



RELEASED FOR  
FABRICATION/INSTALLATION  
PPPL Drafting

- NOTES:
1. WELDING SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF AWS D1.1 OR PPL PPPL PROCEDURE ENG-037. VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH THE ACCEPTANCE CRITERIA OF AWS D1.1 Section 6.
  2. VENDOR TO CERTIFY THAT STOCK MATERIAL EXHIBITED MAGNETIC PERMEABILITY OF LESS THAN 1.02 Mu.
  3. IF AFTER WORKING OR MACHINING PART HAS MAGNETIC PERMEABILITY GREATER THAN 1.02 Mu, THEN PART IS TO BE VACUUM HEAT TREATED AT 1100°C FOR 2.5 HRS TO BRING THE MAGNETIC PERMEABILITY BELOW 1.02 Mu.
  4. SPECIAL PROCESS WITH HEAT SINK REQUIRED TO GAURENTEE COIL TEMPERATURE DOES NOT EXCEED 100°C FURTHER WELDING PROCESS DEVELOPMENT IS REQUIRED.

PART NO.	DRAWING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY REOD
8	SEI33-044-4	TRIM COIL #1, CHANNEL SUPPORT CAP #4	316 SS/STL	1
7	SEI33-044-3	TRIM COIL #1, CHANNEL SUPPORT CAP #3	316 SS/STL	1
6	SEI33-044-2	TRIM COIL #1, CHANNEL SUPPORT CAP #2	316 SS/STL	1
5	SEI33-044-1	TRIM COIL #1, CHANNEL SUPPORT CAP #1	316 SS/STL	1
4	SEI33-041	TRIM COIL #2 GROUND-WRAPPED ASSEMBLY	COPPER/EPOXY	1
3	SEI33-063-3	TRIM COIL #1 BASE, SUPPORT #3	316 SS/STL	1
2	SEI33-063-2	TRIM COIL #1 BASE, SUPPORT #2	316 SS/STL	2
1	SEI33-063-1	TRIM COIL #1 BASE, SUPPORT #1	316 SS/STL	1

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E		CENTRAL FILES: UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	PRINCETON PLASMA PHYSICS LABORATORY NATIONAL COMPACT STELLARATOR EXPERIMENT STELLARATOR CORE TRIM COILS TRIM COIL #1 WELDMENT	
WEIGHT 123.1 lbs	MODEL NAME SEI33-063-01	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX ±.000 .XXX ±.005 ANGULAR ±.0°-15°	DSN: R. UPCAVAGE 6/9/08 CHK: M. KALISH 6/9/08 ENGR: M. KALISH 6/9/08 SUPV: J. SIEGEL 6/9/08	DRAWING NO: <b>SEI33-063</b> SHEET 1 OF 1 REV 0

RELEASE LEVEL: \*\*\*  
DWG VERSION NO: 25

NCSX-SEI33-063