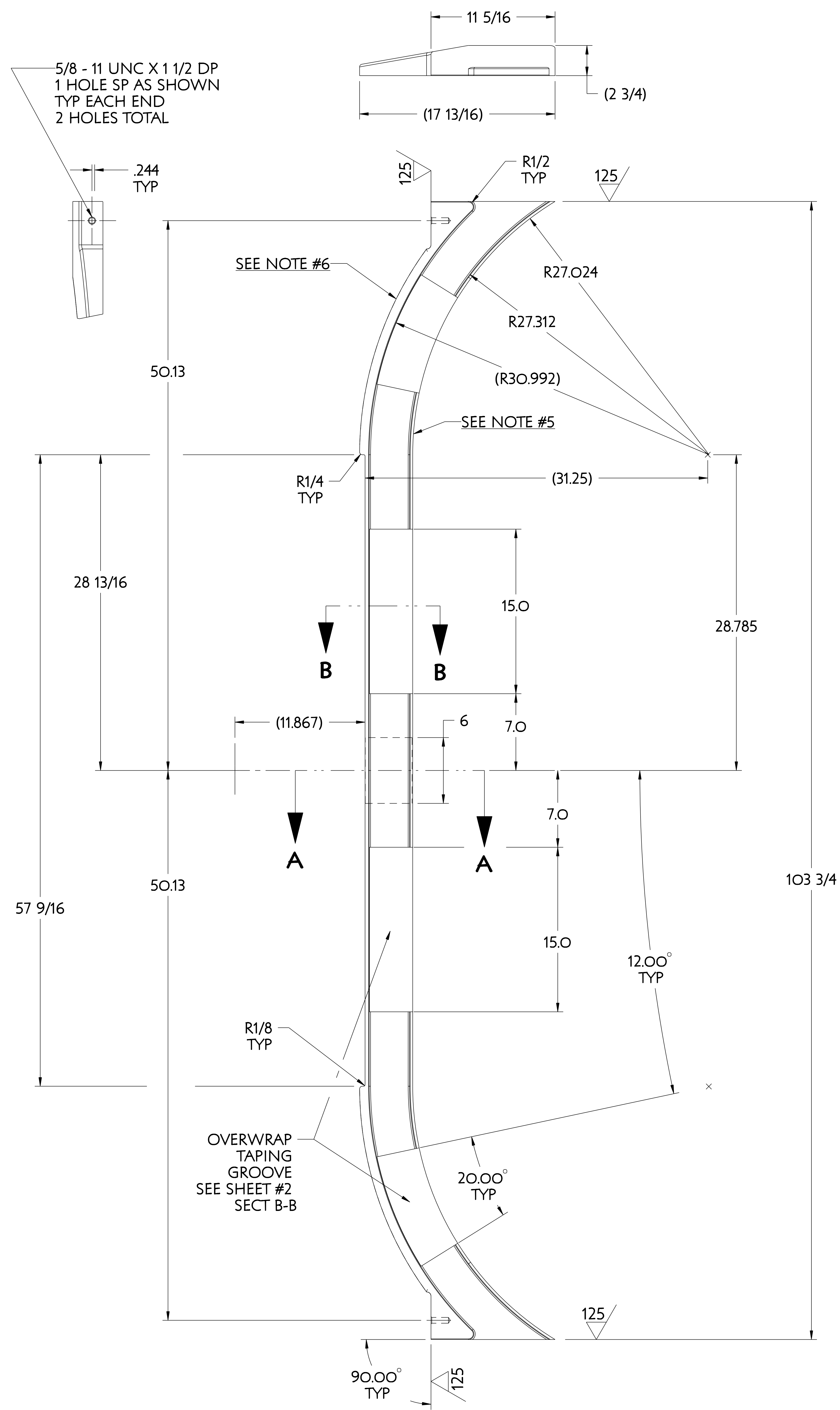


NO.	REVISION	BY	CH	SUP	APPROVED	DATE



5/8 - 11 UNC X 1 1/2 DP
1 HOLE SP AS SHOWN
TYP EACH END
2 HOLES TOTAL

244
TYP

SEE NOTE #6

R1/4
TYP

A

OVERWRAP
TAPING
GROOVE
SEE SHEET #2
SECT B-B

B

20.00°
TYP

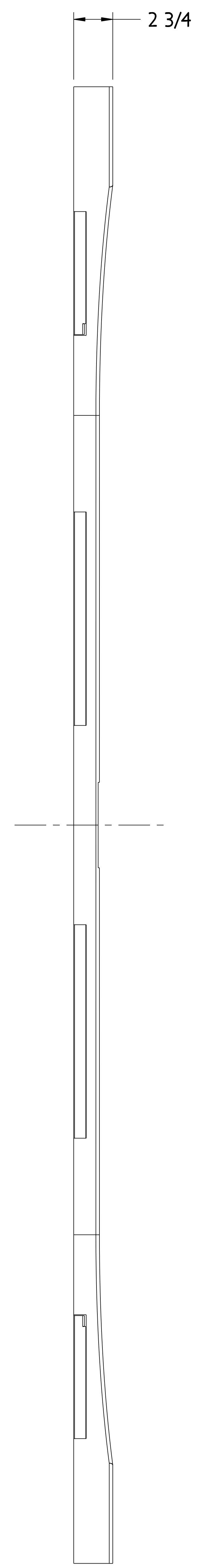
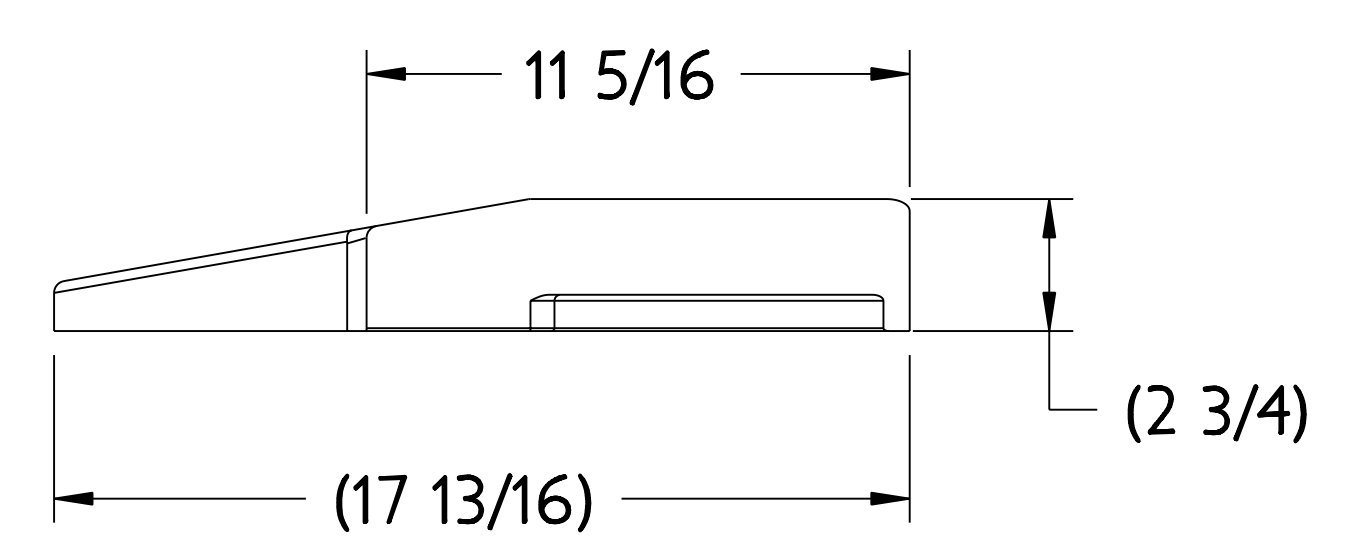
90.00°
TYP

SEE NOTE #5

6

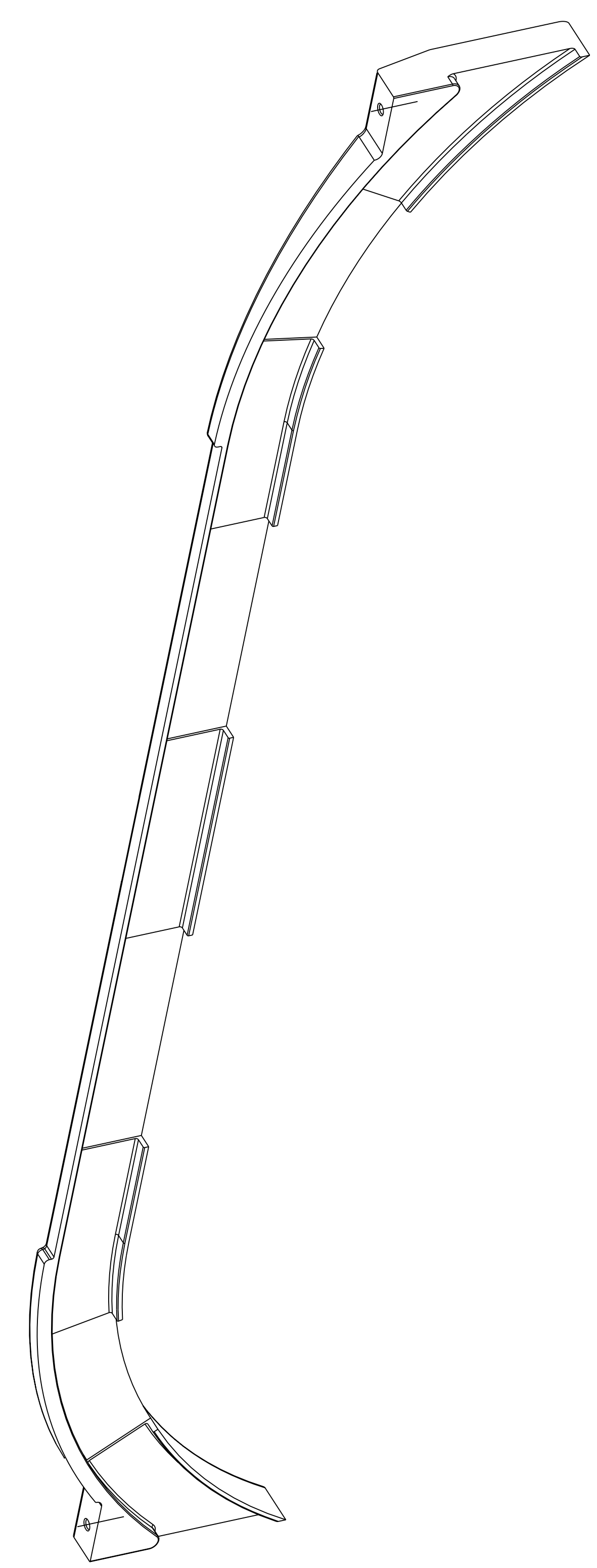
12.00°
TYP

125



NOTES:

1. DIMENSIONS ARE IN INCHES
2. SEE SPECIFICATION, NCSX-CSPEC-131-03 FOR ADDITIONAL REQUIREMENTS.
3. GEOMETRY IS DEFINED IN PRO ENGINEER CAD MODELS/FILES SE131-007.PRT.
4. DRAWING AND CAD MODELS COMBINED DEFINE FINISHED MACHINED PART.
5. MACHINED FINISHED SURFACES TO CAD DATA PROFILE TO BE WITHIN 0.020" UNLESS OTHERWISE SPECIFIED. PROFILE TOLERANCE IS BILATERAL, ie. 0.005" EITHER SIDE OF THE REFERENCE SURFACE.
6. AS-CAST SURFACES SHOWN IN NOMINAL MATERIAL CONDITION, THICKNESS TOLERANCE +/- 0.13. SURFACE PROFILE MUST BE WITHIN 0.13 INCHES OF CAD DATA.
7. DIMENSIONS APPLY AT ROOM TEMPERATURE. OPERATING TEMP 80 K.



RELEASE LEVEL:
DWG VERSION NO:

WEIGHT
165.2 lbs

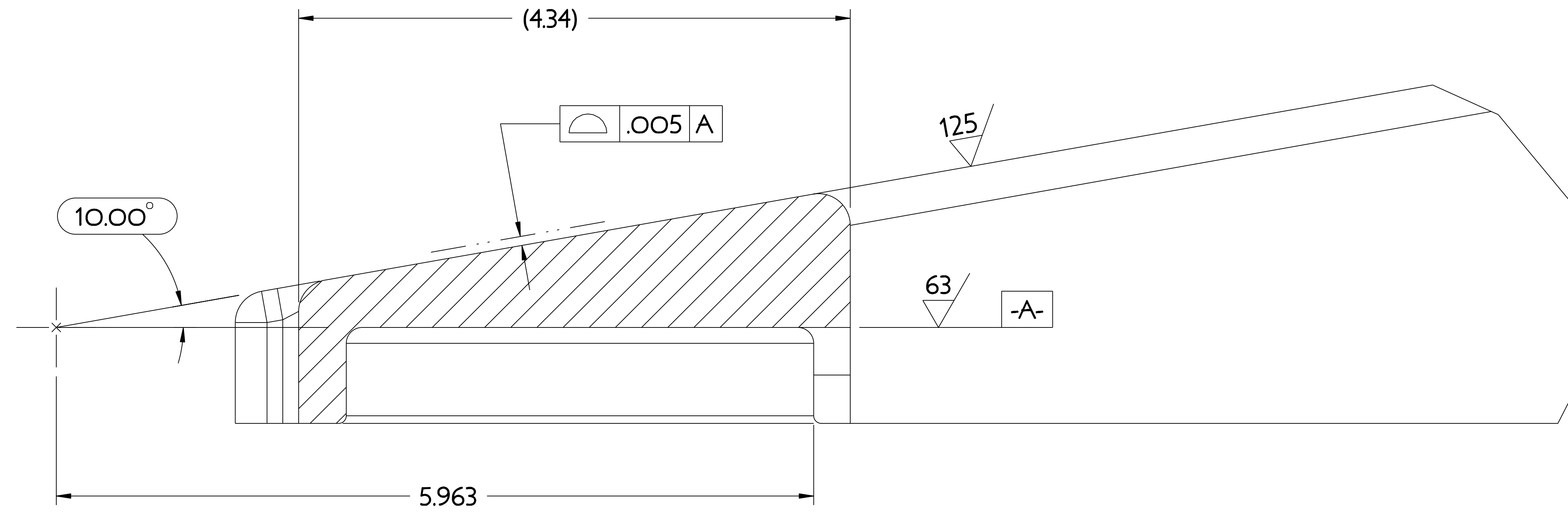
MODEL NAME
SE131-007

WELDING
ENGINEER

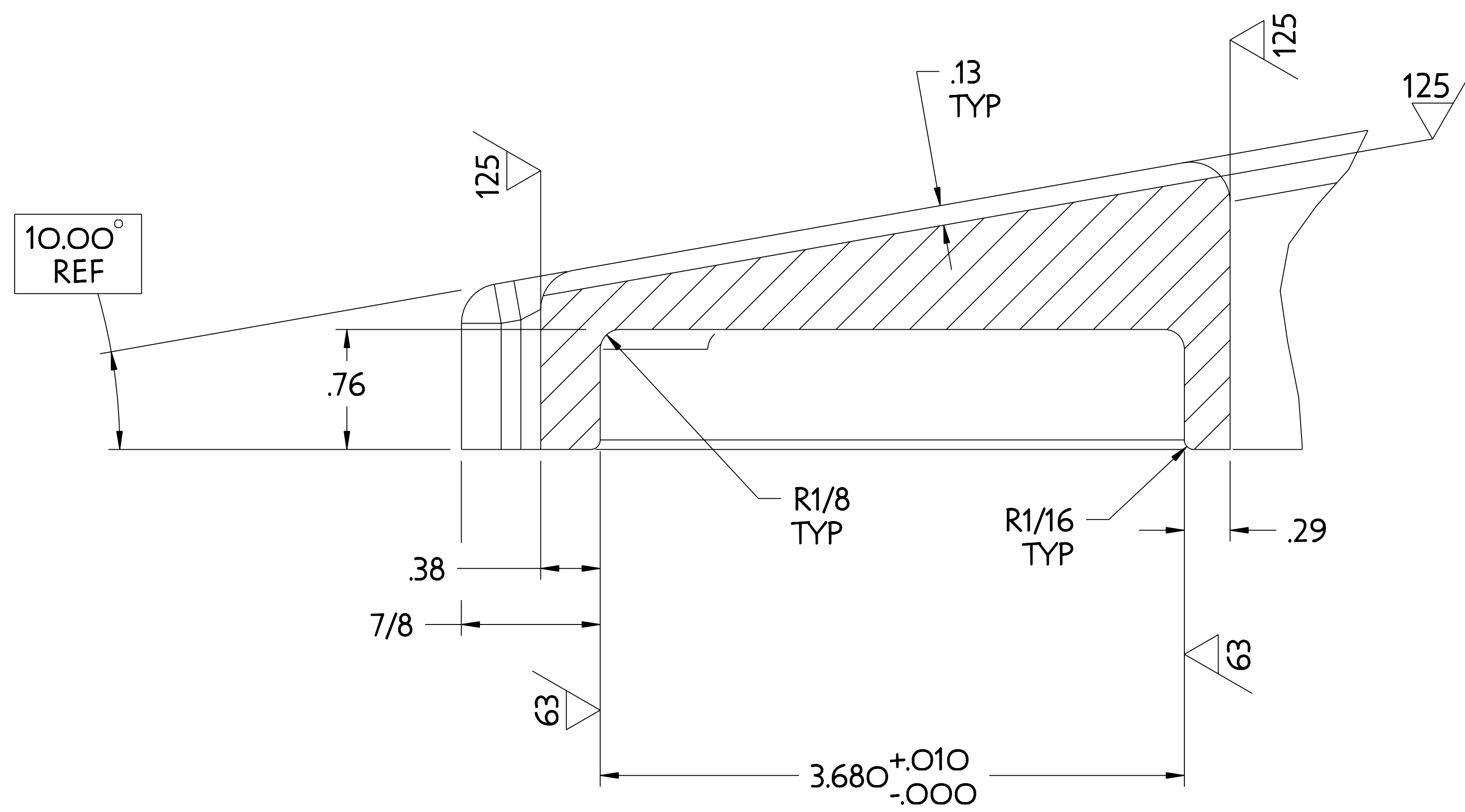
1	SE131-007	TF COIL NOSE WEDGE CASTING	STN STL	36
PART NO.	DRAWING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY REQD
PARTS LIST				
COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED		CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY NATIONAL COMPACT STELLARATOR EXPERIMENT	
DO NOT VERIFY INFORMATION BY SCALING DRAWING		Pro E	STELLARATOR CORE CONVENTIONAL COILS TF COIL NOSE CASTING MACHINING DETAIL	
SCALE 0.250		TOLERANCES NON-CUMULATIVE	DSN: J RUSHINSKI	DRAWING NO:
NEXT ASSEMBLY		DECIMAL - INCH FRACTIONS	CHK:	SE131-007
		.XX +/- .000 0°-120° +/- .010	ENGR: M KALISH	SHEET 1 OF 2
		.XXX +/- .005 120°-120° +/- .010	SUP:	REV
		ANGULAR +/- 0°-15° OVER 120° +/- .010		

NCSX-SE131-007

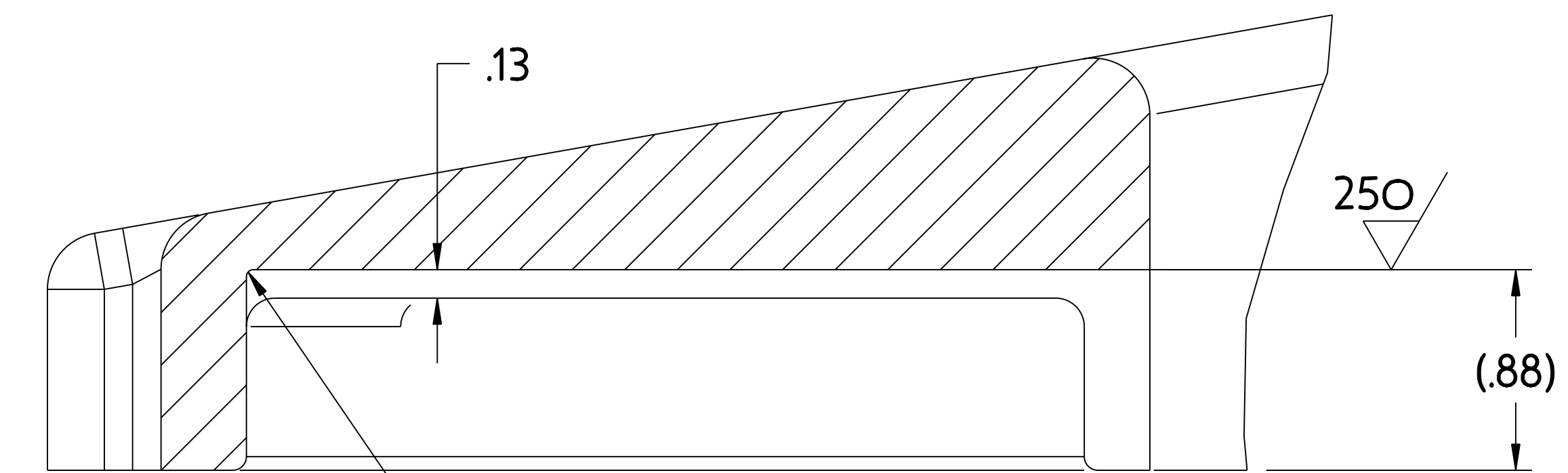
NO.	REVISION	BY	CH	SUP	APPROVED	DATE



SECTION A-A
PRIOR TO MACHINING OF MIDPLANE TAPING GROOVE
SCALE 1.750



SECTION A-A
SHOWING MACHINING OF COIL CAVITY
AND MIDPLANE TAPING GROOVE
SCALE 1.750



SECTION B-B
MACHINING OF COIL OVERWRAP TAPING GROOVE
TYP 4 LOCATIONS
SCALE 1.750

RELEASE LEVEL: WIP
 DWG VERSION NO: 6

WEIGHT
 165.2 lbs
 MODEL NAME
 SE131-007
 WELDING
 ENGINEER

PART NO.	DRAWING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY REQD
PARTS LIST				
COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E		CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY NATIONAL COMPACT STELLARATOR EXPERIMENT	
DO NOT VERIFY INFORMATION BY SCALING DRAWING		DIMENSIONS ARE IN INCHES MACHINE SURFACES UNLESS OTHERWISE SPECIFIED	STELLARATOR CORE CONVENTIONAL COILS TF NOSE CASTING MACHINING DETAIL	
NEXT ASSEMBLY		TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX ±.000 .XXX ±.005 ANGULAR ±.0°-15°	DSN: J RUSHINSKI CHK: ENGR: M KALISH SUP:	DRAWING NO: SE131-007
SHEET 2 OF 2				REV 0

NCSX-SE131-007