

- NOTES
1. DRAWING PREPARED IN ACCORDANCE WITH ASME Y14.8M-1996.
  2. INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M-1994.
  3. DIMENSIONS ARE IN INCHES.
  4. DRAWING DEPICTS FLAT PATTERN OF FORMED PARTS DEFINED BY PRO/ENGINEER FILES SE142C-384-XXX.FORM.PRT.
  5. PROFILE TOLERANCE OF FLAT PATTERN IS +/- .010 IN.
  6. REMOVE ALL BURRS AND SHARP EDGES.
  7. IDENTIFY PARTS BY ETCHING OR PERMANENT MARKER.

INSTANCE NAME	HOLE	S-DIM	PART NAME	INSTANCE NAME	HOLE	S-DIM	PART NAME	INSTANCE NAME	HOLE	S-DIM	PART NAME
SE142C-384_FLAT_270		0.885417	SE142C-384-270	SE142C-384_FLAT_174		0.385417	SE142C-384-174	SE142C-384_FLAT_174		0.385417	SE142C-384-174
SE142C-384_FLAT_271	1	0.890625	SE142C-384-271	SE142C-384_FLAT_175	49	0.390625	SE142C-384-175	SE142C-384_FLAT_175	49	0.390625	SE142C-384-175
SE142C-384_FLAT_272		0.895833	SE142C-384-272	SE142C-384_FLAT_176		0.395833	SE142C-384-176	SE142C-384_FLAT_176		0.395833	SE142C-384-176
SE142C-384_FLAT_273	2	0.901042	SE142C-384-273	SE142C-384_FLAT_177	50	0.401042	SE142C-384-177	SE142C-384_FLAT_177	50	0.401042	SE142C-384-177
SE142C-384_FLAT_274		0.906250	SE142C-384-274	SE142C-384_FLAT_178		0.406250	SE142C-384-178	SE142C-384_FLAT_178		0.406250	SE142C-384-178
SE142C-384_FLAT_275	3	0.911458	SE142C-384-275	SE142C-384_FLAT_179	51	0.411458	SE142C-384-179	SE142C-384_FLAT_179	51	0.411458	SE142C-384-179
SE142C-384_FLAT_276		0.916667	SE142C-384-276	SE142C-384_FLAT_180		0.416667	SE142C-384-180	SE142C-384_FLAT_180		0.416667	SE142C-384-180
SE142C-384_FLAT_277	4	0.921875	SE142C-384-277	SE142C-384_FLAT_181	52	0.421875	SE142C-384-181	SE142C-384_FLAT_181	52	0.421875	SE142C-384-181
SE142C-384_FLAT_278		0.927083	SE142C-384-278	SE142C-384_FLAT_182		0.427083	SE142C-384-182	SE142C-384_FLAT_182		0.427083	SE142C-384-182
SE142C-384_FLAT_279	5	0.932292	SE142C-384-279	SE142C-384_FLAT_183	53	0.432292	SE142C-384-183	SE142C-384_FLAT_183	53	0.432292	SE142C-384-183
SE142C-384_FLAT_280		0.937500	SE142C-384-280	SE142C-384_FLAT_184		0.437500	SE142C-384-184	SE142C-384_FLAT_184		0.437500	SE142C-384-184
SE142C-384_FLAT_281	6	0.942708	SE142C-384-281	SE142C-384_FLAT_185	54	0.442708	SE142C-384-185	SE142C-384_FLAT_185	54	0.442708	SE142C-384-185
SE142C-384_FLAT_282		0.947917	SE142C-384-282	SE142C-384_FLAT_186		0.447917	SE142C-384-186	SE142C-384_FLAT_186		0.447917	SE142C-384-186
SE142C-384_FLAT_283	7	0.953125	SE142C-384-283	SE142C-384_FLAT_187	55	0.453125	SE142C-384-187	SE142C-384_FLAT_187	55	0.453125	SE142C-384-187
SE142C-384_FLAT_284		0.958333	SE142C-384-284	SE142C-384_FLAT_188		0.458333	SE142C-384-188	SE142C-384_FLAT_188		0.458333	SE142C-384-188
SE142C-384_FLAT_285	8	0.963542	SE142C-384-285	SE142C-384_FLAT_189	56	0.463542	SE142C-384-189	SE142C-384_FLAT_189	56	0.463542	SE142C-384-189
SE142C-384_FLAT_286		0.968750	SE142C-384-286	SE142C-384_FLAT_190		0.468750	SE142C-384-190	SE142C-384_FLAT_190		0.468750	SE142C-384-190
SE142C-384_FLAT_287	9	0.973958	SE142C-384-287	SE142C-384_FLAT_191	57	0.473958	SE142C-384-191	SE142C-384_FLAT_191	57	0.473958	SE142C-384-191
SE142C-384_FLAT_288		0.979167	SE142C-384-288	SE142C-384_FLAT_192		0.479167	SE142C-384-192	SE142C-384_FLAT_192		0.479167	SE142C-384-192
SE142C-384_FLAT_289	10	0.984375	SE142C-384-289	SE142C-384_FLAT_193	58	0.484375	SE142C-384-193	SE142C-384_FLAT_193	58	0.484375	SE142C-384-193
SE142C-384_FLAT_290		0.989583	SE142C-384-290	SE142C-384_FLAT_194		0.489583	SE142C-384-194	SE142C-384_FLAT_194		0.489583	SE142C-384-194
SE142C-384_FLAT_291	11	0.994792	SE142C-384-291	SE142C-384_FLAT_195_NEW	59	0.494792	SE142C-384-195	SE142C-384_FLAT_195	59	0.494792	SE142C-384-195
SE142C-384_FLAT_290-NEW		0.000000	SE142C-384-290	SE142C-384_FLAT_196		0.500000	SE142C-384-196	SE142C-384_FLAT_196		0.500000	SE142C-384-196
SE142C-384_FLAT_101	12	0.005208	SE142C-384-101	SE142C-384_FLAT_197	60	0.505208	SE142C-384-197	SE142C-384_FLAT_197	60	0.505208	SE142C-384-197
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SE142C-384_FLAT_NEW_104		0.019341	SE142C-384-104	SE142C-384_FLAT_200		0.520833	SE142C-384-200	SE142C-384_FLAT_200		0.520833	SE142C-384-200
SE142C-384_FLAT_105	14	0.024000	SE142C-384-105	SE142C-384_FLAT_201	62	0.526042	SE142C-384-201	SE142C-384_FLAT_201	62	0.526042	SE142C-384-201
SE142C-384_FLAT_NEW_106		0.024579	SE142C-384-106	SE142C-384_FLAT_202		0.531250	SE142C-384-202	SE142C-384_FLAT_202		0.531250	SE142C-384-202
SE142C-384_FLAT_NEW_107	15	0.036000	SE142C-384-107	SE142C-384_FLAT_203	63	0.536458	SE142C-384-203	SE142C-384_FLAT_203	63	0.536458	SE142C-384-203
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SE142C-384_FLAT_109	16	0.046875	SE142C-384-109	SE142C-384_FLAT_205	64	0.546875	SE142C-384-205	SE142C-384_FLAT_205	64	0.546875	SE142C-384-205
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SE142C-384_FLAT_111	17	0.057292	SE142C-384-111	SE142C-384_FLAT_207	65	0.557292	SE142C-384-207	SE142C-384_FLAT_207	65	0.557292	SE142C-384-207
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SE142C-384_FLAT_115	19	0.078125	SE142C-384-115	SE142C-384_FLAT_211	67	0.578125	SE142C-384-211	SE142C-384_FLAT_211	67	0.578125	SE142C-384-211
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SE142C-384_FLAT_117	20	0.088542	SE142C-384-117	SE142C-384_FLAT_213	68	0.588542	SE142C-384-213	SE142C-384_FLAT_213	68	0.588542	SE142C-384-213
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SE142C-384_FLAT_137	30	0.192708	SE142C-384-137	SE142C-384_FLAT_233	78	0.692708	SE142C-384-233	SE142C-384_FLAT_233	78	0.692708	SE142C-384-233
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SE142C-384_FLAT_139	31	0.203125	SE142C-384-139	SE142C-384_FLAT_235	79	0.703125	SE142C-384-235	SE142C-384_FLAT_235	79	0.703125	SE142C-384-235
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SE142C-384_FLAT_143	33	0.223958	SE142C-384-143	SE142C-384_FLAT_239	81	0.723958	SE142C-384-239	SE142C-384_FLAT_239	81	0.723958	SE142C-384-239
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SE142C-384_FLAT_145	34	0.234375	SE142C-384-145	SE142C-384_FLAT_241	82	0.734375	SE142C-384-241	SE142C-384_FLAT_241	82	0.734375	SE142C-384-241
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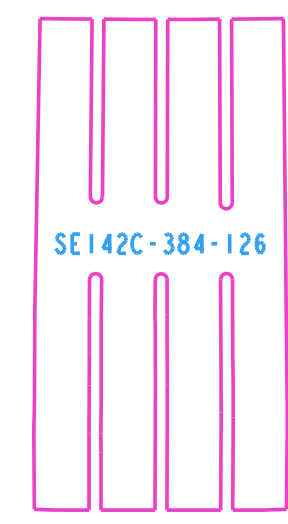
**ECN-5140R2 pending.** This ECN permits the use of UNS C11000 ETP as acceptable material per RFD-14-021.  
**(See ECN-5140R2 for details)**

SCALE ALL VIEWS: 1.00

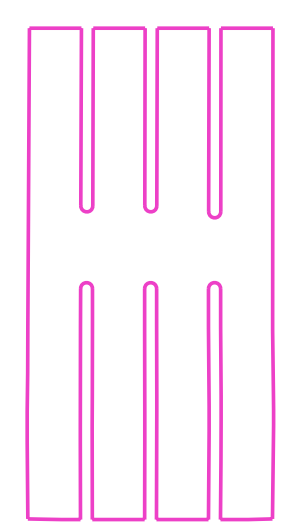
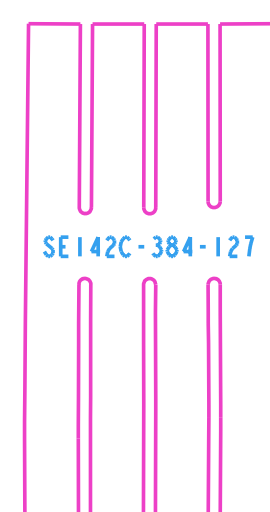
**RELEASED FOR  
 FABRICATION / INSTALLATION**  
 PPPL Drafting:

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:						
<b>NATIONAL COMPACT STELLARATOR EXPERIMENT</b> MODULAR COIL TYPE - C SIDE - A LOWER CLADDING FLAT PATTERN LAYOUT						
VERSION NO.	PLANT	BLDG	FL	SHT OF	TYPE	CLASS
6	X-10	5700	3	2	S	U
RELEASE LEVEL		SE142C-384		REV		
Fabrication				0		

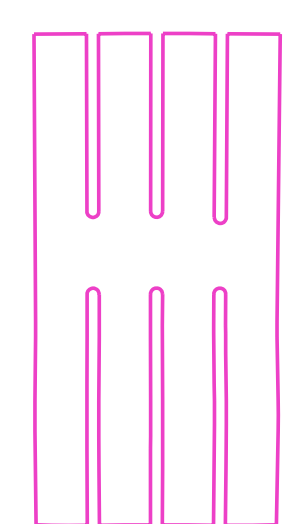
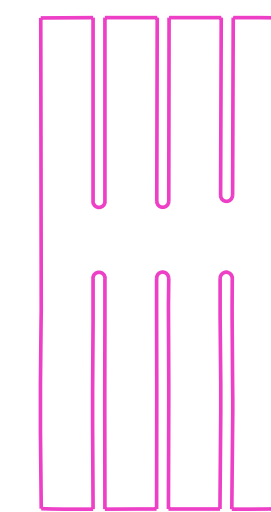
SE142C-384



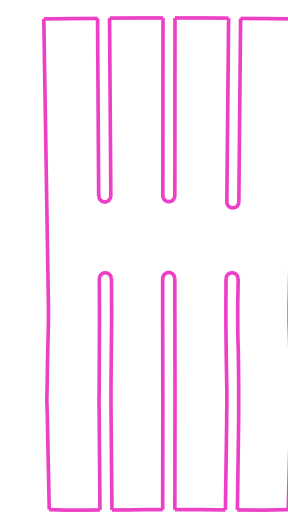
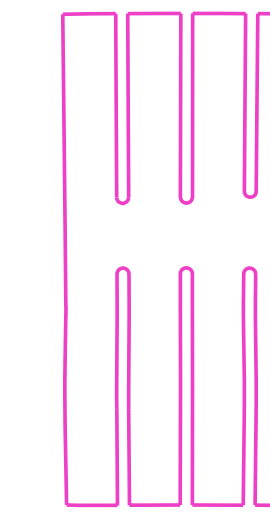
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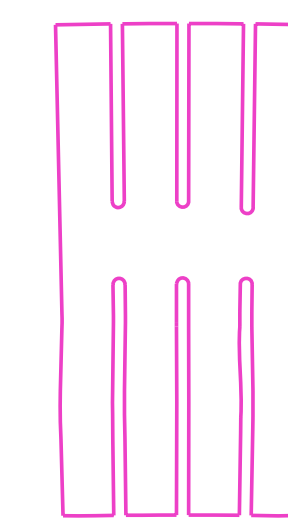
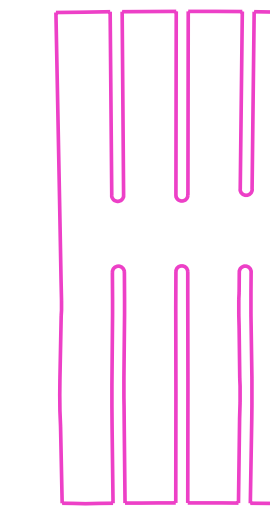
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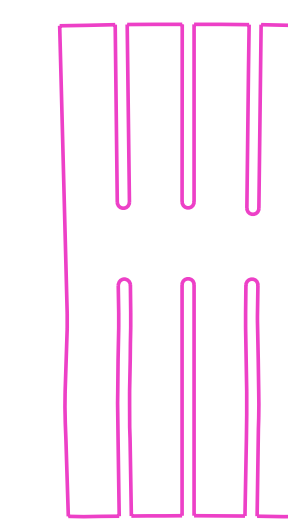
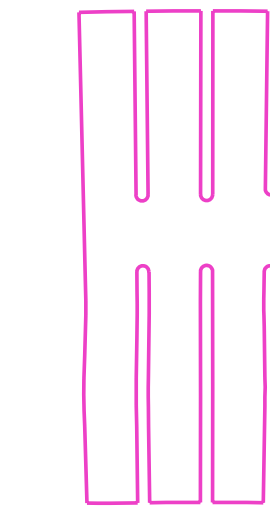
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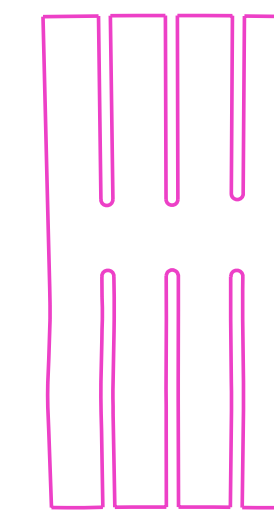
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INSTANCE:  
SE142C-384\_FLAT\_126

INSTANCE:  
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INSTANCE:  
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INSTANCE:  
SE142C-384\_FLAT\_129

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INSTANCE:  
SE142C-384\_FLAT\_132

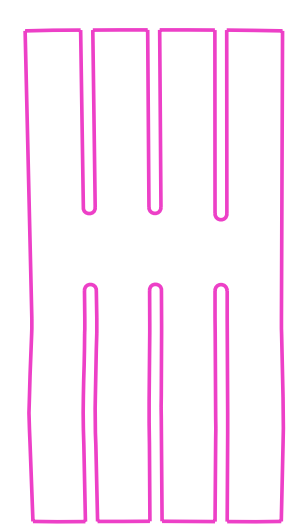
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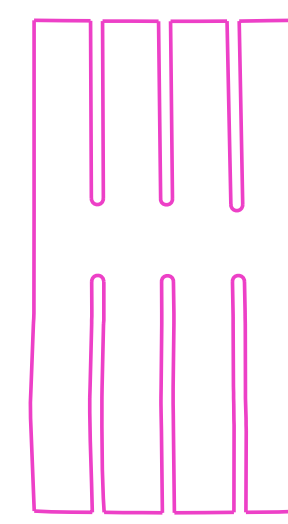
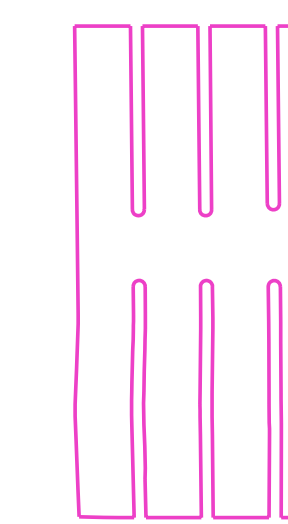
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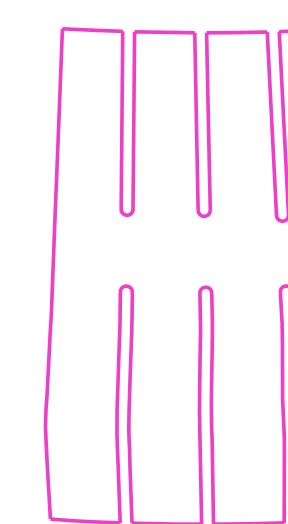
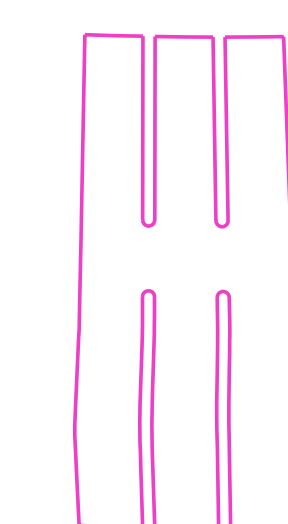
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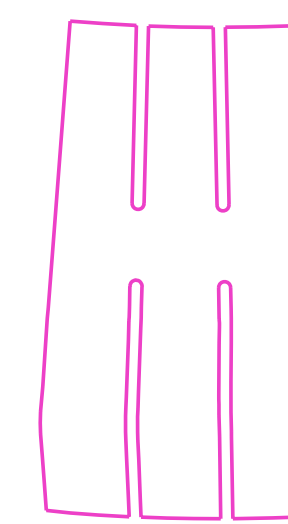
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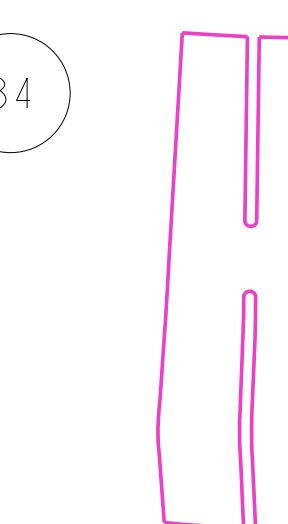
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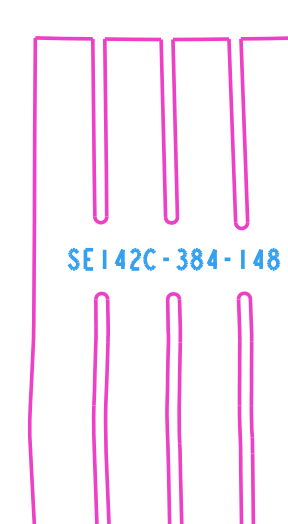
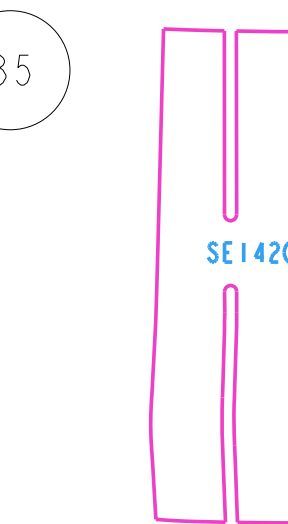
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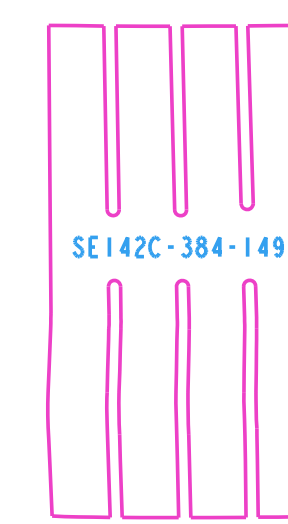
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INSTANCE:  
SE142C-384\_FLAT\_141

INSTANCE:  
SE142C-384\_FLAT\_142

INSTANCE:  
SE142C-384\_FLAT\_143

INSTANCE:  
SE142C-384\_FLAT\_144

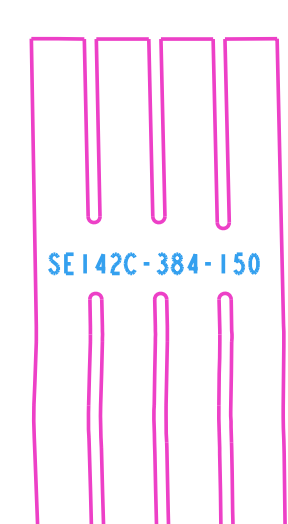
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SE142C-384\_FLAT\_145

INSTANCE:  
SE142C-384\_FLAT\_146

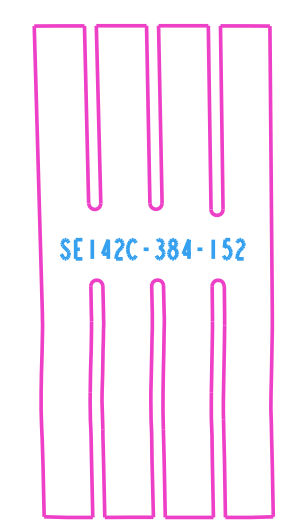
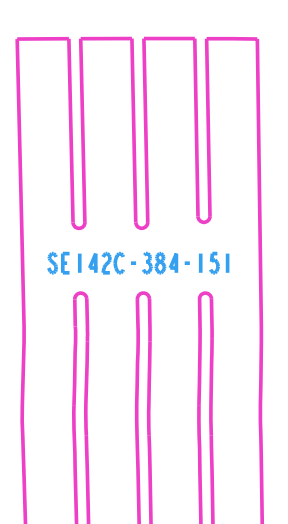
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INSTANCE:  
SE142C-384\_FLAT\_148

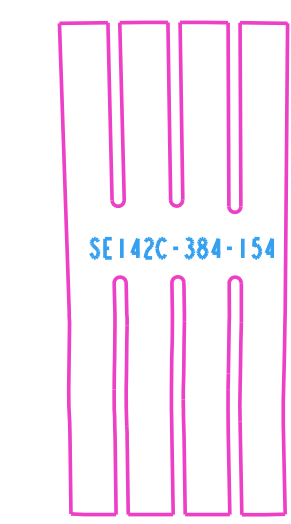
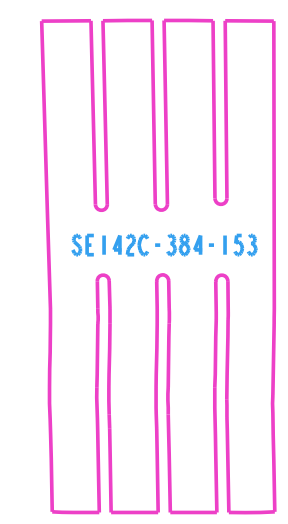
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SE142C-384\_FLAT\_149



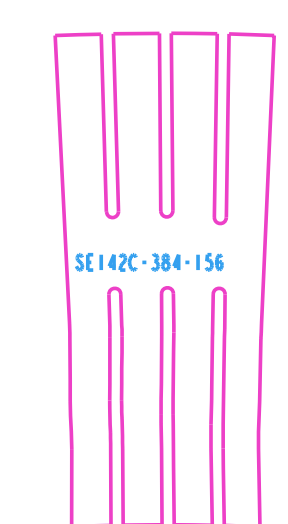
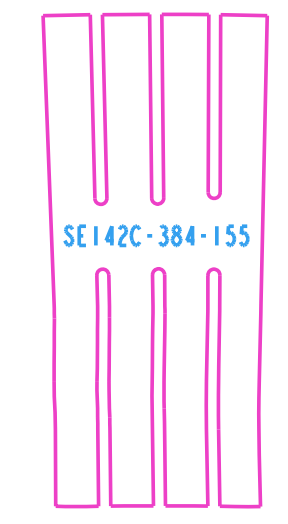
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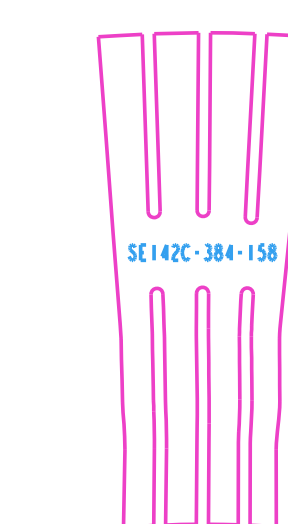
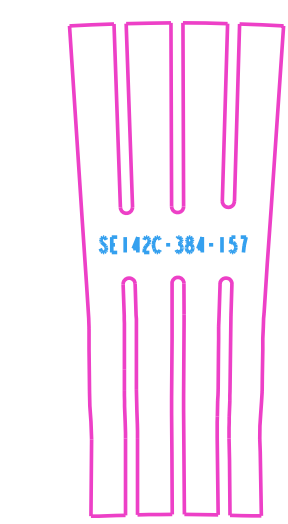
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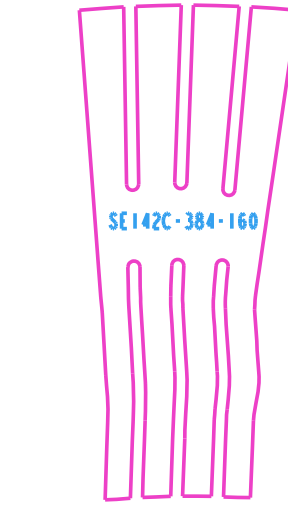
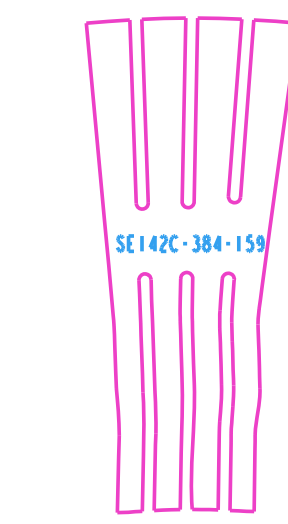
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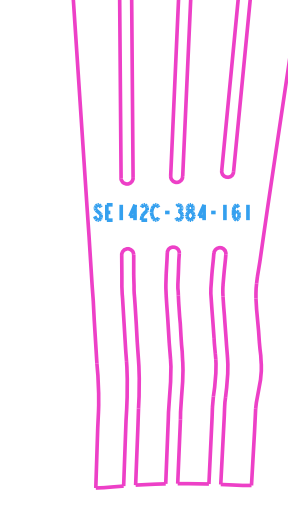
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41



42



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SE142C-384\_FLAT\_150

INSTANCE:  
SE142C-384\_FLAT\_151

INSTANCE:  
SE142C-384\_FLAT\_152

INSTANCE:  
SE142C-384\_FLAT\_153

INSTANCE:  
SE142C-384\_FLAT\_154

INSTANCE:  
SE142C-384\_FLAT\_155

INSTANCE:  
SE142C-384\_FLAT\_156

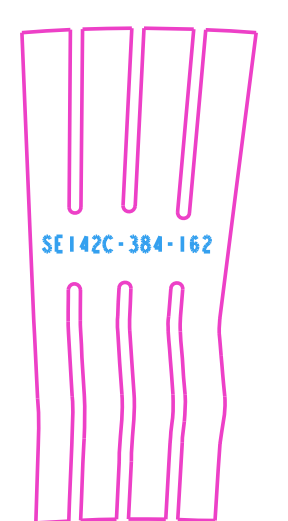
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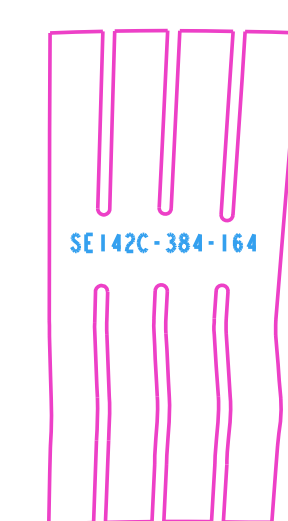
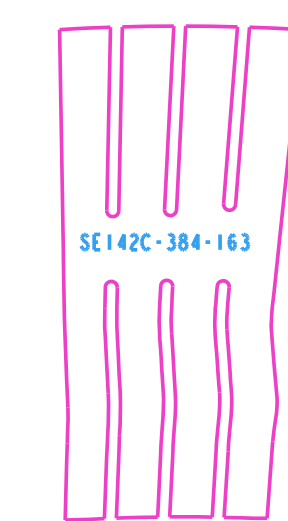
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INSTANCE:  
SE142C-384\_FLAT\_160

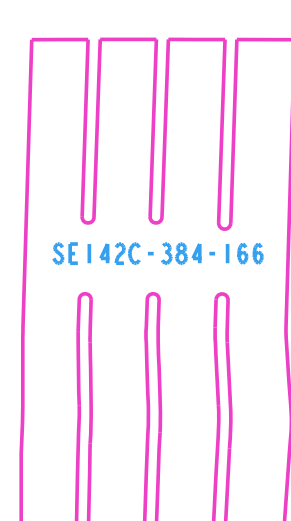
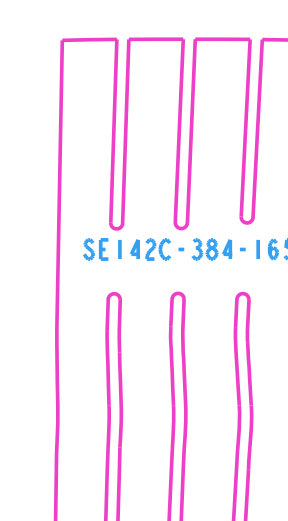
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SE142C-384\_FLAT\_161



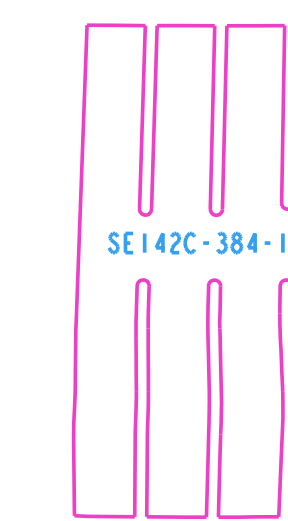
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44



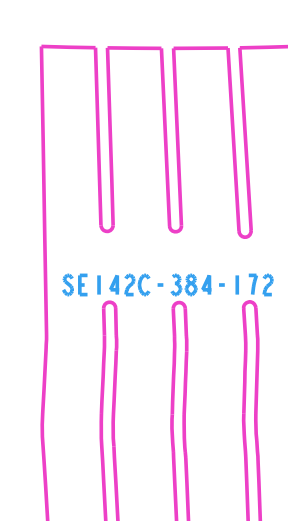
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46



47



48



INSTANCE:  
SE142C-384\_FLAT\_162

INSTANCE:  
SE142C-384\_FLAT\_163

INSTANCE:  
SE142C-384\_FLAT\_164

INSTANCE:  
SE142C-384\_FLAT\_165

INSTANCE:  
SE142C-384\_FLAT\_166

INSTANCE:  
SE142C-384\_FLAT\_167

INSTANCE:  
SE142C-384\_FLAT\_168

INSTANCE:  
SE142C-384\_FLAT\_169

INSTANCE:  
SE142C-384\_FLAT\_170

INSTANCE:  
SE142C-384\_FLAT\_171

INSTANCE:  
SE142C-384\_FLAT\_172

INSTANCE:  
SE142C-384\_FLAT\_173

**ECN-5140R2 pending.** This ECN permits the use of UNS C11000 ETP as acceptable material per RFD-14-021. (See ECN-5140R2 for details)

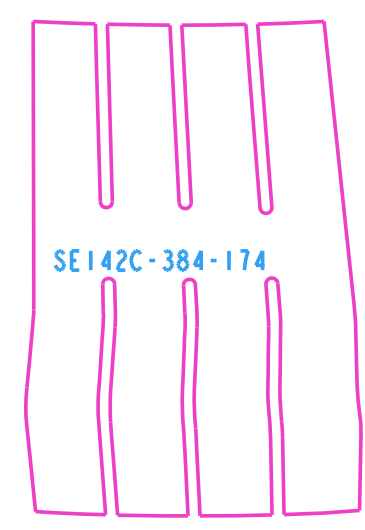
SCALE ALL VIEWS: 1.00

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

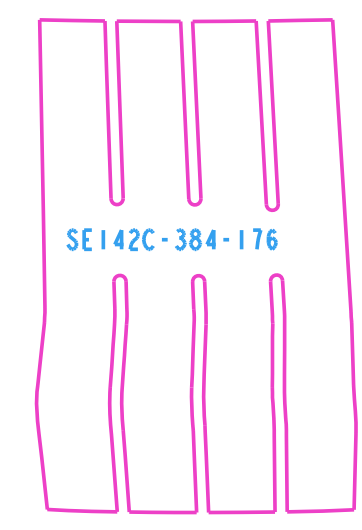
Oak Ridge National Laboratory managed for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT contract DE-AC05-00OR22725 UT-BATTELLE, LLC, Oak Ridge, Tennessee PROJECT NAME:							
<b>NATIONAL COMPACT STELLARATOR EXPERIMENT</b> MODULAR COIL TYPE - C SIDE - A LOWER CLADDING FLAT PATTERN LAYOUT							
VERSION NO.	PLANT	BLDG	FL	SHT OF	TYPE	CLASS	
6	X-10	5700	3	3	5	S	U
RELEASE LEVEL		SE142C-384					
Fabrication		REV 0					

SE142C-384

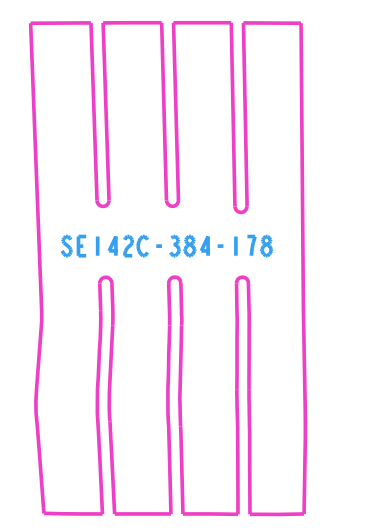
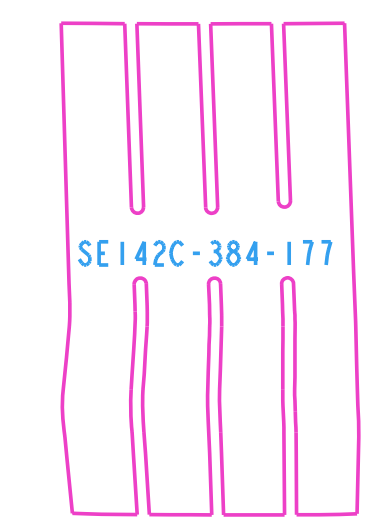
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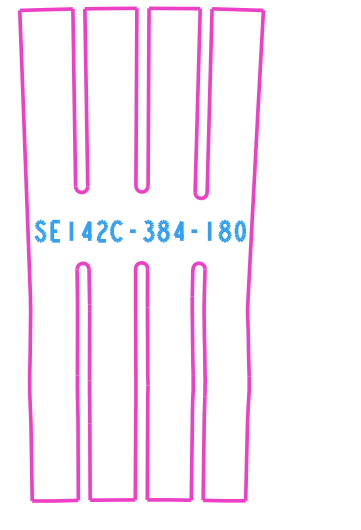
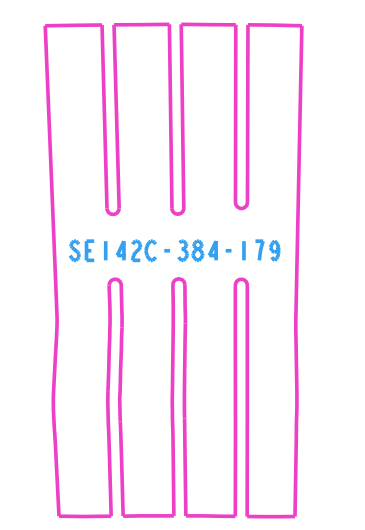
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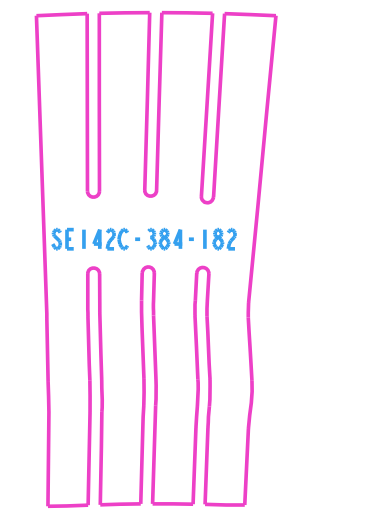
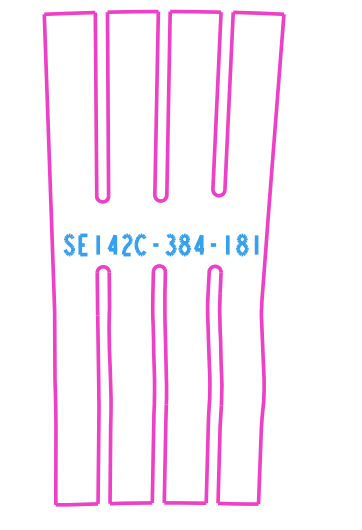
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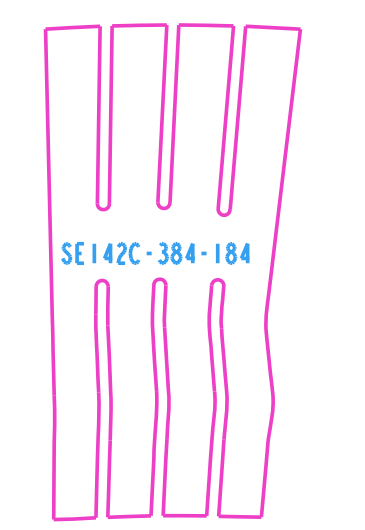
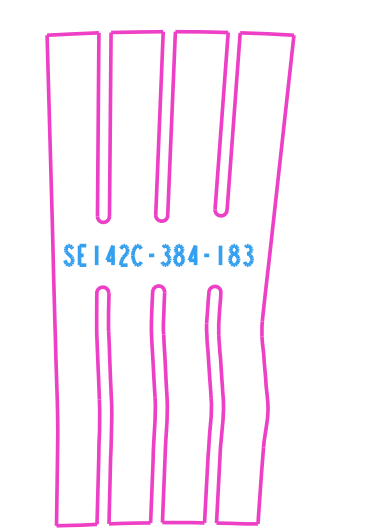
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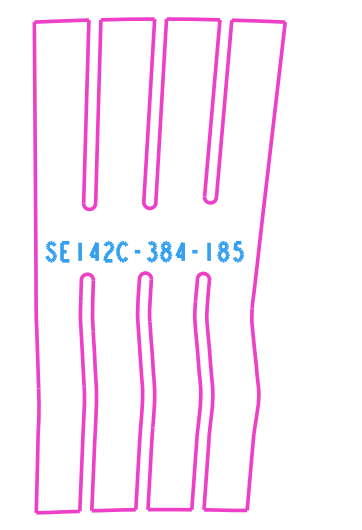
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53



54



INSTANCE:  
SE142C-384\_FLAT\_174

INSTANCE:  
SE142C-384\_FLAT\_175

INSTANCE:  
SE142C-384\_FLAT\_176

INSTANCE:  
SE142C-384\_FLAT\_177

INSTANCE:  
SE142C-384\_FLAT\_178

INSTANCE:  
SE142C-384\_FLAT\_179

INSTANCE:  
SE142C-384\_FLAT\_180

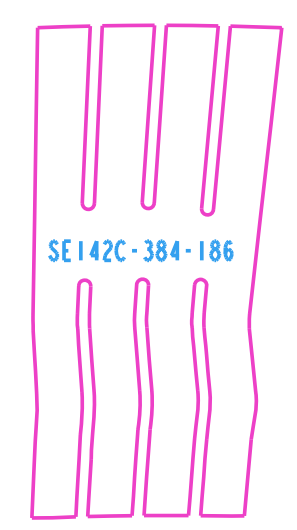
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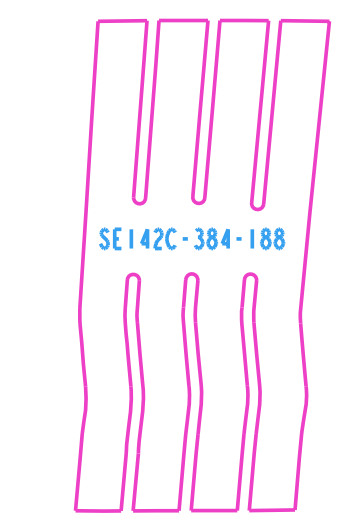
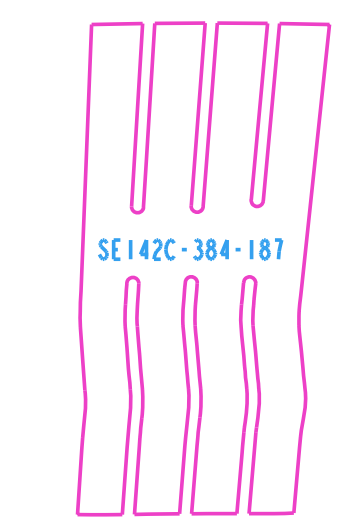
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SE142C-384\_FLAT\_183

INSTANCE:  
SE142C-384\_FLAT\_184

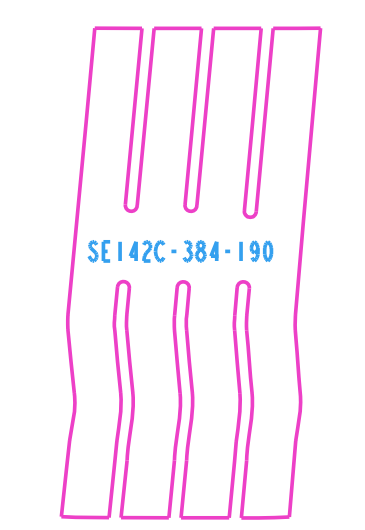
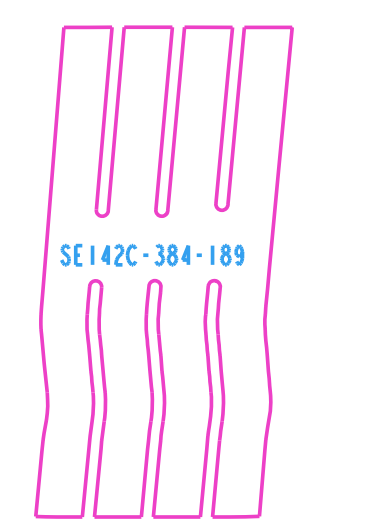
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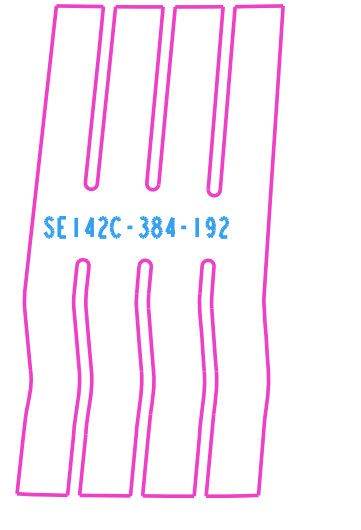
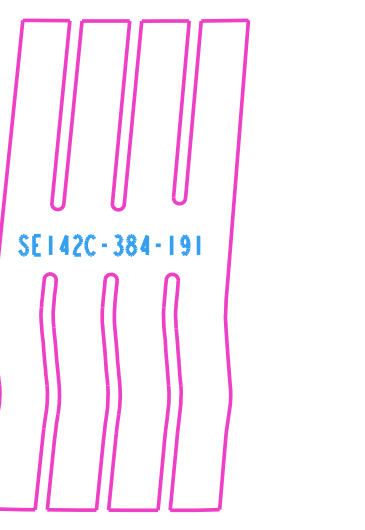
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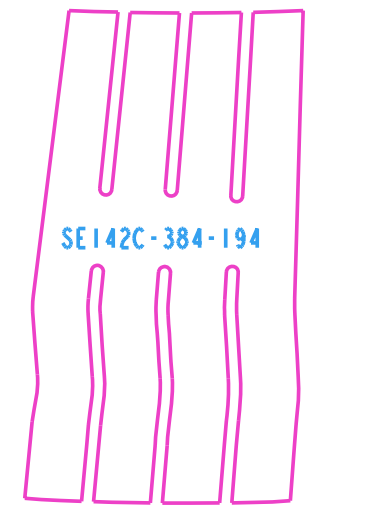
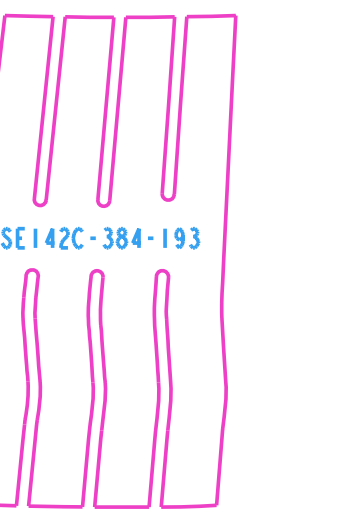
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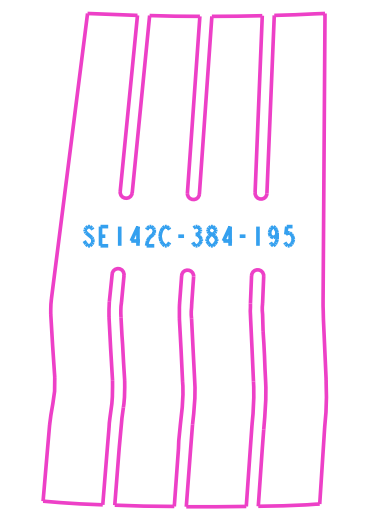
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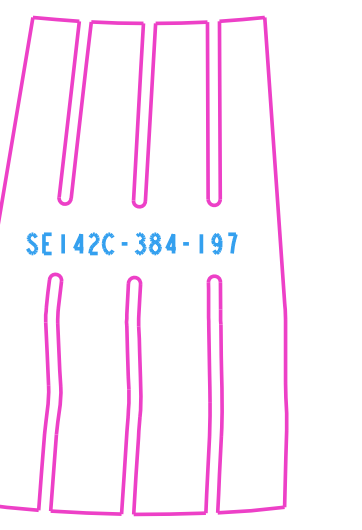
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59



60



INSTANCE:  
SE142C-384\_FLAT\_186

INSTANCE:  
SE142C-384\_FLAT\_187

INSTANCE:  
SE142C-384\_FLAT\_188

INSTANCE:  
SE142C-384\_FLAT\_189

INSTANCE:  
SE142C-384\_FLAT\_190

INSTANCE:  
SE142C-384\_FLAT\_191

INSTANCE:  
SE142C-384\_FLAT\_192

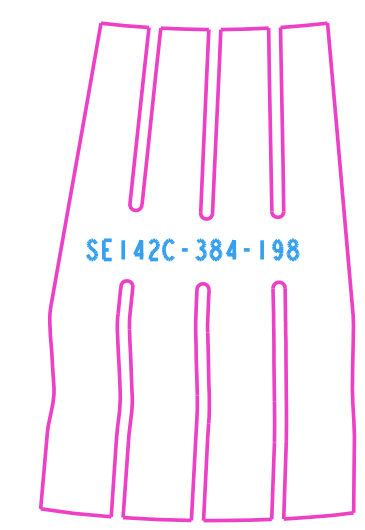
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INSTANCE:  
SE142C-384\_FLAT\_194

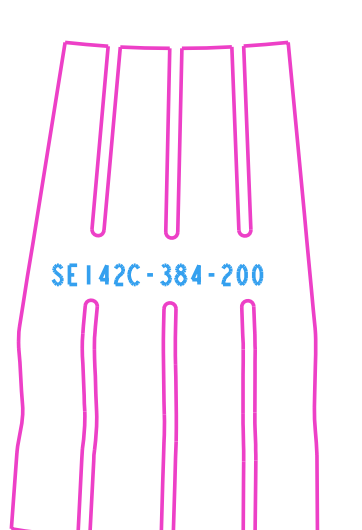
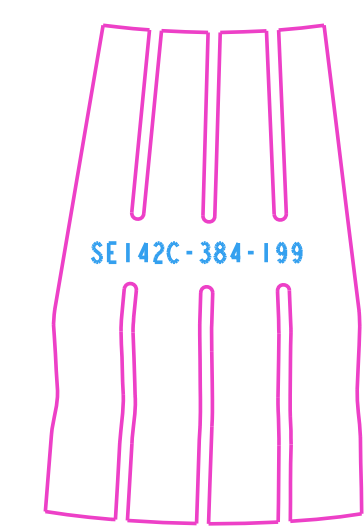
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INSTANCE:  
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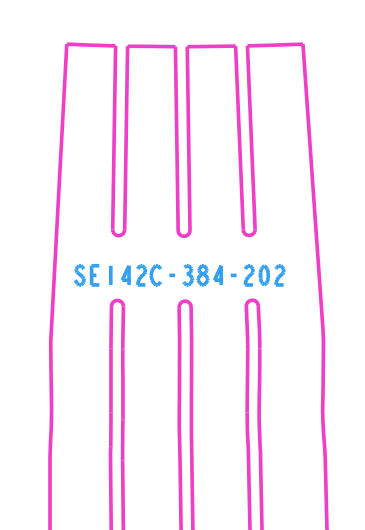
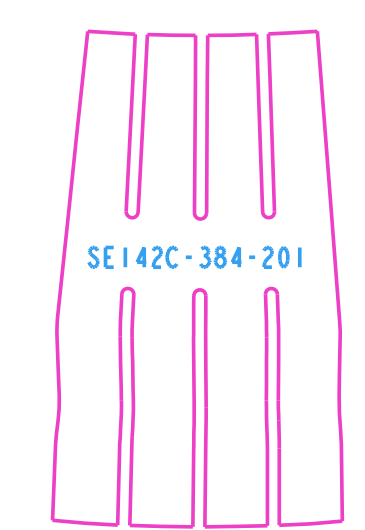
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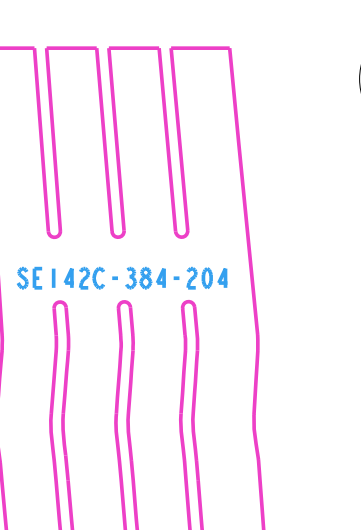
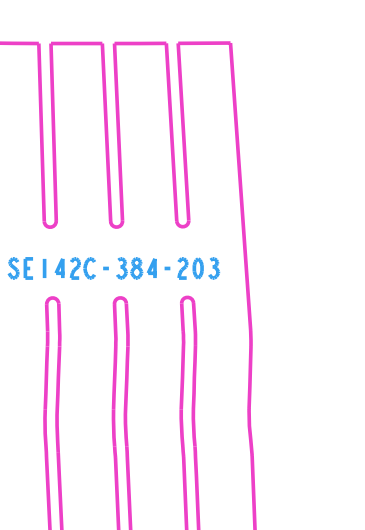
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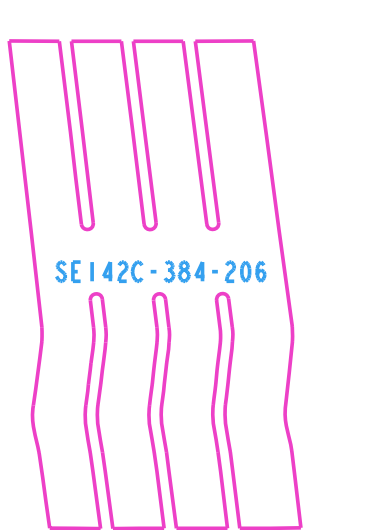
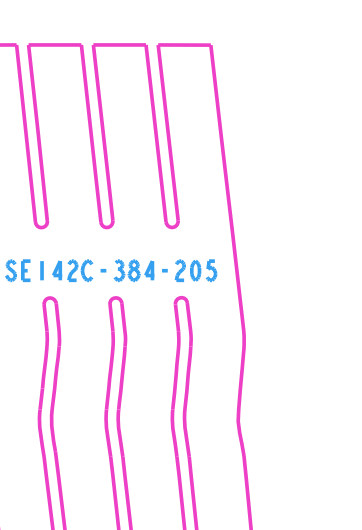
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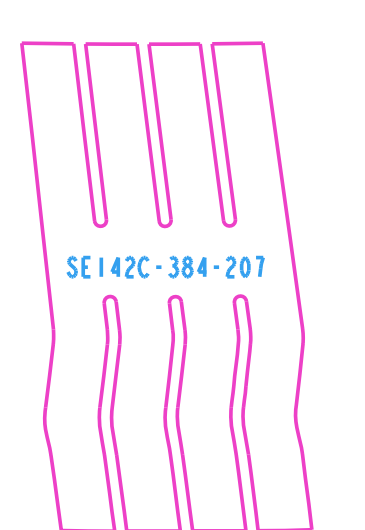
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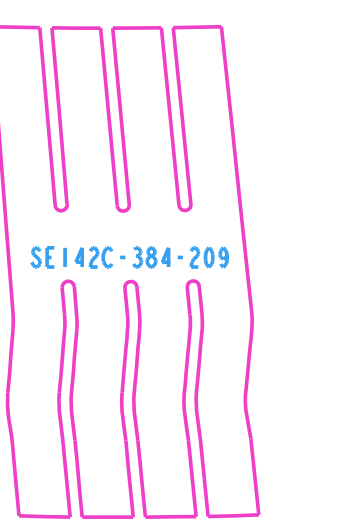
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65



66



INSTANCE:  
SE142C-384\_FLAT\_198\_291\_NO\_CLAMP

INSTANCE:  
SE142C-384\_FLAT\_199\_292\_NO\_CLAMP

INSTANCE:  
SE142C-384\_FLAT\_198

INSTANCE:  
SE142C-384\_FLAT\_201

INSTANCE:  
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INSTANCE:  
SE142C-384\_FLAT\_203

INSTANCE:  
SE142C-384\_FLAT\_204

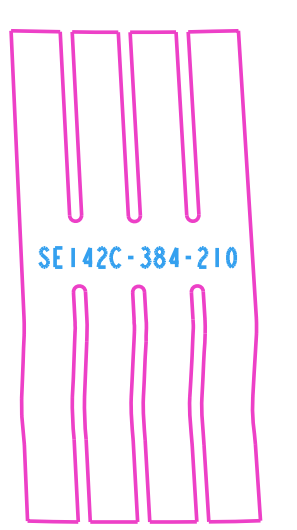
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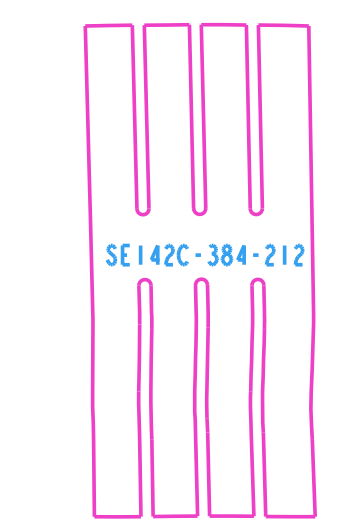
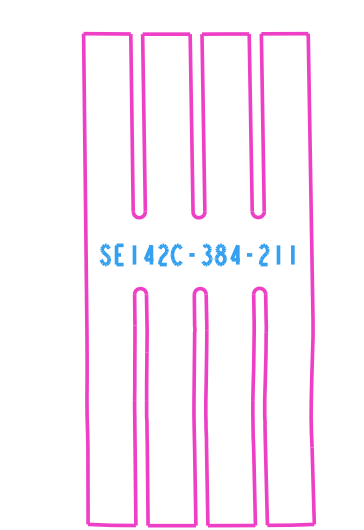
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INSTANCE:  
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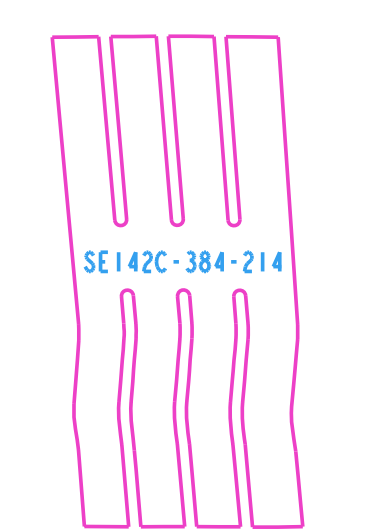
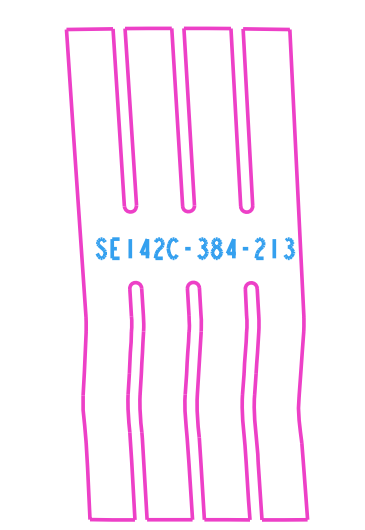
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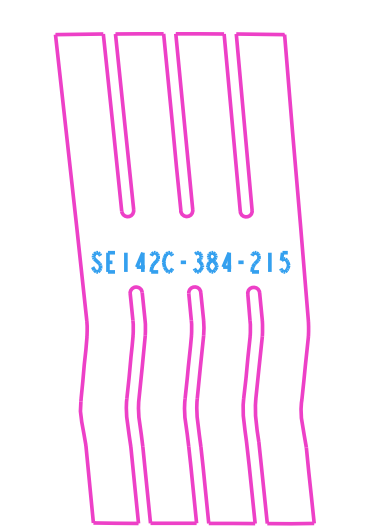
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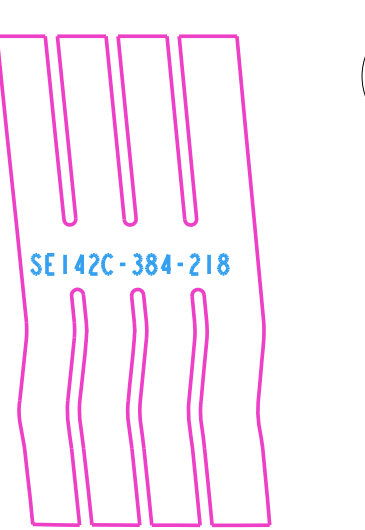
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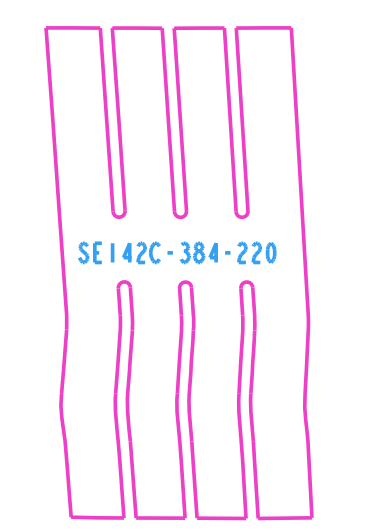
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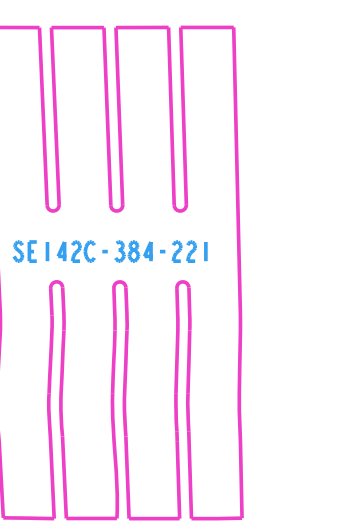
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71



72



INSTANCE:  
SE142C-384\_FLAT\_210

INSTANCE:  
SE142C-384\_FLAT\_211

INSTANCE:  
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INSTANCE:  
SE142C-384\_FLAT\_213

INSTANCE:  
SE142C-384\_FLAT\_214

INSTANCE:  
SE142C-384\_FLAT\_215

INSTANCE:  
SE142C-384\_FLAT\_216

INSTANCE:  
SE142C-384\_FLAT\_217

INSTANCE:  
SE142C-384\_FLAT\_218

INSTANCE:  
SE142C-384\_FLAT\_219

INSTANCE:  
SE142C-384\_FLAT\_220

INSTANCE:  
SE142C-384\_FLAT\_221

**ECN-5140R2 pending.** This ECN permits the use of UNS C11000 ETP as acceptable material per RFD-14-021.  
**(See ECN-5140R2 for details)**

SCALE ALL VIEWS: 1.00

**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:						
<b>NATIONAL COMPACT STELLARATOR EXPERIMENT</b> MODULAR COIL TYPE - C SIDE - A LOWER CLADDING FLAT PATTERN LAYOUT						
VERSION NO.	PLANT	BLDG	FL	SHT OF	TYPE	CLASS
6	X-10	5700	3	4	5	S
RELEASE LEVEL	REV					
Fabrication	SE142C-384					
	U					
	0					

SE142C-384



SCALE ALL VIEWS: 1.00

**ECN-5140R2 pending.** This ECN permits the use of UNS C11000 ETP as acceptable material per RFD-14-021.  
**(See ECN-5140R2 for details)**

**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:						
<b>NATIONAL COMPACT STELLARATOR EXPERIMENT</b> MODULAR COIL TYPE - C SIDE - A LOWER CLADDING FLAT PATTERN LAYOUT						
VERSION NO.	PLANT	BLDG	FL	SHT OF	TYPE	CLASS
6	X-10	5700	3	5	S	U
RELEASE LEVEL		REV				
Fabrication		SE142C-384			0	

SE142C-384