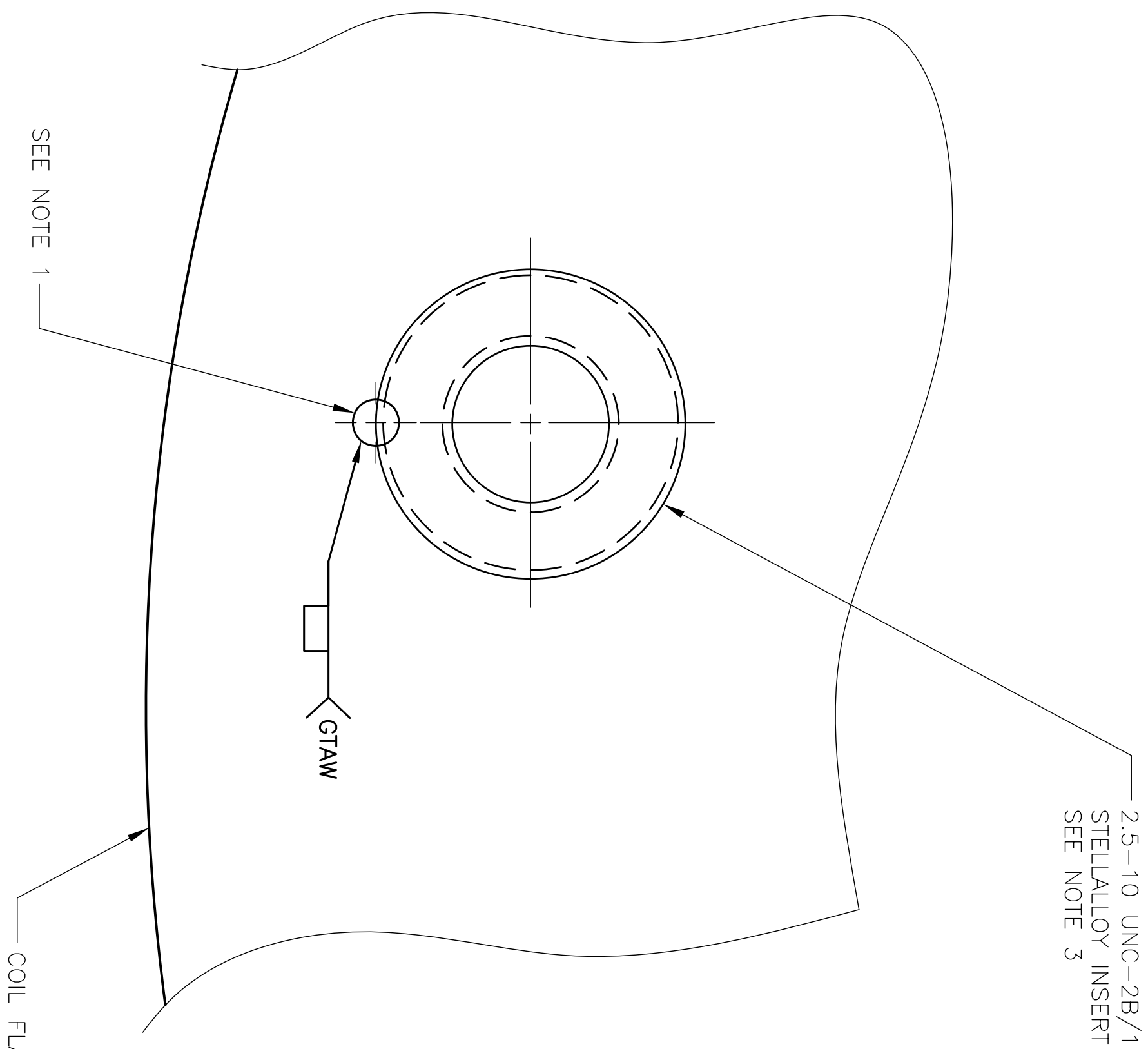


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NO.	REVISION	BY	CH	SUP	APPROVED	DATE

2.5-10 UNC-2B/1.375-6 UNC-2B
 STELLALLOY INSERT (REF.)
 SEE NOTE 3



- NOTES
1. DRILL HOLE, 3/8" DIA. X 1/4" DEEP MINIMUM, STANDARD OR PILOT POINT TWIST DRILL.
 2. WELDING SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF PPPL PROCEDURE NO. ENG-037, VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH THE ACCEPTANCE CRITERIA OF AWS D1.6.

REFERENCE DRAWING & DOCUMENTS
 SE141-114 DATUM -E- FLANGE INSERT
 NCSX RFD PART-1 14-020

**RELEASED FOR
 FABRICATION / INSTALLATION**

PPPL Drafting

03	02	01	PART NO.	NOMENCLATURE OR DESCRIPTION	DRAWING NO.	MATERIAL		
COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED			CENTRAL FILES:	PRINCETON PLASMA PHYSICS LABORATORY NATIONAL COMPACT STELLARATOR EXPERIMENT MODULAR COILS TOOLING & WINDING THREADED INSERT WELDING DETAIL	CAD FILE: SE141-603.DWG			
AutoCAD2000			UNLESS OTHERWISE SPECIFIED					
DO NOT VERIFY INFORMATION BY SCALING DRAWING			DIMENSIONS ARE IN INCHES MACHINE SURFACES 125/	DIV: MECHANICAL	DATE: 5/31/07			
SCALE: 1-1			BREAK SHARP EDGES .005/.020				APPROVED	NCSX SE141-603
NEXT ASSEMBLY			TOLERANCES NON-CUMULATIVE				ENG: G. GETTELFINGER	
			DECIMAL-INCH	DWN: FRANK JONES	CHK: JIM NELSON			
			XX ±.100	FRACTIONS	CHK: JIM NELSON			
			XXX ±.030	0"-12" ±1/16				
			ANGULAR ±.005	12"-72" ±1/8				
				72"-120" ±1/4				
				OVER 120" ±1/2				

WELDING ENGINEER
 APPVD: G. GETTELFINGER DATE 5/31/07

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SE141-603