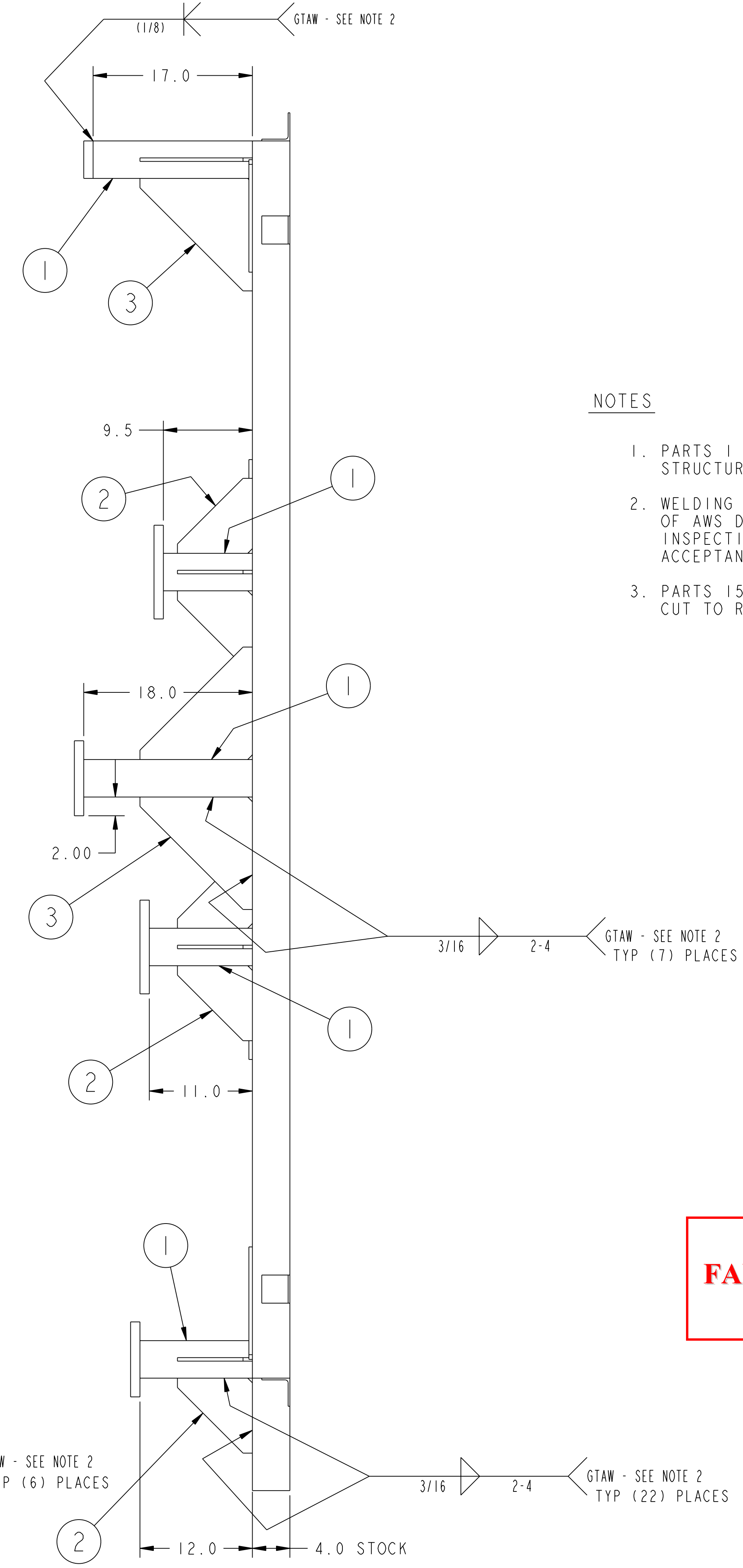
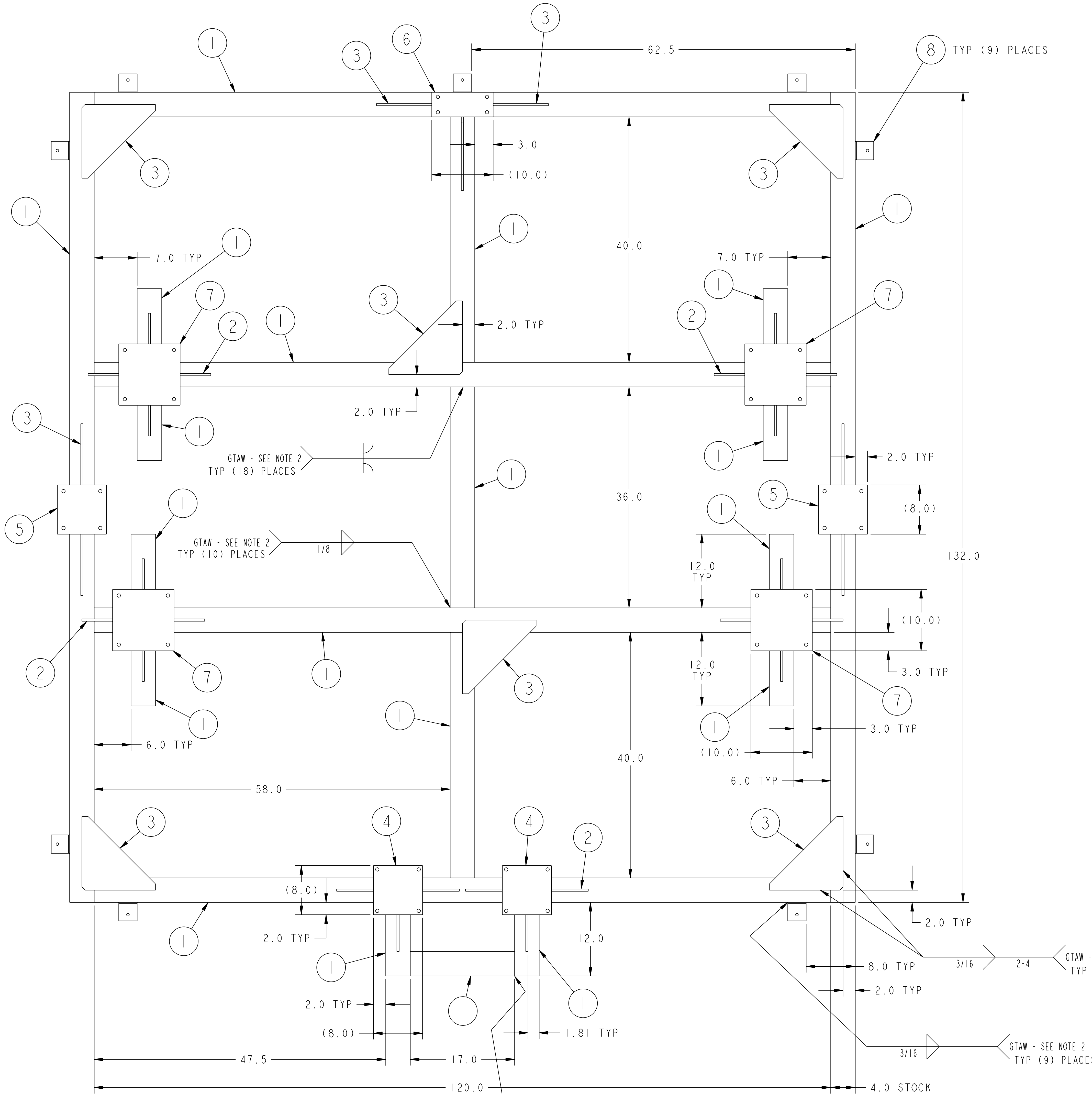


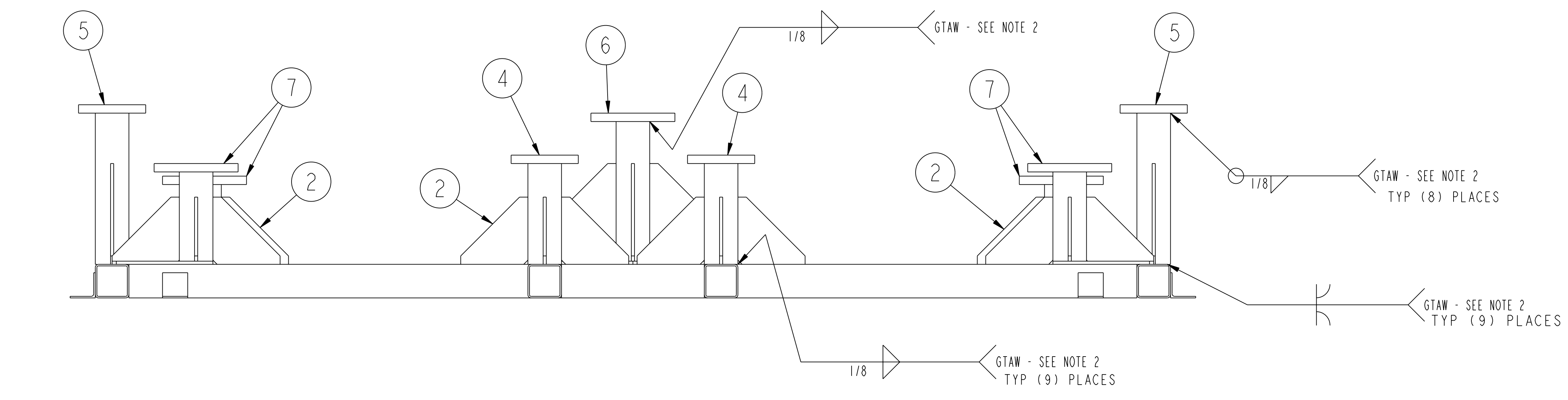
NO.	REVISION	BY	CH	SUP	APPROVED	DATE



**NOTES**

1. PARTS 1 TO BE FABRICATED USING 4 x 4 x 3/16 SQUARE STRUCTURAL TUBING CUT TO REQUIRED LENGTH.
2. WELDING SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF AWS D1.1 SECTION 6 AND PPPL PROCEDURE EM-002. VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH THE ACCEPTANCE CRITERIA OF AWS D1.1 SECTION 6.
3. PARTS 15 TO BE FABRICATED FROM 1" THICK STOCK PLATE CUT TO REQUIRED SIZE.

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



QTY	PART NO.	DESCRIPTION	MATERIAL	QTY REQD
1	15	THIS DWG	1" THICK PLATE x REQ'D SIZE	A/R
1	14	1/2-13 UNC-2A x 9.0 LG THREADED ROD	C' STL	16
1	13	TOP PLATE - MCWF	ASTM A36	4
1	12	TOP PLATE - TYPE "B"	ASTM A36	1
4	11	1/2-13 UNC-2A x 6.0 LG THREADED ROD	C' STL	12
1	10	STOP BLOCK	ASTM A36	2
1	9	TOP PLATE - TYPE "A"	ASTM A36	2
9	8	FLOOR MOUNTING CLIP	ASTM A36	9
4	7	MODULAR COIL WINDING FORM SUPPORT PAD	ASTM A36	4
1	6	SUPPORT RING PAD - TYPE "B"	ASTM A36	1
2	5	SUPPORT RING PAD - TYPE "A"	ASTM A36	2
2	4	CLEVIS SUPPORT PAD	ASTM A36	2
13	3	GUSSET - TYPE "B"	ASTM A36	13
22	2	GUSSET - TYPE "A"	ASTM A36	22
A/R	1	4 x 4 x 3/16 SQUARE TUBE x REQ'D LENGTH	ASTM A36	A/R
		"T" TYPE SPACER WELDMENT		2
		"C" TYPE SPACER WELDMENT		2
		MOD. COIL WINDING FORM ADJUSTABLE PAD WELDMENT		4
		SUPPORT RING ADJUSTABLE PAD - TYPE "B" WELDMENT		1
		SUPPORT RING ADJUSTABLE PAD - TYPE "A" WELDMENT		2
		ASSEMBLY FIXTURE FRAME WELDMENT		1

06	05	04	03	02	01	PART NO.	DRAWING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY REQD

01 ASSEMBLY ASSEMBLY FIXTURE FRAME WELDMENT

(1) REQ'D

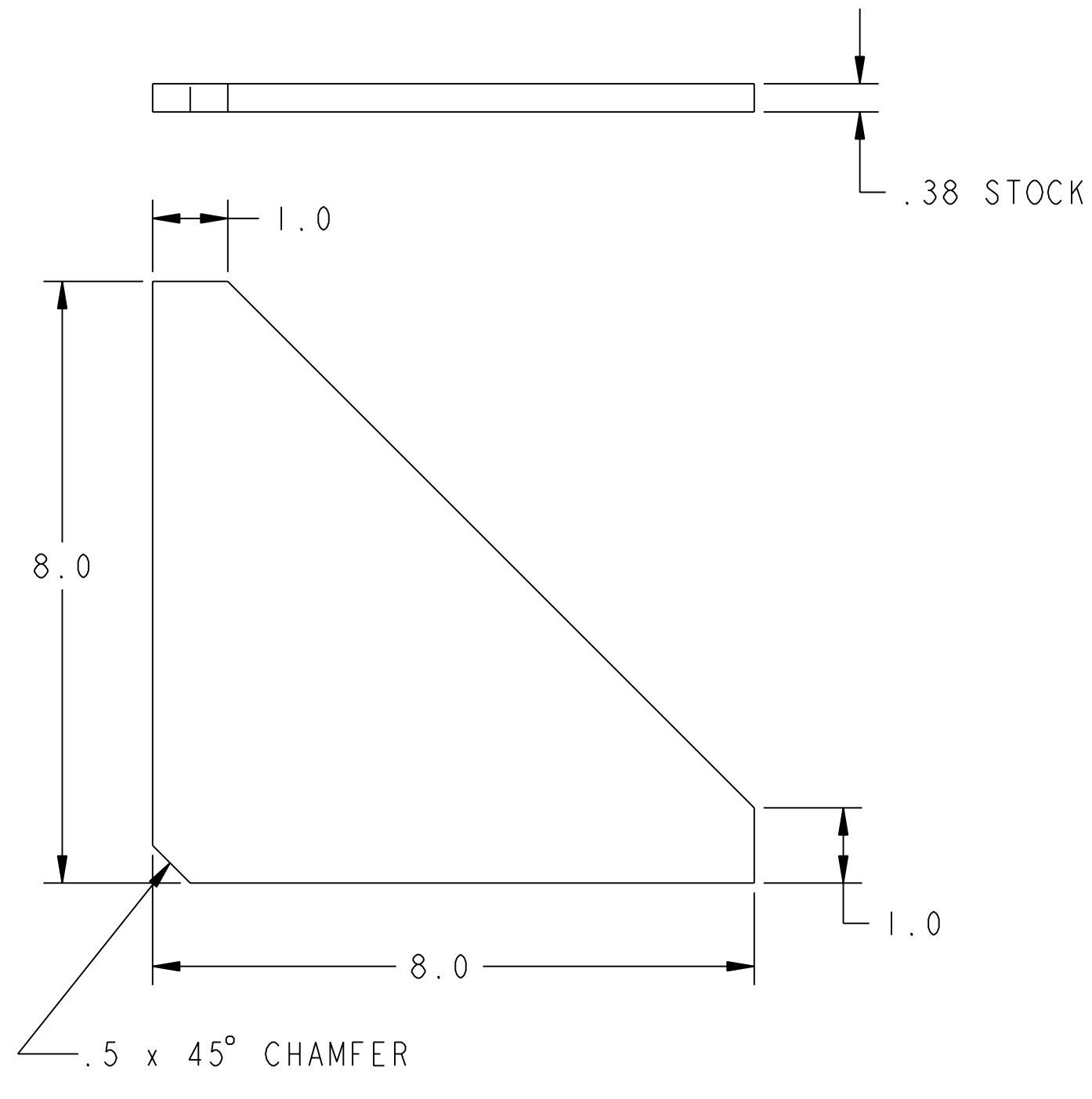
**RELEASE LEVEL:**  
**DWG VERSION NO:**

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> MODULAR COIL ASSEMBLY WINDING RING ASSEMBLY ASSEMBLY FIXTURE FRAME WELDMENTS AND DETAILS
DO NOT VERIFY INFORMATION BY SCALING DRAWING	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS XXX +/- .005 12" - 12" +/- .118 ANGLAR +/- .015 12" - 12" +/- .118	DSN: L. MORRIS 9-23-04 CHK: S. RAFTOPOULOS 9-23-04 ENGR: J. CHRZANOWSKI 9-23-04 SUPV: J. SIEGEL 9-23-04
WEIGHT 1269.9 lbs	MODEL NAME SE144-051-01	DRAWING NO: <b>SE144-051</b>
WELDING ENGINEER R. PARSELLS 9-23-04		SHEET 1 OF 3 REV 0

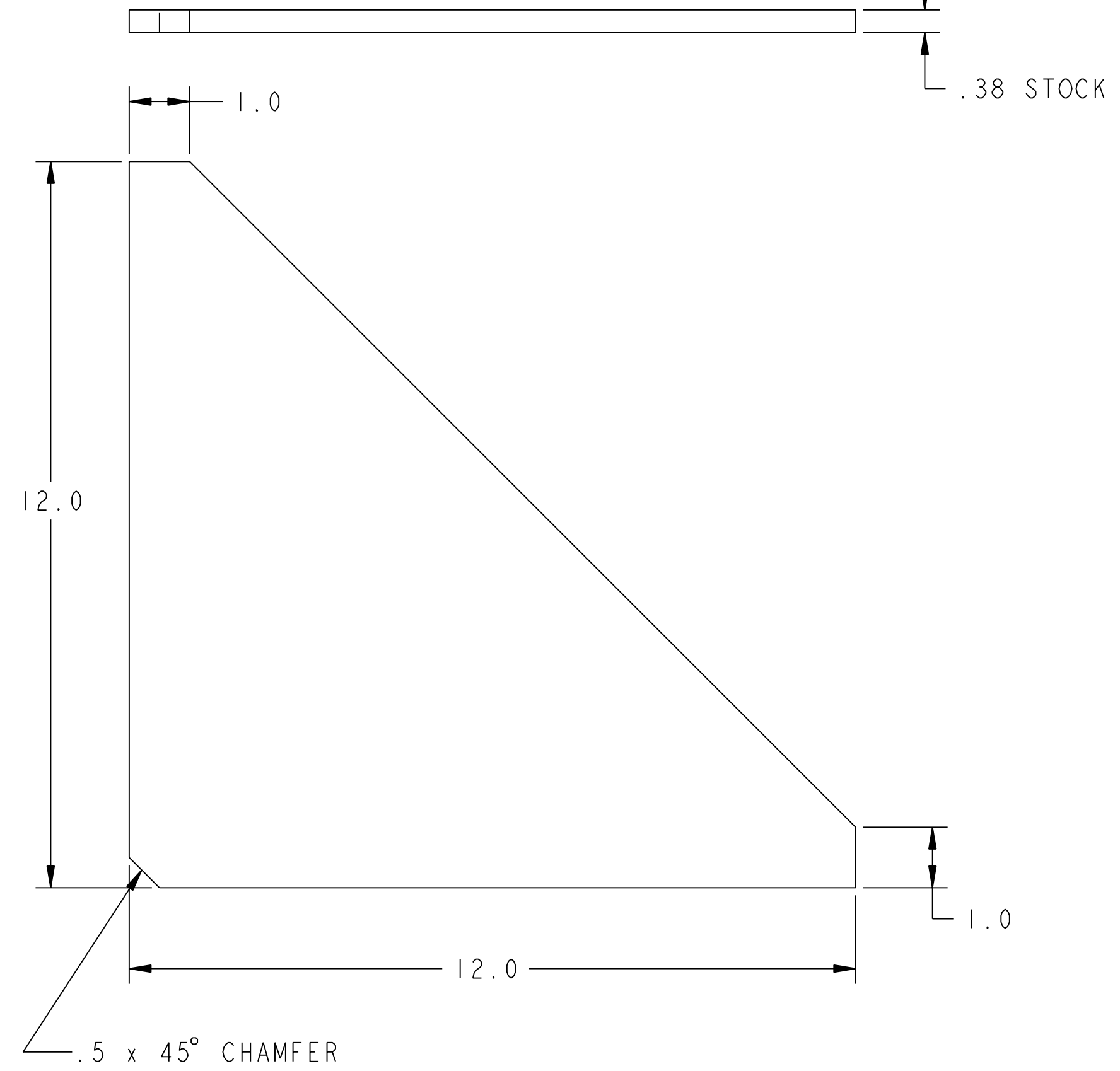
NCSX-SE144-051

NCSX-ASSY-FORMAT.E

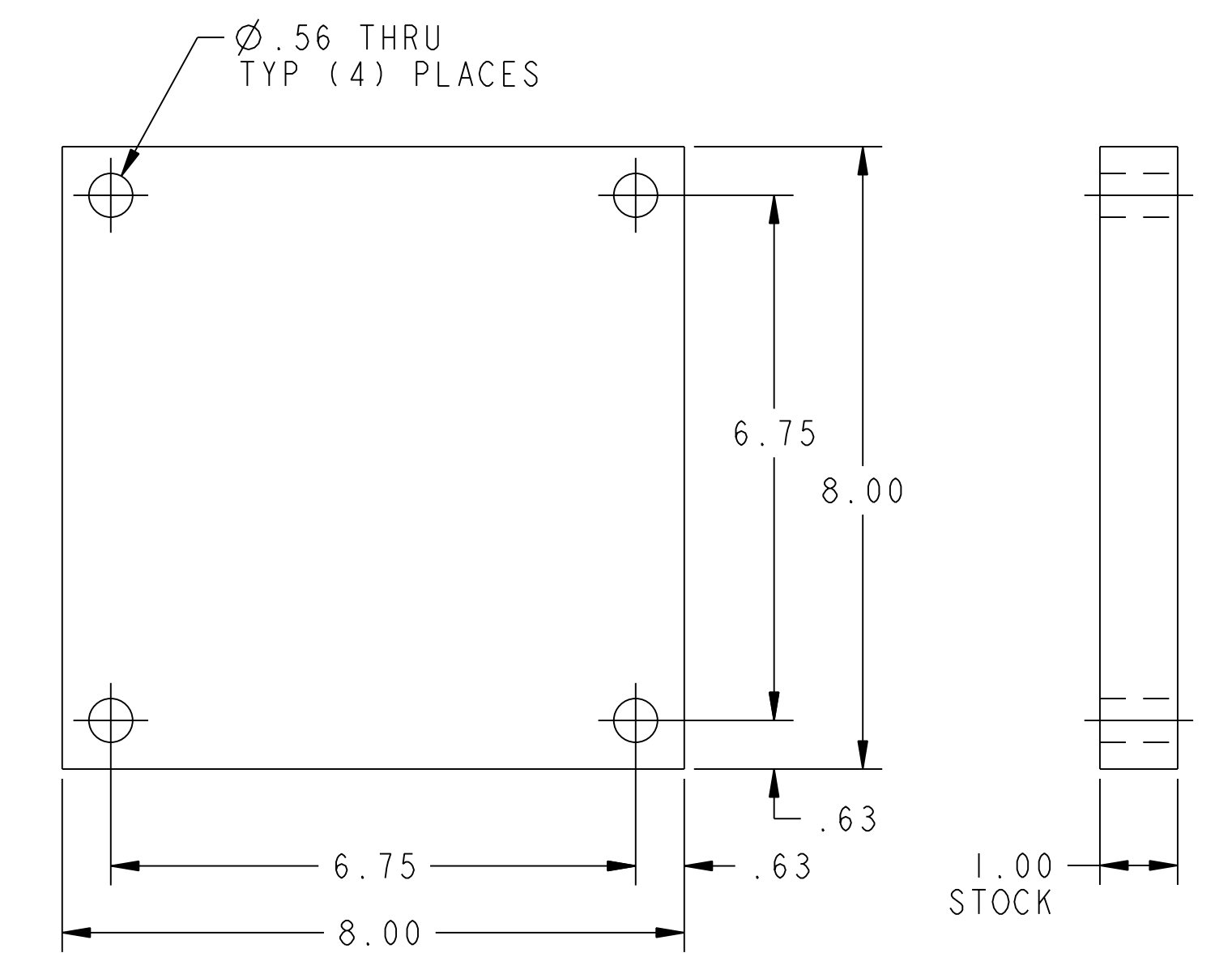
NO.	REVISION	BY	CH	SUP	APPROVED	DATE



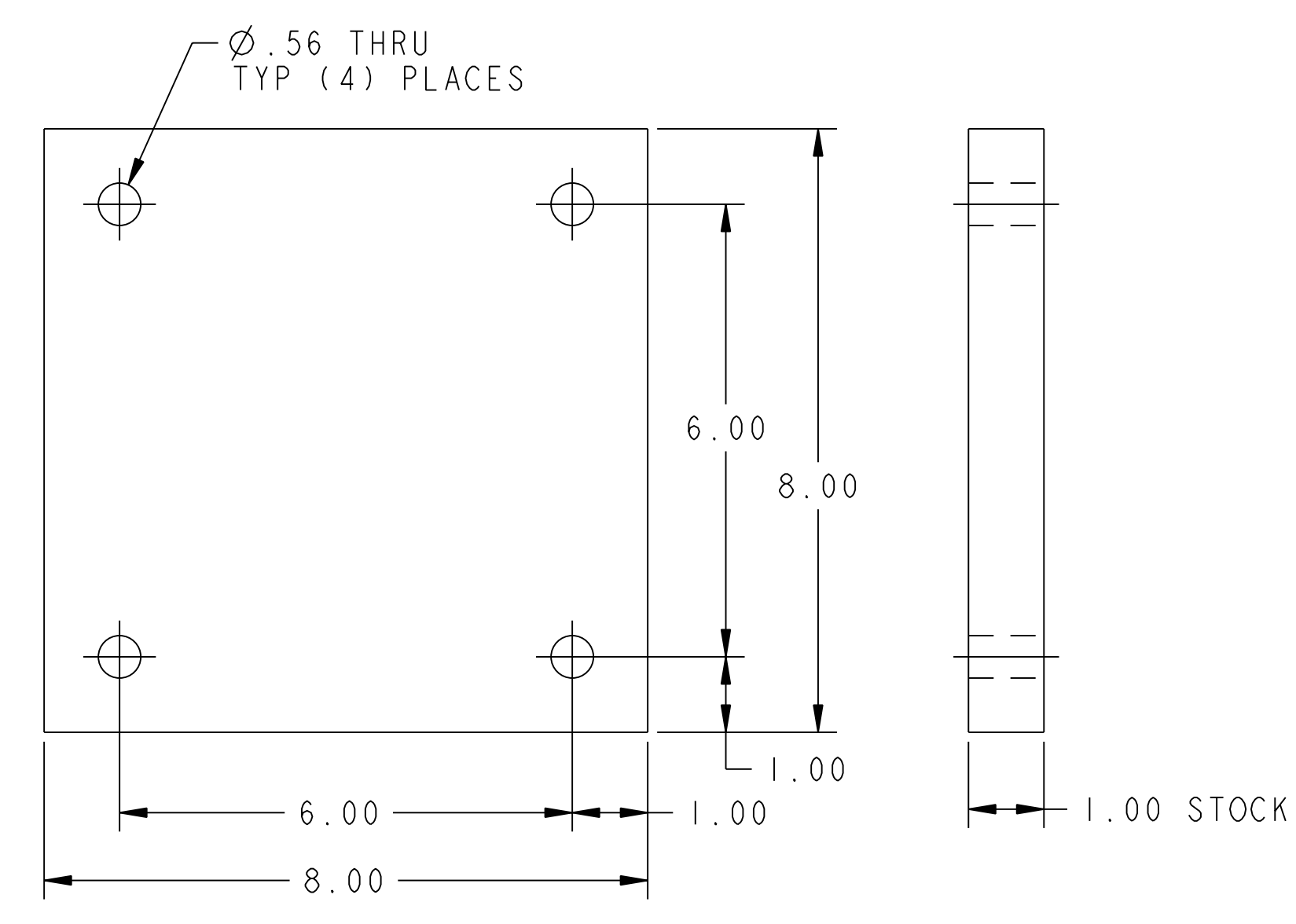
2 GUSSET - TYPE "A"  
(22) REQ'D



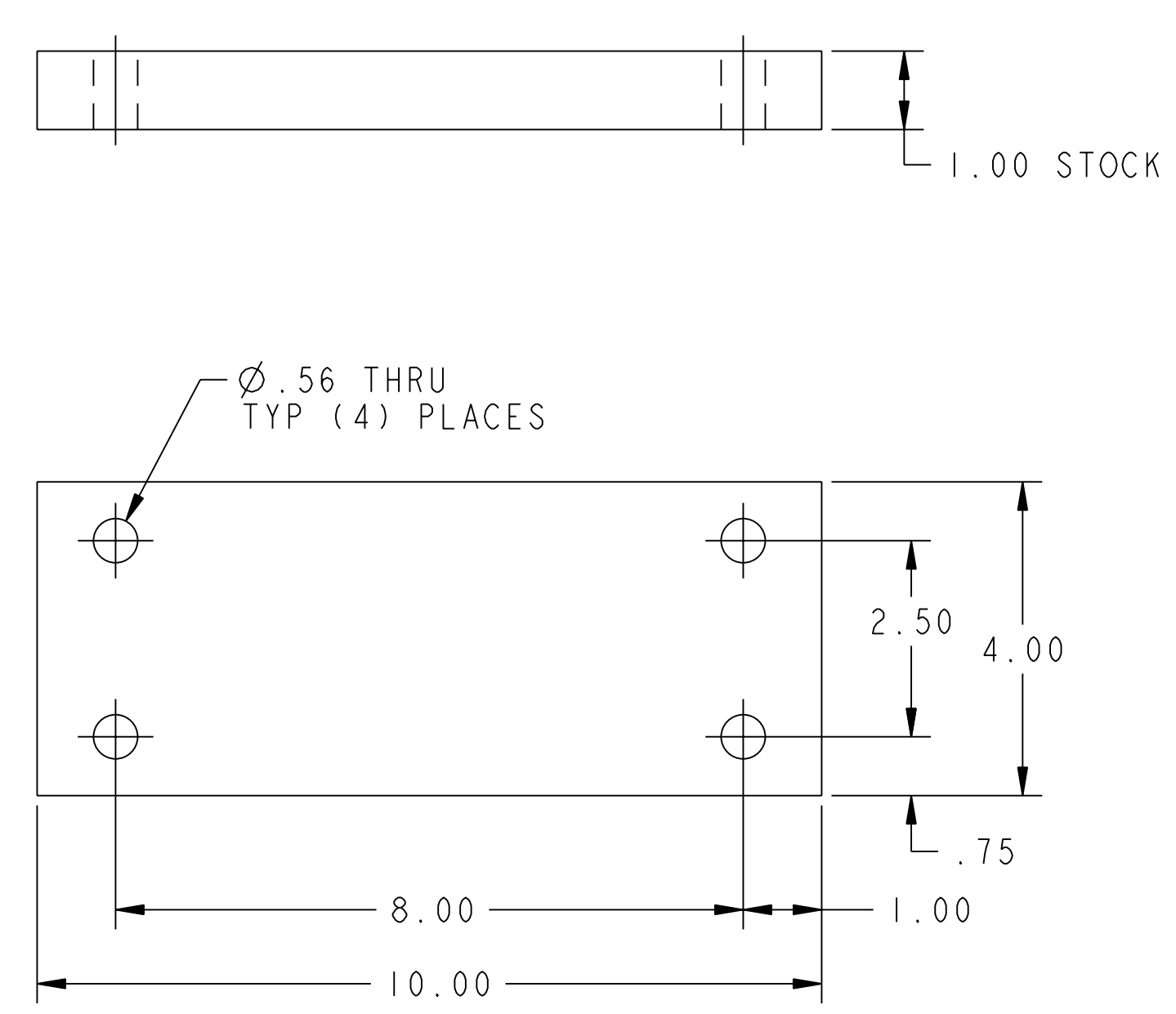
3 GUSSET - TYPE "B"  
(13) REQ'D



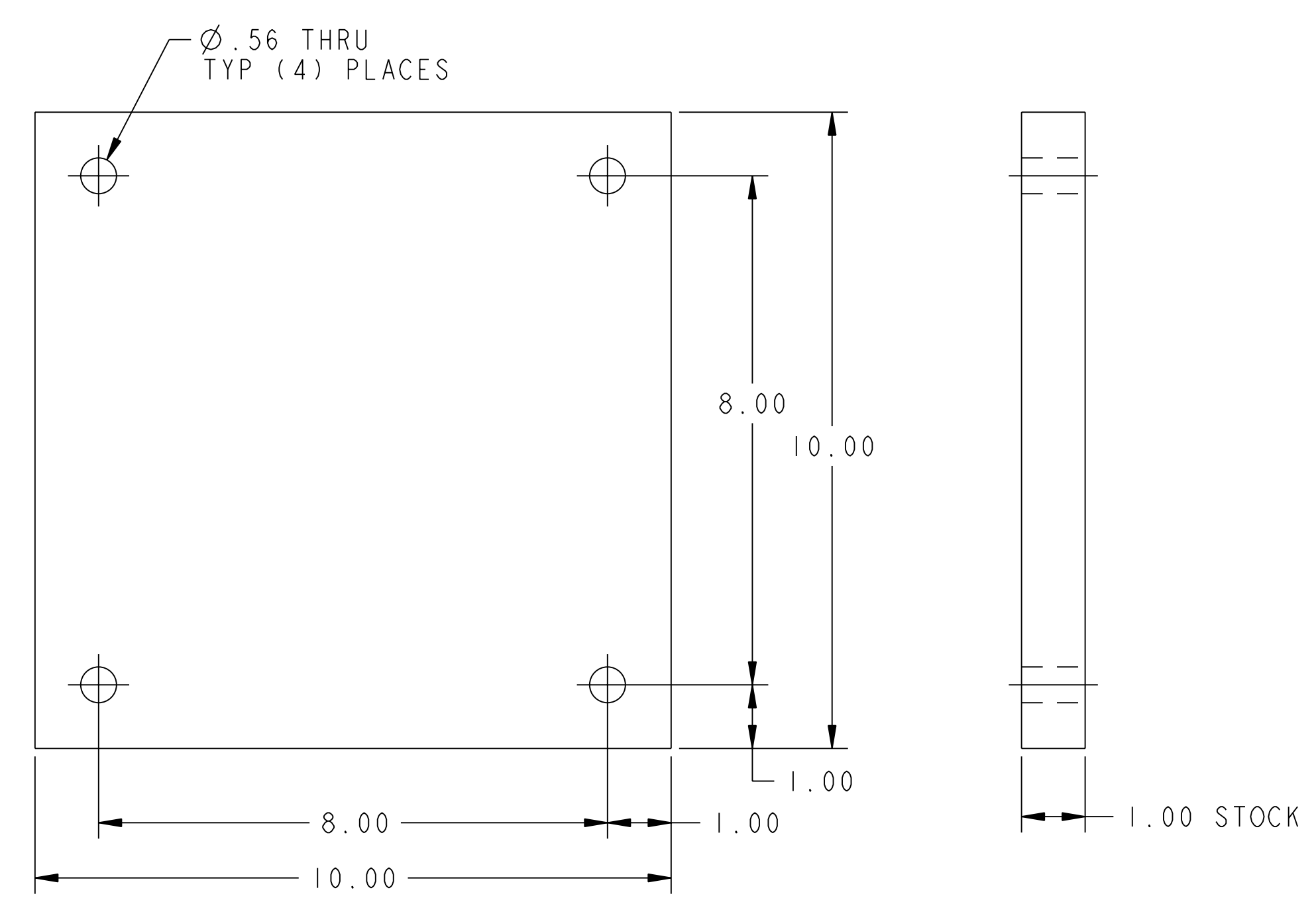
4 CLEVIS SUPPORT PAD  
(2) REQ'D



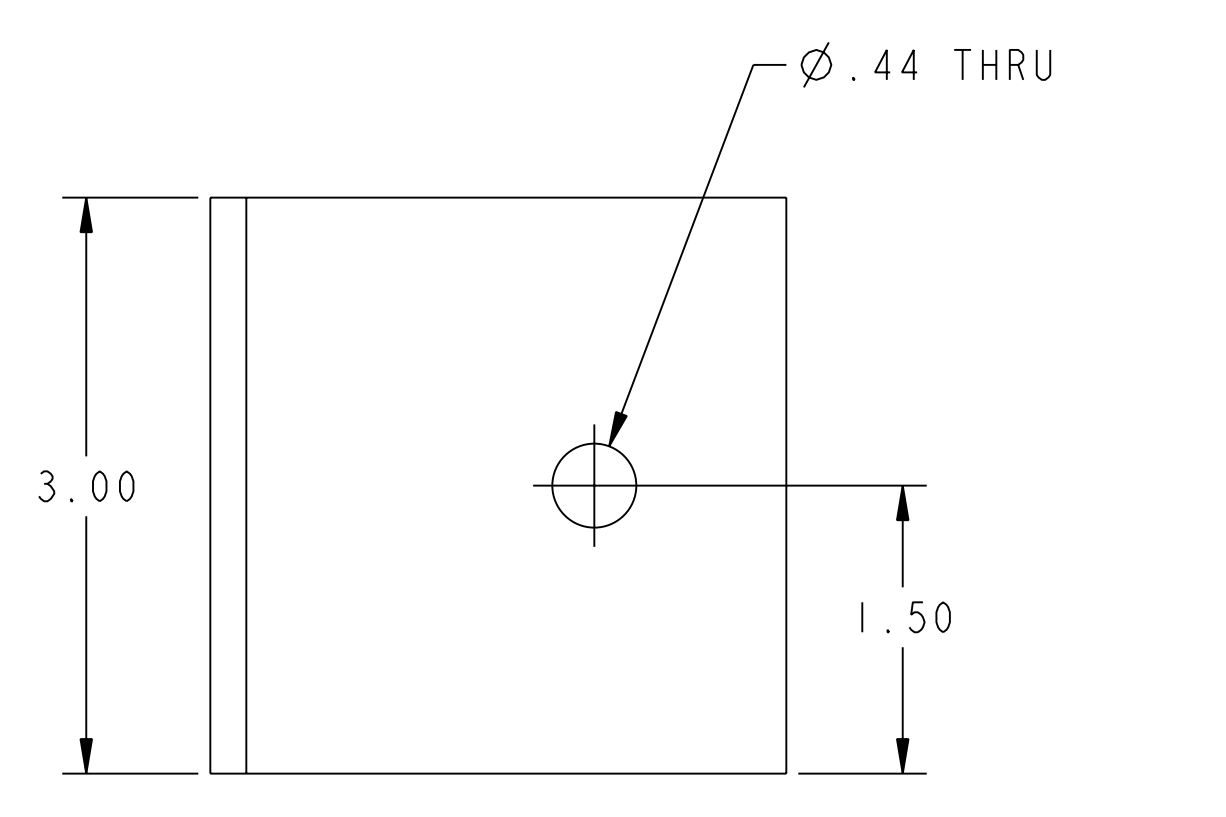
5 SUPPORT RING PAD - TYPE "A"  
(2) REQ'D



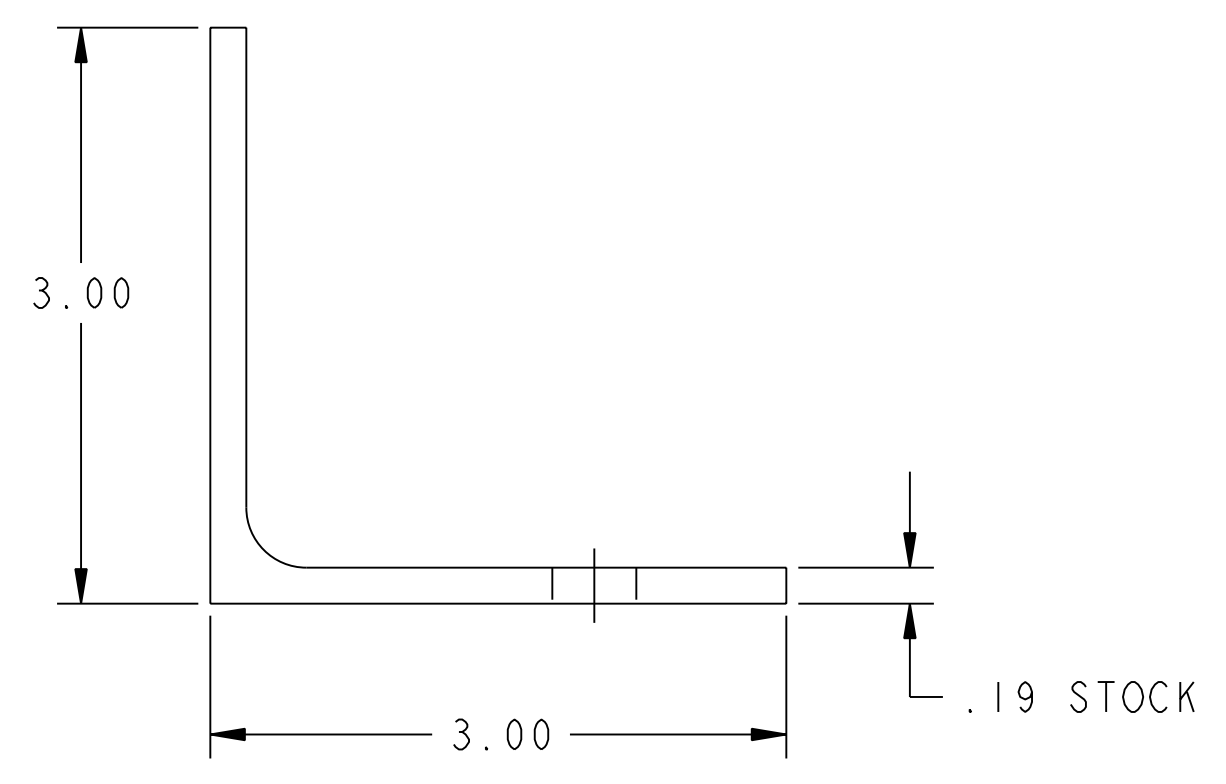
6 SUPPORT RING PAD - TYPE "B"  
(1) REQ'D



7 MODULAR COIL WINDING FORM SUPPORT PAD  
(4) REQ'D



8 FLOOR MOUNTING CLIP  
(9) REQ'D



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PPPL Drafting:

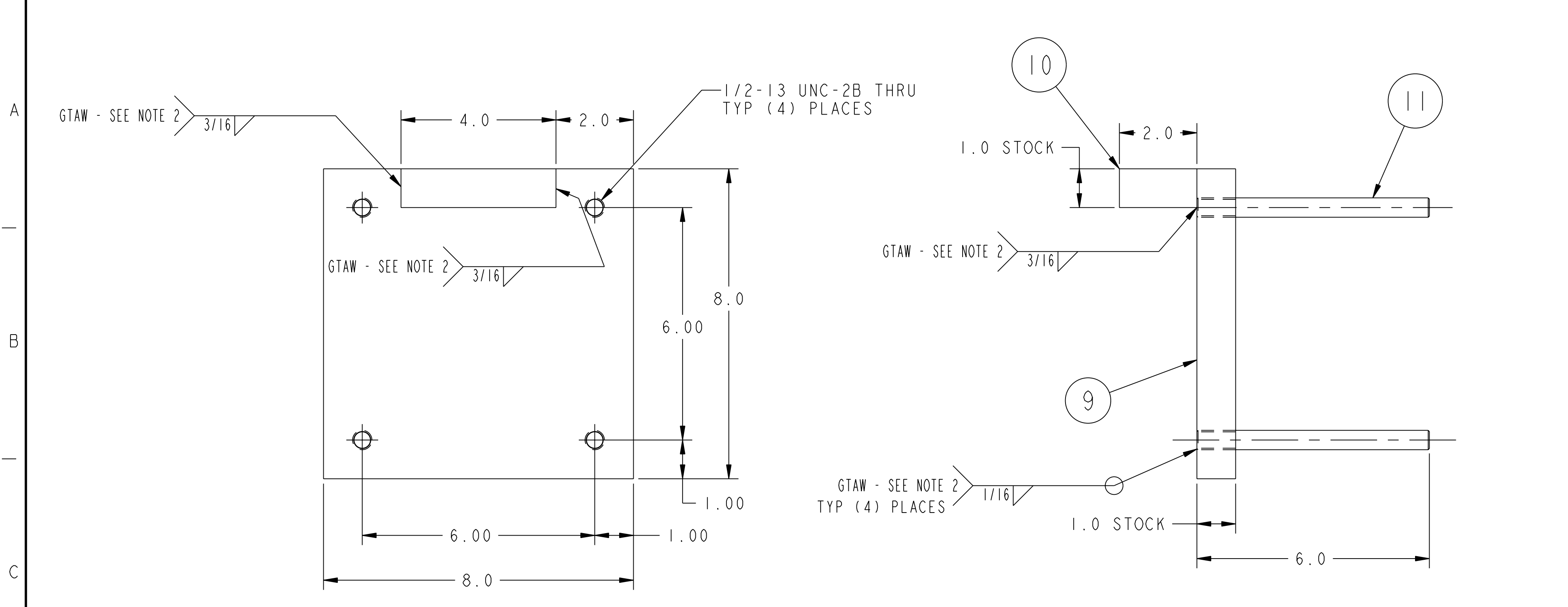
FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

RELEASE LEVEL: Fabrication  
DWG VERSION NO: 1

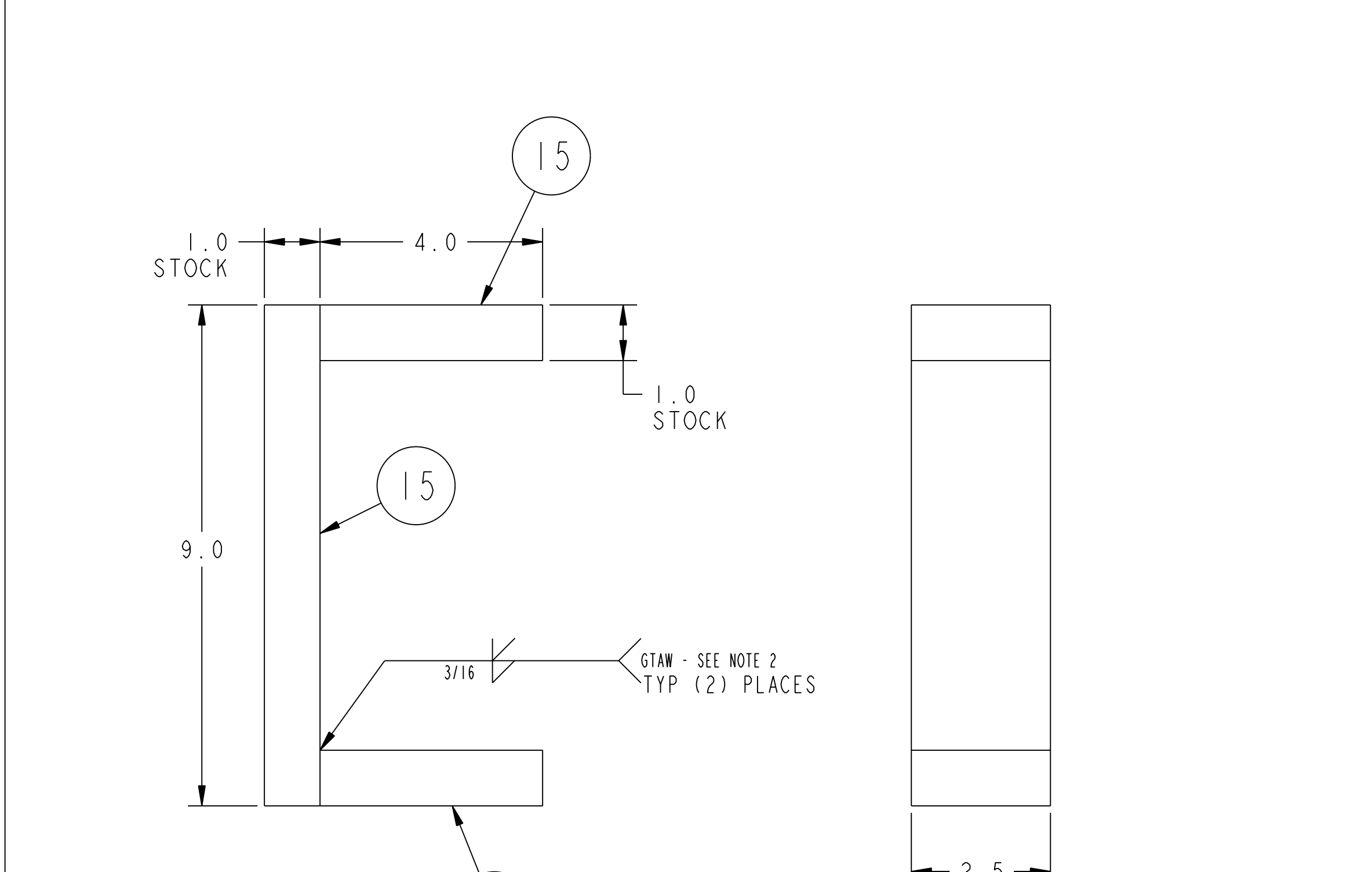
WEIGHT	1269.9 lbs
MODEL NAME	SE144-051-01
WELDING ENGINEER	

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 NATIONAL COMPACT STELLARATOR EXPERIMENT MODULAR COIL ASSEMBLY WINDING RING ASSEMBLY ASSEMBLY FIXTURE FRAME WELDMENTS AND DETAILS	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX +/- .000 .XXX +/- .005 ANGULAR +/- .05	DSN: L. MORRIS CHK: S. RAFTOPOULOS ENGR: J. CHRZANOWSKI SUPV: J. SIEGEL	9-23-04 9-23-04 9-23-04 9-23-04
NEXT ASSEMBLY		DRAWING NO: <b>SE144-051</b>	SHEET 2 OF 3 REV 0

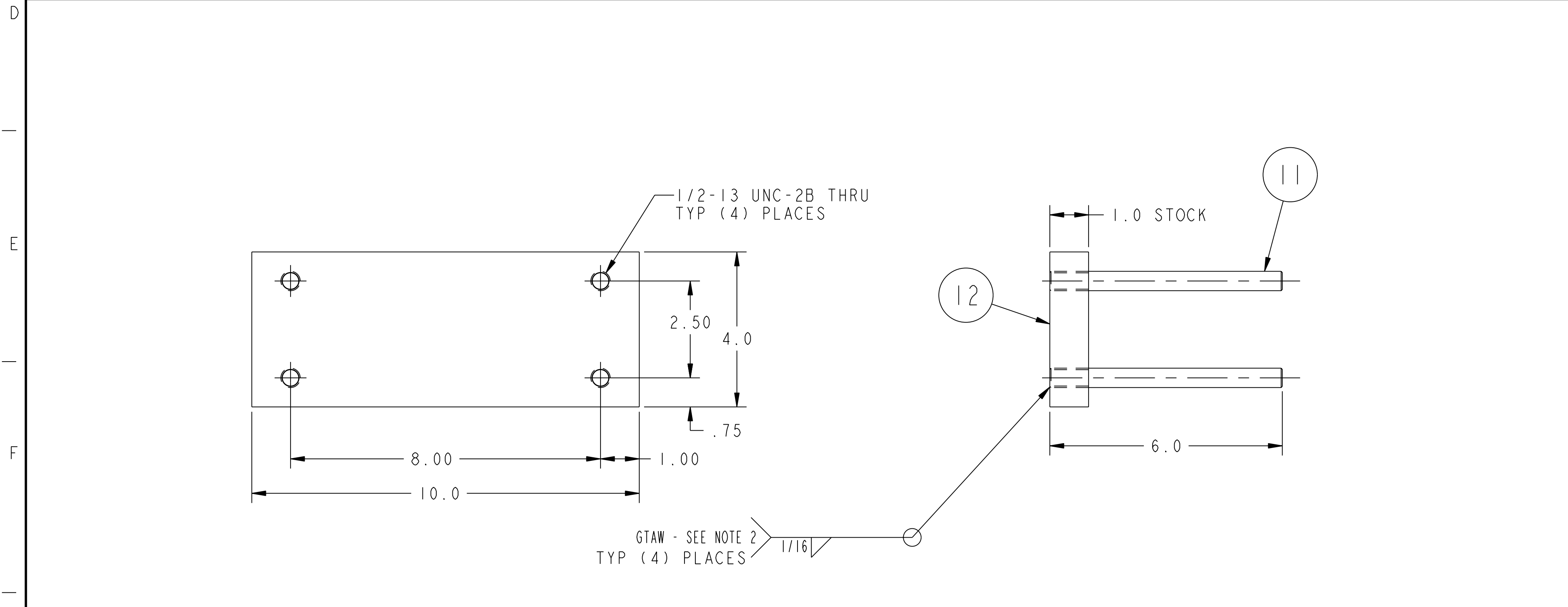
NO.	REVISION	BY	CH	SUP	APPROVED	DATE



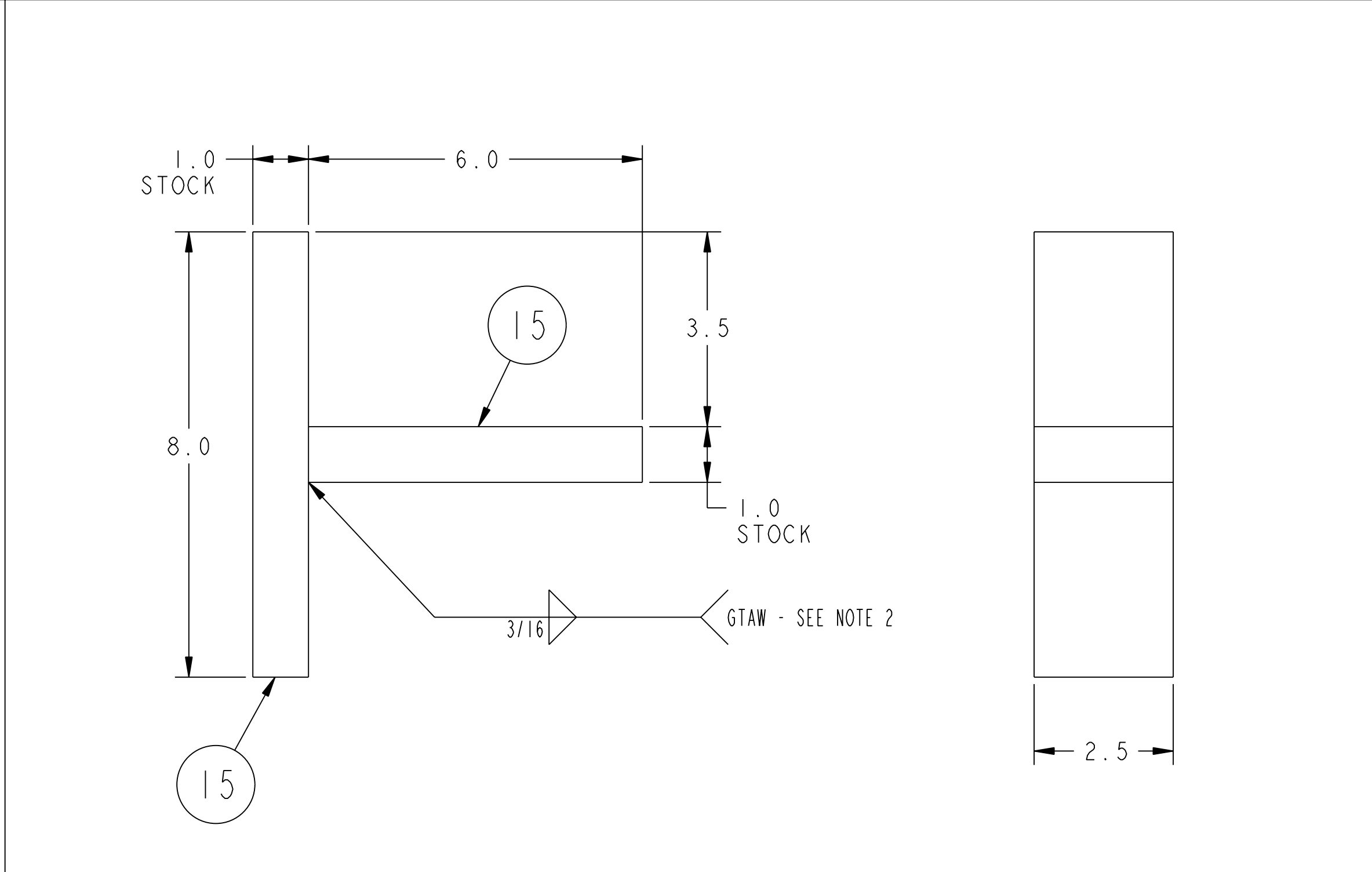
**02 ASSEMBLY SUPPORT RING ADJUSTABLE PAD - TYPE "A"**  
(2) REQ'D



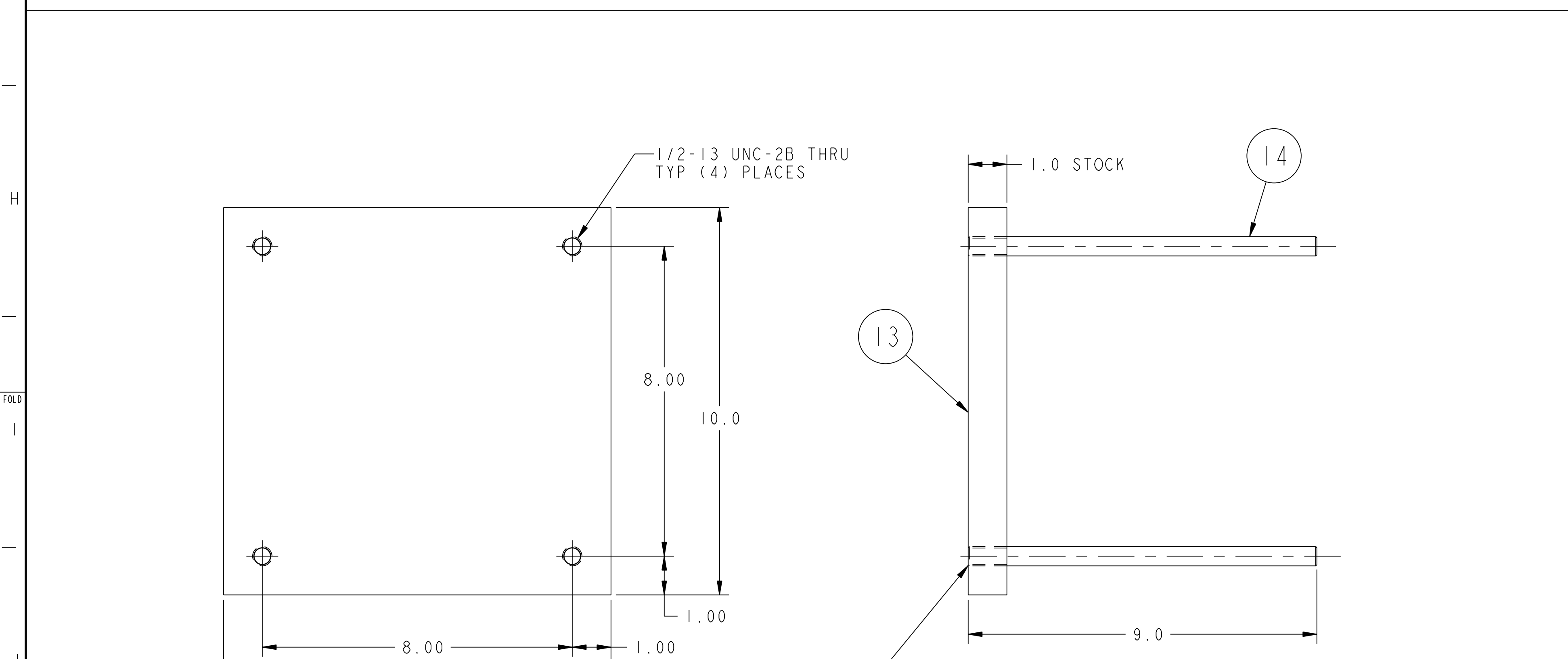
**05 ASSEMBLY "C" TYPE SPACER**  
(2) REQ'D



**03 ASSEMBLY SUPPORT RING ADJUSTABLE PAD - TYPE "B"**  
(1) REQ'D



**06 ASSEMBLY "T" TYPE SPACER**  
(2) REQ'D



**04 ASSEMBLY MODULAR COIL WINDING FORM ADJUSTABLE SUPPORT PAD**  
(4) REQ'D

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

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

**RELEASE LEVEL: Fabrication**  
**DWG VERSION NO: 1**

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES:	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY	
	UNLESS OTHERWISE SPECIFIED	<b>NATIONAL COMPACT STELLARATOR EXPERIMENT</b>	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	MODULAR COIL ASSEMBLY WINDING RING ASSEMBLY ASSEMBLY FIXTURE FRAME WELDMENTS AND DETAILS	
NEXT ASSEMBLY	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .X +/- .000 .XX +/- .005 ANGULAR +/- .015	DSN: L. MORRIS CHK: S. RAFTOPOULOS ENGR: J. CHRZANOWSKI SUPV: J. SIEGEL	9-23-04 9-23-04 9-23-04 9-23-04
WEIGHT 11.9 lbs	MODEL NAME SEI44-051-05	DRAWING NO: <b>SEI44-051</b>	
WELDING ENGINEER R. PARSELLS 9-23-04	SHEET 3 OF 3 REV 0		