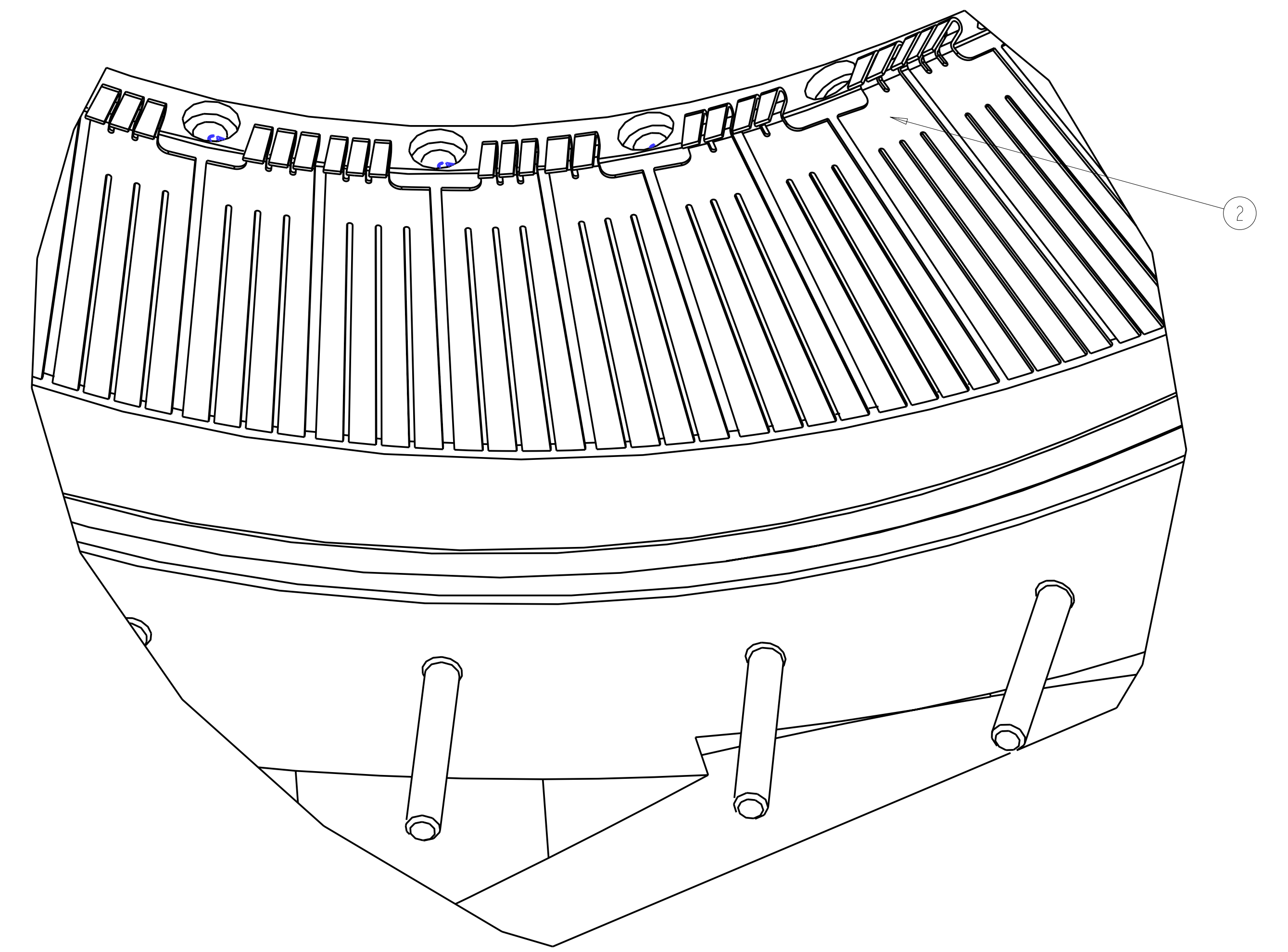


NOTES

- DRAWING PREPARED IN ACCORDANCE WITH ASME Y14.8M-1996.
- INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M-1994.
- DIMENSIONS ARE IN INCHES.
- DRAWING DEPICTS FLAT PATTERN OF FORMED PARTS DEFINED BY PRO/ENGINEER FILES SE142C-482-XXX.FORM.PRT.
- PROFILE TOLERANCE OF FLAT PATTERN IS +/- .010 IN.
- REMOVE ALL BURRS AND SHARP EDGES.
- IDENTIFY PARTS BY ETCHING OR PERMANENT MARKER.

Instance Name	Hole	S-Dim	Part Name	Instance Name	Hole	S-Dim	Part Name
SE142C-482_FLAT_270		0.885417	SE142C-482-270	SE142C-482_FLAT_174-NEW	49	0.385417	SE142C-482-174
SE142C-482_FLAT_271	1	0.890625	SE142C-482-271	SE142C-482_FLAT_175-NEW		0.390625	SE142C-482-175
SE142C-482_FLAT_272		0.895833	SE142C-482-272	SE142C-482_FLAT_176-NEW		0.395833	SE142C-482-176
SE142C-482_FLAT_273	2	0.901042	SE142C-482-273	SE142C-482_FLAT_177-NEW	50	0.401042	SE142C-482-177
SE142C-482_FLAT_274		0.906250	SE142C-482-274	SE142C-482_FLAT_178		0.406250	SE142C-482-178
SE142C-482_FLAT_275	3	0.911458	SE142C-482-275	SE142C-482_FLAT_179	51	0.411458	SE142C-482-179
SE142C-482_FLAT_276		0.916667	SE142C-482-276	SE142C-482_FLAT_180		0.416667	SE142C-482-180
SE142C-482_FLAT_277	4	0.921875	SE142C-482-277	SE142C-482_FLAT_181	52	0.421875	SE142C-482-181
SE142C-482_FLAT_278		0.927083	SE142C-482-278	SE142C-482_FLAT_182		0.427083	SE142C-482-182
SE142C-482_FLAT_279	5	0.932292	SE142C-482-279	SE142C-482_FLAT_183	53	0.432292	SE142C-482-183
SE142C-482_FLAT_280		0.937500	SE142C-482-280	SE142C-482_FLAT_184		0.437500	SE142C-482-184
SE142C-482_FLAT_281	6	0.942708	SE142C-482-281	SE142C-482_FLAT_185	54	0.442708	SE142C-482-185
SE142C-482_FLAT_282		0.947917	SE142C-482-282	SE142C-482_FLAT_186		0.447917	SE142C-482-186
SE142C-482_FLAT_283	7	0.953125	SE142C-482-283	SE142C-482_FLAT_187	55	0.453125	SE142C-482-187
SE142C-482_FLAT_284		0.958333	SE142C-482-284	SE142C-482_FLAT_188		0.458333	SE142C-482-188
SE142C-482_FLAT_285	8	0.963542	SE142C-482-285	SE142C-482_FLAT_189	56	0.463542	SE142C-482-189
SE142C-482_FLAT_286		0.968750	SE142C-482-286	SE142C-482_FLAT_190		0.468750	SE142C-482-190
SE142C-482_FLAT_287	9	0.973958	SE142C-482-287	SE142C-482_FLAT_191	57	0.473958	SE142C-482-191
SE142C-482_FLAT_288		0.979167	SE142C-482-288	SE142C-482_FLAT_192		0.479167	SE142C-482-192
SE142C-482_FLAT_289	10	0.984375	SE142C-482-289	SE142C-482_FLAT_193	58	0.484375	SE142C-482-193
SE142C-482_FLAT_290		0.989583	SE142C-482-290	SE142C-482_FLAT_194		0.489583	SE142C-482-194
SE142C-482_FLAT_291	11	0.994792	SE142C-482-291	SE142C-482_FLAT_195-NEW	59	0.494792	SE142C-482-195
SE142C-482_FLAT_292-NEW		0.000000	SE142C-482-292	SE142C-482_FLAT_196		0.500000	SE142C-482-196
SE142C-482_FLAT_101	12	0.005208	SE142C-482-101	SE142C-482_FLAT_197	60	0.505208	SE142C-482-197
SE142C-482_FLAT_102		0.010417	SE142C-482-102	SE142C-482_FLAT_198-NEW		0.510417	SE142C-482-198
SE142C-482_FLAT_103-NEW	13	0.015625	SE142C-482-103	SE142C-482_FLAT_199-NEW	61	0.515625	SE142C-482-199
SE142C-482_FLAT_104-NEW		0.019341	SE142C-482-104	SE142C-482_FLAT_200-NEW		0.520833	SE142C-482-200
SE142C-482_FLAT_106-NEW	14	0.024000	SE142C-482-106	SE142C-482_FLAT_201	62	0.526042	SE142C-482-201
SE142C-482_FLAT_107-NEW		0.036000	SE142C-482-107	SE142C-482_FLAT_202		0.531250	SE142C-482-202
SE142C-482_FLAT_108-NEW	15	0.041000	SE142C-482-108	SE142C-482_FLAT_203	63	0.536458	SE142C-482-203
SE142C-482_FLAT_109		0.046875	SE142C-482-109	SE142C-482_FLAT_204		0.541667	SE142C-482-204
SE142C-482_FLAT_110	16	0.052083	SE142C-482-110	SE142C-482_FLAT_205	64	0.546875	SE142C-482-205
SE142C-482_FLAT_111		0.057292	SE142C-482-111	SE142C-482_FLAT_206		0.552083	SE142C-482-206
SE142C-482_FLAT_112	17	0.062500	SE142C-482-112	SE142C-482_FLAT_207	65	0.557292	SE142C-482-207
SE142C-482_FLAT_113		0.067708	SE142C-482-113	SE142C-482_FLAT_208		0.562500	SE142C-482-208
SE142C-482_FLAT_114	18	0.072917	SE142C-482-114	SE142C-482_FLAT_209	66	0.567708	SE142C-482-209
SE142C-482_FLAT_115		0.078125	SE142C-482-115	SE142C-482_FLAT_210		0.572917	SE142C-482-210
SE142C-482_FLAT_116	19	0.083333	SE142C-482-116	SE142C-482_FLAT_211	67	0.578125	SE142C-482-211
SE142C-482_FLAT_117		0.088542	SE142C-482-117	SE142C-482_FLAT_212		0.583334	SE142C-482-212
SE142C-482_FLAT_118	20	0.093750	SE142C-482-118	SE142C-482_FLAT_213	68	0.588542	SE142C-482-213
SE142C-482_FLAT_119		0.098958	SE142C-482-119	SE142C-482_FLAT_214		0.593750	SE142C-482-214
SE142C-482_FLAT_120	21	0.104167	SE142C-482-120	SE142C-482_FLAT_215	69	0.598959	SE142C-482-215
SE142C-482_FLAT_121		0.109375	SE142C-482-121	SE142C-482_FLAT_216		0.604167	SE142C-482-216
SE142C-482_FLAT_122	22	0.114583	SE142C-482-122	SE142C-482_FLAT_217	70	0.609375	SE142C-482-217
SE142C-482_FLAT_123		0.119792	SE142C-482-123	SE142C-482_FLAT_218		0.614584	SE142C-482-218
SE142C-482_FLAT_124	23	0.125000	SE142C-482-124	SE142C-482_FLAT_219	71	0.619792	SE142C-482-219
SE142C-482_FLAT_125		0.130208	SE142C-482-125	SE142C-482_FLAT_220		0.625000	SE142C-482-220
SE142C-482_FLAT_126	24	0.135417	SE142C-482-126	SE142C-482_FLAT_221	72	0.630209	SE142C-482-221
SE142C-482_FLAT_127		0.140625	SE142C-482-127	SE142C-482_FLAT_222		0.635417	SE142C-482-222
SE142C-482_FLAT_128	25	0.145833	SE142C-482-128	SE142C-482_FLAT_223	73	0.640625	SE142C-482-223
SE142C-482_FLAT_129		0.151042	SE142C-482-129	SE142C-482_FLAT_224		0.645834	SE142C-482-224
SE142C-482_FLAT_130	26	0.156250	SE142C-482-130	SE142C-482_FLAT_225	74	0.651042	SE142C-482-225
SE142C-482_FLAT_131		0.161458	SE142C-482-131	SE142C-482_FLAT_226		0.656250	SE142C-482-226
SE142C-482_FLAT_132	27	0.166667	SE142C-482-132	SE142C-482_FLAT_227	75	0.661458	SE142C-482-227
SE142C-482_FLAT_133		0.171875	SE142C-482-133	SE142C-482_FLAT_228		0.666667	SE142C-482-228
SE142C-482_FLAT_134	28	0.177083	SE142C-482-134	SE142C-482_FLAT_229	76	0.671875	SE142C-482-229
SE142C-482_FLAT_135		0.182292	SE142C-482-135	SE142C-482_FLAT_230		0.677083	SE142C-482-230
SE142C-482_FLAT_136	29	0.187500	SE142C-482-136	SE142C-482_FLAT_231	77	0.682292	SE142C-482-231
SE142C-482_FLAT_137		0.192708	SE142C-482-137	SE142C-482_FLAT_232		0.687500	SE142C-482-232
SE142C-482_FLAT_138	30	0.197917	SE142C-482-138	SE142C-482_FLAT_233	78	0.692708	SE142C-482-233
SE142C-482_FLAT_139		0.203125	SE142C-482-139	SE142C-482_FLAT_234		0.697917	SE142C-482-234
SE142C-482_FLAT_140	31	0.208333	SE142C-482-140	SE142C-482_FLAT_235	79	0.703125	SE142C-482-235
SE142C-482_FLAT_141		0.213542	SE142C-482-141	SE142C-482_FLAT_236		0.708333	SE142C-482-236
SE142C-482_FLAT_142	32	0.218750	SE142C-482-142	SE142C-482_FLAT_237	80	0.713542	SE142C-482-237
SE142C-482_FLAT_143-NEW		0.223958	SE142C-482-143	SE142C-482_FLAT_238		0.718750	SE142C-482-238
SE142C-482_FLAT_144-NEW	33	0.229167	SE142C-482-144	SE142C-482_FLAT_239	81	0.723958	SE142C-482-239
SE142C-482_FLAT_145-NEW		0.234375	SE142C-482-145	SE142C-482_FLAT_240-NEW		0.729167	SE142C-482-240
SE142C-482_FLAT_146-NEW	34	0.239583	SE142C-482-146	SE142C-482_FLAT_241-NEW	82	0.734375	SE142C-482-241
SE142C-482_FLAT_147		0.244792	SE142C-482-147	SE142C-482_FLAT_242-NEW		0.739583	SE142C-482-242
SE142C-482_FLAT_148	35	0.250000	SE142C-482-148	SE142C-482_FLAT_243-NEW	83	0.744792	SE142C-482-243
SE142C-482_FLAT_149		0.255208	SE142C-482-149	SE142C-482_FLAT_244-NEW		0.750000	SE142C-482-244
SE142C-482_FLAT_150	36	0.260417	SE142C-482-150	SE142C-482_FLAT_245	84	0.755208	SE142C-482-245
SE142C-482_FLAT_151		0.265625	SE142C-482-151	SE142C-482_FLAT_246		0.760417	SE142C-482-246
SE142C-482_FLAT_152	37	0.270833	SE142C-482-152	SE142C-482_FLAT_247	85	0.765625	SE142C-482-247
SE142C-482_FLAT_153		0.276042	SE142C-482-153	SE142C-482_FLAT_248		0.770833	SE142C-482-248
SE142C-482_FLAT_154	38	0.281250	SE142C-482-154	SE142C-482_FLAT_249	86	0.776042	SE142C-482-249
SE142C-482_FLAT_155		0.286458	SE142C-482-155	SE142C-482_FLAT_250		0.781250	SE142C-482-250
SE142C-482_FLAT_156	39	0.291667	SE142C-482-156	SE142C-482_FLAT_251	87	0.786458	SE142C-482-251
SE142C-482_FLAT_157		0.296875	SE142C-482-157	SE142C-482_FLAT_252		0.791667	SE142C-482-252
SE142C-482_FLAT_158	40	0.302083	SE142C-482-158	SE142C-482_FLAT_253	88	0.796875	SE142C-482-253
SE142C-482_FLAT_159		0.307292	SE142C-482-159	SE142C-482_FLAT_254		0.802083	SE142C-482-254
SE142C-482_FLAT_160	41	0.312500	SE142C-482-160	SE142C-482_FLAT_255	89	0.807292	SE142C-482-255
SE142C-482_FLAT_161		0.317708	SE142C-482-161	SE142C-482_FLAT_256		0.812500	SE142C-482-256
SE142C-482_FLAT_162	42	0.322917	SE142C-482-162	SE142C-482_FLAT_257	90	0.817708	SE142C-482-257
SE142C-482_FLAT_163		0.328125	SE142C-482-163	SE142C-482_FLAT_258		0.822917	SE142C-482-258
SE142C-482_FLAT_164	43	0.333333	SE142C-482-164	SE142C-482_FLAT_259	91	0.828125	SE142C-482-259
SE142C-482_FLAT_165		0.338542	SE142C-482-165	SE142C-482_FLAT_260		0.833333	SE142C-482-260
SE142C-482_FLAT_166	44	0.343750	SE142C-482-166	SE142C-482_FLAT_261	92	0.838542	SE142C-482-261
SE142C-482_FLAT_167		0.348958	SE142C-482-167	SE142C-482_FLAT_262		0.843750	SE142C-482-262
SE142C-482_FLAT_168	45	0.354167	SE142C-482-168	SE142C-482_FLAT_263	93	0.848958	SE142C-482-263
SE142C-482_FLAT_169		0.359375	SE142C-482-169	SE142C-482_FLAT_264		0.854167	SE142C-482-264
SE142C-482_FLAT_170	46	0.364583	SE142C-482-170	SE142C-482_FLAT_265	94	0.859375	SE142C-482-265
SE142C-482_FLAT_171		0.369792	SE142C-482-171	SE142C-482_FLAT_266		0.864583	SE142C-482-266
SE142C-482_FLAT_172	47	0.375000	SE142C-482-172	SE142C-482_FLAT_267	95	0.869792	SE142C-482-267
SE142C-482_FLAT_173		0.380208	SE142C-482-173	SE142C-482_FLAT_268		0.875000	SE142C-482-268
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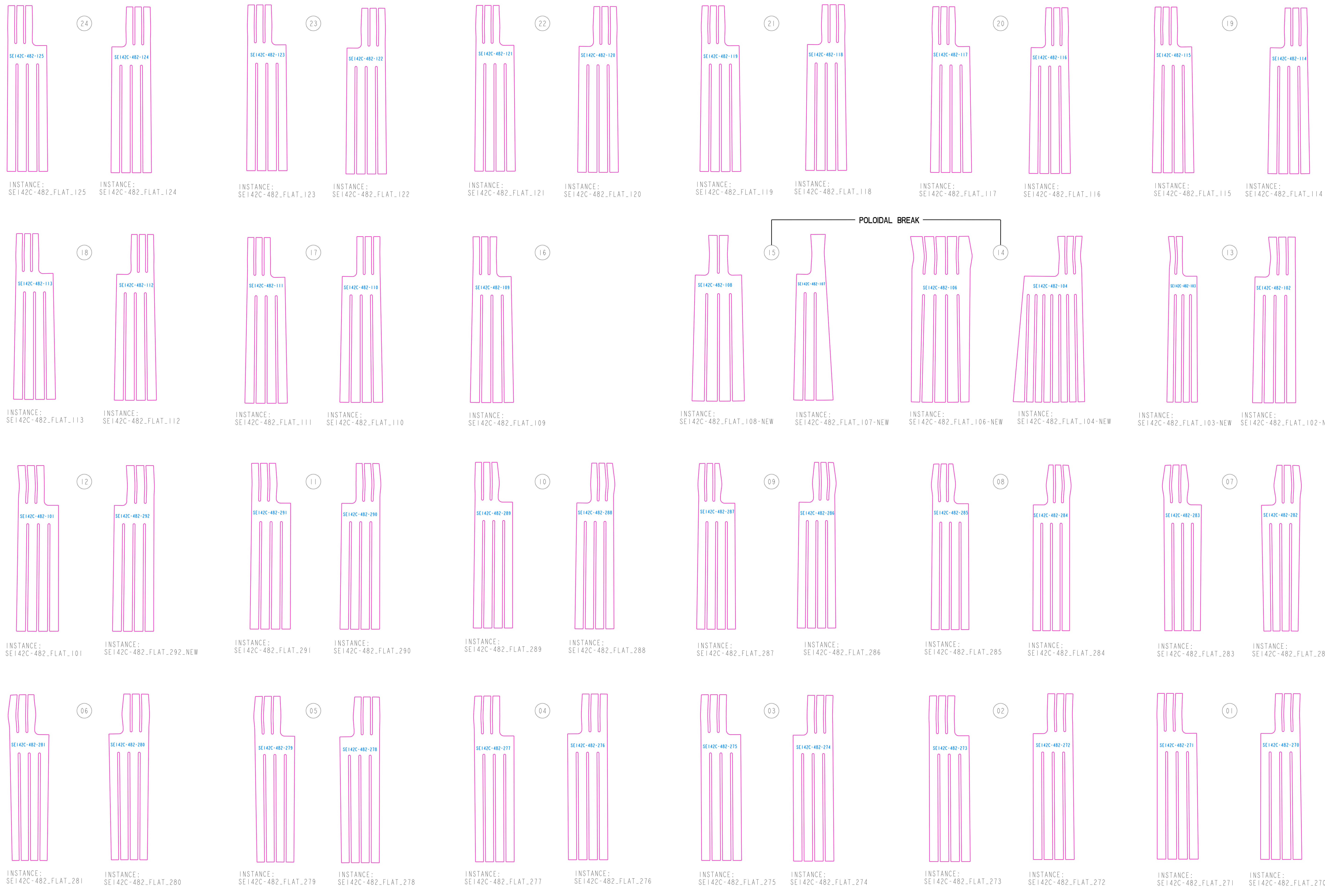
ECN-5140R2 pending. This ECN permits the use of UNS C11000 ETP as acceptable material per RFD-14-021.
 (See ECN-5140R2 for details)



ISOMETRIC VIEW
 SCALE 1.00

RELEASED FOR FABRICATION / INSTALLATION
 PPPL Drafting:

191	-2	CLADDING PARTS	COPPER, ANNEALED UNS C10100, C10200	2
AR	-1	TYPE-C SIDE-B UPPER CLADDING ASM		1
SE142C-251		CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION
				MATERIAL / SPECIFICATION
				FIN NO
				PARTS LIST



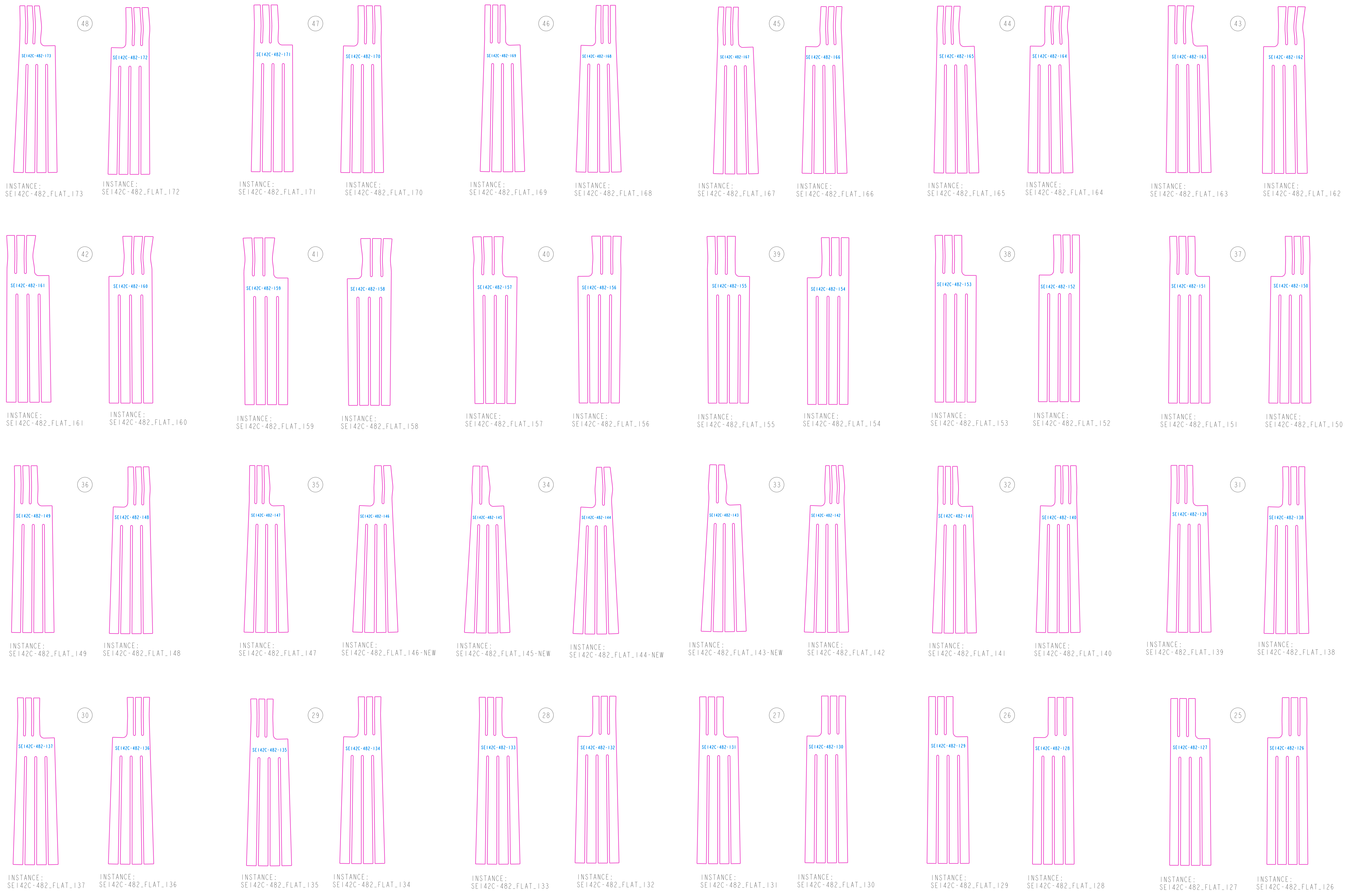
ECN-5140R2 pending. This ECN permits the use of UNS C11000 ETP as acceptable material per RFD-14-021.
 (See ECN-5140R2 for details)

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:						
NATIONAL COMPACT STELLARATOR EXPERIMENT						
MODULAR COIL TYPE - C SIDE -B UPPER CLADDING FLAT PATTERN LAYOUT						
VERSION NO.	PLANT	BLDG	FL	SHT OF	TYPE	CLASS
4	X-10	5700	3	25	S	U
RELEASE LEVEL		SEI42C-482		REV		
Fabrication				0		

SEI42C-482



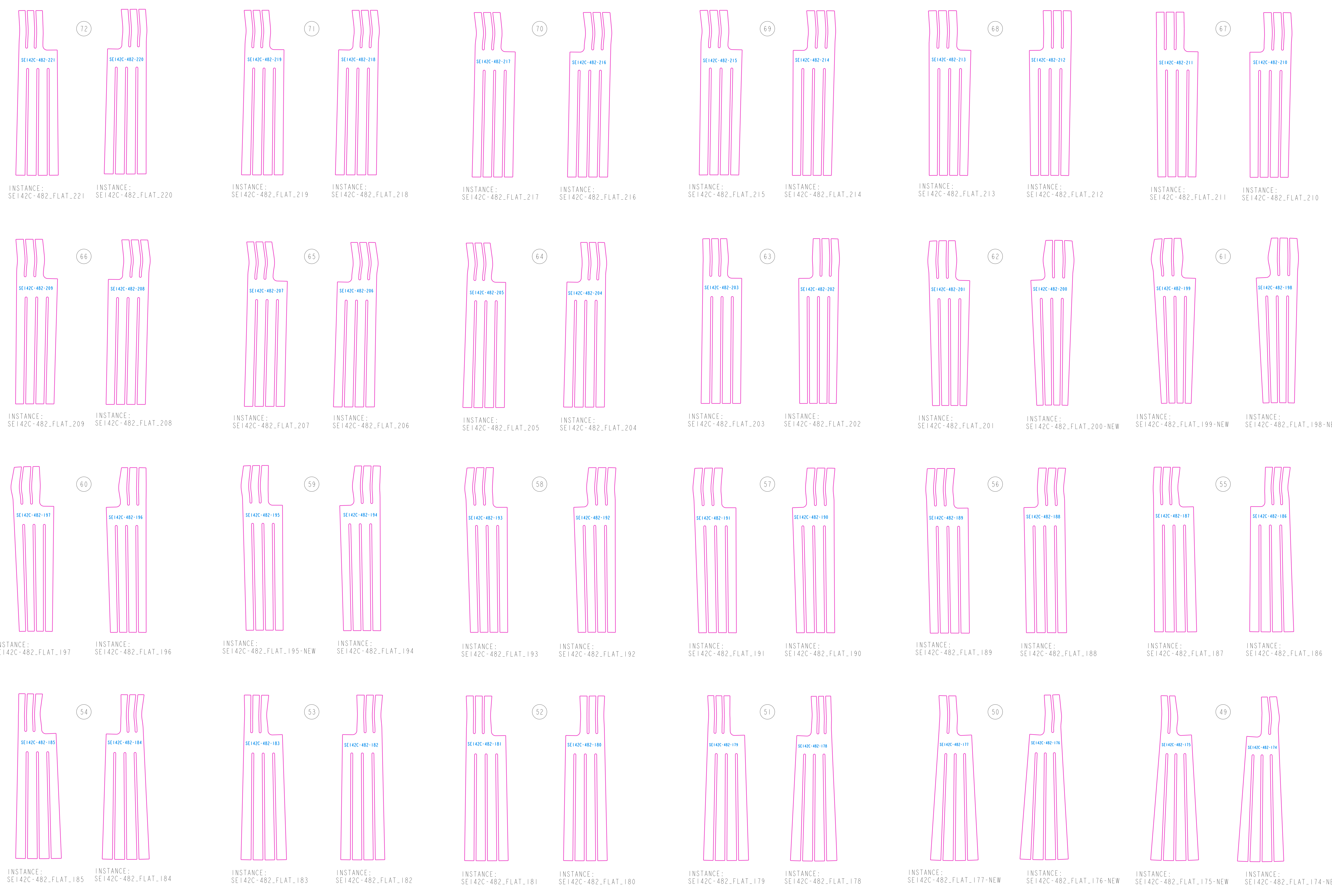
ECN-5140R2 pending. This ECN permits the use of UNS C11000 ETP as acceptable material per RFD-14-021.
(See ECN-5140R2 for details)

RELEASED FOR FABRICATION / INSTALLATION
PPPL Drafting:

SCALE ALL VIEWS: 1.00

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 TITLE			
NATIONAL COMPACT STELLARATOR EXPERIMENT			
MODULAR COIL TYPE - C			
SIDE -B UPPER CLADDING			
FLAT PATTERN LAYOUT			
VERSION NO.	PLANT	BLDG	FL SHOT OF
4	X-10	5700	3 3 5
RELEASE LEVEL	TYPE CLASS		
Fabrication	U		
REV			0
SE142C-482			

SE142C-482

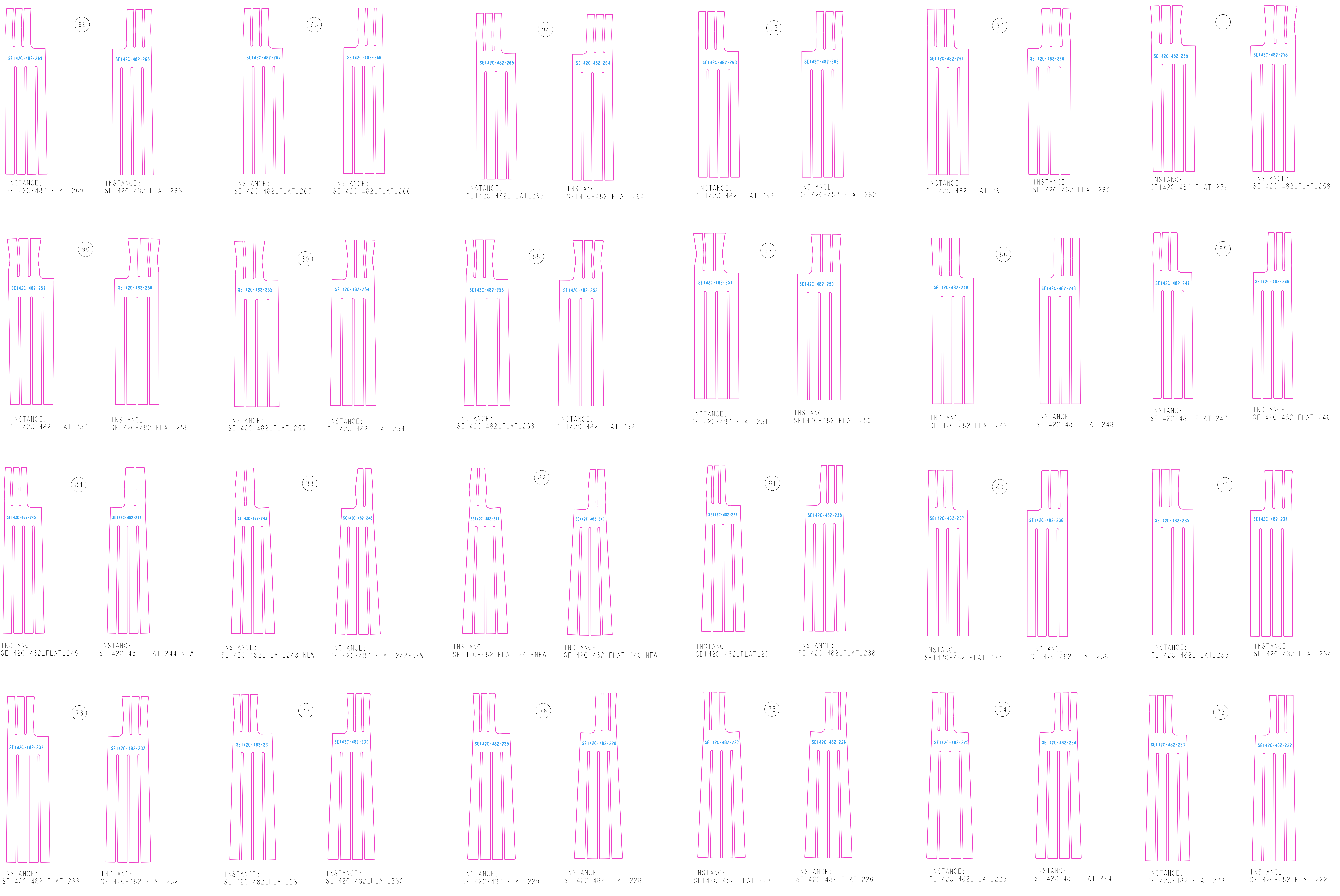


ECN-5140R2 pending. This ECN permits the use of UNS C11000 ETP as acceptable material per RFD-14-021.
 (See ECN-5140R2 for details)

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 FABRICATION / INSTALLATION**
 PPPL Drafting:

SCALE ALL VIEWS: 1.00

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 - C SIDE -B UPPER CLADDING FLAT PATTERN LAYOUT						
VERSION NO.	PLANT	BLDG	FL	SHT OF	TYPE	CLASS
4	X-10	5700	3	4	S	U
RELEASE LEVEL		REV				
Fabrication		SE142C-482				



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

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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 NAME:						
NATIONAL COMPACT STELLARATOR EXPERIMENT						
MODULAR COIL TYPE - C SIDE -B UPPER CLADDING FLAT PATTERN LAYOUT						
VERSION NO.	PLANT	BLDG	FL	SHT OF	TYPE	CLASS
4	X-10	5700	3	5	S	U
RELEASE LEVEL		SE142C-482		REV		
Fabrication				0		

SE142C-482