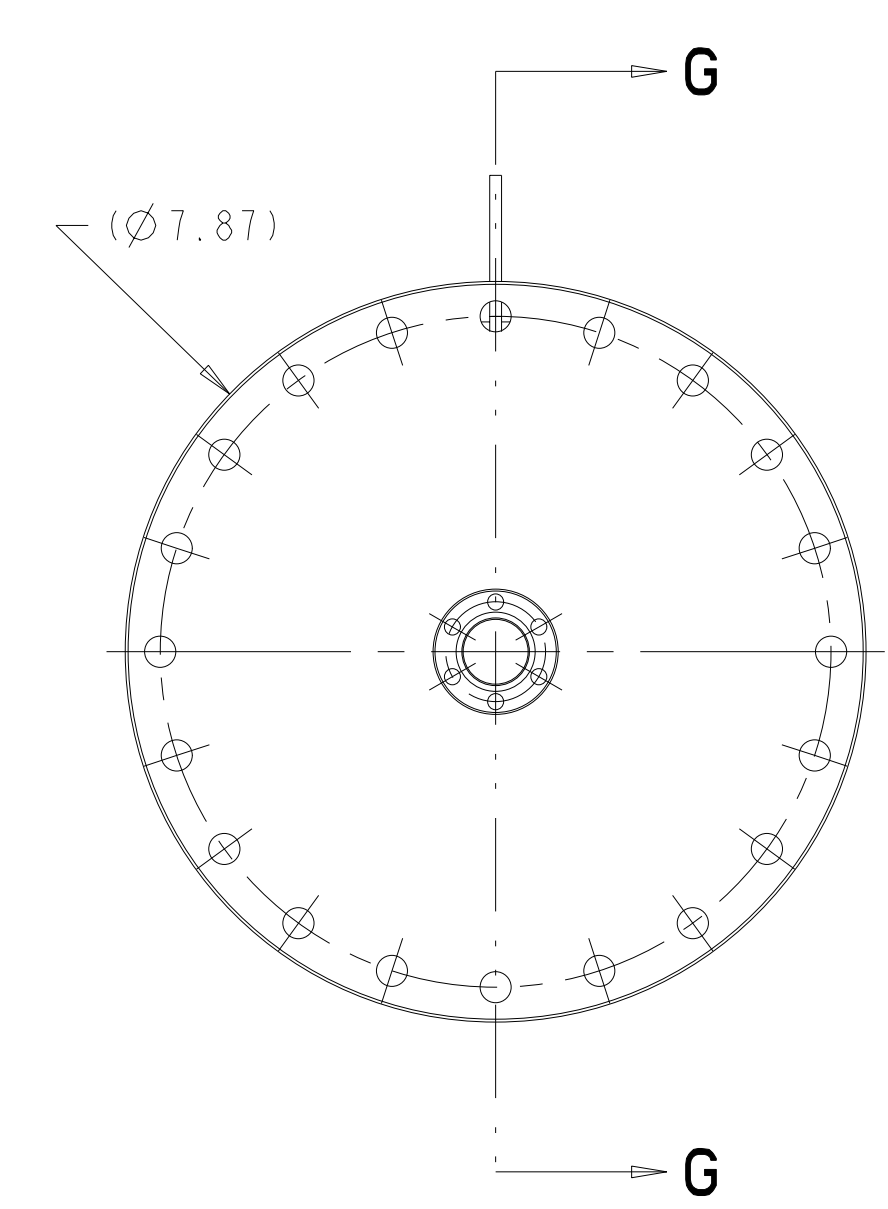
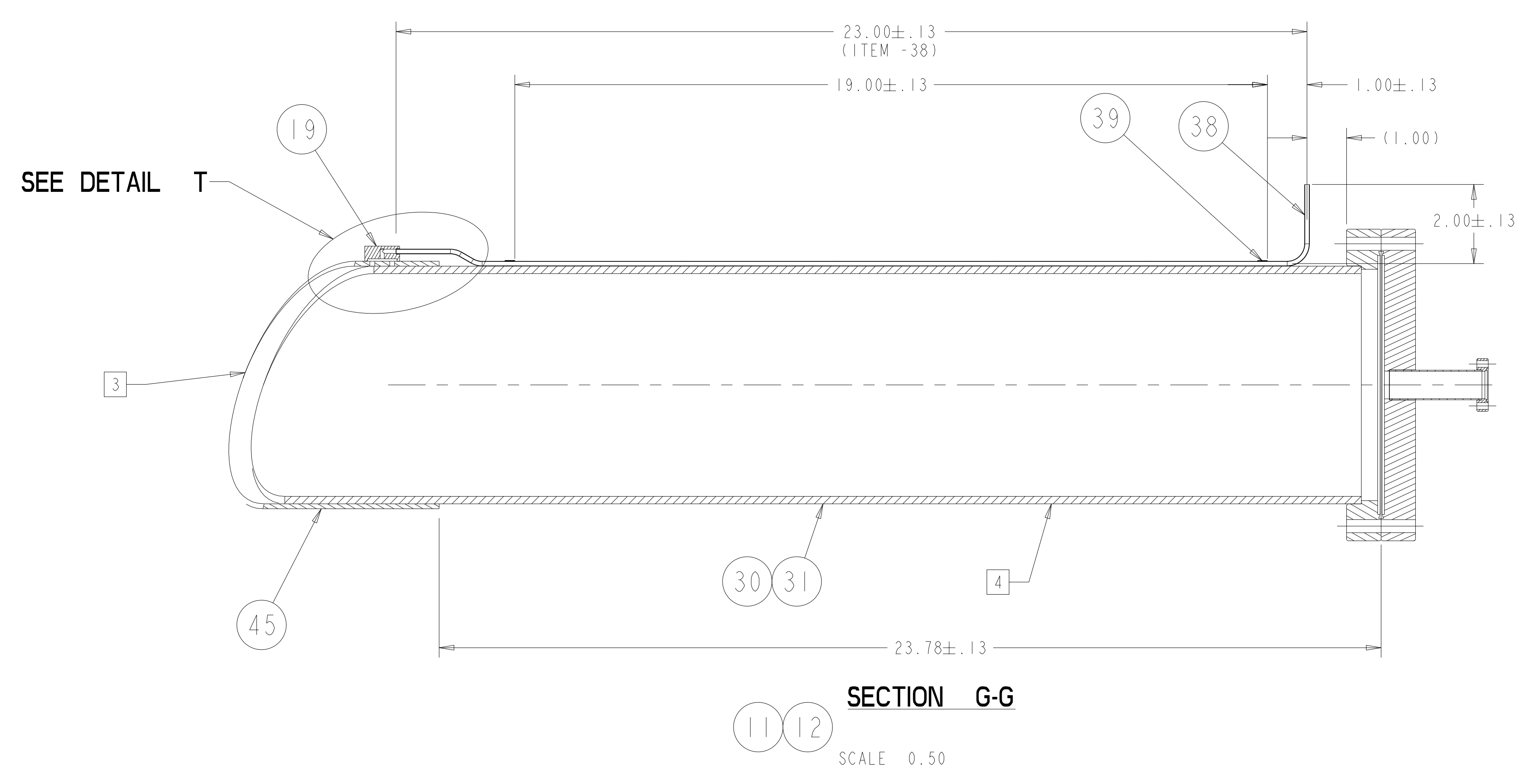
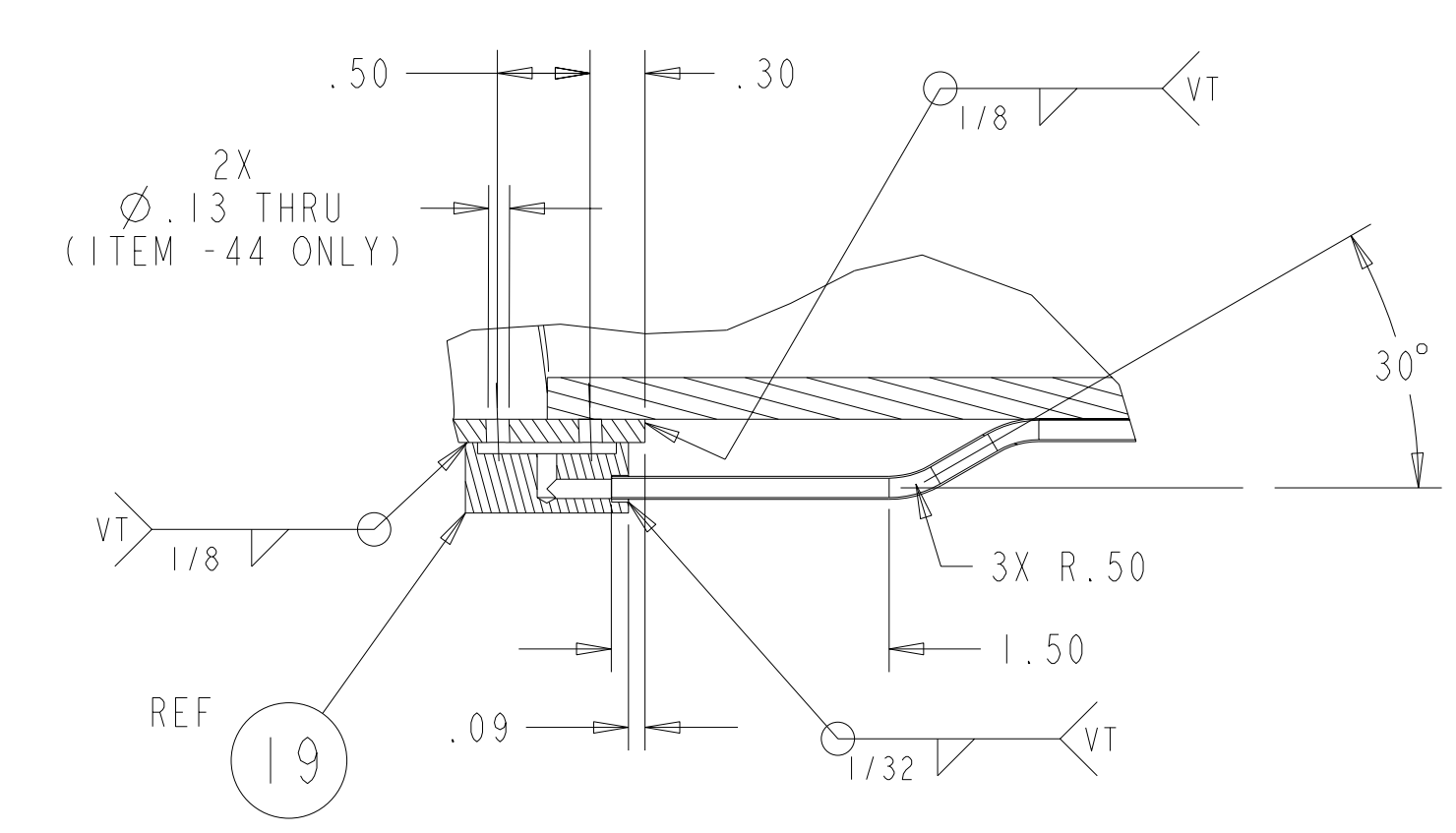
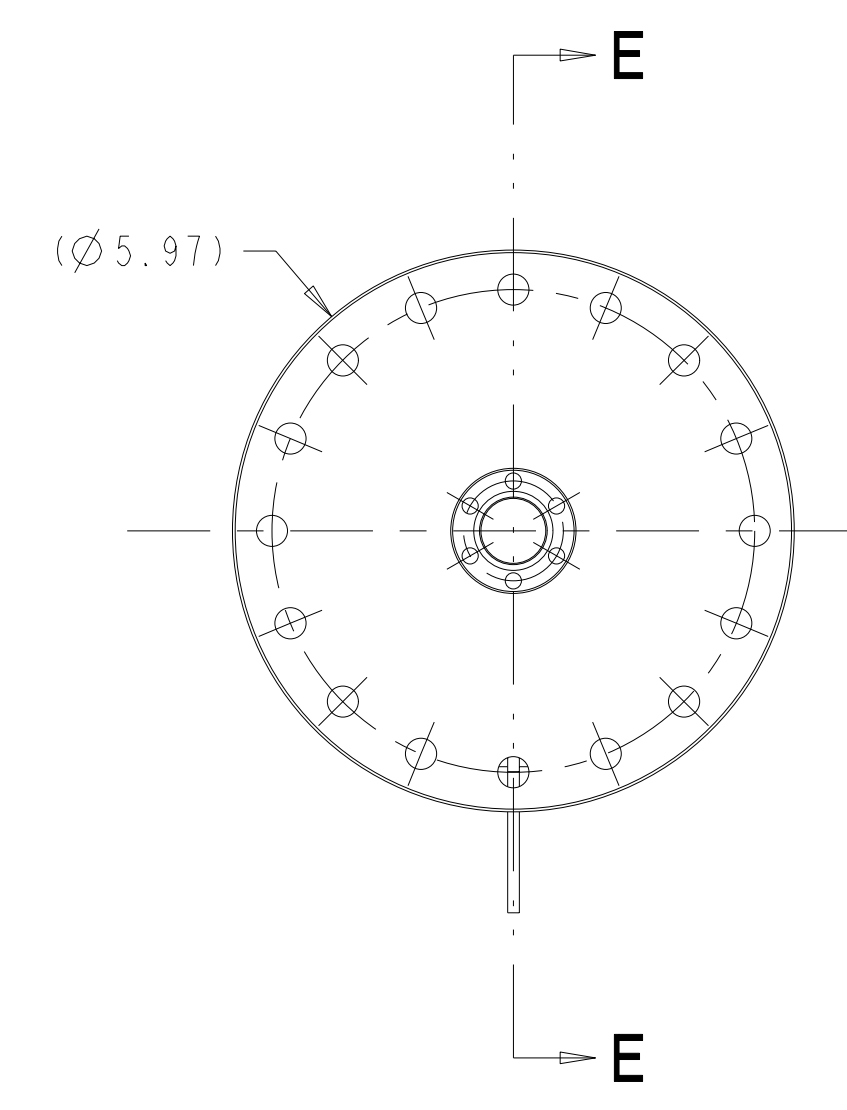
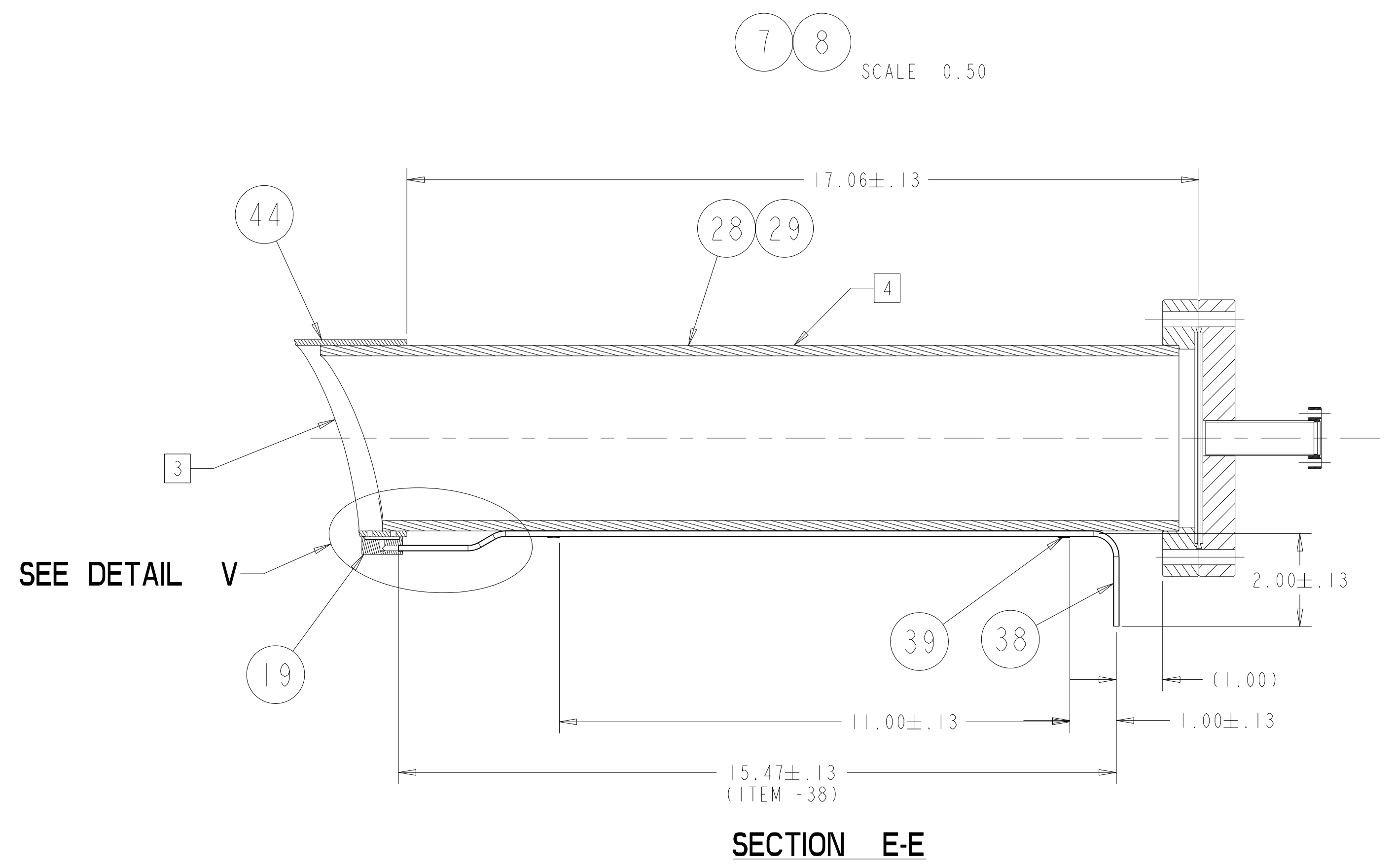
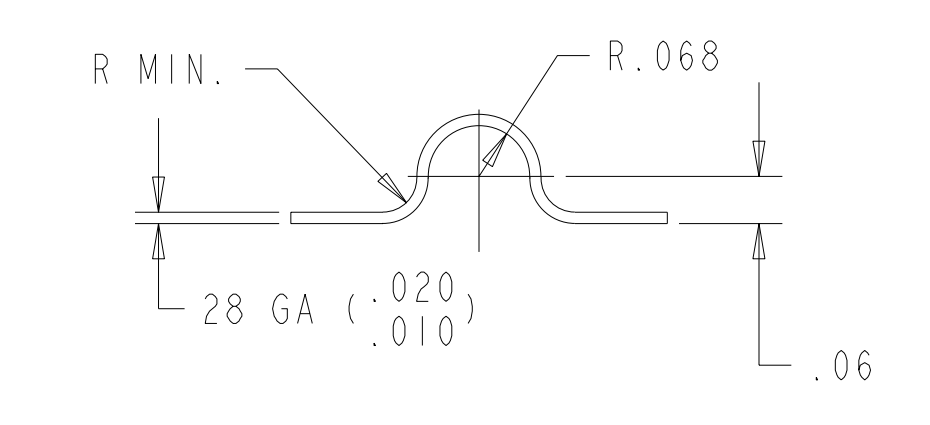
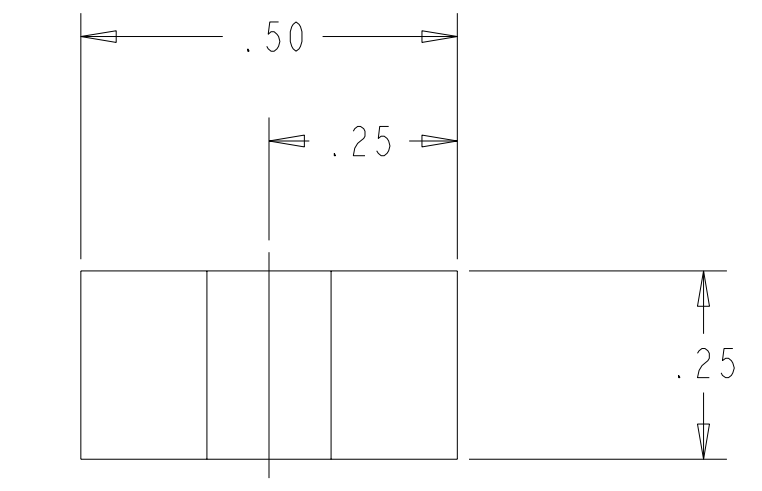
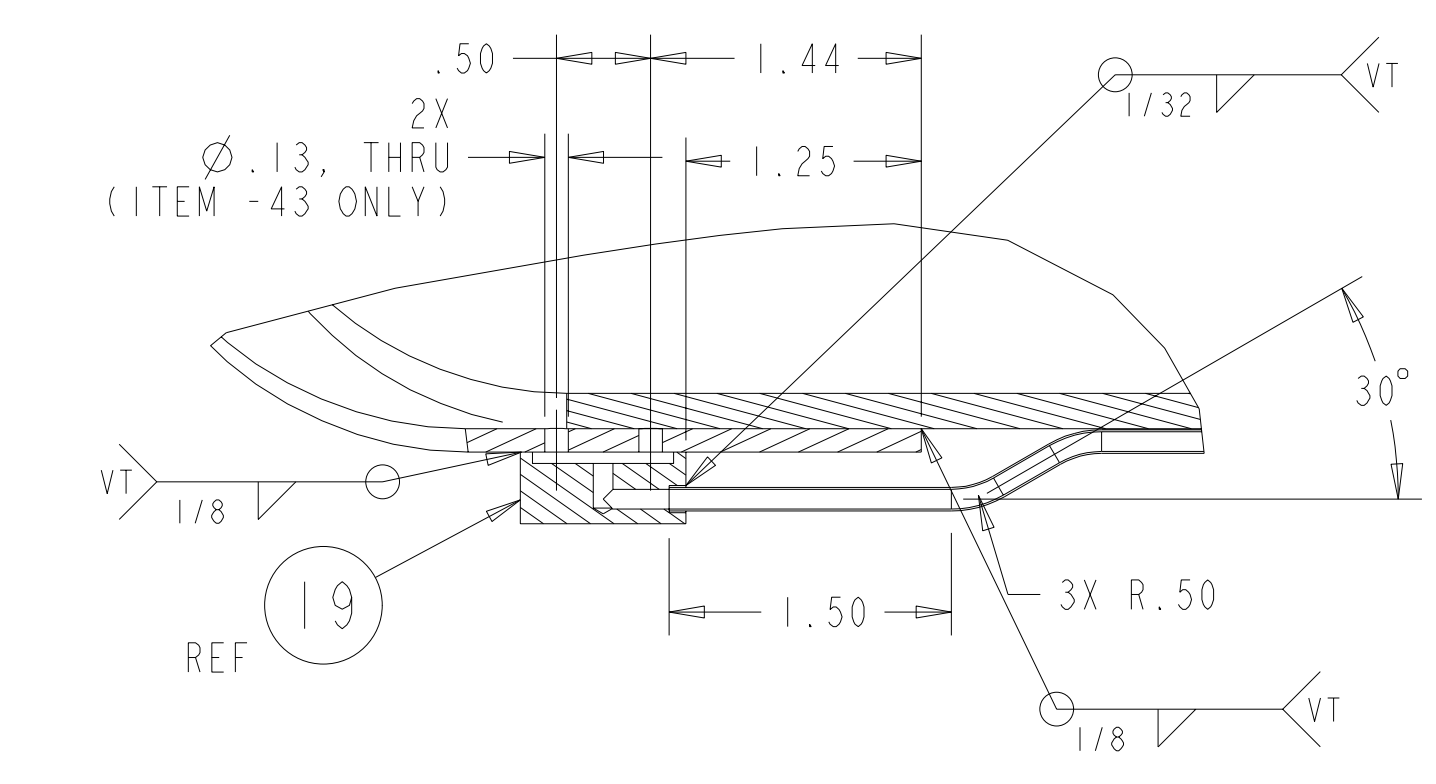
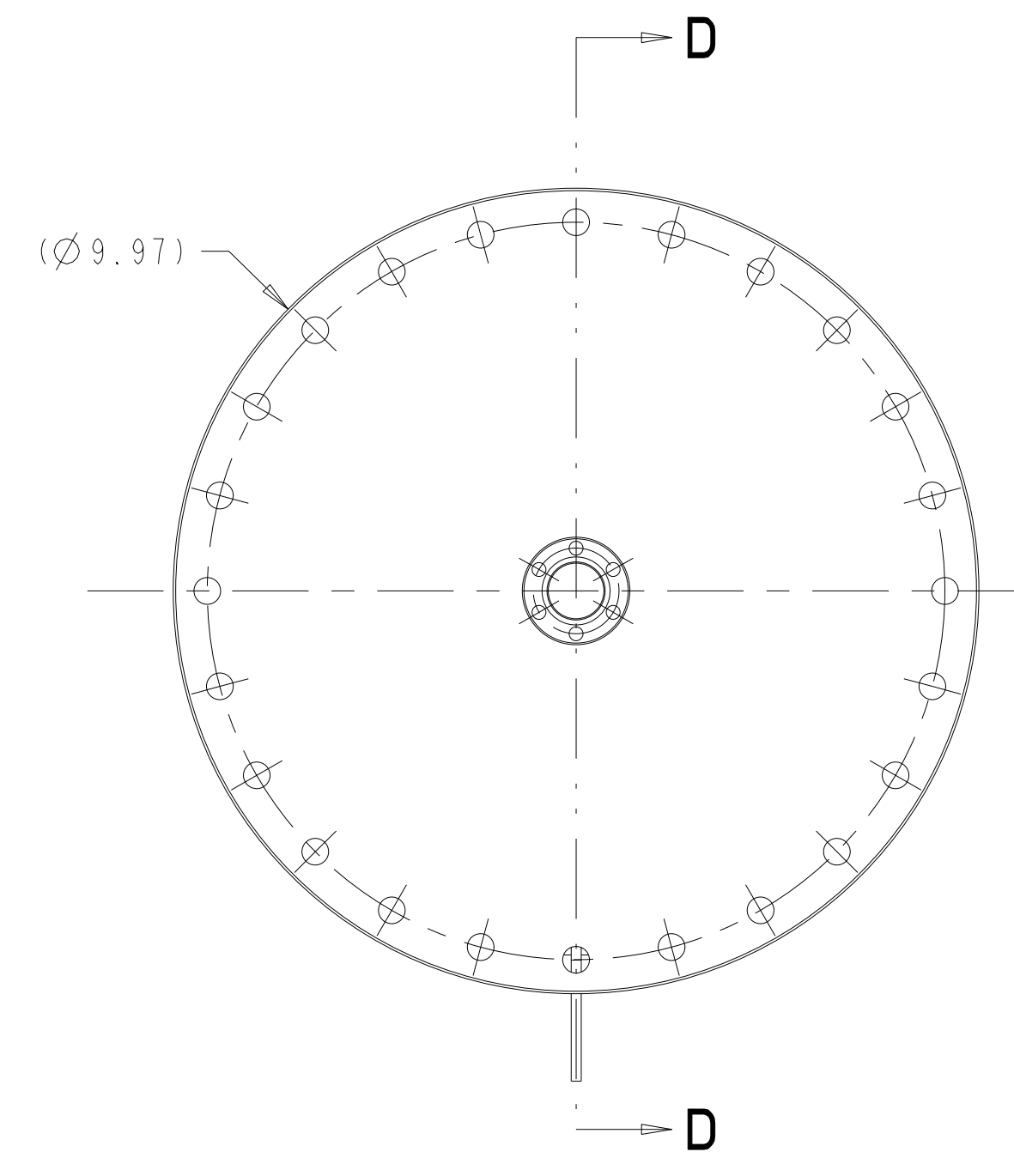
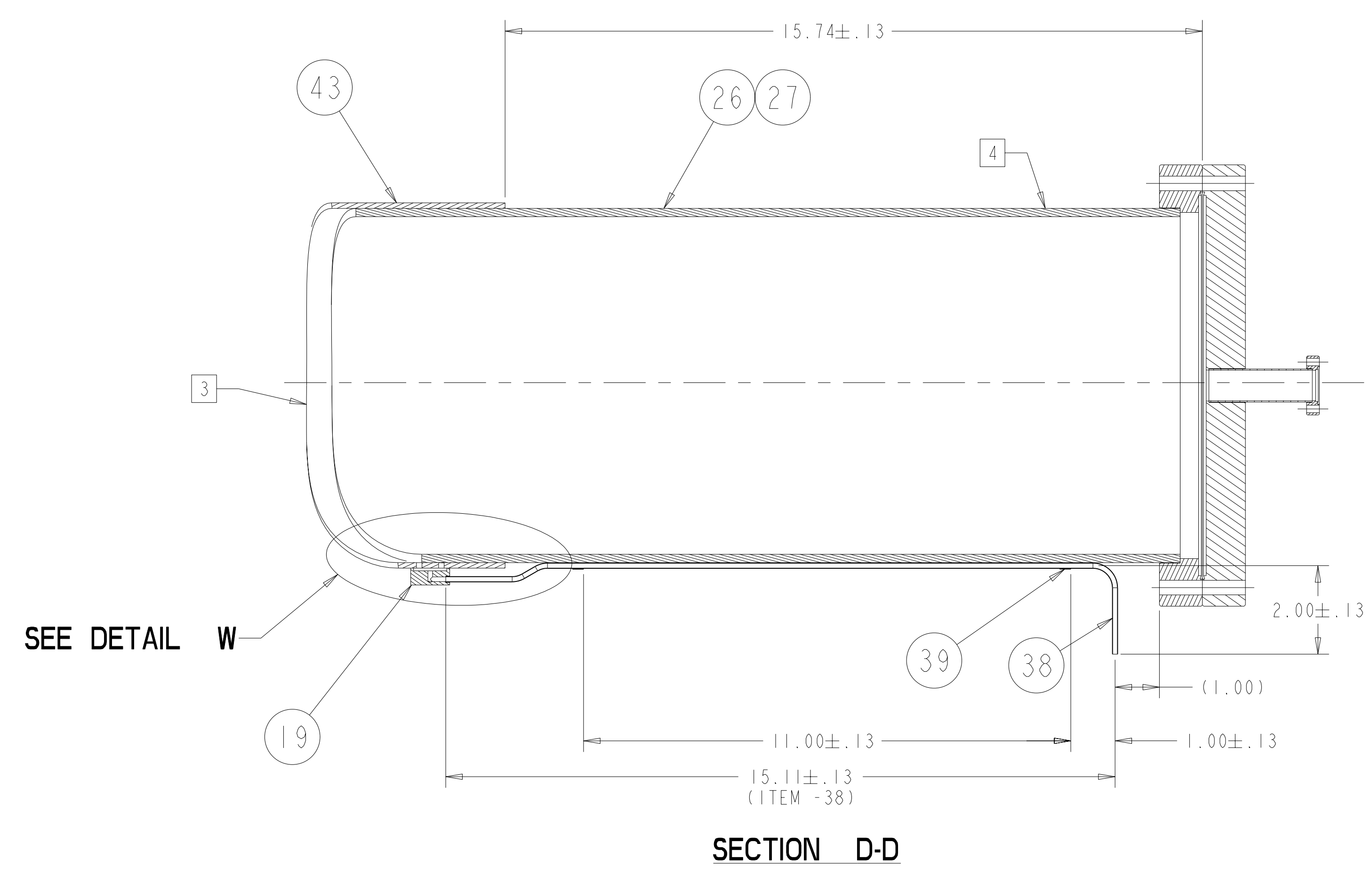
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SCALE	NOTED	DES	DATE	CHK	DATE	SECT	DEPT	PROJECT NAME	VERSION NO.	PLANT	BLDG	FL	SHT	OF	TYPE	CLASS
		P. L. GORANSON	8/03	G. H. JONES	8/03			NATIONAL COMPACT STELLARATOR EXPERIMENT	27	X-10	5700	3	1	3	S	U
		D. W. SPARKS	6/04					VACUUM VESSEL PORT EXTENSION WELDMNT								
		J. SIEGEL	6/04													

SEI20-005

A

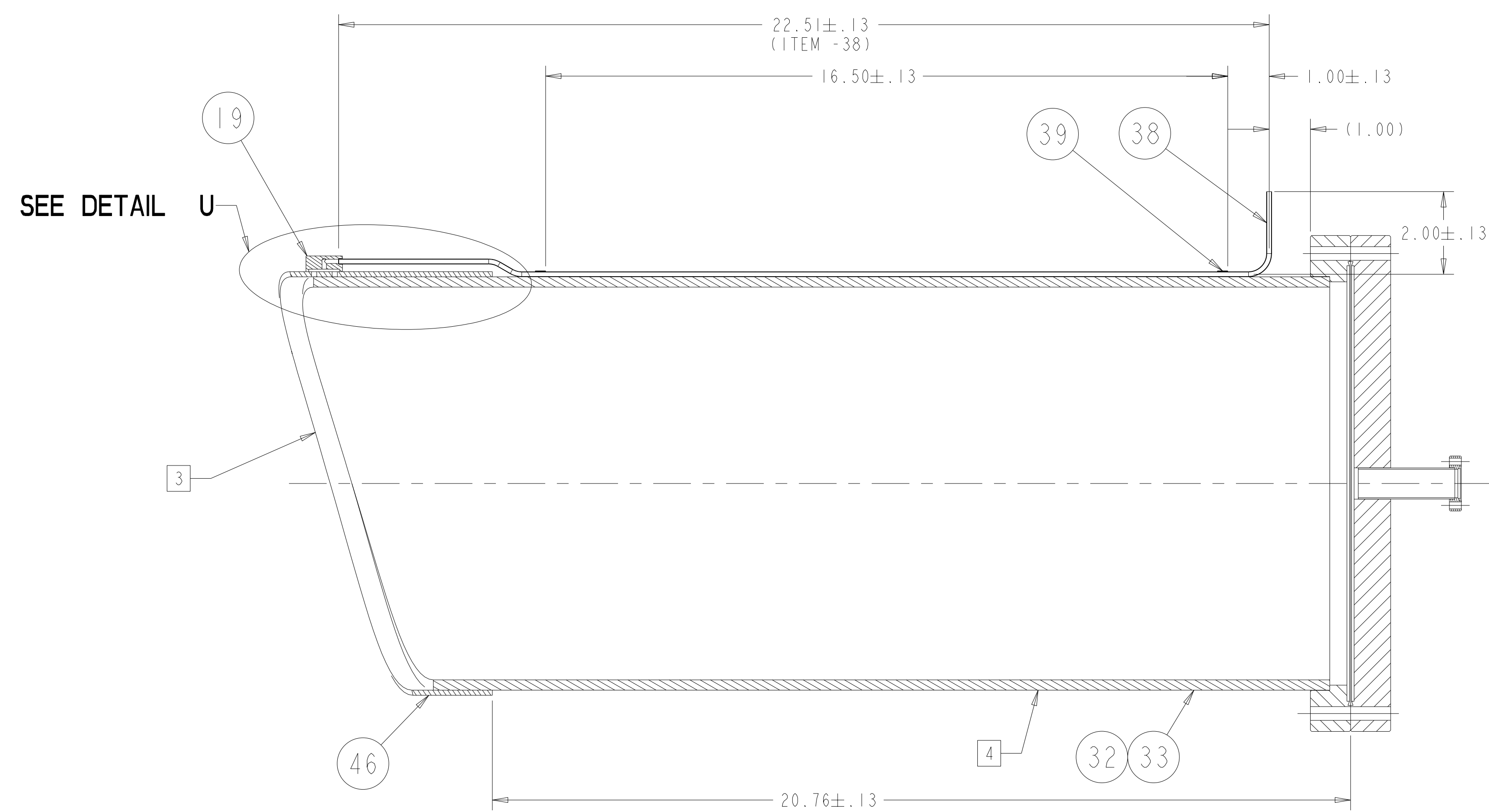
FOR NOTES AND PARTS LIST SEE SHEET 1



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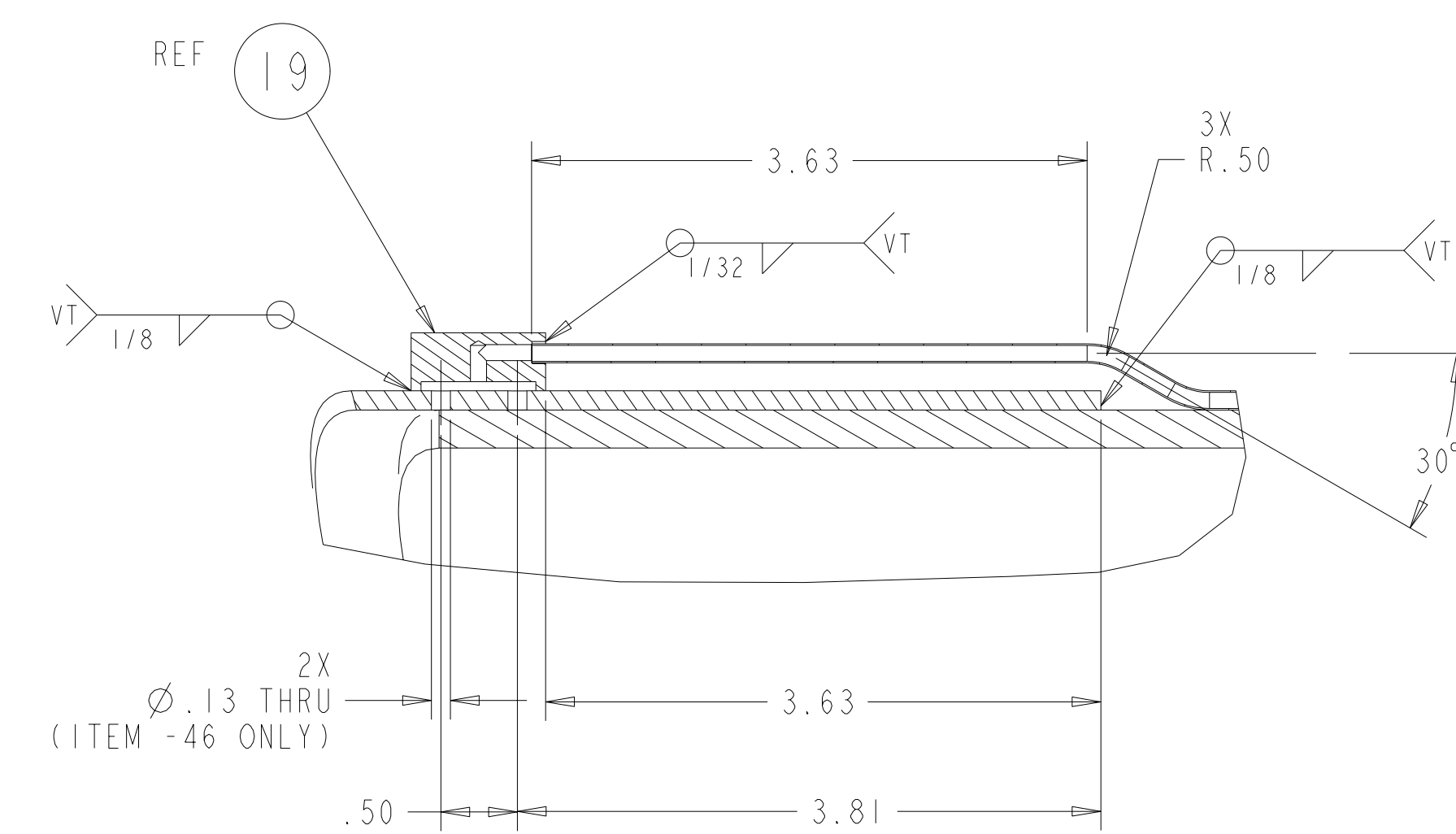
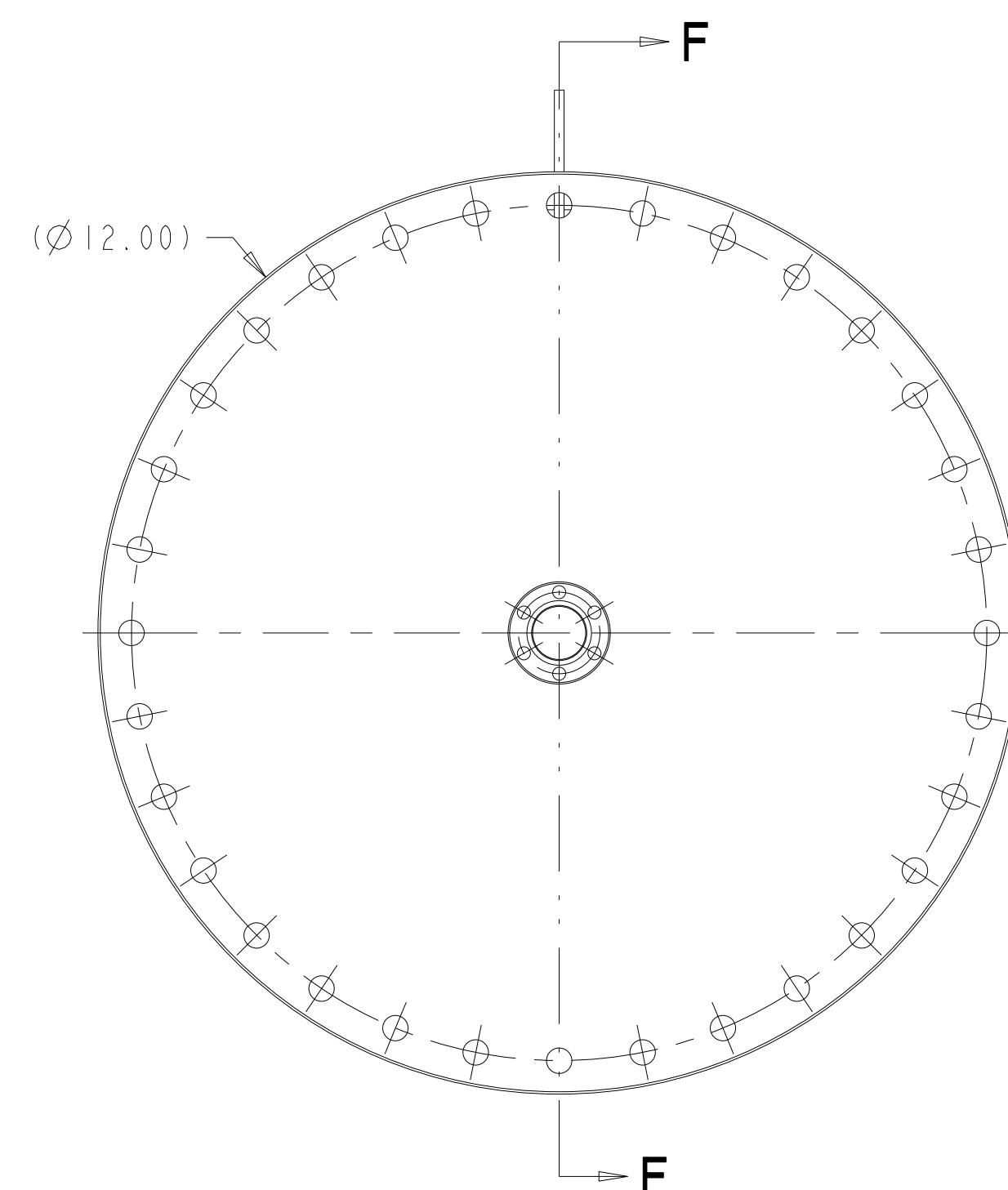
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PROJECT NAME													
NATIONAL COMPACT STELLARATOR EXPERIMENT													
VACUUM VESSEL PORT EXTENSION WELDMENT													
VERSION NO.	PLANT	BLDG	FL	SHT	OF	TYPE	CLASS						
27	X-10	5700	3	2	3	S	U						
RELEASE LEVEL		SE120-005											
Fabrication													
							REV						
							0						

FOR NOTES AND PARTS LIST SEE SHEET 1

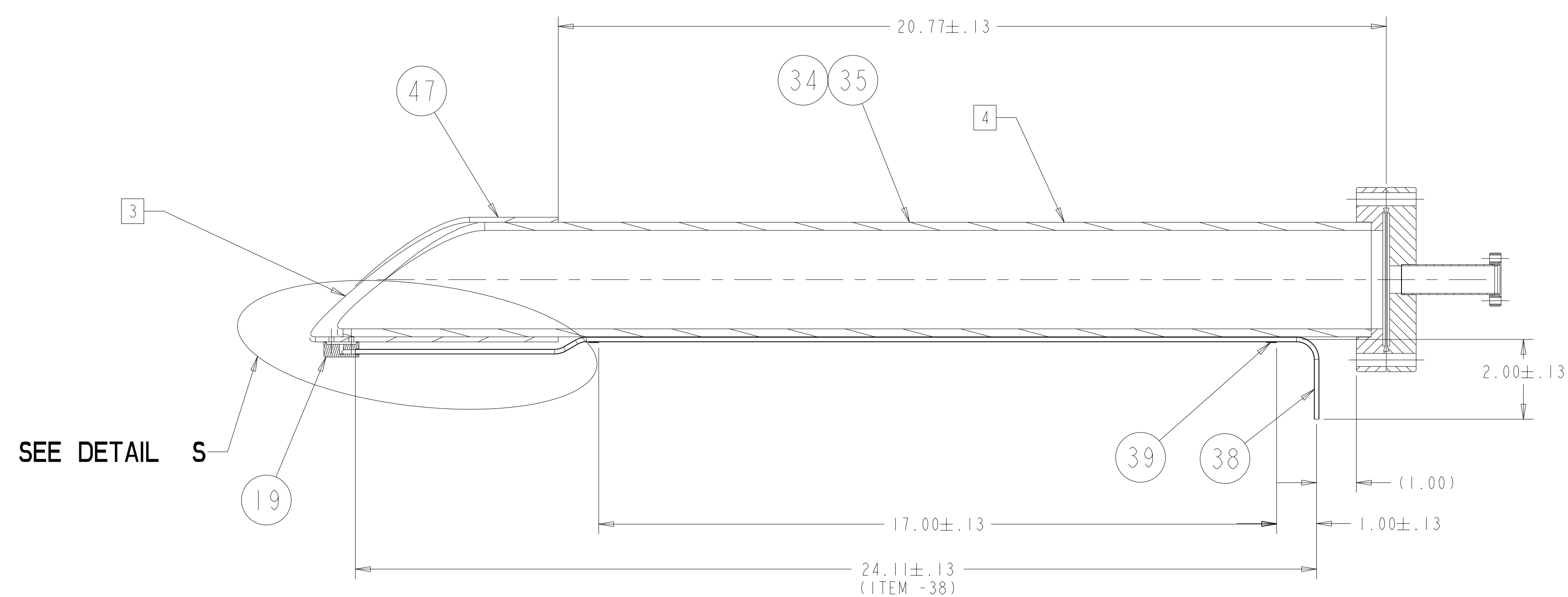


SECTION F-F

13 14 SCALE 0.50

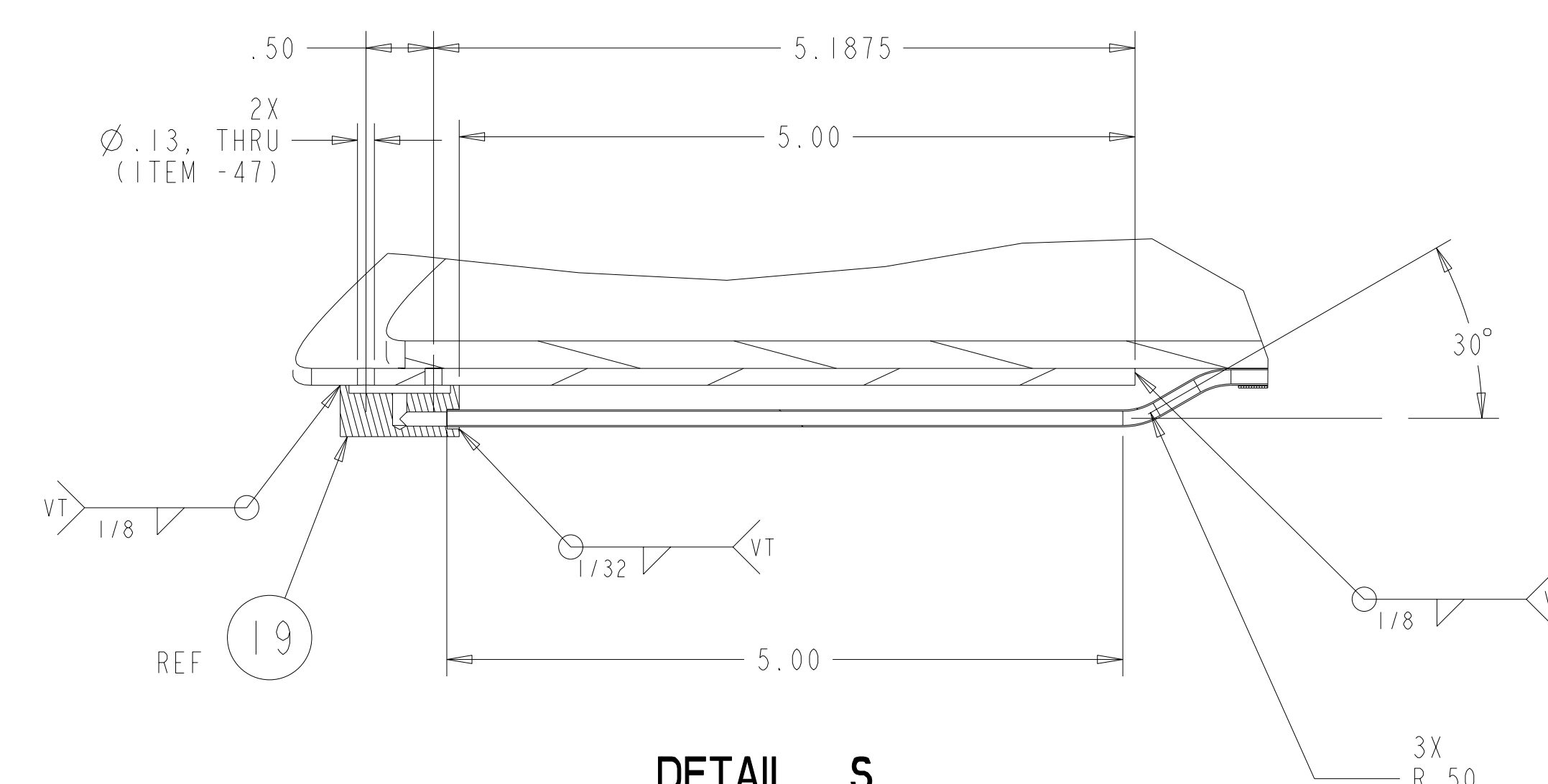
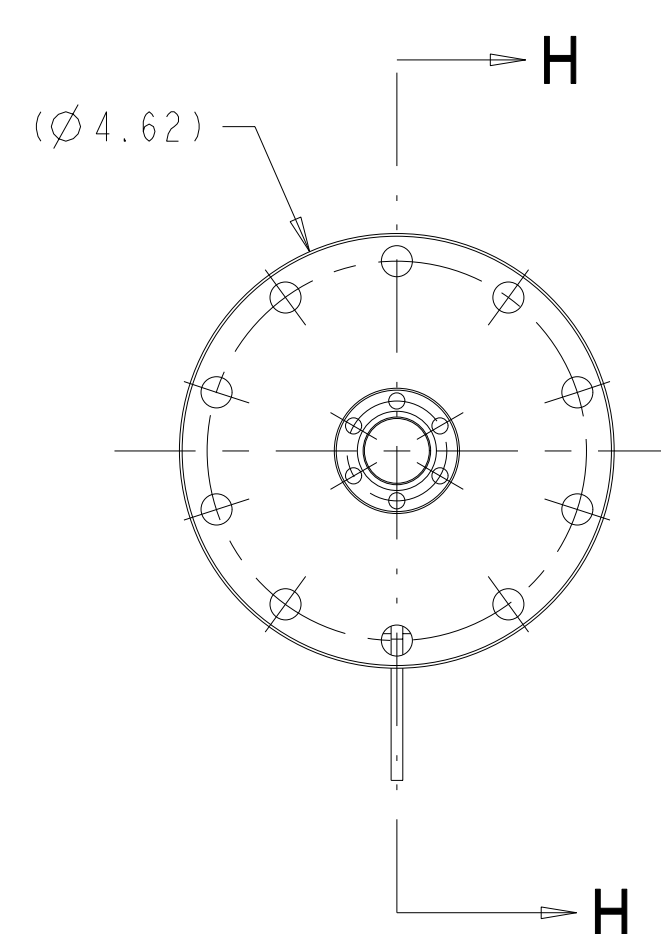


DETAIL U
SCALE 1.00

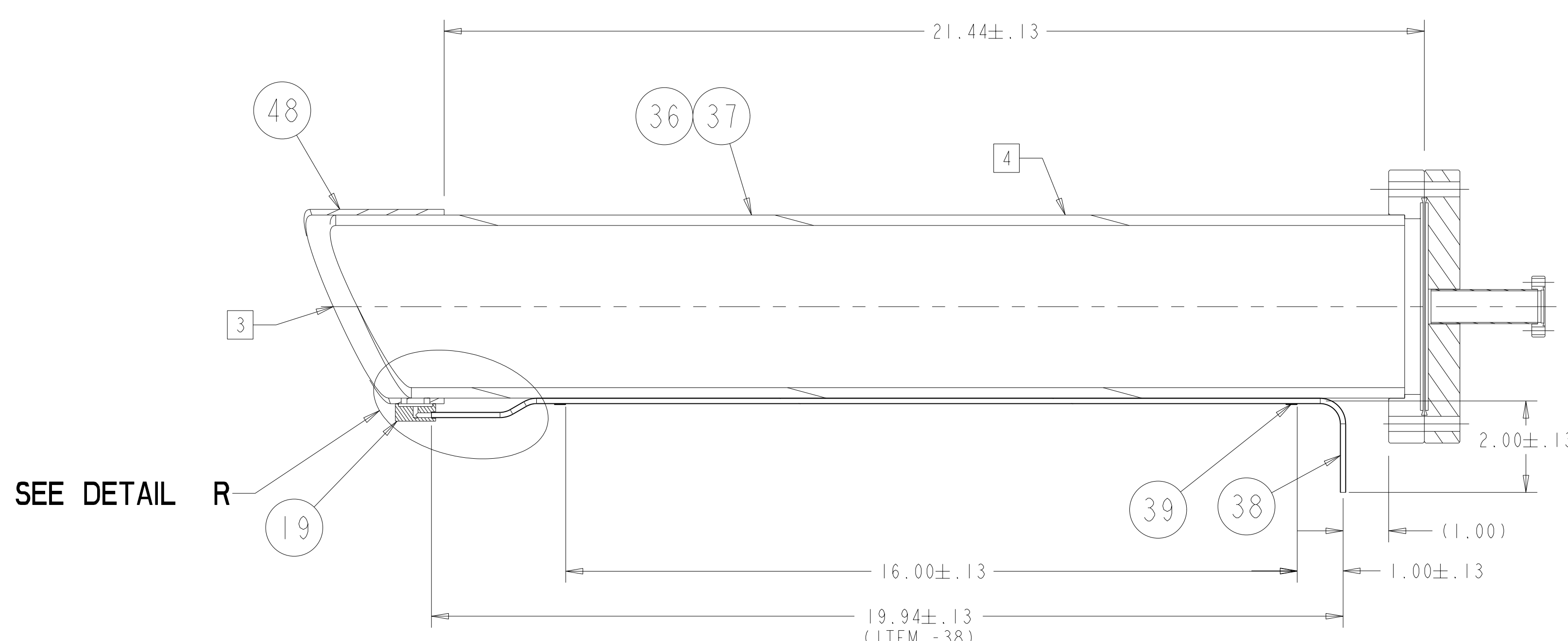


SECTION H-H

15 16 SCALE 0.50

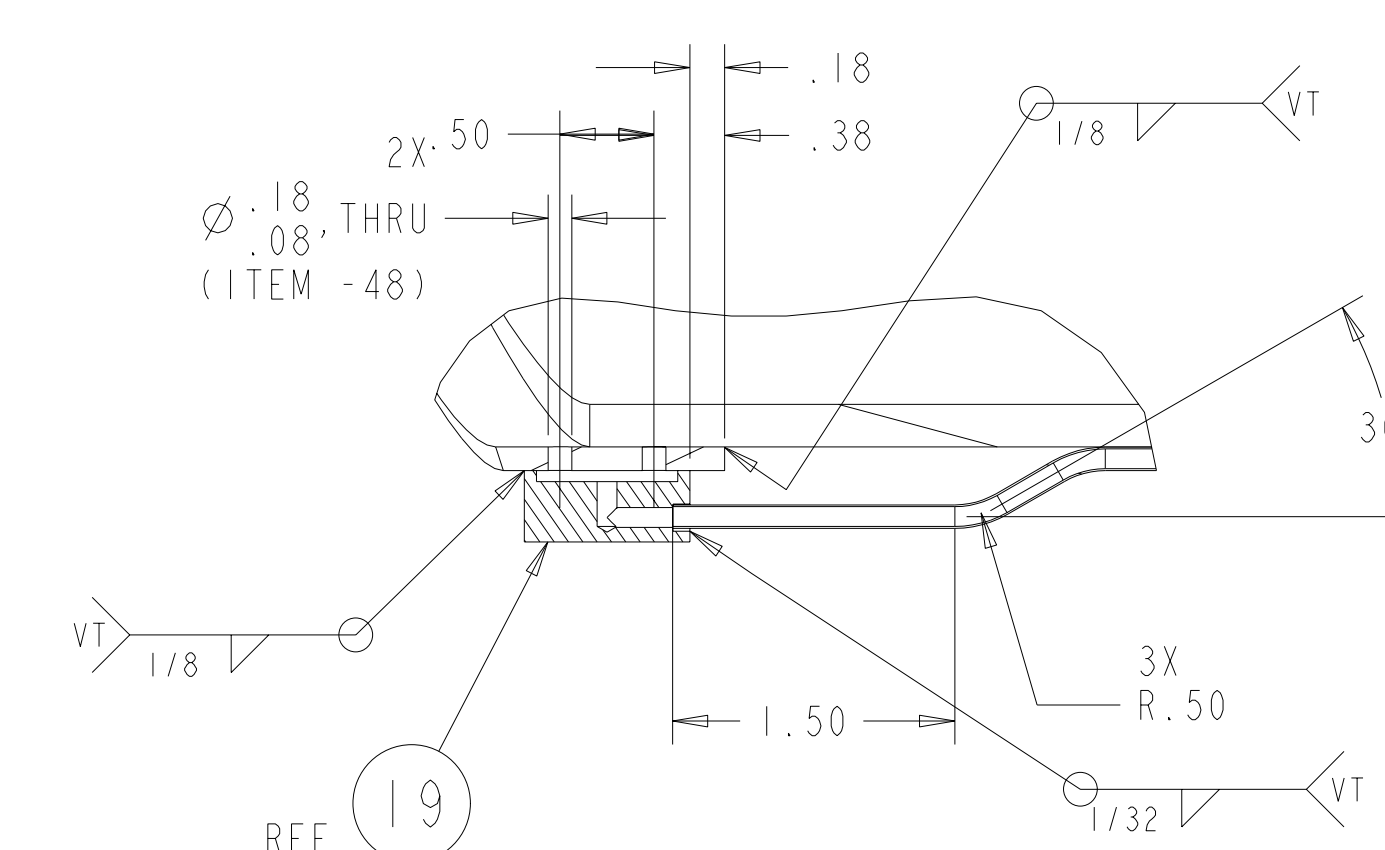
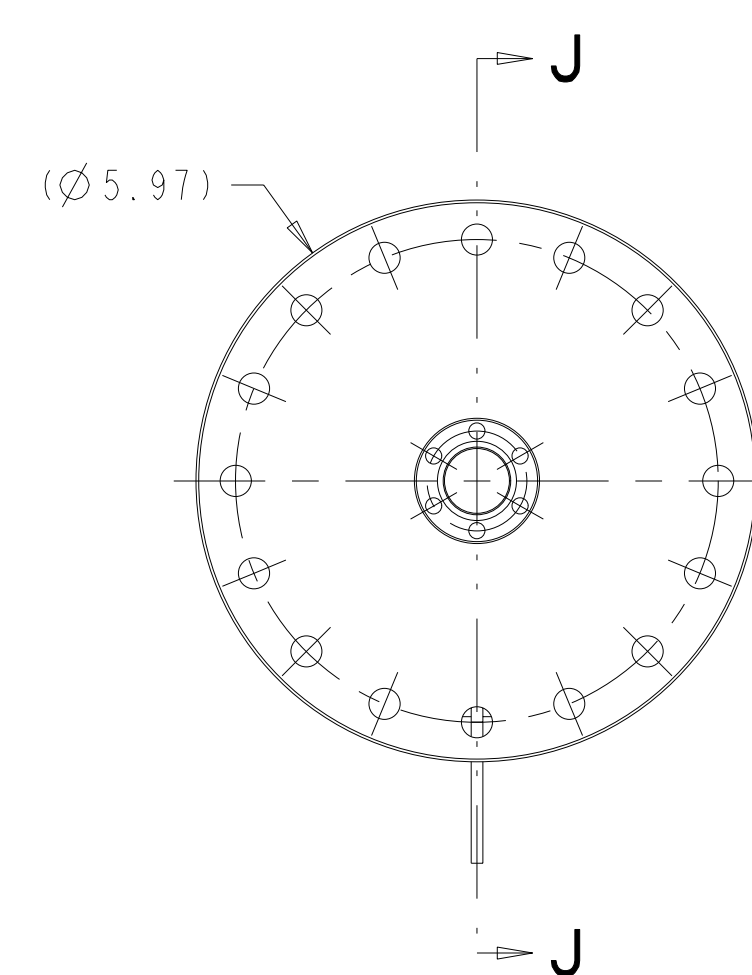


DETAIL S
SCALE 1.00



SECTION J-J

17 18 SCALE 0.50



DETAIL R
SCALE 1.00

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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 NATIONAL COMPACT STELLARATOR EXPERIMENT						
VACUUM VESSEL PORT EXTENSION WELDMENT						
VERSION NO. 27	PLANT X-10	BLDG 5700	FL 3	SHT OF 3	TYPE S	CLASS U
RELEASE LEVEL Fabrication		SE120-005			REV 0	