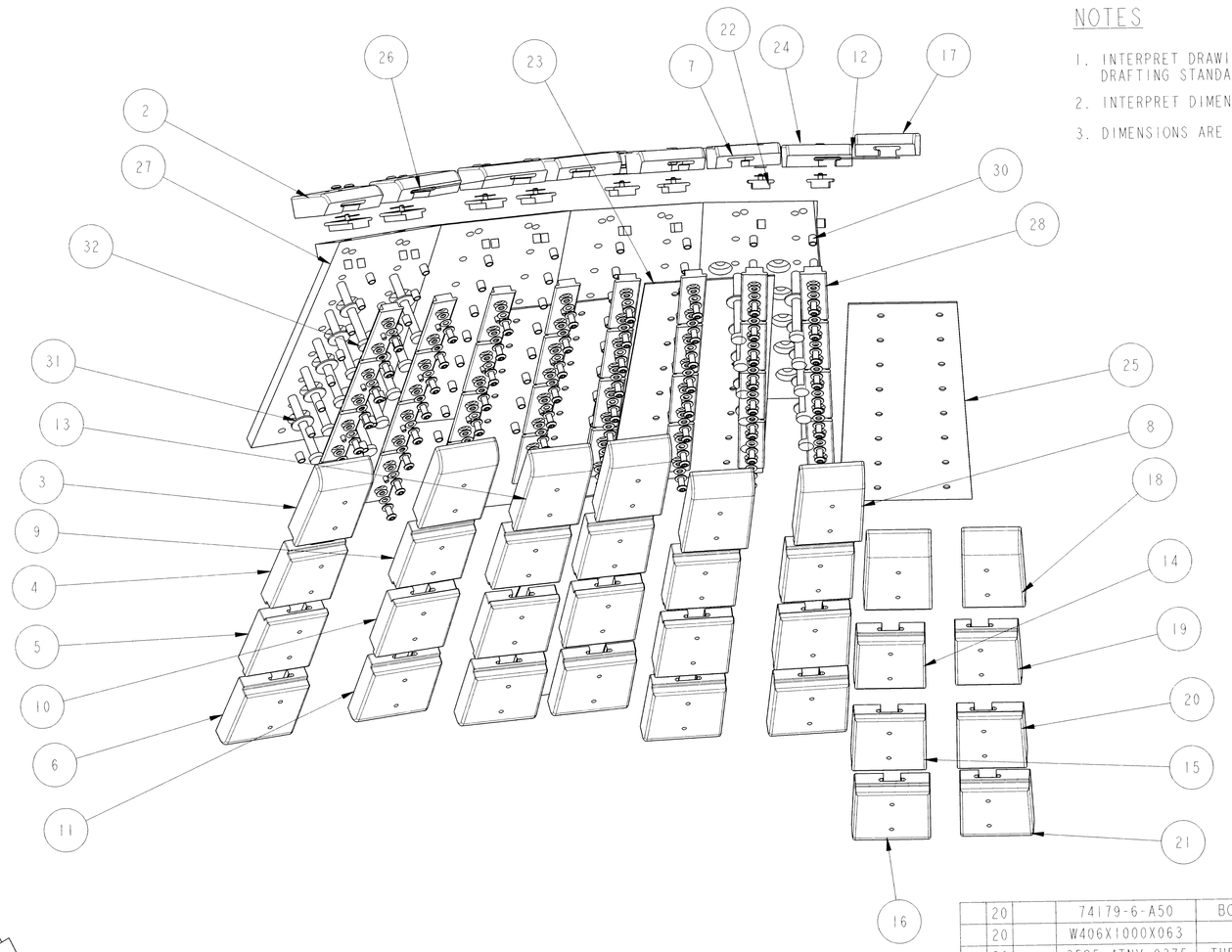
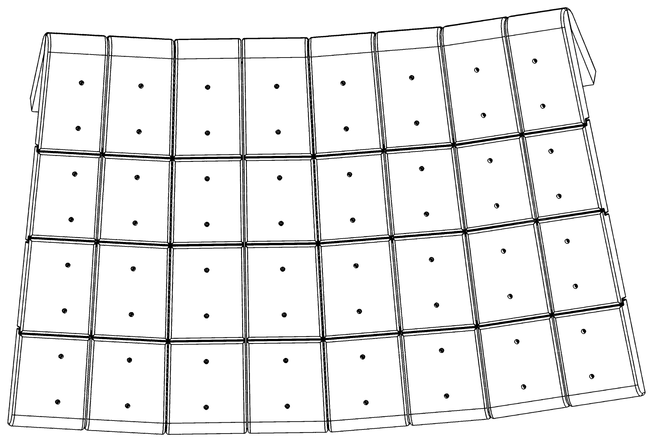
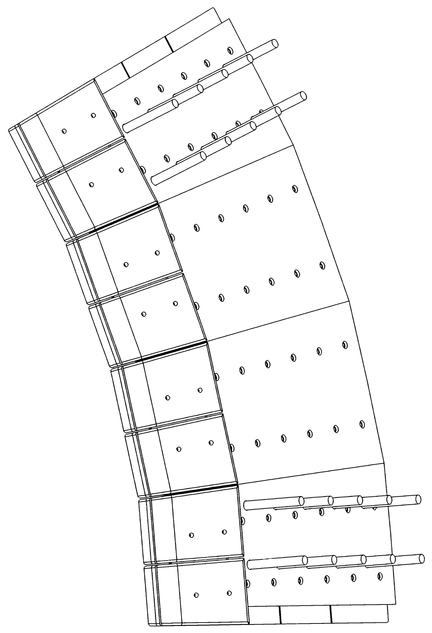
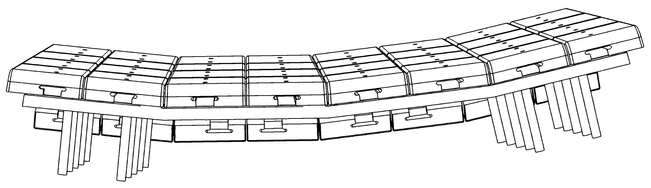


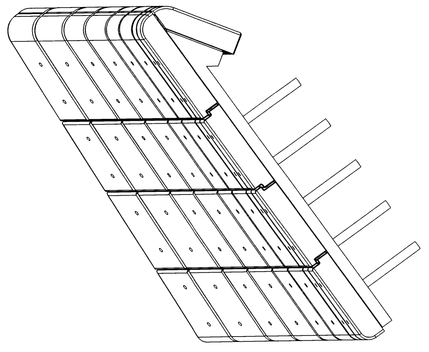
NOTES

1. INTERPRET DRAWING PER MECHANICAL ENGINEERING DRAFTING STANDARD ES-3.1-2.
2. INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M.
3. DIMENSIONS ARE IN INCHES.









ITEM	CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
NEXT ASSY						
20		74179-6-A50	BOLT 12 POINT LOW PRIFILE HD	INCO 718	--	32
20		W406X1000X063	WASHER PLAN FLAT 3/8 DIA	INCONEL		31
80		3585-4TNV-0375	THREAD INSERT 1/4-20 HELI-COIL	ST STL	--	30
32		X3E017104A290	RAIL HARDWARE ASSY			28
1		X3E017104A289	CDA 18150 COPPER	--	--	27
2		X3E017104A249	SEC PASS PLT TOP FACE GASKET	GRAFOIL	--	26
2		X3E017104A248	SEC PASS PLT - FACE GASKET	GRAFOIL	--	25
2		X3E017104A247	SEC PASS PLT TOP FACE GASKET	GRAFOIL	--	24
2		X3E017104A246	SEC PASS PLT - FACE GASKET	GRAFOIL	--	23
8		X3E017104A241	SEC PASS PLT TOP RAIL T-BAR ASSY			22
1		X3E017104A238	SEC. PASS PLT TILE	ATJ GRAPHITE	--	21
1		X3E017104A237	SEC. PASS PLT TILE	ATJ GRAPHITE	--	20
1		X3E017104A236	SEC. PASS PLT TILE	ATJ GRAPHITE	--	19
1		X3E017104A235	SEC. PASS PLT TILE	ATJ GRAPHITE	--	18
1		X3E017104A234	SEC. PASS PLT TILE	ATJ GRAPHITE	--	17
3		X3E017104A228	SEC. PASS PLT TILE	ATJ GRAPHITE	--	16
3		X3E017104A227	SEC. PASS PLT TILE	ATJ GRAPHITE	--	15
3		X3E017104A226	SEC. PASS PLT TILE	ATJ GRAPHITE	--	14
3		X3E017104A225	SEC. PASS PLT TILE	ATJ GRAPHITE	--	13
3		X3E017104A224	SEC. PASS PLT TILE	ATJ GRAPHITE	--	12
3		X3E017104A218	SEC. PASS PLT TILE	ATJ GRAPHITE	--	11
3		X3E017104A217	SEC. PASS PLT TILE	ATJ GRAPHITE	--	10
3		X3E017104A216	SEC. PASS PLT TILE	ATJ GRAPHITE	--	9
3		X3E017104A215	SEC. PASS PLT TILE	ATJ GRAPHITE	--	8
3		X3E017104A214	SEC. PASS PLT TILE	ATJ GRAPHITE	--	7
1		X3E017104A208	SEC. PASS PLT TILE	ATJ GRAPHITE	--	6
1		X3E017104A207	SEC. PASS PLT TILE	ATJ GRAPHITE	--	5
1		X3E017104A206	SEC. PASS PLT TILE	ATJ GRAPHITE	--	4
1		X3E017104A205	SEC. PASS PLT TILE	ATJ GRAPHITE	--	3
1		X3E017104A204	SEC. PASS PLT TILE	ATJ GRAPHITE	--	2
1		X3E017104A276				1

PARTS LIST

QUALITY VERIFICATION

MECHANICAL AND STRUCTURAL
REFERENCE ORNL QV-001

QV CLAUSE	DOCUMENTS REQUIRED	APPLICABLE TO PART NO *
303	MATERIAL MILL TEST REPORT	
325	MATERIAL SELLER CERT	
326	SPECIAL MATERIAL INSPECTION REPORT	
205	MANUFACTURING, INSPECTION, AND TEST PLAN	
312	FIELD INSPECTION AND TEST PLAN	
321	WELD AND BRAZE INSPECTION REPORT	
322	HEAT TREAT REPORT (VACUARC)	
310	LEAK TEST REPORT	
315	CLEANING CERT	
318	DEVIATION REQUEST	X
319	NONCONFORMANCE REPORT	X
323	DIMENSIONAL REPORT	
330	FUNCTIONAL TEST REPORT	
100	DOCUMENTION	X

* SYMBOL X INDICATES APPLICABLE TO ALL PARTS OR ITEMS

QA COORDINATOR W.A. Brumbaugh DATE 6-3-98

CFS N-NSTX-222 R0 DATE REC 6/4/98
PRINCETON UNIVERSITY
PLASMA PHYSICS LABORATORY
TOKAMAK FUSION TEST REACTOR
PO ITEM

DRAWING REVIEW A	NO COMMENTS, PRINT TO VENDOR	1
	COMMENTS AS NOTED, PRINT TO VENDOR	2
	DRAWING NOT APPLICABLE, PRINT TO VENDOR	3
	NO COMMENTS, NO PRINT TO VENDOR	4
	FOR INFORMATION ONLY	5
DRAWING REVIEW B	NO FURTHER REPRODUCIBLE REQUIRED	1
	SUBMIT REVISED REPRODUCIBLE	2
VENDOR DRAWING APPROVAL	NO FURTHER REPRODUCIBLE REQUIRED	3
	SUBMIT REVISED REPRODUCIBLE	4

X3E017104A276

REV	CHANGE TYPE	CHANGE CONTROL SYSTEM	CHANGE NOTICE NUMBER	DESCRIPTION	A-E	BY	CHK	SECT	DEPT	DATE	PE	REQ	DATE	LM-ES	DATE	DOE	DATE	OA	CV	EC	EE	EM	IE	M	PD	SE	ST	XAD	PES
0	-	3	-	ORIGINAL ISSUE		MTB			3/98																				

REVISION OR ISSUE PURPOSE — REVISION APPROVALS — SQUAD CHECK

SCALE

TOLERANCES UNLESS OTHERWISE SPECIFIED

FRACTIONS
XX DECIMALS ±.01
XXX DECIMALS ±.005
ANGLES ±0°15'
BREAK SHARP EDGES .06 MAX
FINISH .125 UNLESS OTHERWISE SPECIFIED

DRAWING APPROVALS		DATE
DES	P GORANSON	02/98
DRW	MT BROWN	03/98
CHK		
SECT		
DEPT	PS Gettelfinger	8/3/98
PE		
CR		
PJ	R.D. Bourn	8/6/98
REQ	D.W. Darro	7/20/98

LOCKHEED MARTIN LOCKHEED MARTIN ENERGY SYSTEMS, INC.
operated for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT contract DE-AC-05-840R21400
Oak Ridge, Tennessee - Paducah, Kentucky

PROJECT NAME: NSTX

SECONDARY PASSIVE PLATE ASSEMBLY

1	48	49	50	PLANT	BLDG	FL	SHT	OF	TYPE	CLASS
3	M	E	U	Y-12	FEDC	1	1	1	A	U
51		52		53	X3E017104A276					REV 0

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P THIS DRAWING PRODUCED ON PRO-ENGINEER

THIS DOCUMENT CONTROLLED BY
CHANGE CONTROL SYSTEM 3
ENGINEERING PROCEDURE EP-C-18