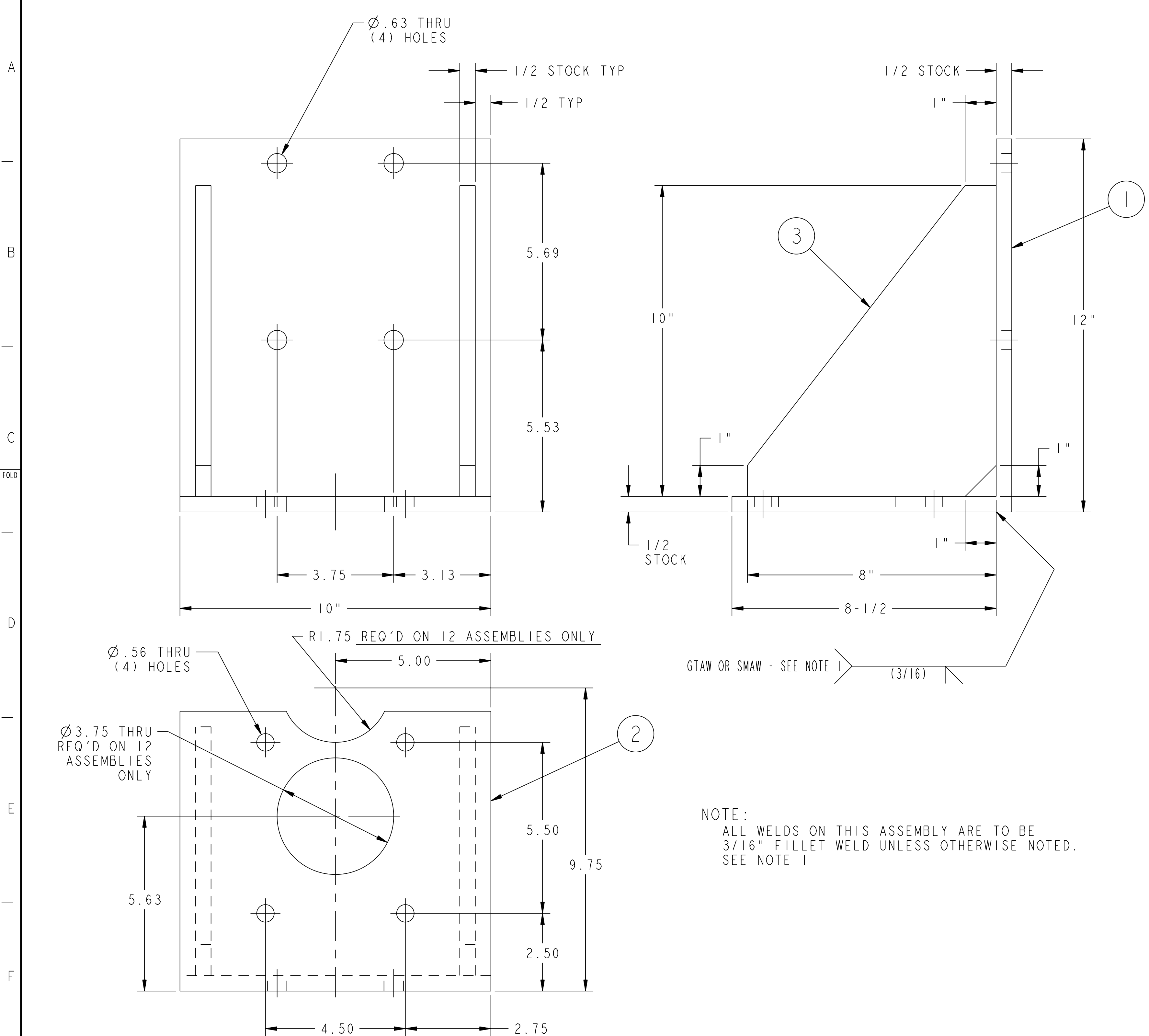
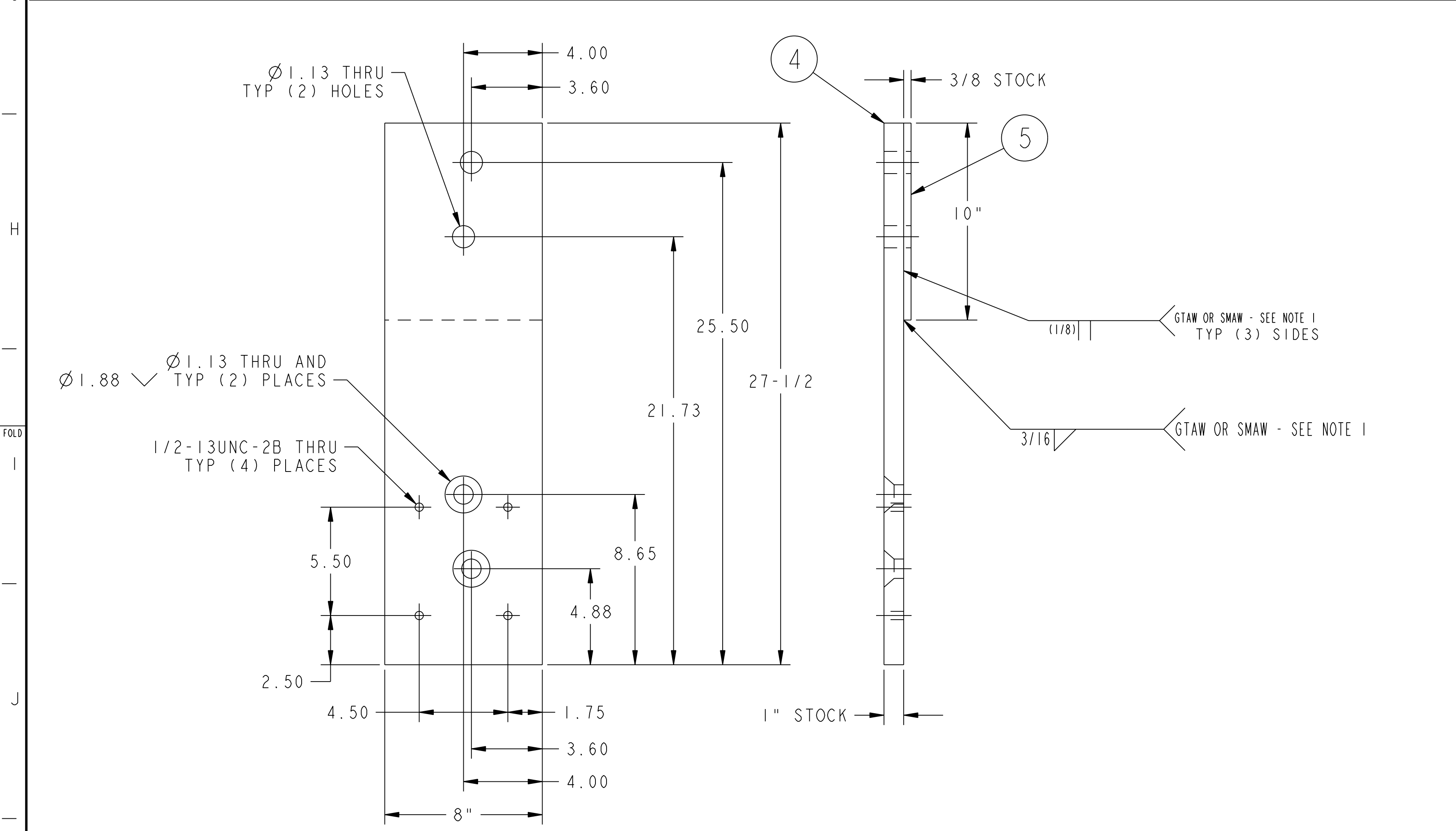


NO.	REVISION	BY	CH	SUP	APPROVED	DATE

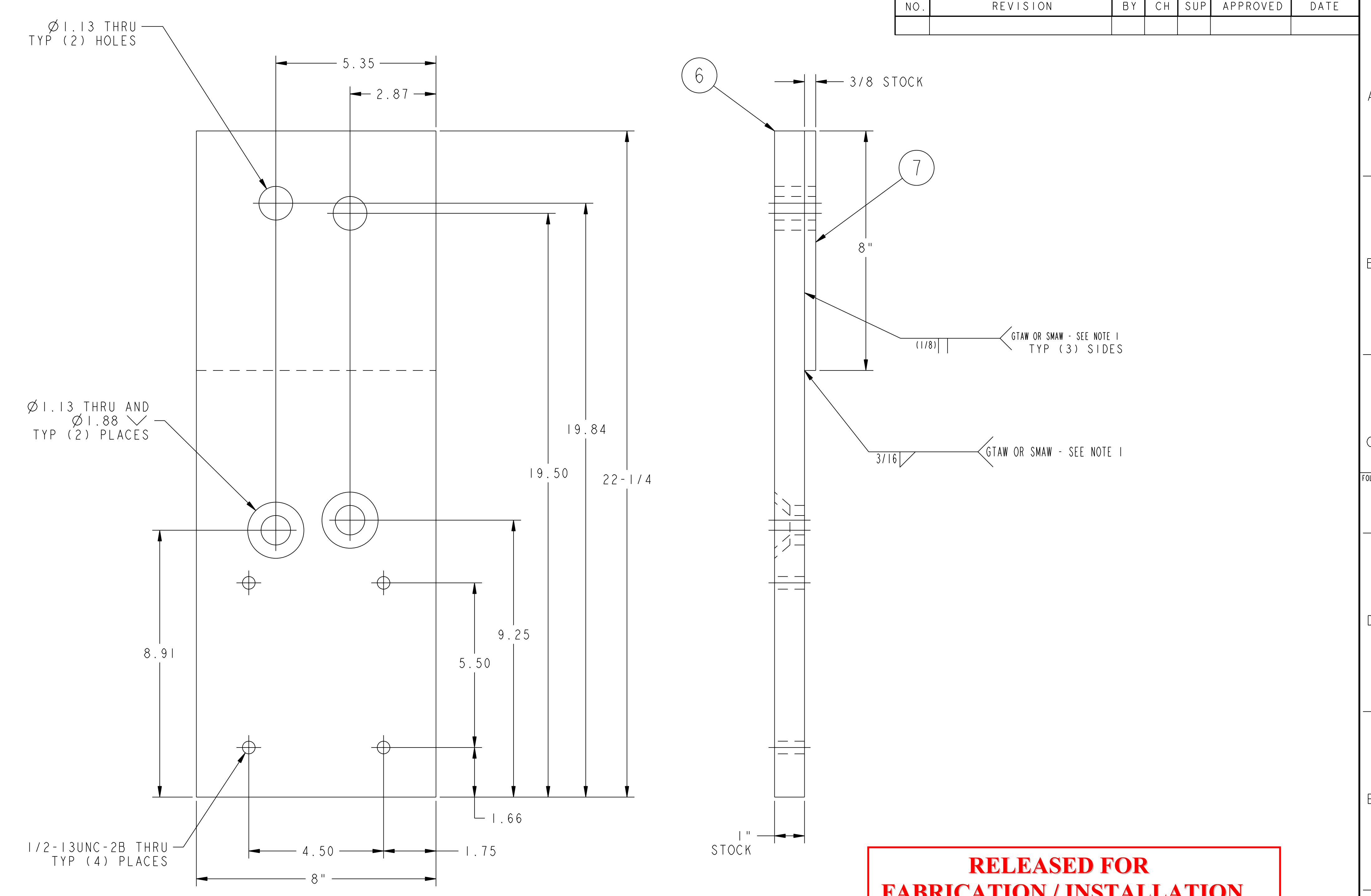


NOTE:  
ALL WELDS ON THIS ASSEMBLY ARE TO BE  
3/16" FILLET WELD UNLESS OTHERWISE NOTED.  
SEE NOTE 1

01 ASSEMBLY CASTER SUPPORT BRACKET WELDMENT  
72 REQ'D - 12 TO BE MODIFIED AS INDICATED



02 ASSEMBLY SUPPORT PLATE WELDMENT - TYPE "A" - AS SHOWN  
03 ASSEMBLY SUPPORT PLATE WELDMENT - TYPE "A" - OPPOSITE



04 ASSEMBLY SUPPORT PLATE WELDMENT - TYPE "B" - AS SHOWN  
05 ASSEMBLY SUPPORT PLATE WELDMENT - TYPE "B" - OPPOSITE

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

**NOTES**

1. WELDING SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF AWS D1.1 AND PPPL PROCEDURE ENG-037. VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH THE ACCEPTANCE CRITERIA OF AWS D1.1 SECTION 6.

QTY	DESCRIPTION	MATERIAL	DATE
12	BACKING PLATE	ASTM A36	12
12	FRONT PLATE	ASTM A36	12
12	BACKING PLATE	ASTM A36	12
12	FRONT PLATE	ASTM A36	12
12	GUSSET	ASTM A36	12
12	BACK PLATE	ASTM A36	12
24	SIDE PLATE	ASTM A36	24
12	FRONT PLATE	ASTM A36	12
12	BACKING PLATE	ASTM A36	12
12	FRONT PLATE	ASTM A36	12
12	BACKING PLATE	ASTM A36	12
12	FRONT PLATE	ASTM A36	12
12	BACKING PLATE	ASTM A36	12
12	FRONT PLATE	ASTM A36	12
144	GUSSET	ASTM A36	144
72	BACK PLATE	ASTM A36	72
72	BASE PLATE	ASTM A36	72
6	SUPPORT PLATE WELDMENT - TYPE "E" - OPPOSITE		6
6	SUPPORT PLATE WELDMENT - TYPE "E" - AS SHOWN		6
6	SUPPORT PLATE WELDMENT - TYPE "D" - OPPOSITE		6
6	SUPPORT PLATE WELDMENT - TYPE "D" - AS SHOWN		6
6	SUPPORT PLATE WELDMENT - TYPE "C" - OPPOSITE		6
6	SUPPORT PLATE WELDMENT - TYPE "C" - AS SHOWN		6
6	SUPPORT PLATE WELDMENT - TYPE "B" - OPPOSITE		6
6	SUPPORT PLATE WELDMENT - TYPE "B" - AS SHOWN		6
6	SUPPORT PLATE WELDMENT - TYPE "A" - OPPOSITE		6
6	SUPPORT PLATE WELDMENT - TYPE "A" - AS SHOWN		6
72	CASTER SUPPORT BRACKET WELDMENT		72

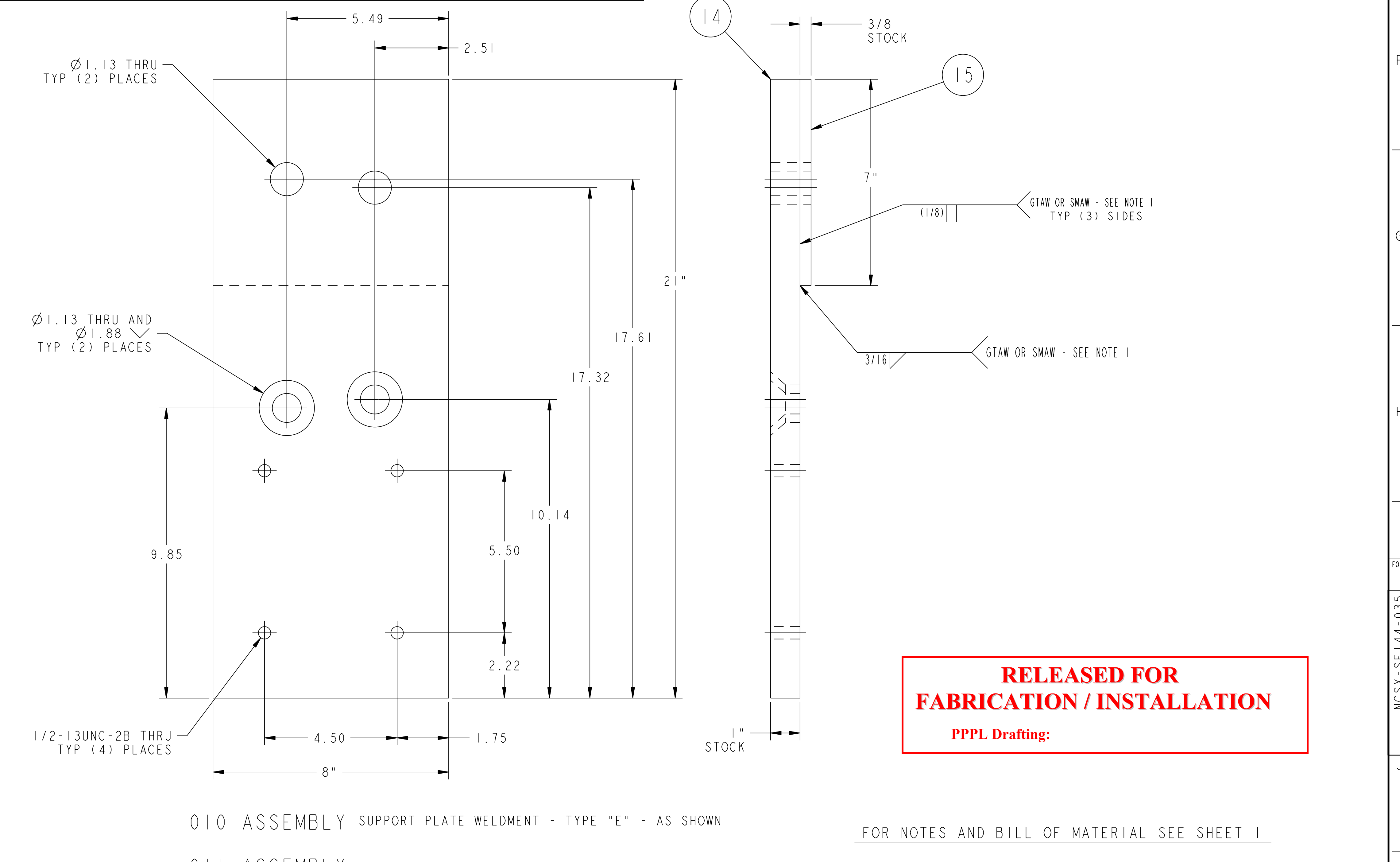
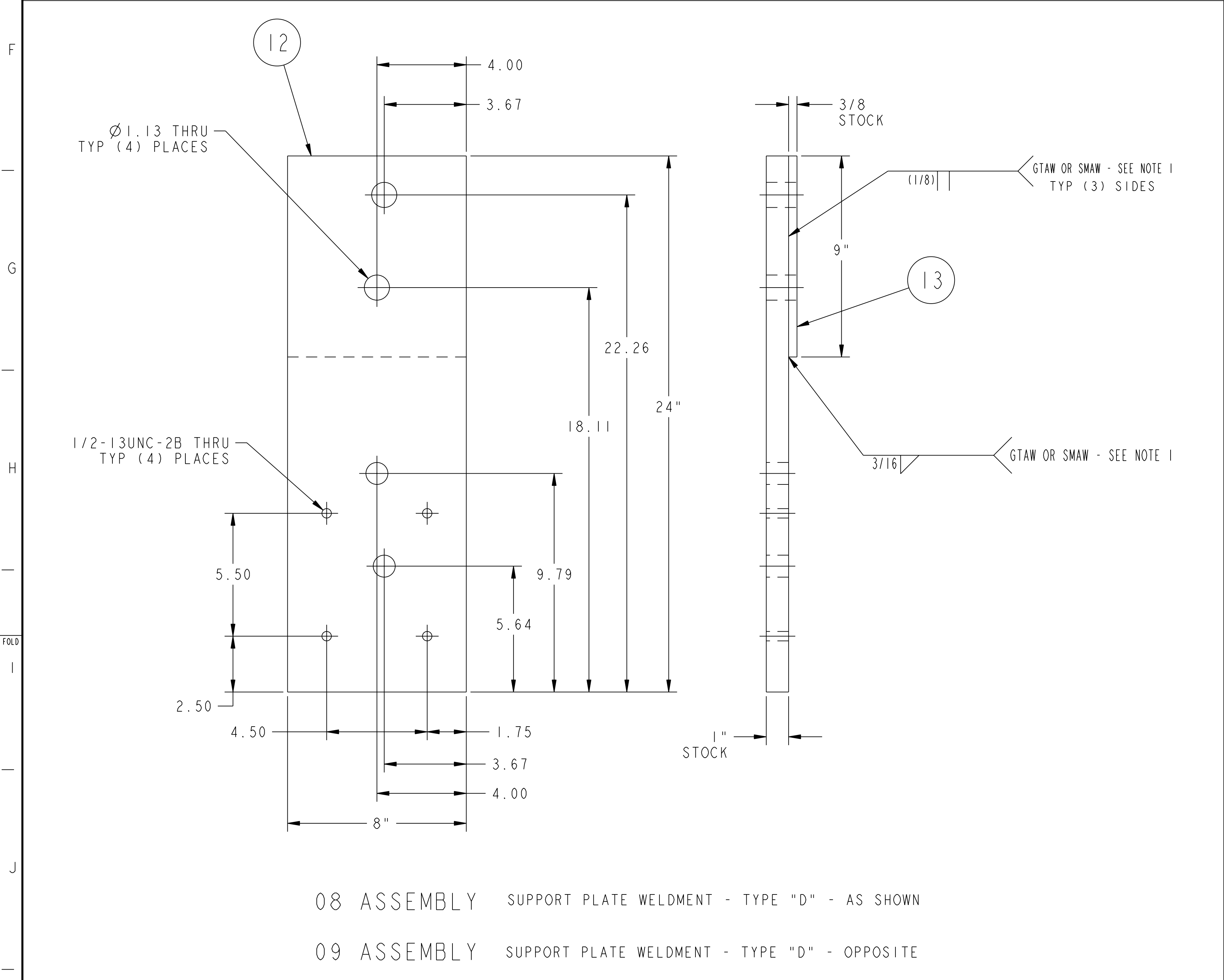
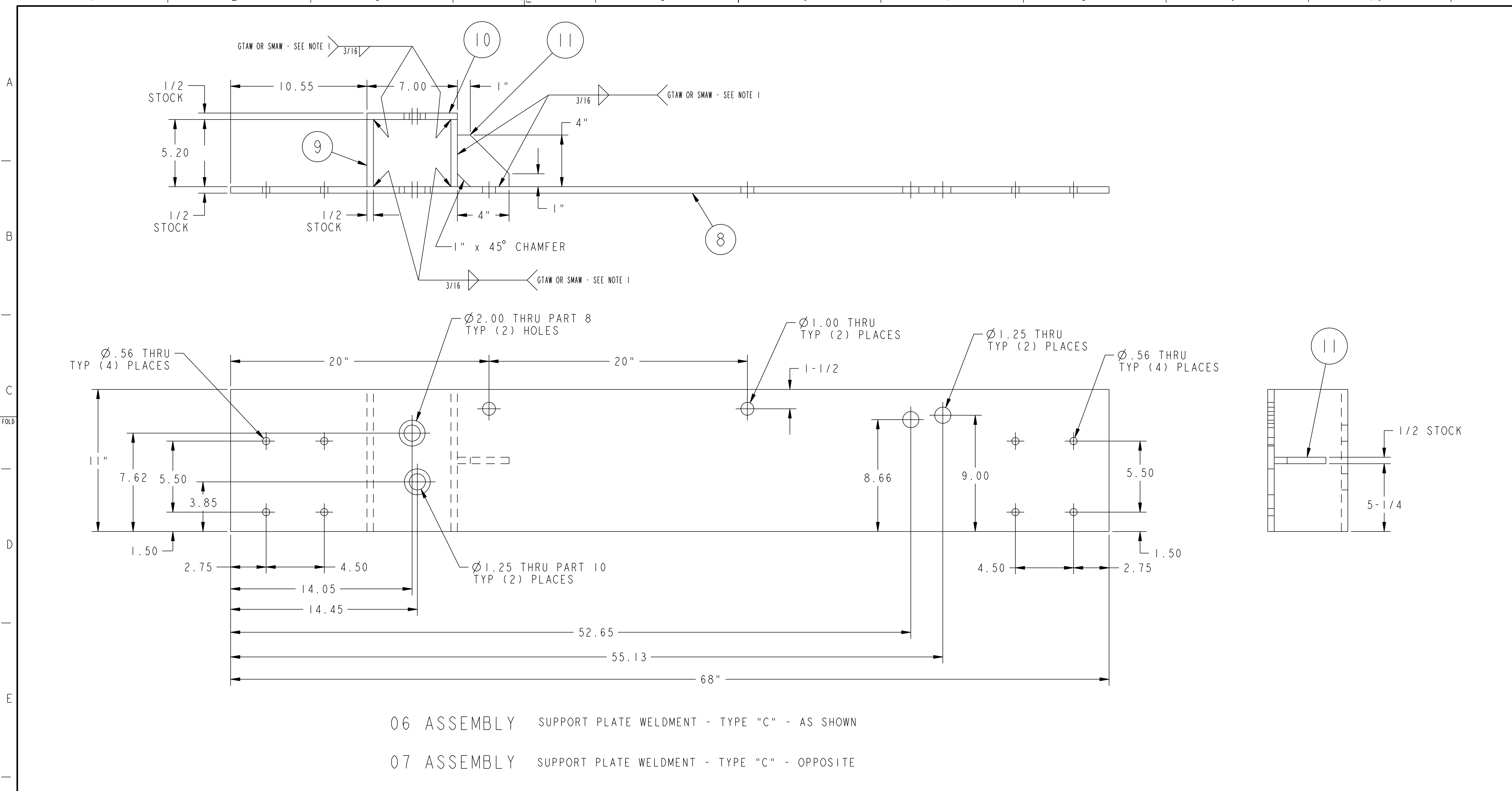
QTY	DESCRIPTION	MATERIAL	DATE
72	CASTER SUPPORT BRACKET WELDMENT		72

RELEASE LEVEL: FABRICATION  
DWG VERSION NO: 2

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES MACHINE SURFACES UNLESS NOTED BREAK SHARP EDGES .005/.020	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY <b>NATIONAL COMPACT STELLARATOR EXPERIMENT</b> MODULAR COIL ASSEMBLY MODULAR COIL WINDING FORM TEST ASSEMBLY CASTER SUPPORT WELDMENTS AND DETAILS
WEIGHT 41.6 LBS	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX ±.000 .XXX ±.005 ANGULAR ±.015	DSN: L. MORRIS 2-16-06 CHK: S. RAFTOPOULOS 2-16-06 ENGR: G. GETTELFINGER 2-16-06 SUPV: J. SIEGEL 2-16-06
MODEL NAME SE144-035-01	WELDING ENGINEER G. GETTELFINGER 2-16-06	DRAWING NO: <b>SE144-035</b> SHEET 1 OF 2 REV 0

NCSX-SE144-035

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



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

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

**RELEASE LEVEL: Fabrication**  
**DWG VERSION NO: 2:**

WEIGHT	56.9 lbs
MODEL NAME	SEI44-035-04
WELDING ENGINEER	

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 PRINCETON UNIVERSITY <b>NATIONAL COMPACT STELLARATOR EXPERIMENT</b>	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX ±.005 .XXX ±.005 ANGULAR ±.05°	DSN: L. MORRIS CHK: S. RAFTOPOULOS ENGR: G. GETTELFINGER SUPV: J. SIEGEL	2-16-06 2-16-06 2-16-06 2-16-06
NEXT ASSEMBLY	MODULAR COIL ASSEMBLY MODULAR COILWINDING FORM TEST ASSEMBLY CASTER SUPPORT WELDMENTS AND DETAILS	DRAWING NO: <b>SEI44-035</b>	SHEET 2 OF 2 REV 0

NCSX-SEI44-035