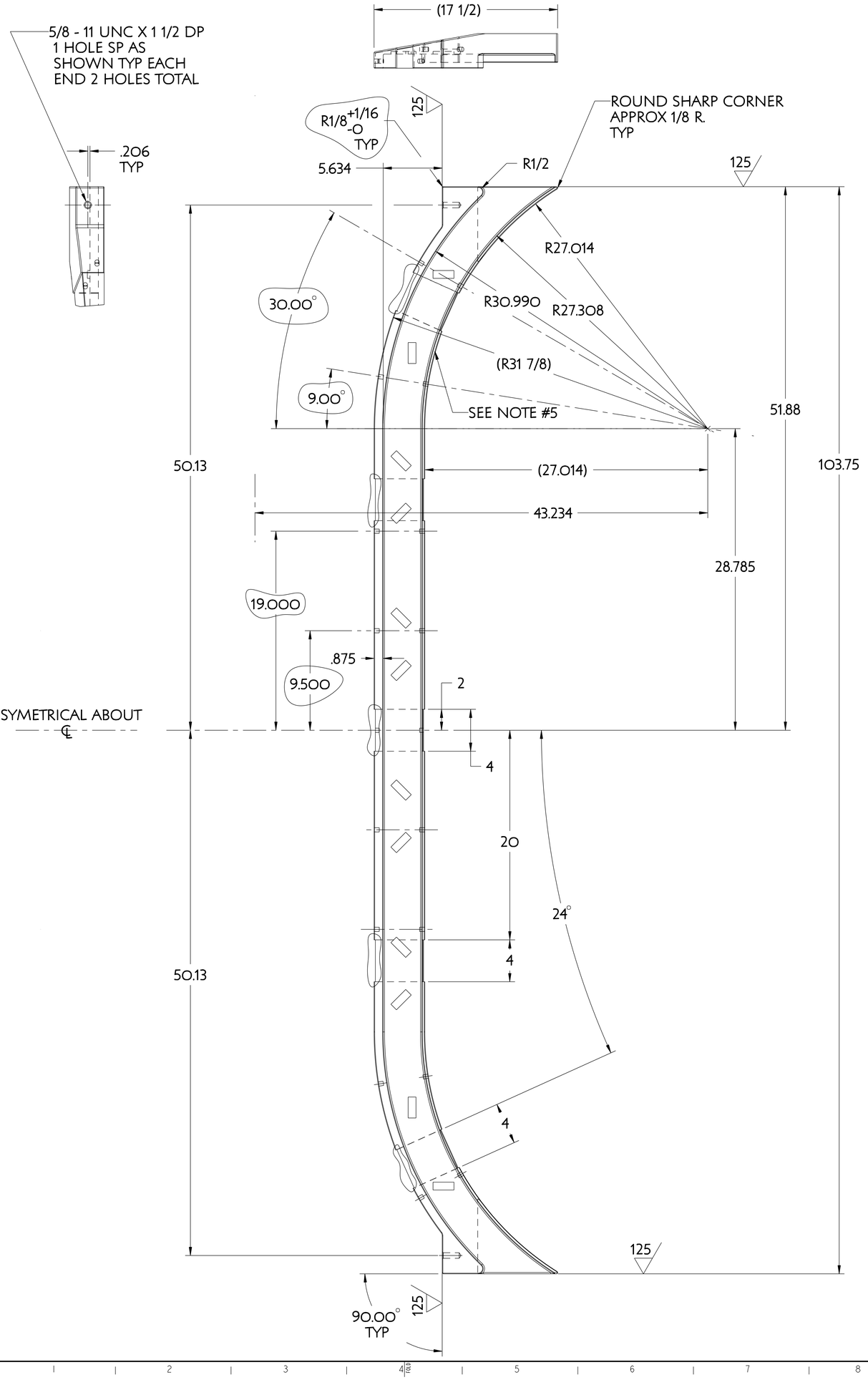
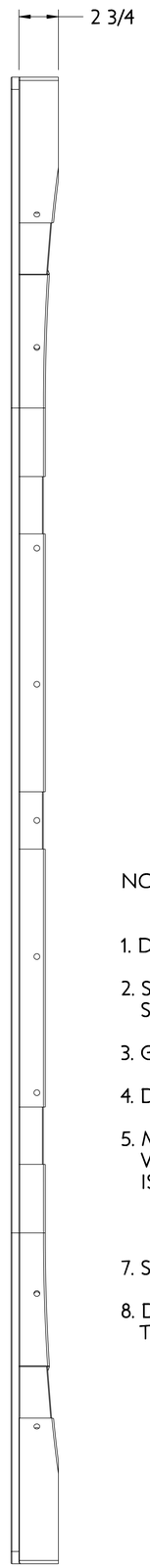
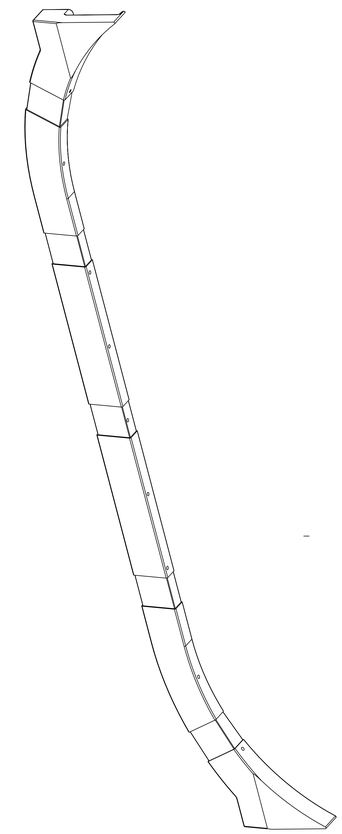
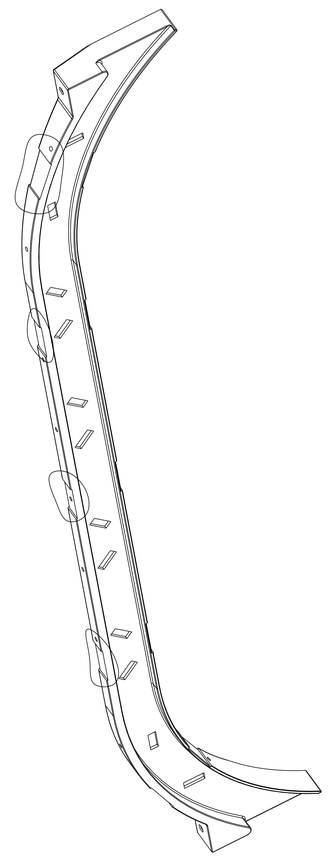
| NO. | REVISION | BY | CH | SUP | APPROVED | DATE |
|---|---|---|---|---|---|---|
| 1 | REVISED PER ECN #5073 | JDR | MK | JS | M. KALISH | 2/03/06 |
| 2 | REVISED PER ECN #5103 | JDR | MK | JS | M. KALISH | 4/07/06 |
| 3 | REVISED PER ECN # 5178 | JDR | MK | JS | M. KALISH | 10/14/06 |





NOTES:

1. DIMENSIONS ARE IN INCHES
2. SEE SPECIFICATION, NCSX-CSPEC-131-03 IF CASTING PROCESS IS USED TO MANUFACTURE. SEE SPECIFICATION NCSX-CSPEC-131-04 IF WELDMENT PROCESS IS USED TO MANUFACTURE.
3. GEOMETRY IS DEFINED IN PRO ENGINEER CAD MODELS/FILES SE131-085.PRT
4. DRAWING AND CAD MODEL COMBINED DEFINE PART.
5. MACHINED FINISHED SURFACES TO CAD DATA. PROFILE TO BE WITHIN .020 UNLESS OTHERWISE SPECIFIED. PROFILE TOLERANCE IS BILATERAL ie 0.010 EITHER SIDE OF THE REFERENCED SURFACE.
7. SPOTFACE MIN. DIA/DEPTH AS REQ'D.
8. DIMENSIONS APPLY AT ROOM TEMPERATURE. OPERATING TEMPERATURE 80° K.

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PPPL Drafting: Jerry Siegel 2006.11.16 13:26:03 -05'00'

| PART NO. | DRAWING NO | NOMENCLATURE OR DESCRIPTION | MATERIAL | QTY REQD |
|---|---|---|---|---|
| 1 | SE131-085 | TF COIL WEDGE STRUCTURE | SEE SPEC | 36 |

PARTS LIST

| | | |
|---|---|---|
| COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED | CENTRAL FILES: UNLESS OTHERWISE SPECIFIED | PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY NATIONAL COMPACT STELLARATOR EXPERIMENT |
| Pro E | DIMENSIONS ARE IN INCHES MACHINE SURFACES 125 | STELLARATOR CORE CONVENTIONAL COILS TF COIL WEDGE STRUCTURE DETAIL |
| DO NOT VERIFY INFORMATION BY SCALING DRAWING | BREAK SHARP EDGES .005/.020 | |
| SCALE 0.250 | TOLERANCES NON-CUMULATIVE | DSN: J. RUSHINSKI 8/01/05 DRAWING NO: |
| NEXT ASSEMBLY | DECIMAL-INCH FRACTIONS | CHK: M. KALISH 8/01/05 SE131-085 |
| | .X +/-.100 0°-12° +/-1/16 | |
| | .XX +/-.030 12°-72° +/-1/8 | ENGR: M. KALISH 8/01/05 |
| | .XXX +/-.005 72°-120° +/-1/4 | |
| | ANGULAR +/-0°-15' OVER 120° +/-1/2 | SUPV: J. SIEGEL 8/01/05 SHEET 1 OF 2 REV 3 |

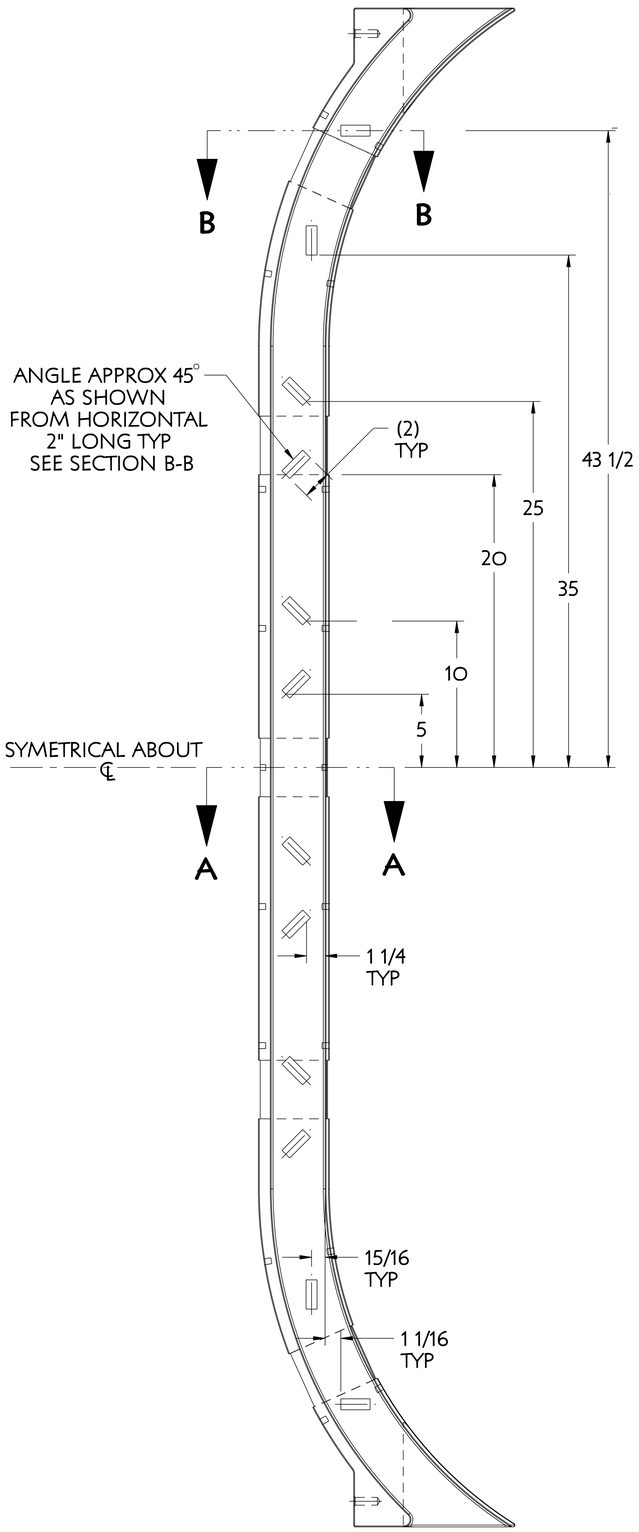
| WEIGHT | MODEL NAME | WELDING ENGINEER |
|---|---|---|
| 190.7 lbs | SE131-085 | |

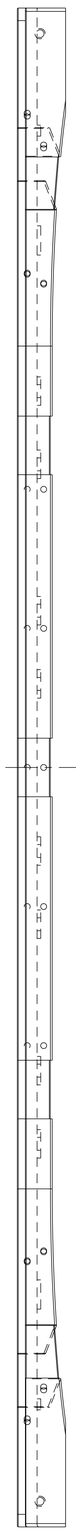
RELEASE LEVEL: Fabrication
DWG VERSION NO: 5

NCSX_PART_FORMAT_E

NCSX-SE131-085

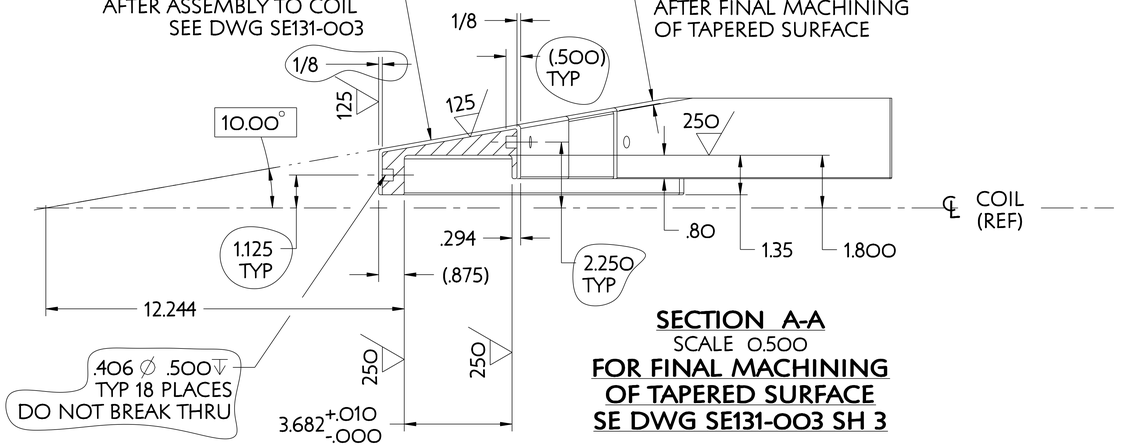
| NO. | REVISION | BY | CH | SUP | APPROVED | DATE |
|---|---|---|---|---|---|---|
| 1 | REVISED PER ECN #5073 | JDR | MK | JS | M. KALISH | 2/03/06 |
| 2 | REVISED PER ECN # 5103 | JDR | MK | JS | M. KALISH | 04/07/06 |
| 3 | REVISED PER ECN #5178 | JDR | MK | JS | M. KALISH | 10/06/06 |



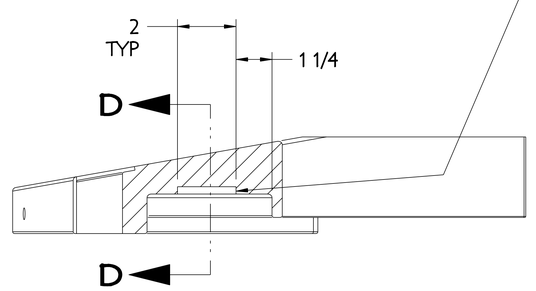
AT VENDORS DISCRETION
EXCESS MATERIAL MAYBE
ADDED ON THIS SURFACE
TO ALLOW FOR FINAL
MACHINING OF SURFACE
AFTER ASSEMBLY TO COIL
SEE DWG SE131-003

1/8 DEEP MINIMUM
AFTER FINAL MACHINING
OF TAPERED SURFACE

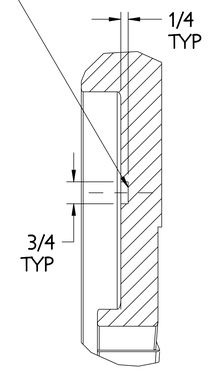



**SECTION A-A**
SCALE 0.500
**FOR FINAL MACHINING OF TAPERED SURFACE SE DWG SE131-003 SH 3**

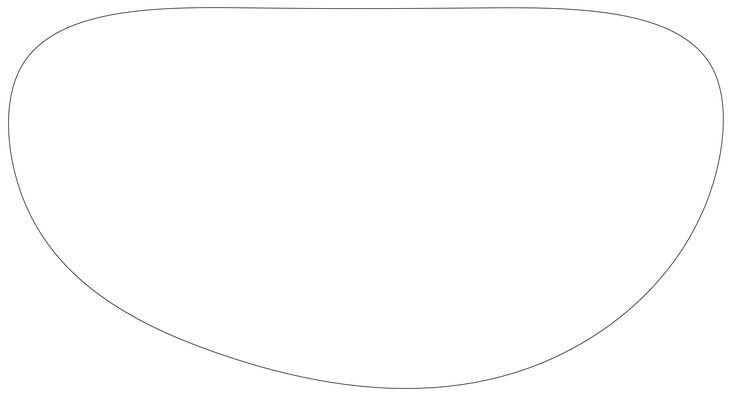
IF CASTING MANUFACTURING PROCESS IS USED
THESE ARE UNMACHINED SURFACES
IF FABRICATED FROM STRUCTURAL PLATE
MACHINED FULL RADIUSES ARE PERMITTED
IN ALL PLANES




**SECTION B-B**
SCALE 0.500




**SECTION D-D**
SCALE 0.500



**RELEASED FOR FABRICATION / INSTALLATION**
PPPL Drafting ? Jerry Siegel 2006.11.16 13:26:03 -05'00'

| 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 PRINCETON UNIVERSITY NATIONAL COMPACT STELLARATOR EXPERIMENT | | |
| Pro E | DIMENSIONS ARE IN INCHES MACHINE SURFACES | STELLARATOR CORE CONVENTIONAL COILS TF COIL WEDGE STRUCTURE DETAIL | | |
| DO NOT VERIFY INFORMATION BY SCALING DRAWING | BREAK SHARP EDGES .005/.020 | | | |
| SCALE 0.250 | TOLERANCES NON-CUMULATIVE | DSN: J. RUSHINSKI | 8/01/05 | DRAWING NO: |
| NEXT ASSEMBLY | DECIMAL-INCH: .X +/-.100, .XX +/-.030, .XXX +/-.005, ANGULAR +/-0°-15'; FRACTIONS: 0°-12° +/-1/16, 12°-72° +/-1/8, 72°-120° +/-1/4, OVER 120° +/-1/2 | CHK: M. KALISH | 8/01/05 | SE131-085 |
| | | ENGR: M. KALISH | 8/01/05 | |
| | | SUPV: J. SIEGEL | 8/01/05 | SHEET 2 OF 2 REV 3 |

| WEIGHT | MODEL NAME | WELDING ENGINEER |
|---|---|---|
| 190.7 lbs | SE131-085 | |

RELEASE LEVEL: Fabrication
DWG VERSION NO: 5

NCSX-SE131-085

NCSX_PART_FORMAT_E