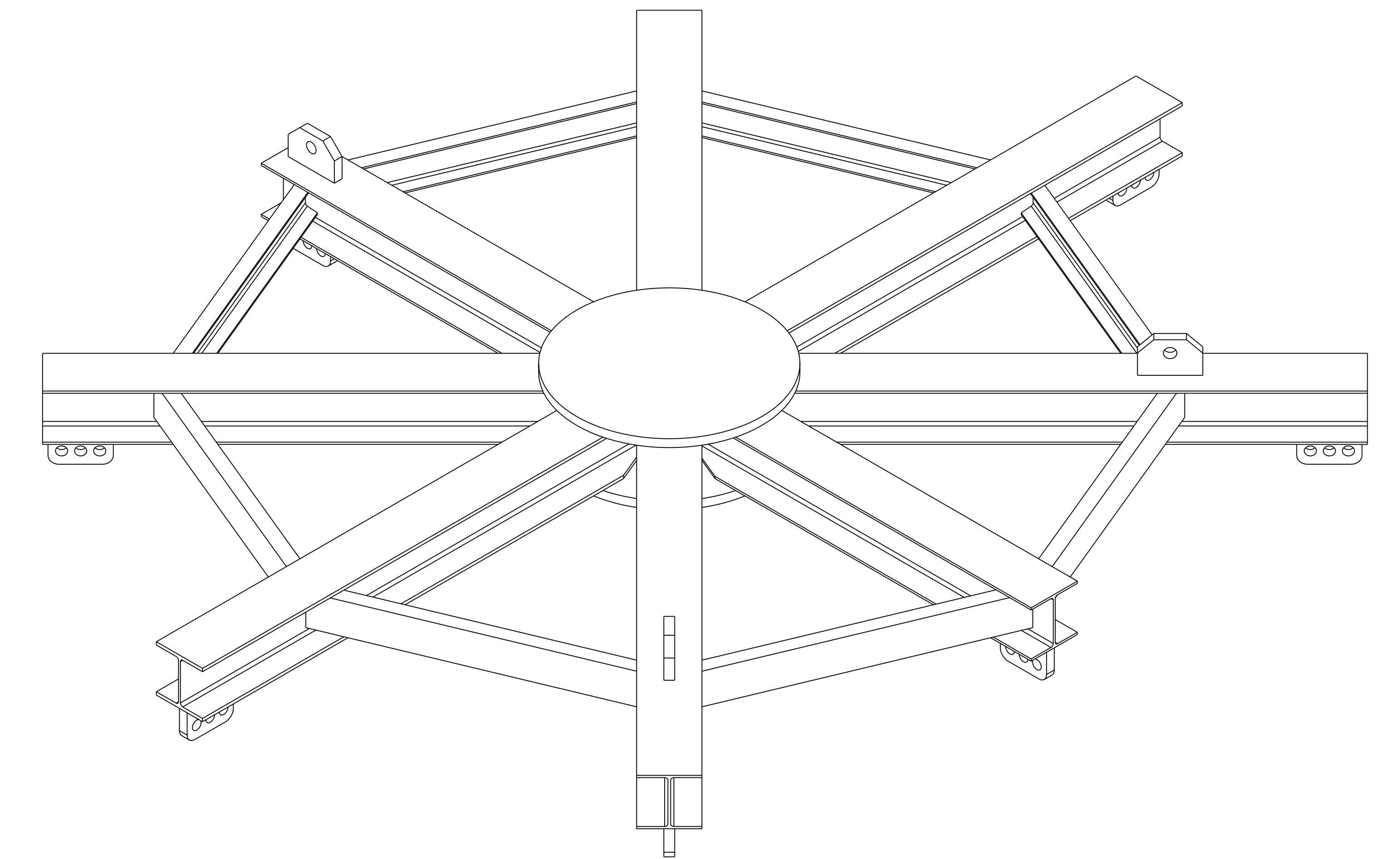
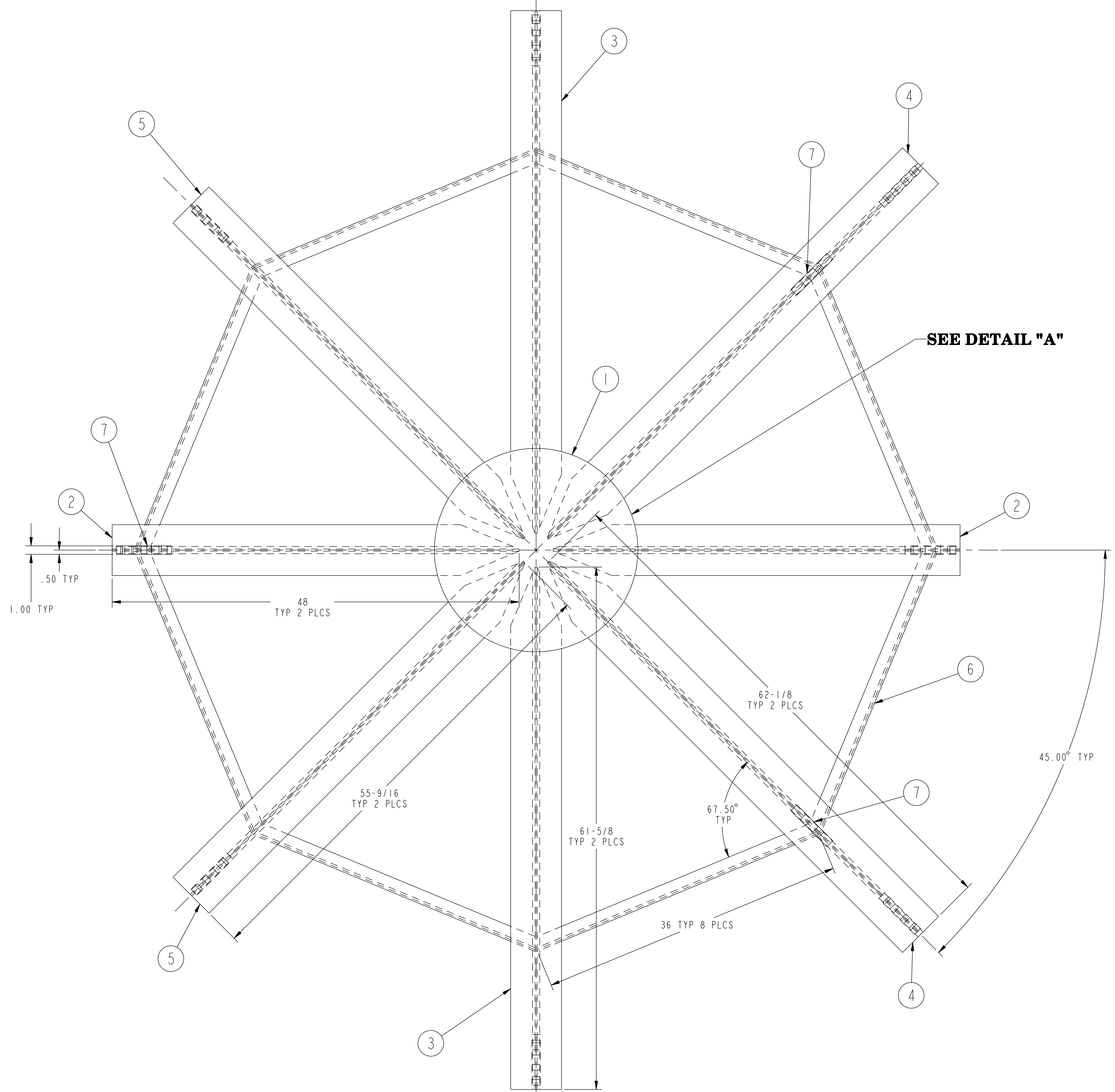
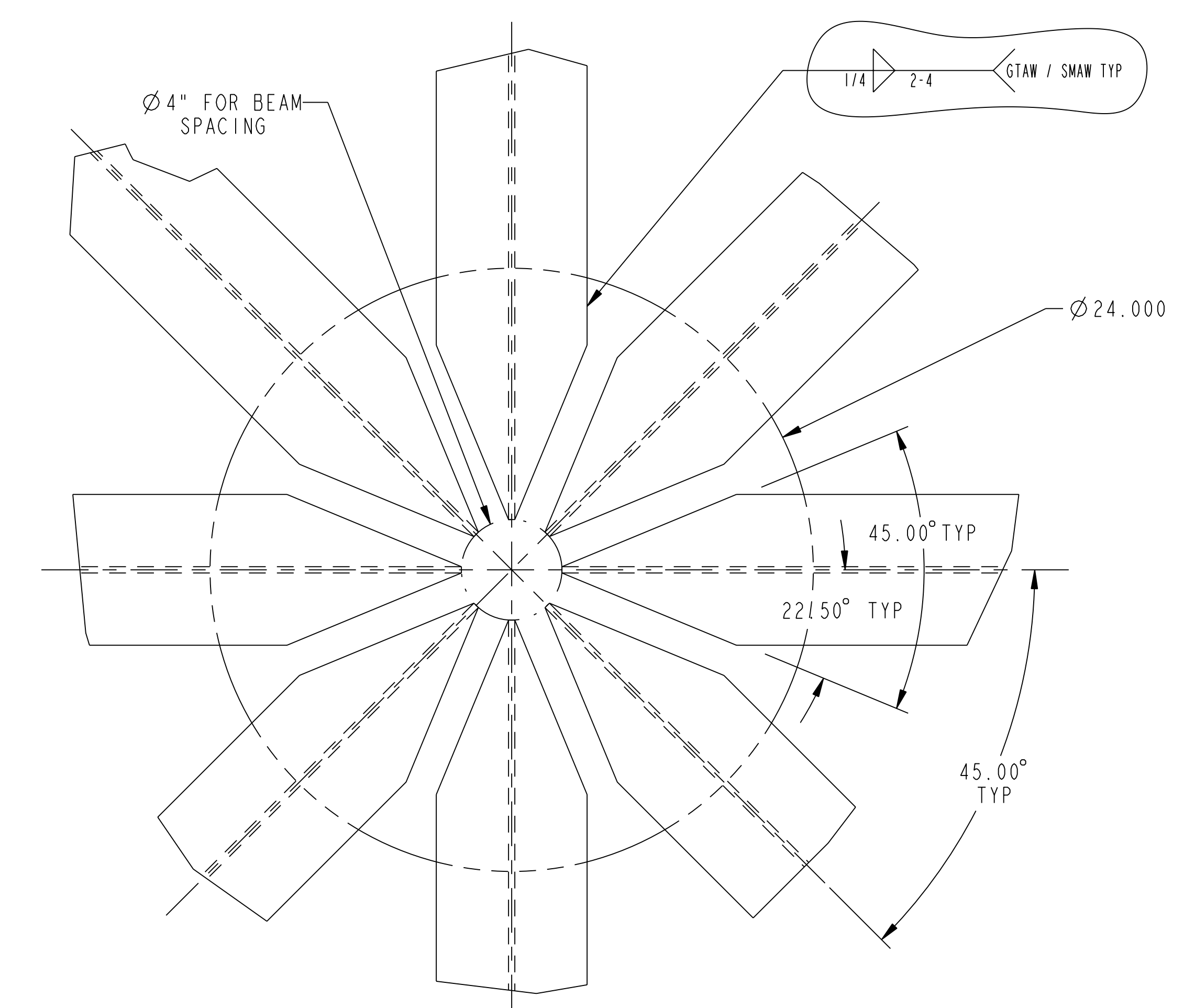


NO.	REVISION	BY	CH	SUP	APPROVED	DATE
1	REVISED PER NO. 5183	BP	JC	JS	J. CHRZANOWSKI	10/11/06

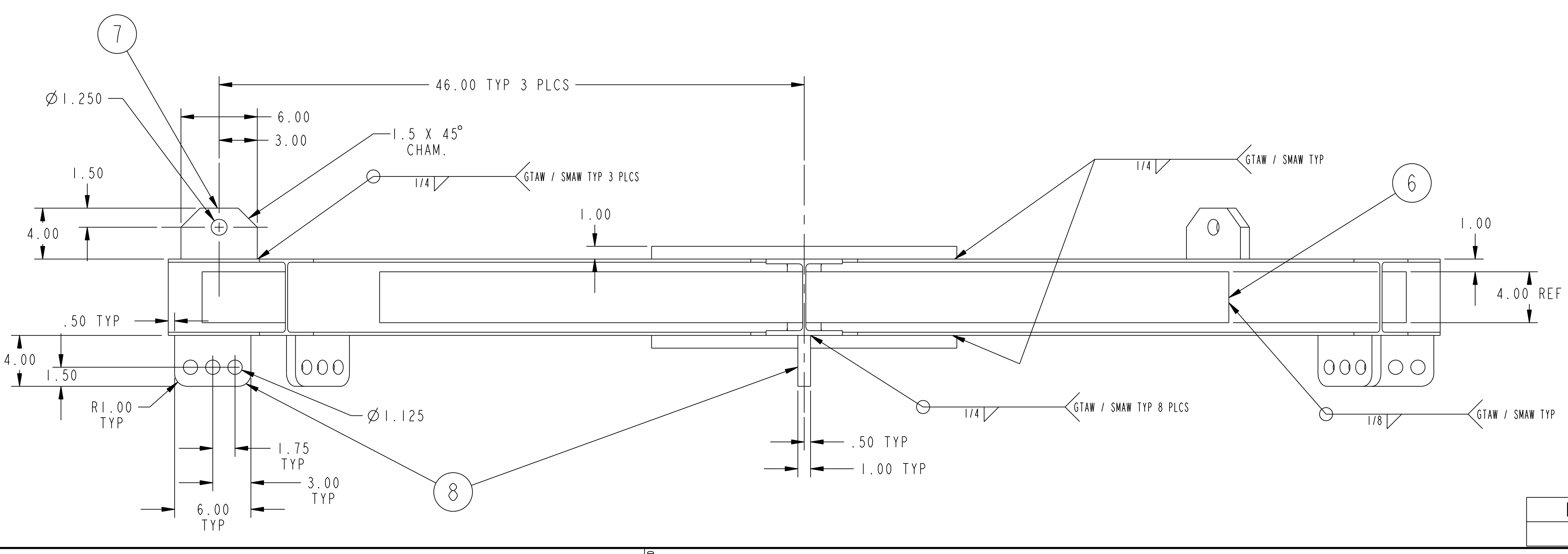


**ISOMETRIC VIEW
TF COIL LIFTING FRAME**



**DETAIL "A"
WELDMENT OF CENTER PLATES
(TOP PART 1 NOT SHOWN FOR CLARITY)**
SCALE 0.250

NOTES:
1. WELDING SHALL BE PERFORMED IN ACCORDANCE WITH PPPL PROCEDURE NO. ENG-037. VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH THE ACCEPTANCE CRITERIA OF AWS D1.1, 6.9.



**RELEASED FOR
FABRICATION / INSTALLATION**
PPPL Drafting:

RELEASE LEVEL: Fabrication
DWG VERSION NO: 5

WEIGHT	905.5 lbs
MODEL NAME	SE1312-052
WELDING ENGINEER	R. KEILBAC / J. GETTELFINGER

ASSY QTY	PART NO.	DRAWING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL
8	8	THIS DWG	1" TH'K PLATE 4" X 6" (CUT AS SHOWN)	A36
3	7	THIS DWG	1" TH'K PLATE 4" X 6" (CUT AS SHOWN)	A36
8	6	THIS DWG	C4 X 7.25# X 36" LG (CUT AS SHOWN)	A36
2	5	THIS DWG	W6 X 15.5# X 55-9/16" LG (CUT AS SHOWN)	A36
2	4	THIS DWG	W6 X 15.5# X 62-1/8" LG (CUT AS SHOWN)	A36
2	3	THIS DWG	W6 X 15.5# X 61-5/8" LG (CUT AS SHOWN)	A36
2	2	THIS DWG	W6 X 15.5# X 48" LG (CUT AS SHOWN)	A36
2	1	THIS DWG	Ø24.00 X 1" TH'K PLATE	A36
1	0	THIS DWG	TF COIL LIFTING FRAME ASSEMBLY	

COMPUTER GENERATED DRAWING	CENTRAL FILES:	PRINCETON PLASMA PHYSICS LABORATORY
MANUAL CHANGES NOT PERMITTED	UNLESS OTHERWISE SPECIFIED	NATIONAL COMPACT STELLARATOR EXPERIMENT
Pro E	DIMENSIONS ARE IN INCHES	TF COIL WINDING ROOM
DO NOT VERIFY INFORMATION BY SCALING DRAWING	MACHINE SURFACES	TF COIL LIFTING FRAME
	BREAK SHARP EDGES .005/.020	WELDED ASSEMBLY
	TOLERANCES NON-CUMULATIVE	DSN: B. PAUL 9/13/05 DRAWING NO:
	DECIMAL-INCH FRACTIONS	CHK: M. KALISH 9/13/05
	NEXT ASSEMBLY	ENGR: J. CHRZANOWSKI 9/13/05
		SUPV: J. SEGIEL 9/13/05

NCSX-SEI 1312-052