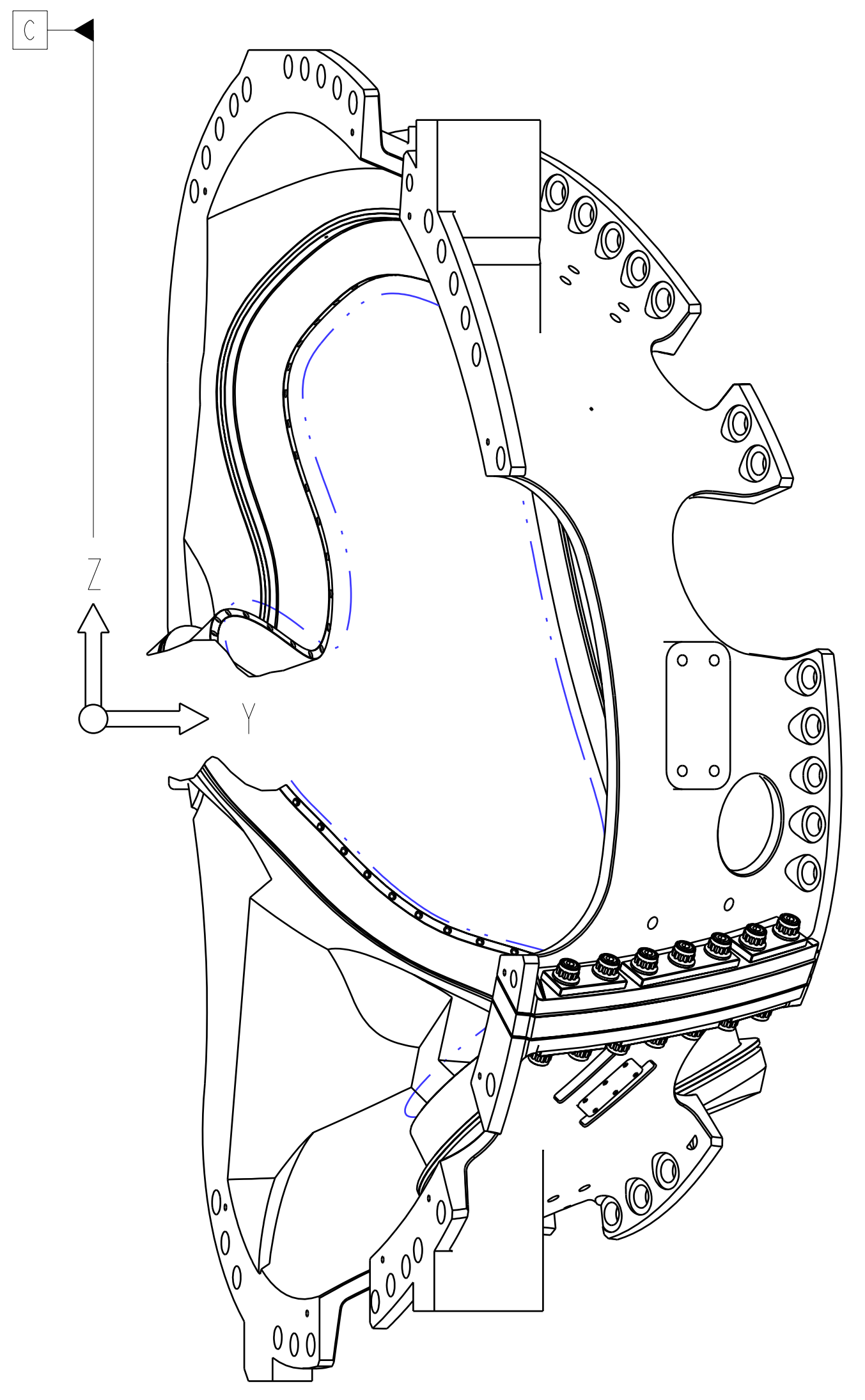
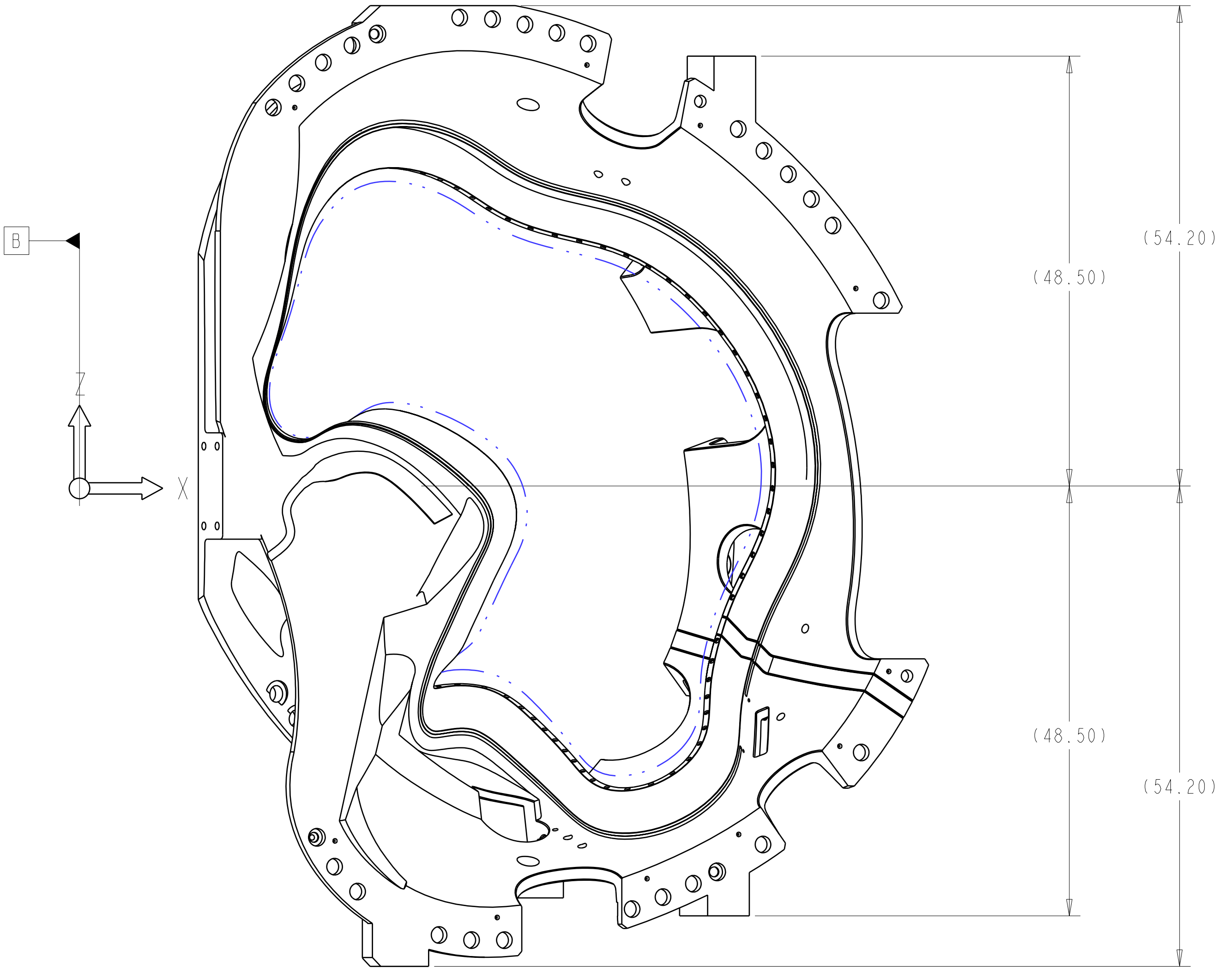


- NOTES:
1. DRAWING PREPARED IN ACCORDANCE WITH ASME Y14.8M-1996
 2. INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M-1994
 3. DIMENSIONS ARE IN INCHES
 4. DRAWING DEPICTS FINAL MACHINED STATE OF PART DEFINED BY PRO/ENGINEER FILE SE141-102.ASM
 5. UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE RELATED TO DATUM A- (PRIMARY X-Y PLANE, TOP) DATUM B- (SECONDARY Y-Z PLANE, SIDE) DATUM C- (TERTIARY X-Z PLANE, FRONT)
 6. DIMENSIONS APPLY AT TEMPERATURE OF 20-30°C (68-86°F)
 7. DIMENSIONS AND TOLERANCES EXCLUDE PROCESS MATERIAL ALLOWANCES WHICH MAY ADD MASS
 8. APPROXIMATE WEIGHT = 4950-LBS
 9. MATCH DRILL OR REAM AS REQUIRED TO ACHIEVE RUNNING FIT BETWEEN PARTS AT ASSEMBLY
 10. LUBRICATE THREADED SURFACES WITH THRED-GARD ANTI-SEIZE COMPOUND FROM FEDERAL PROCESS CORP, CLEVELAND, OH
 11. SEE LATEST REVISION OF SPECIFICATION NCSX-CSPEC-141-03 FOR ADDITIONAL REQUIREMENTS
 12. BOND INSULATING SLEEVE (F/N 5) INTO WINDING FORM (F/N 2) USING LOCTITE 411 PER MANUFACTURER'S INSTRUCTIONS.
 13. ITEM NO. 4 HOLE DIAMETERS TO MATCH OD OF ITEM NO. 6 PLUS .001 TO .002 FOR CLEARANCE FIT.
 14. ITEM NO. 7 MAY BE DIVIDED INTO TWO PARTS IF NECESSARY. HOLE DIAMETERS TO MATCH OUTER DIA OF ITEM NO. 5 PLUS .001 TO .002 CLEARANCE FIT.
 15. TORQUE ITEM NO.8 TO 1500 +/- 30 FT-LBS.



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PPPL Drafting:

3	2	SE141-140	BEARING PLATE, TYPE "B" LONG	10
	4	DS141-139	BEARING PLATE, TYPE "B" SHORT	9
2	14	DS141-060	NUT, 12PT HEX 1.375-6UNC-2B	8
	2	-7	INS SHEET, 26 X 3 X .063 THK NEMA GRADE G-11CR	7
3	7	DS141-036	STUD, 1.375-6UNC-2A X 9.5 LG	6
	14	-5	INS BUSHING, 1.630D X 1.381D X 1.7 LG NEMA GRADE G-11CR	5
2	2	-4	INS SHEET, 15 X 32 X .063 THK NEMA GRADE G-11CR	4
	1	SE141-058	POL BREAK SHIM ASSEMBLY TYPE-B	3
1	1	SE141-115	PRODUCTION WINDING FORM TYPE-B	2
	AR	X	-1	MOD COIL WINDING FORM ASSEMBLY TYPE-B

REV	DESCRIPTION	BY	DATE	CHK	DEPT	DATE	PE	REG	DATE	ORNL	DOE	DATE
3	REVISED ASM AND DRAWING PER ECN 5059	GLL	12/08	MJC			DEW					
2	REVISED ASSEMBLY AND DRAWING PER ECN 5009	GLL	7/08	MJC			DEW					
1	REVISED F/N 2 PER ECN-4903	DW	9/04	MJC			DEW					

CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPECIFICATION	FIND NO
SE141-102	-	MOD COIL WINDING FORM ASSEMBLY TYPE-B		1

SCALE 0.10

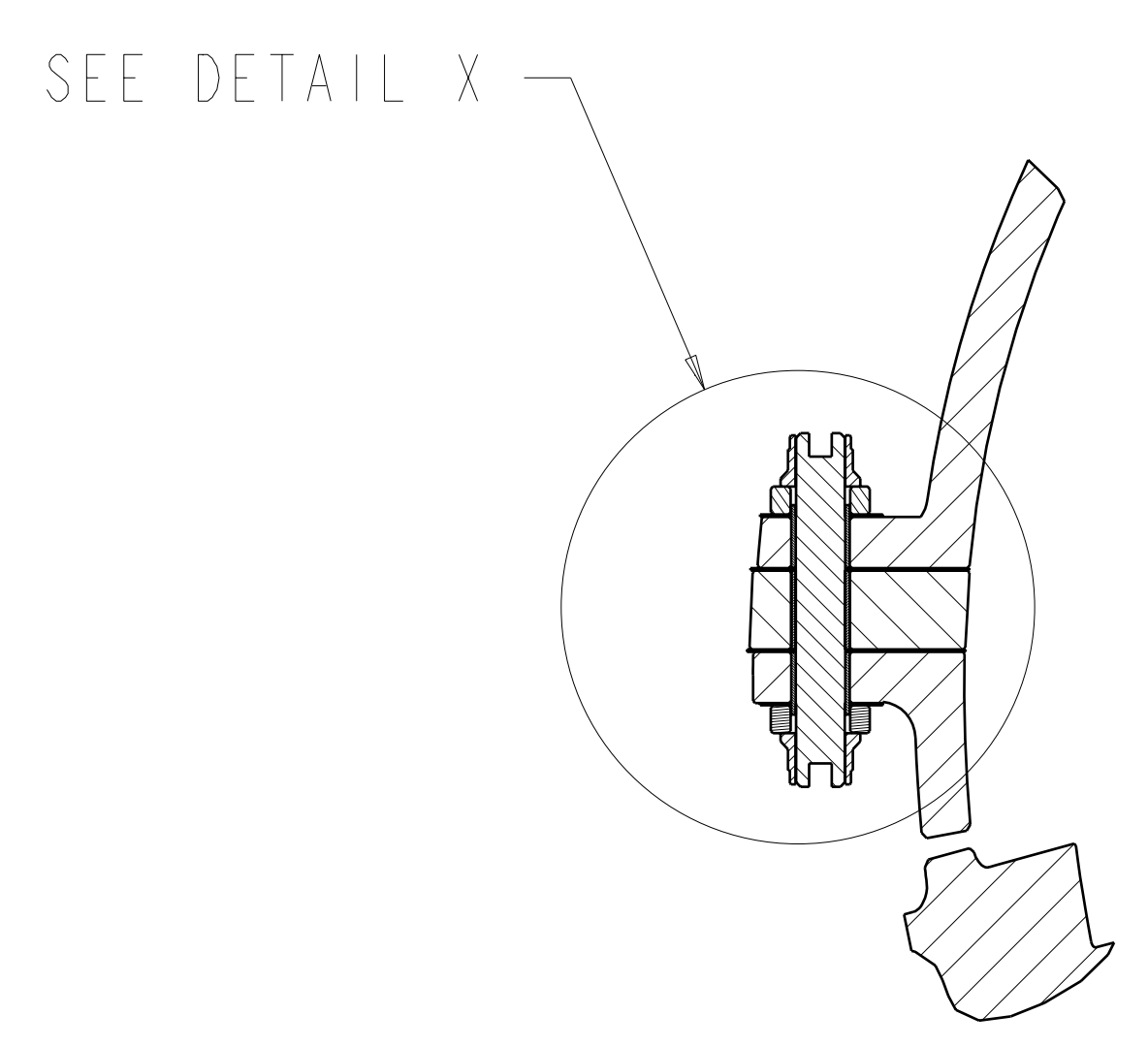
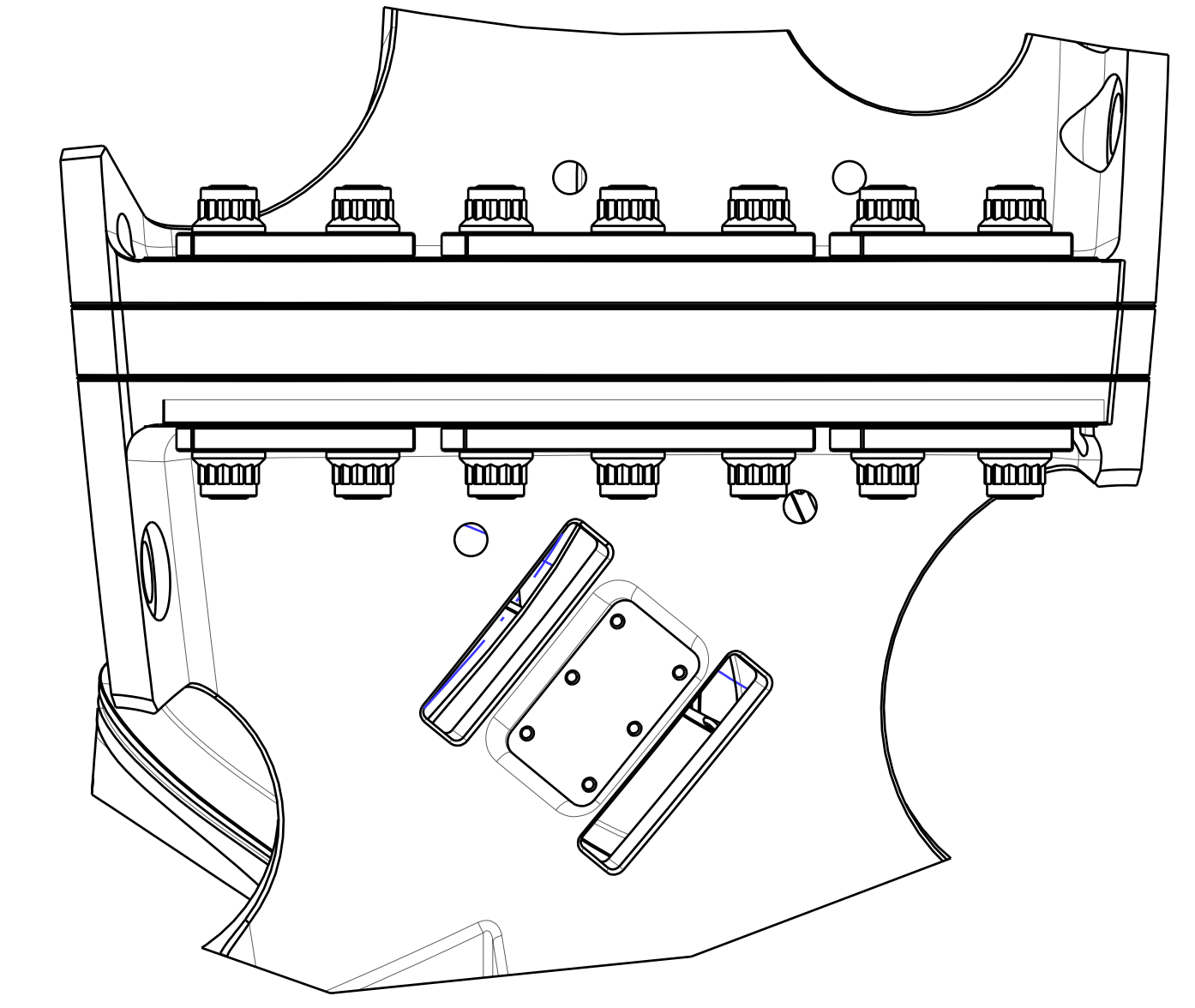
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P THIS DRAWING PRODUCED ON PRO-ENGINEER

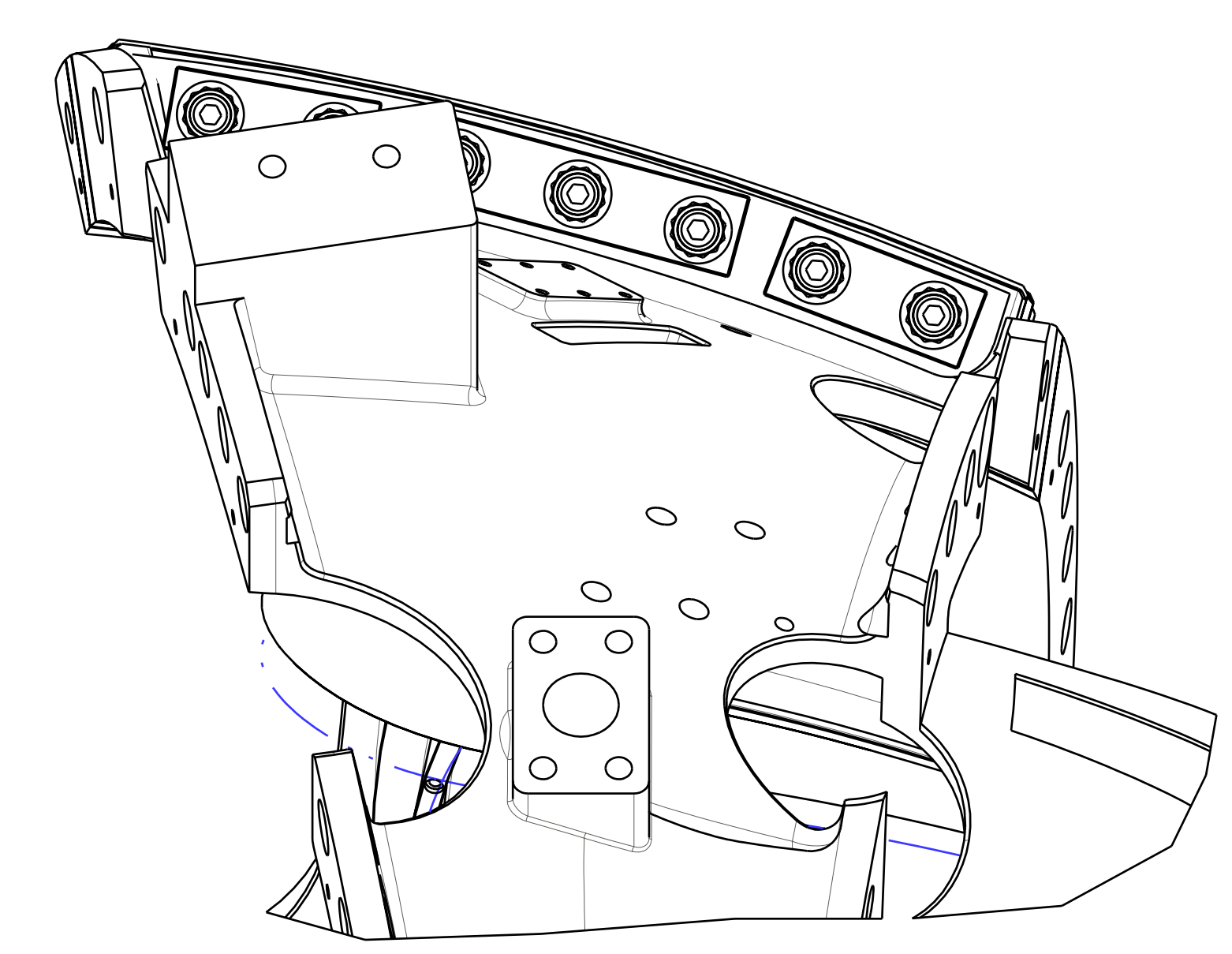
<p>SCALE NOTED</p> <p>TOLERANCES UNLESS OTHERWISE SPECIFIED</p> <p>FRACTIONS : XX DECIMALS ± .01 XXX DECIMALS ± .005 ANGLES ±0°15' BREAK SHARP EDGES .06 MAX FINISH .125 UNLESS OTHERWISE SPECIFIED</p>	<p>DES T. BROWN 6-30-04</p> <p>DRW PAUL MILLER 6-30-04</p> <p>CHK M. COLE 6-30-04</p> <p>SECT : DEPT : PE D. WILLIAMSON 6-30-04</p> <p>CR : PJ : RD : PPPL DRFT J. STEGEL 6-30-04</p>	<p>Oak Ridge National Laboratory managed for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT contract DE-AC05-00OR22725 UT-BATTELLE, LLC. Oak Ridge, Tennessee</p> <p>UT-BATTELLE</p> <p>NATIONAL COMPACT STELLARATOR EXPERIMENT</p> <p>MOD COIL WINDING FORM ASSEMBLY TYPE-B</p>	<p>VERSION NO. 4</p> <p>PLANT X-10</p> <p>BLDG 5700</p> <p>FL 3</p> <p>SHT OF 1</p> <p>TYPE S</p> <p>CLASS U</p> <p>REV 3</p>
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H
G
F
E
D
C
B
A

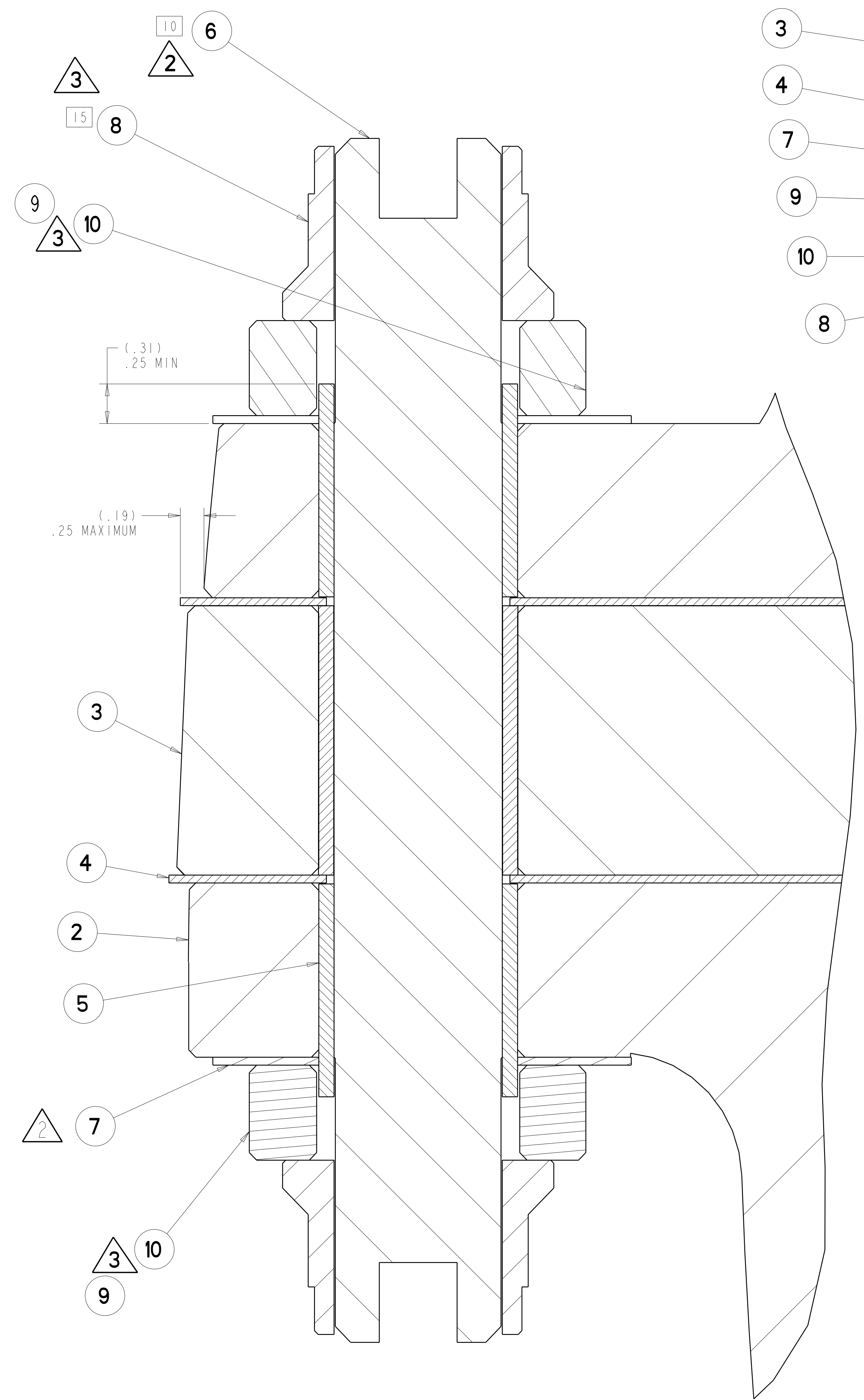
FOR NOTES AND PARTS LIST SEE SHEET 1



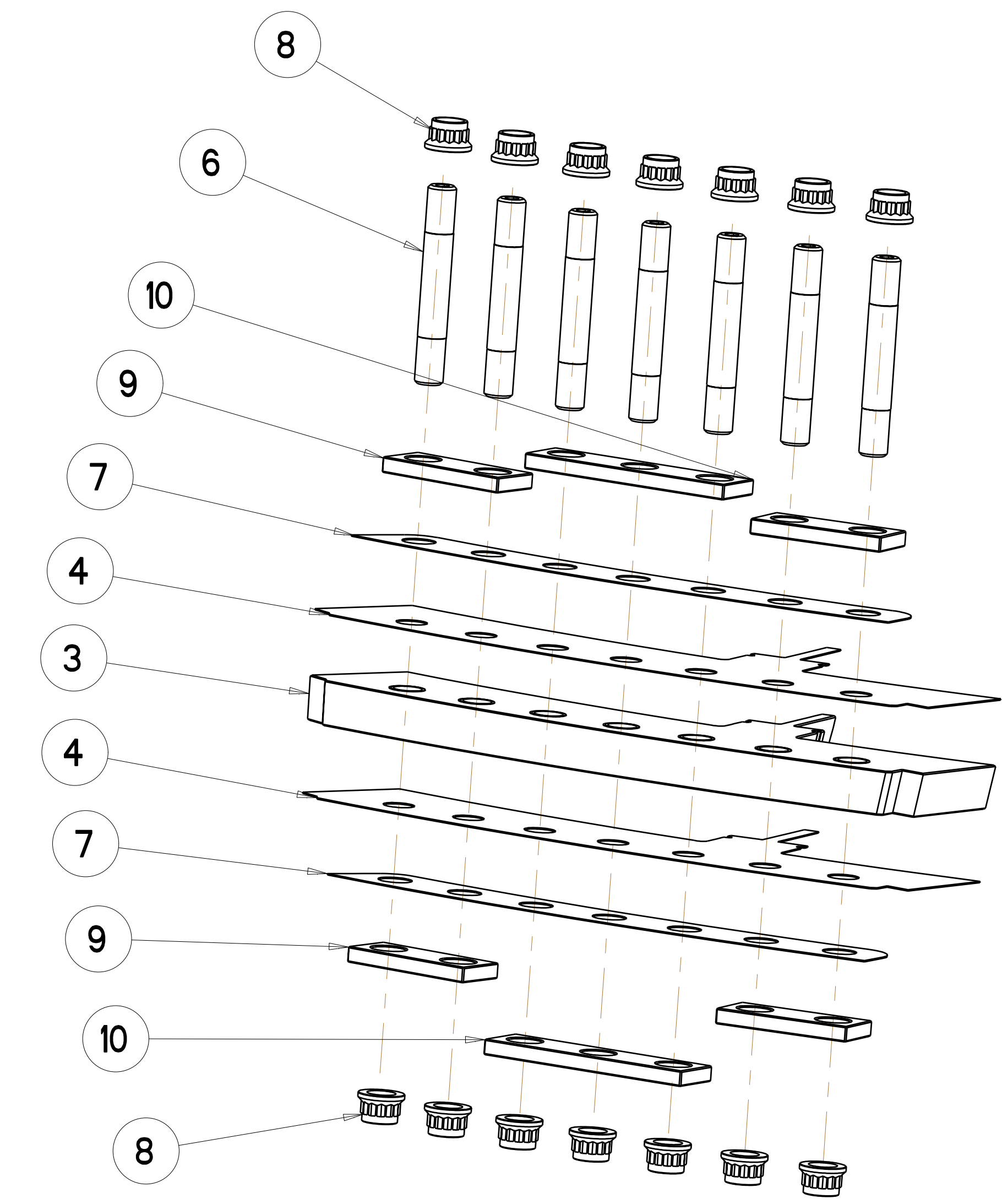
SECTION A-A
SCALE 0.20



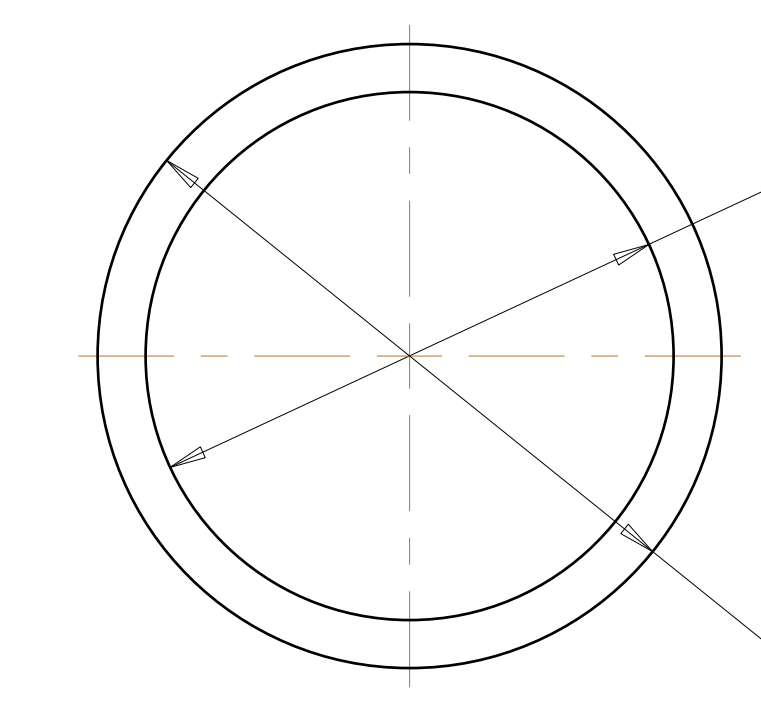
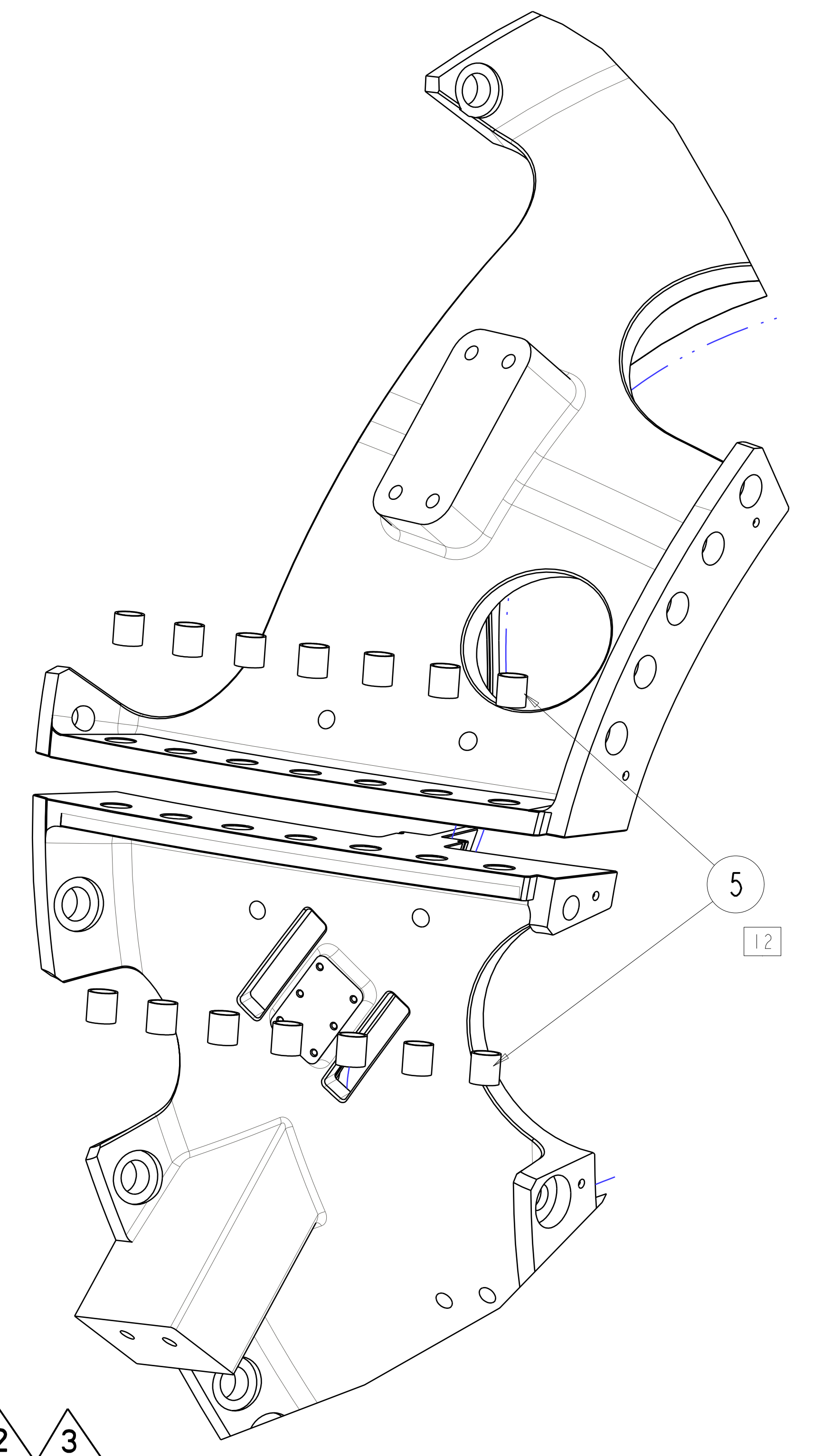
POLOIDAL BREAK DETAIL



DETAIL X
SCALE 2.00

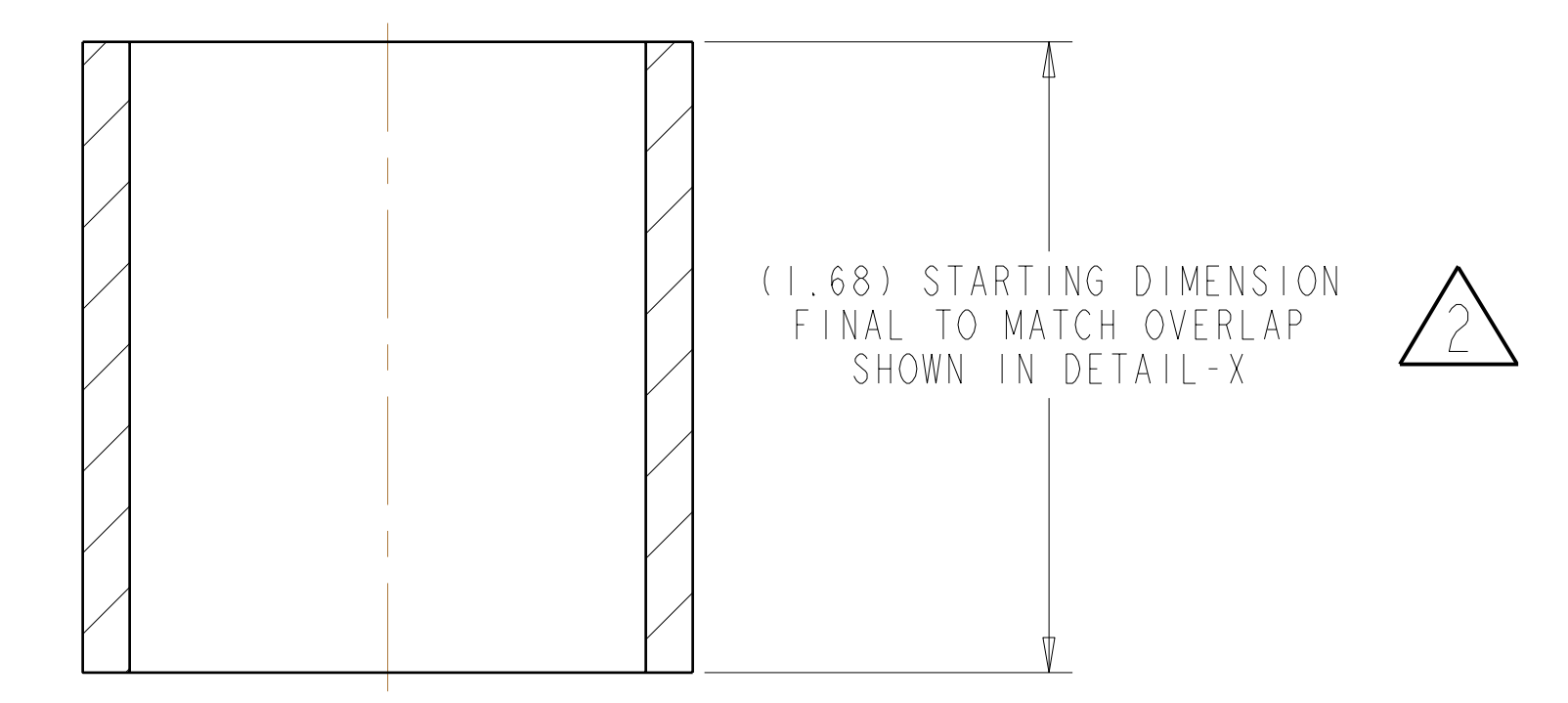
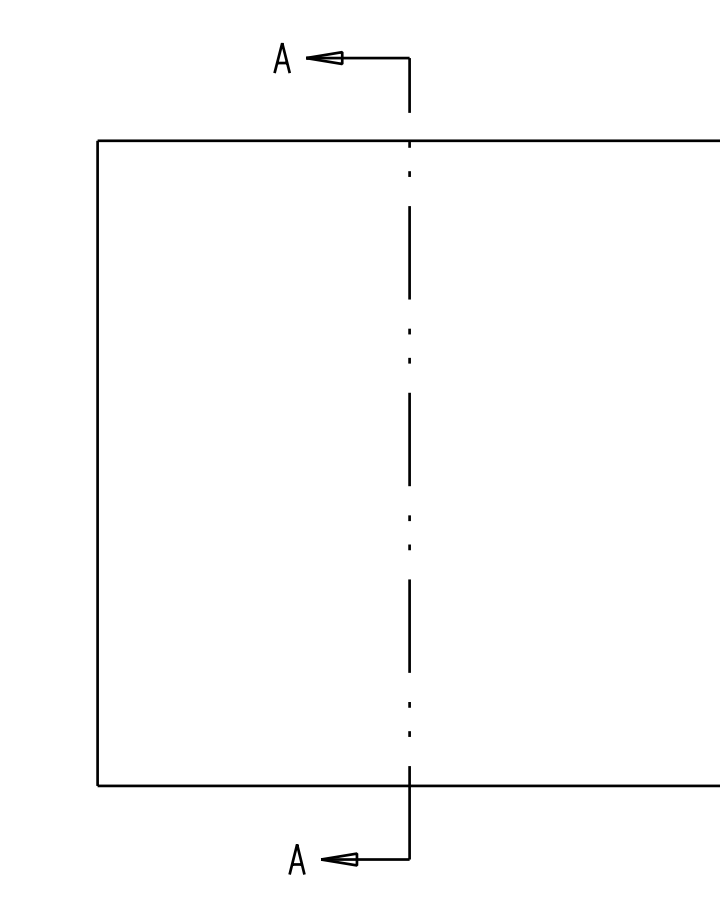


EXPLODED VIEW 2 3
SCALE 0.200



$\varnothing 1.38$ REAM AT ASSEMBLY FOR
.001 TO .002 DIA CLEARANCE
WITH ITEM 6

$\varnothing 1.63$ OD TO MATCH HOLE
DIA MINUS .001 TO .002 FOR
CLEARANCE FIT



SECTION A-A
SCALE 200

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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:							
UT-BATTELLE NATIONAL COMPACT STELLARATOR EXPERIMENT							
MOD COIL WINDING FORM ASSEMBLY TYPE-B							
VERSION NO.	PLANT	BLDG	FL	SHT OF	TYPE	CLASS	
4	X-10	5700	3	2	2	S	U
RELEASE LEVEL	SEI41-102						REV
Fabrication							3

SEI41-102