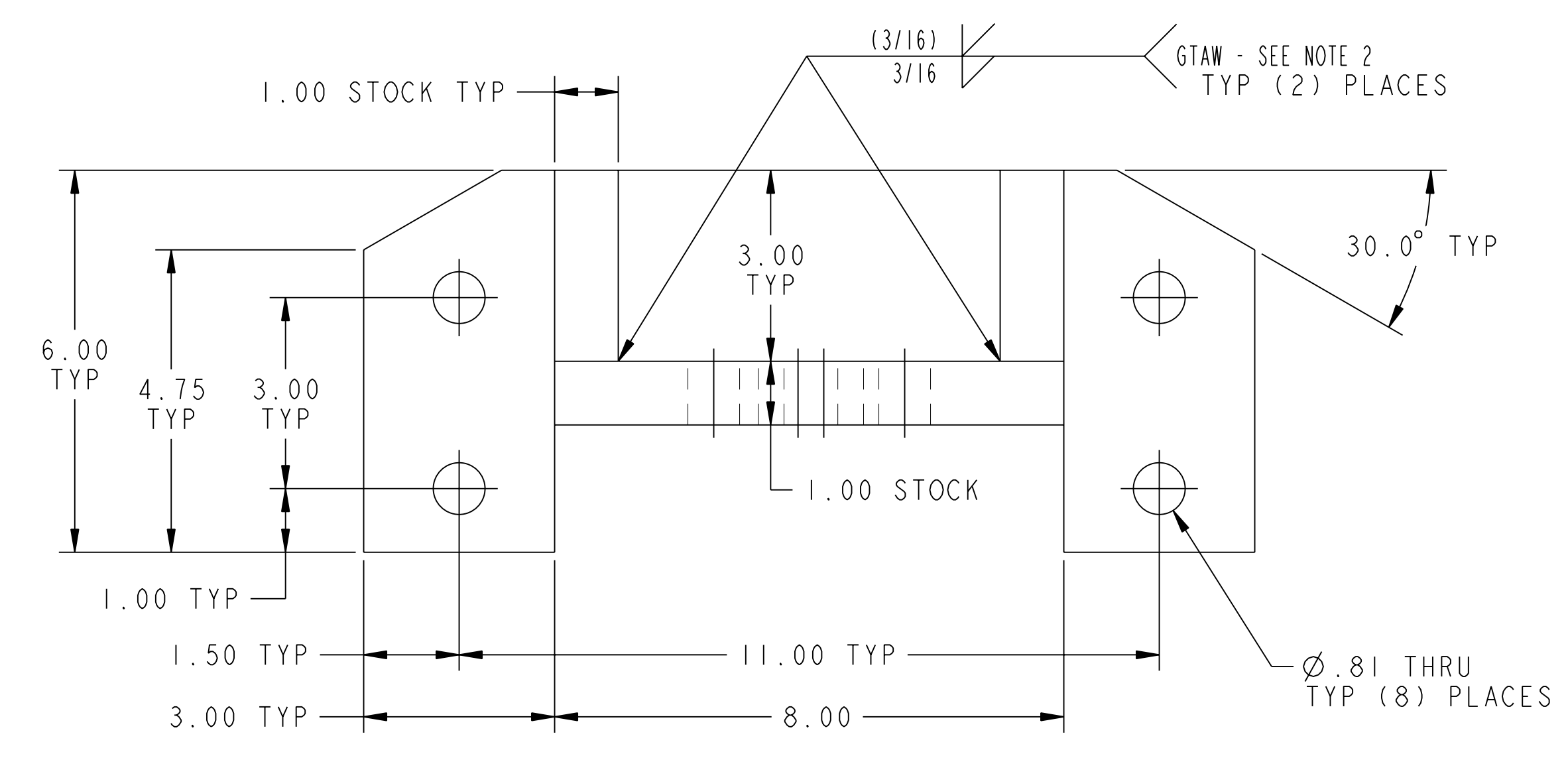
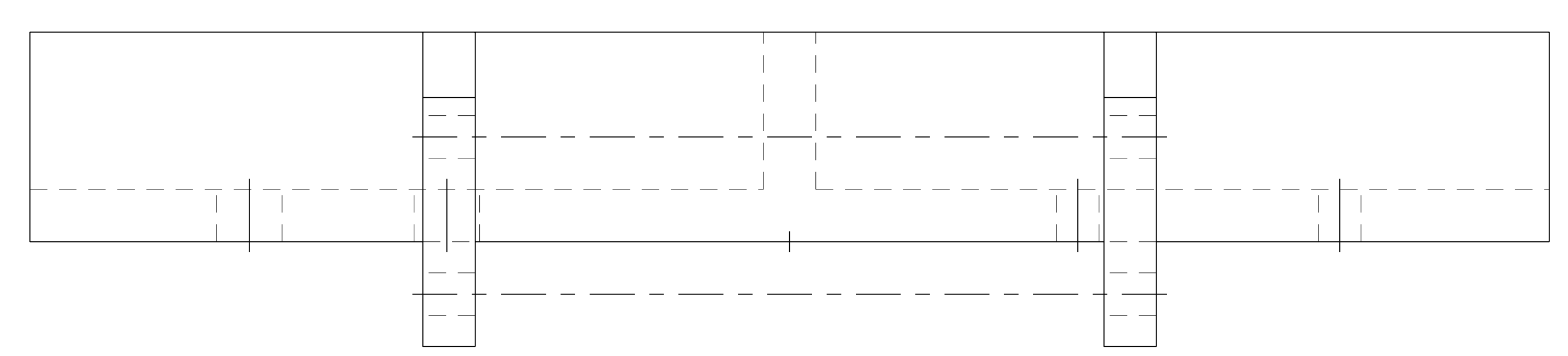


- NOTES**
- ALL PARTS OF THESE WELDMENTS TO BE FABRICATED USING 1" THICK PLATE ASTM A36 CUT TO SUIT.
  - WELDING SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF AWS D1.1 AND/OR PPPL PROCEDURE EM-002. VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH THE ACCEPTANCE CRITERIA OF AWS D1.1 Section 6.
  - ALL HOLES TO BE MACHINED AFTER ALL WELDING IS COMPLETE.



- 01 ASSEMBLY SUPPORT BRACKET WELDMENT - TYPE "A" (AS SHOWN)
- 02 ASSEMBLY SUPPORT BRACKET WELDMENT - TYPE "B" (OPPOSITE)

A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	I	THIS DWG	1" THICK PLATE STOCK - SEE NOTE 1	ASTM A36	A/R
											---	THIS DWG	SUPPORT BRACKET WELDMENT - TYPE "K"		6
											---	THIS DWG	SUPPORT BRACKET WELDMENT - TYPE "J"		6
											---	THIS DWG	SUPPORT BRACKET WELDMENT - TYPE "H"		6
											---	THIS DWG	SUPPORT BRACKET WELDMENT - TYPE "G"		6
											---	THIS DWG	SUPPORT BRACKET WELDMENT - TYPE "F"		6
											---	THIS DWG	SUPPORT BRACKET WELDMENT - TYPE "E"		6
											---	THIS DWG	SUPPORT BRACKET WELDMENT - TYPE "D"		6
											---	THIS DWG	SUPPORT BRACKET WELDMENT - TYPE "C"		6
											---	THIS DWG	SUPPORT BRACKET WELDMENT - TYPE "B"		6
											---	THIS DWG	SUPPORT BRACKET WELDMENT - TYPE "A"		6

PARTS LIST		DRAWING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY RECD										
010	09	08	07	06	05	04	03	02	01	PART NO.					
ASSY	ASSY	ASSY	ASSY	ASSY	ASSY	ASSY	ASSY	ASSY	ASSY						

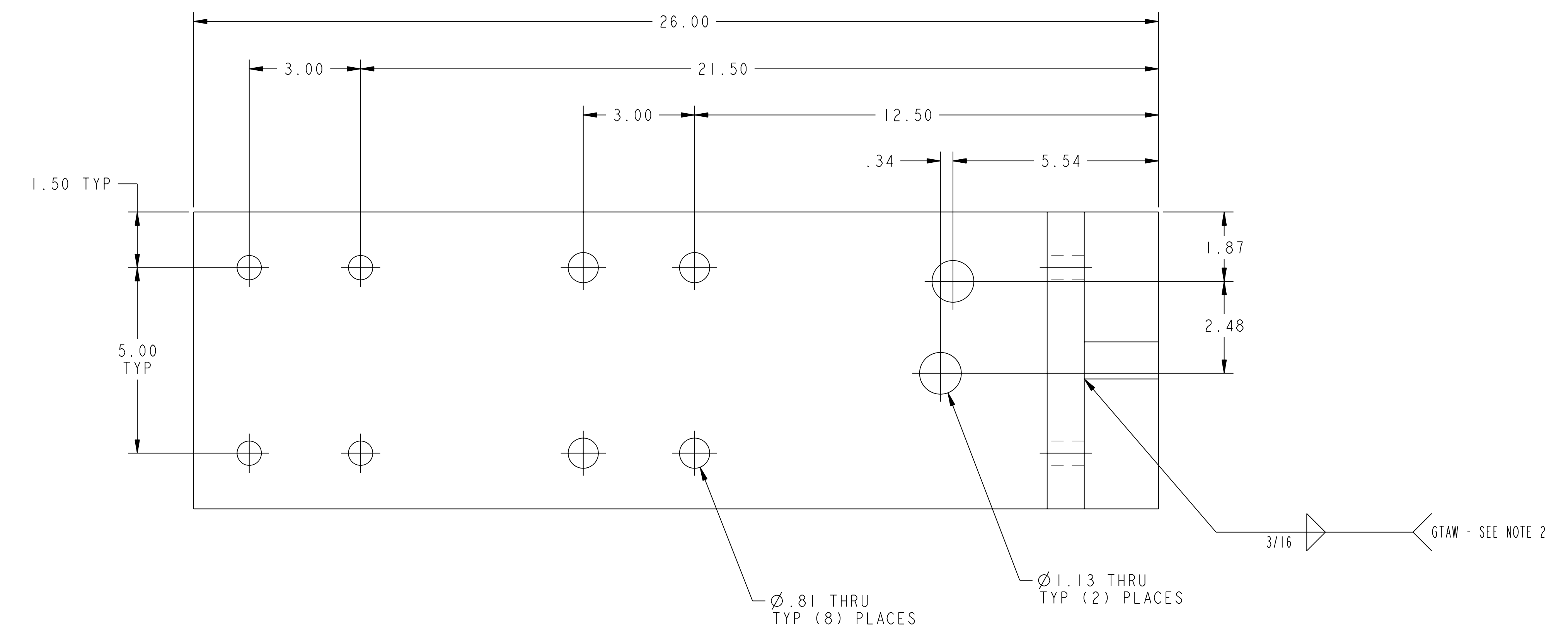
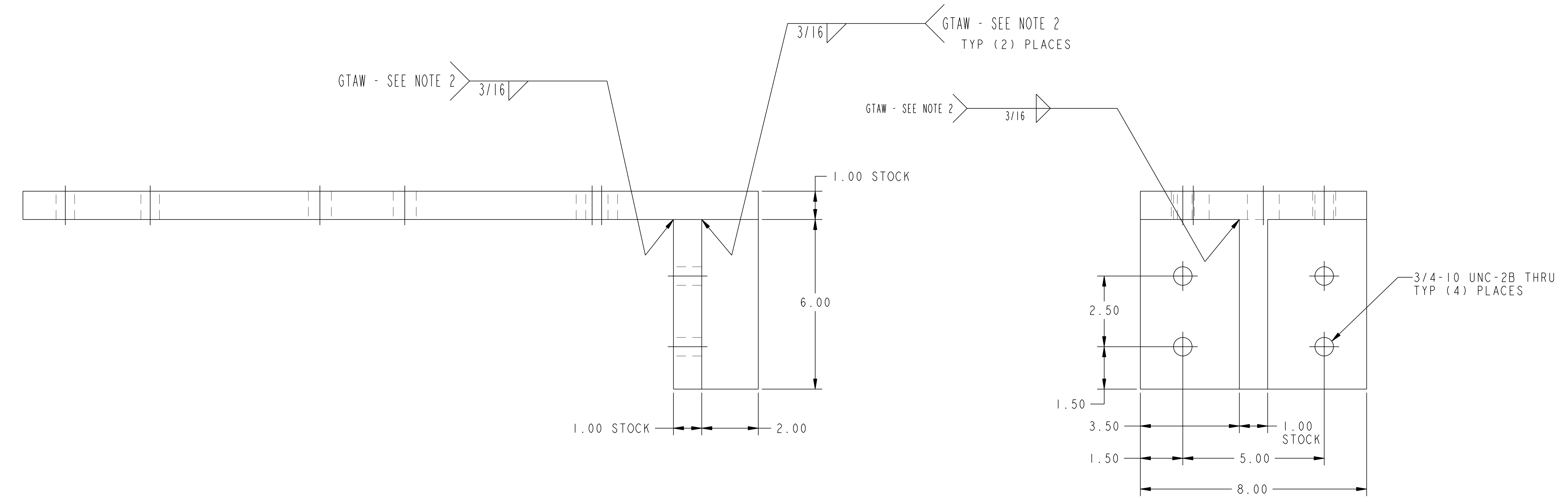
COMPUTER GENERATED DRAWING CHANGES NOT PERMITTED	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY	
Pro E	DIMENSIONS ARE IN INCHES MACHINE SURFACES	NATIONAL COMPACT STELLARATOR EXPERIMENT	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	BREAK SHARP EDGES .005/.020	MODULAR COIL ASSEMBLY WINDING RING ASSEMBLY	
	TOLERANCES NON-CUMULATIVE	TYPE "B" WINDING FORM SUPPORT BRACKET WELDMENTS	
	DECIMAL-INCH FRACTIONS	DSN: L. MORRIS 8-30-04	DRAWING NO:
	XXX +/- .005 12" - 120" +/- .125 ANGLAR +/- 0° - 15° OVER 120" +/- .125	CHK: S. RAFTOPOULOS 8-30-04	SEI44-056
		ENGR: J. CHRZANOWSKI 8-30-04	SHEET 1 OF 6
		SUPV: J. SIEGEL 8-30-04	REV 0

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

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

WEIGHT  
 134.9 lbs  
 MODEL NAME  
 SEI44-056-01  
 WELDING ENGINEER  
 R. PARSELLS 8-30-04

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



- 03 ASSEMBLY SUPPORT BRACKET WELDMENT - TYPE "C" (AS SHOWN)
- 04 ASSEMBLY SUPPORT BRACKET WELDMENT - TYPE "D" (OPPOSITE)

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

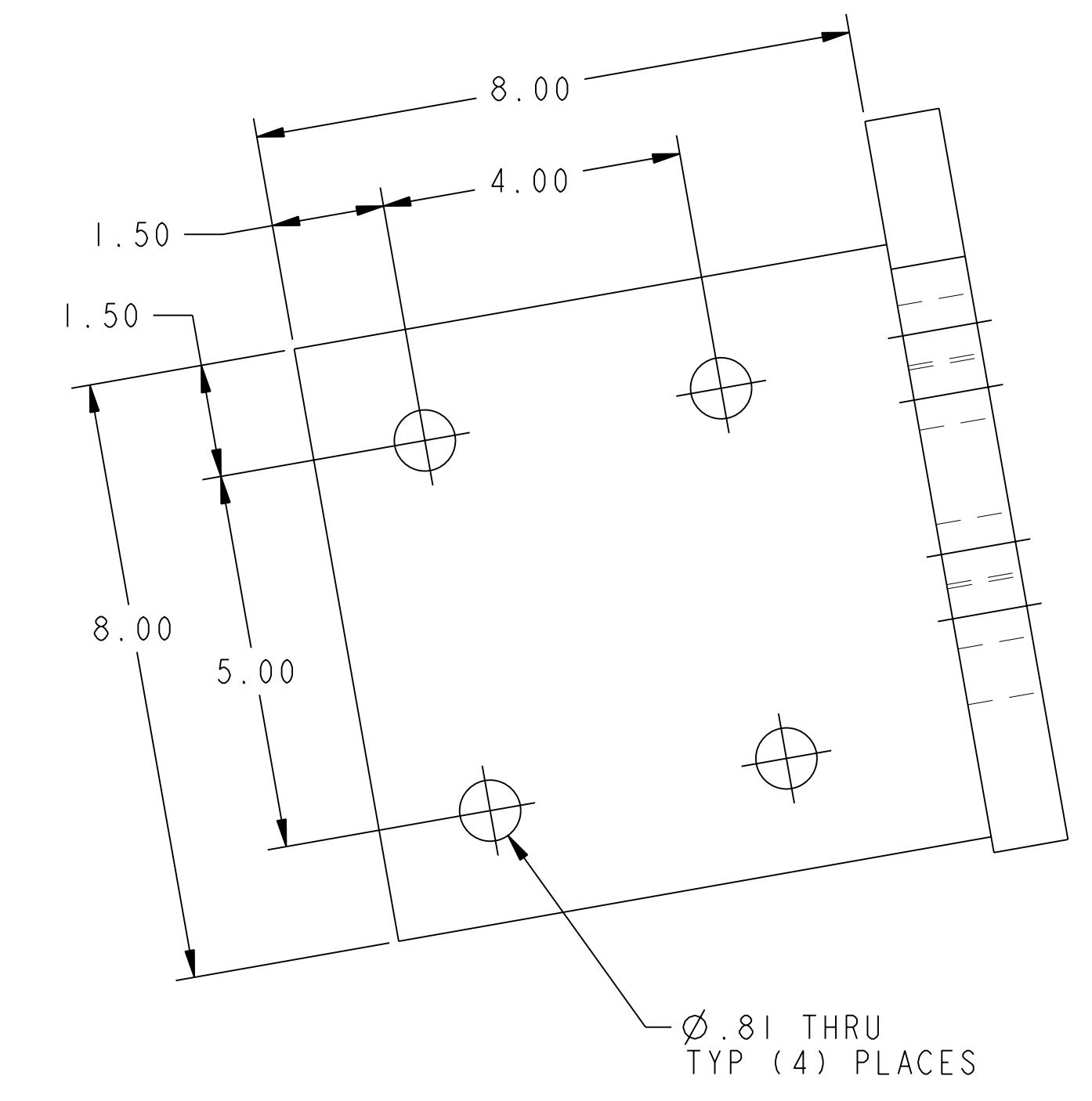
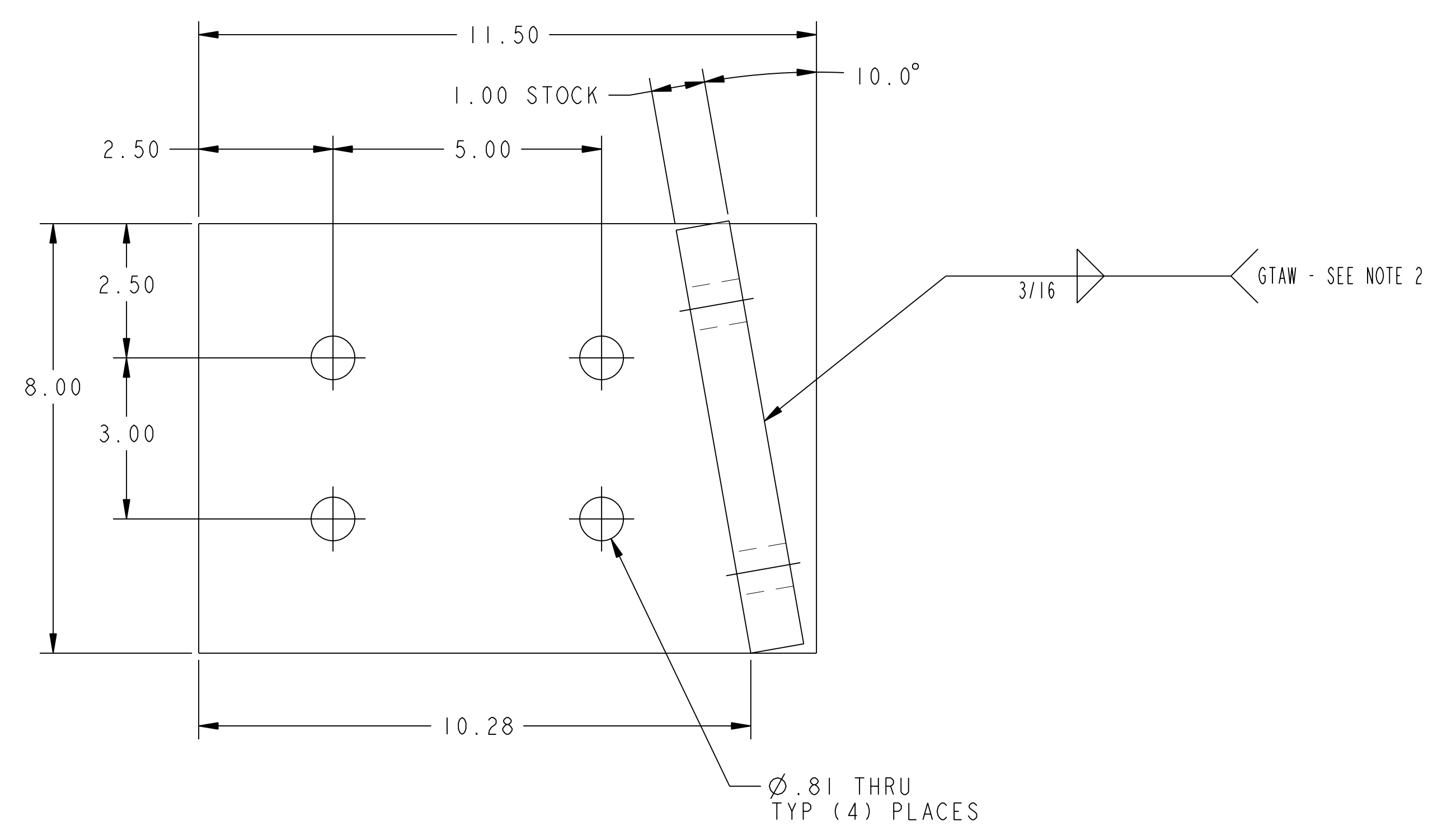
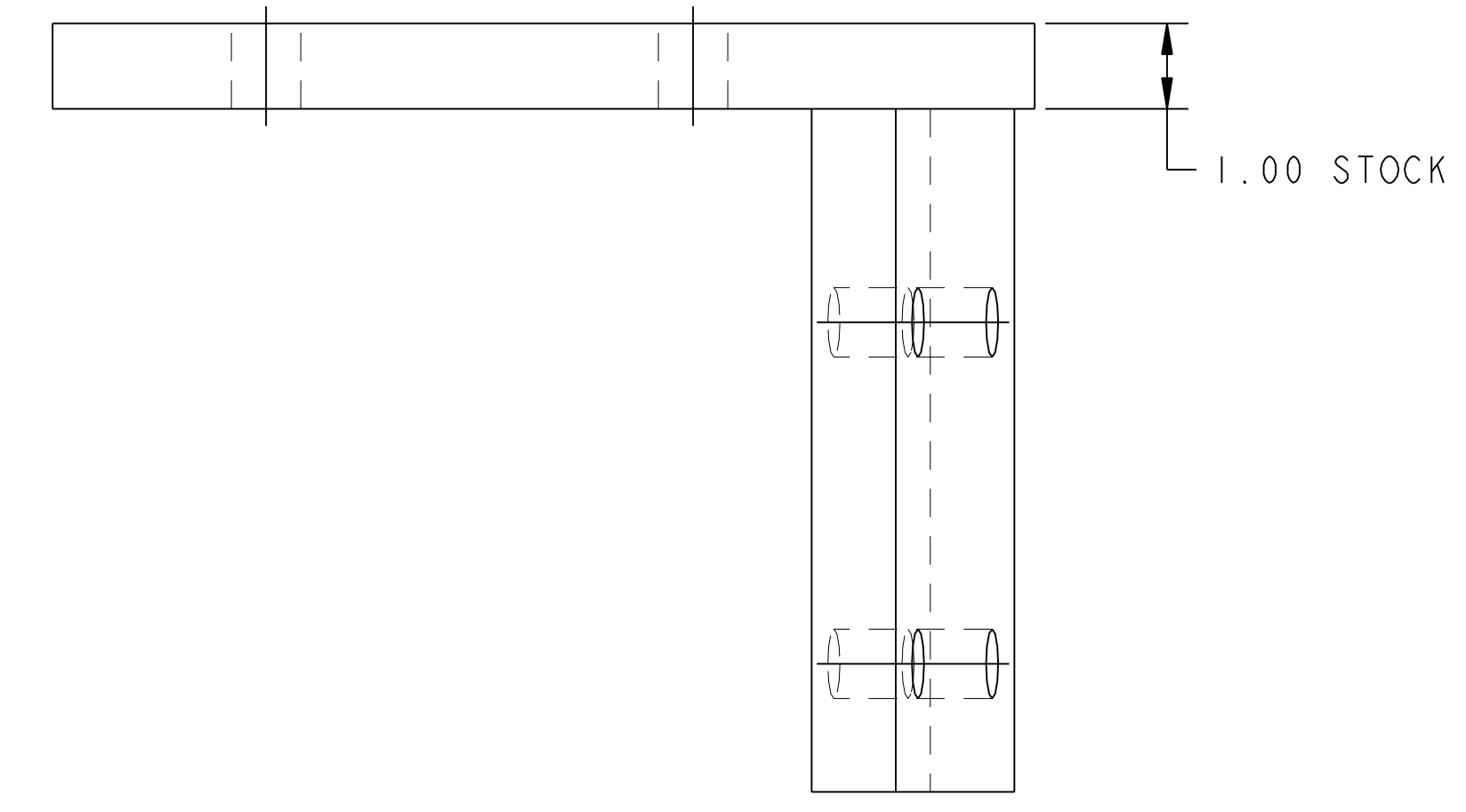
FOR BILL OF MATERIAL AND NOTES SEE SHEET 1

**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 TYPE "B" WINDING FORM SUPPORT BRACKET WELDMENTS			
NEXT ASSEMBLY	TOLERANCES NON-CUMULATIVE	DSN: L. MORRIS	8-30-04	DRAWING NO:	
	DECIMAL-INCH FRACTIONS	CHK: S. RAFTOPOULOS	8-30-04	<b>SE144-056</b>	
WELDING ENGINEER: R. PARSELLS 8-30-04	.XX +/- .100 0°-12° +/- .100 .XX +/- .030 12°-12° +/- .100 .XX +/- .005 12°-120° +/- .100 ANGULAR +/- .0°-15° OVER 120° +/- .100	ENGR: J. CHRZANOWSKI	8-30-04	SHEET 2 OF 6	REV 0
		SUPV: J. SIEGEL	8-30-04		

NCSX-SE144-056

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



05 ASSEMBLY SUPPORT BRACKET WELDMENT - TYPE "E" (AS SHOWN)  
06 ASSEMBLY SUPPORT BRACKET WELDMENT - TYPE "F" (OPPOSITE)

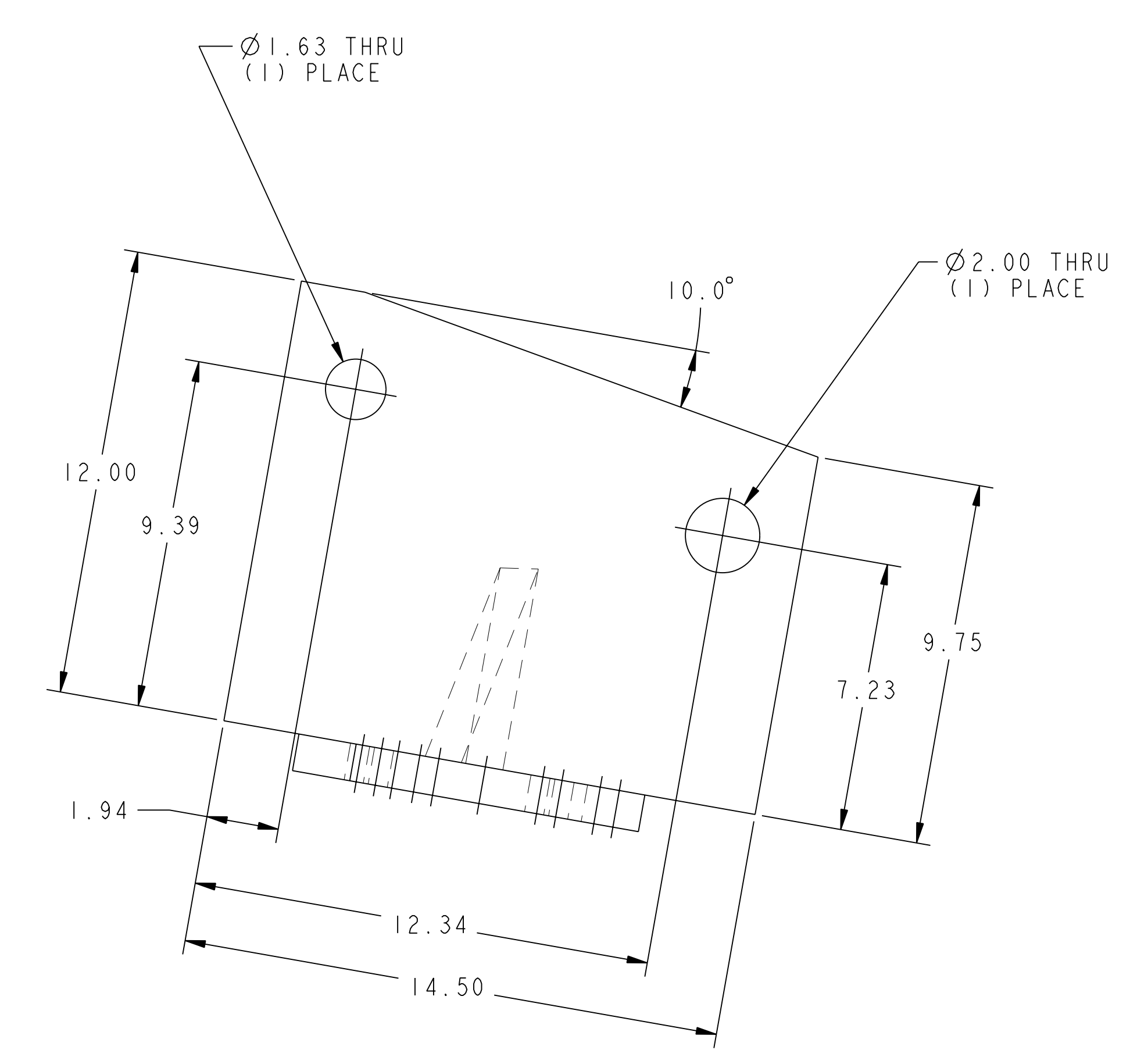
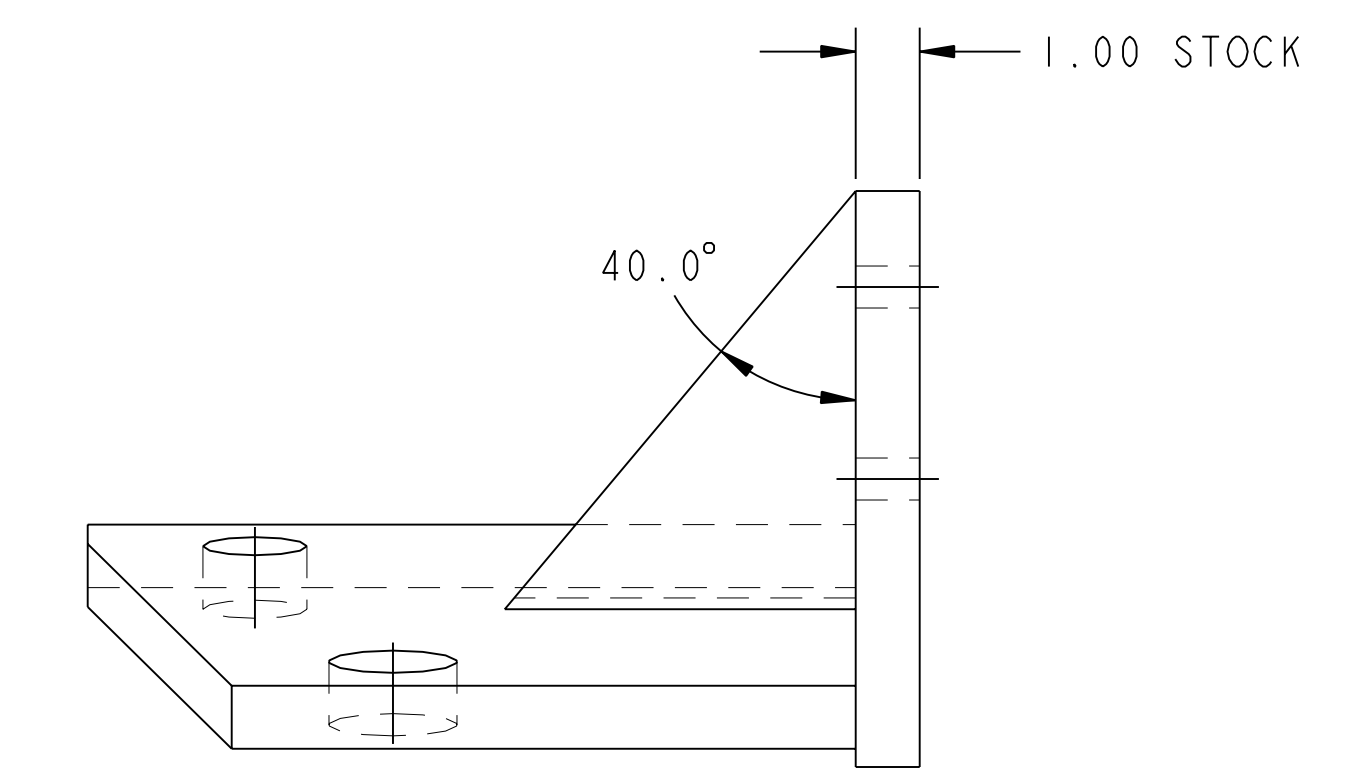
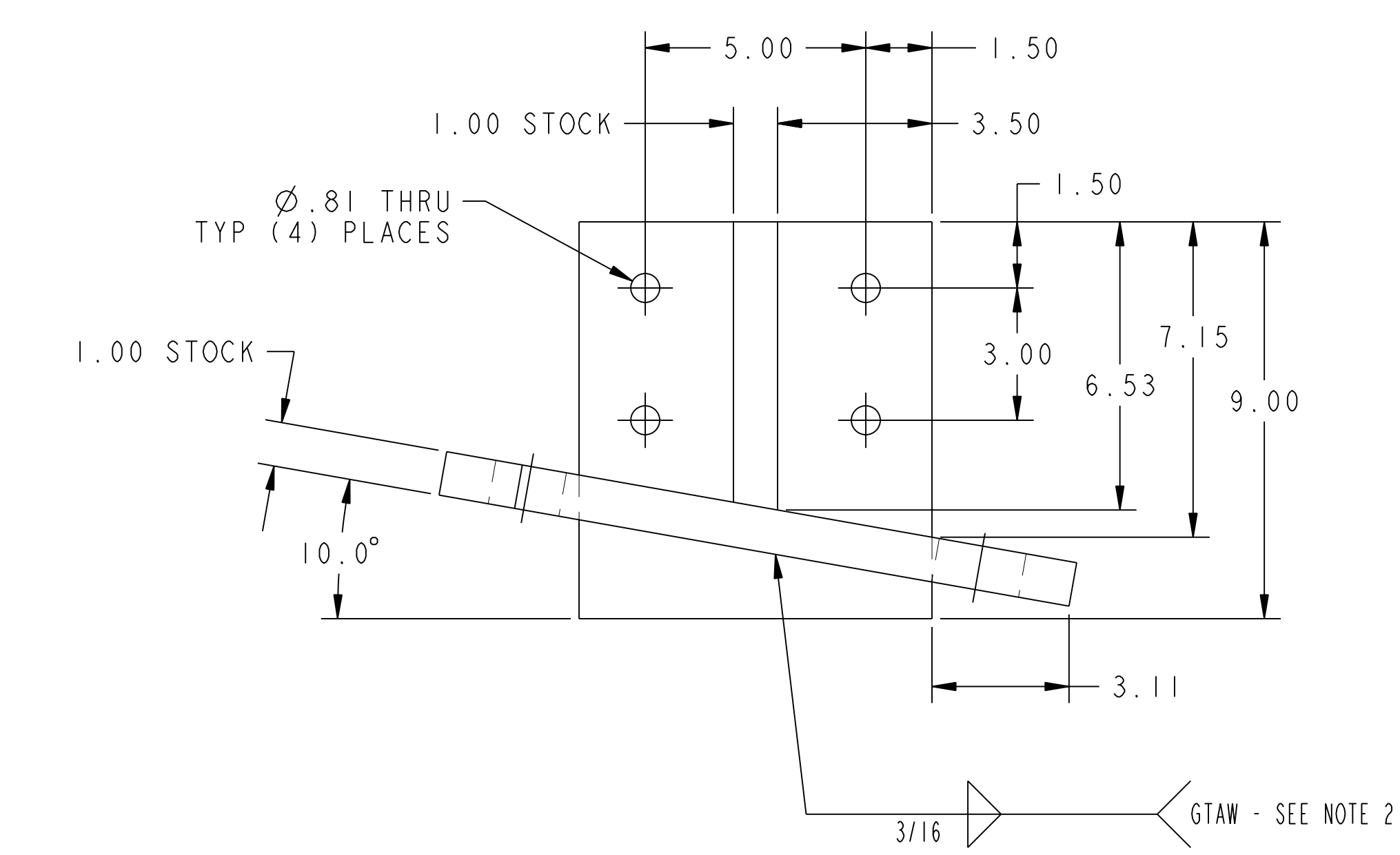
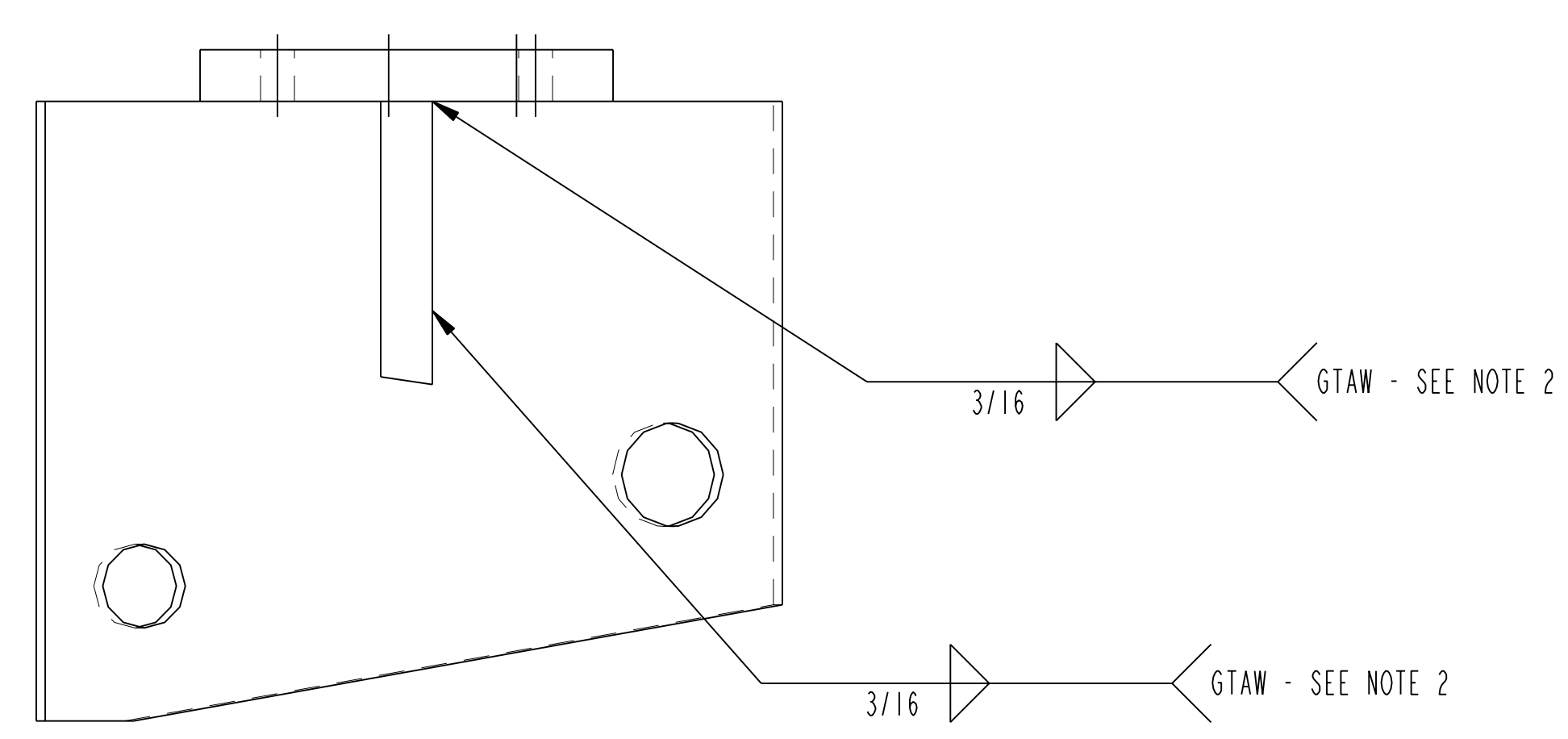
**RELEASED FOR  
FABRICATION / INSTALLATION**  
PPPL Drafting:

FOR BILL OF MATERIAL AND NOTES SEE SHEET 1

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

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pr o E	CENTRAL FILES:	PRINCETON PLASMA PHYSICS LABORATORY NATIONAL COMPACT STELLARATOR EXPERIMENT	
	UNLESS OTHERWISE SPECIFIED	MODULAR COIL ASSEMBLY WINDING RING ASSEMBLY TYPE "B" WINDING FORM SUPPORT BRACKET WELDMENTS	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	DIMENSIONS ARE IN INCHES MACHINE SURFACES	BREAK SHARP EDGES .005/.020	DSN: L. MORRIS 8-30-04 DRAWING NO:
NEXT ASSEMBLY	TOLERANCES NON-CUMULATIVE	DECIMAL-INCH FRACTIONS	CHK: S. RAFTOPOULOS 8-30-04
WEIGHT 42.5 lbs	MODEL NAME SEI44-056-05	.XX +/- .030 12°-12° +/- .110	ENGR: J. CHRZANOWSKI 8-30-04
WELDING ENGINEER R. PARSELLS 8-30-04	WELDING ENGINEER R. PARSELLS 8-30-04	.XXX +/- .005 72°-120° +/- .114 ANGULAR +/- .0°-15° OVER 120° +/- .112	SUPV: J. SIEGEL 8-30-04
		SHEET 3 OF 6 REV 0	

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



07 ASSEMBLY SUPPORT BRACKET WELDMENT - TYPE "G"

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

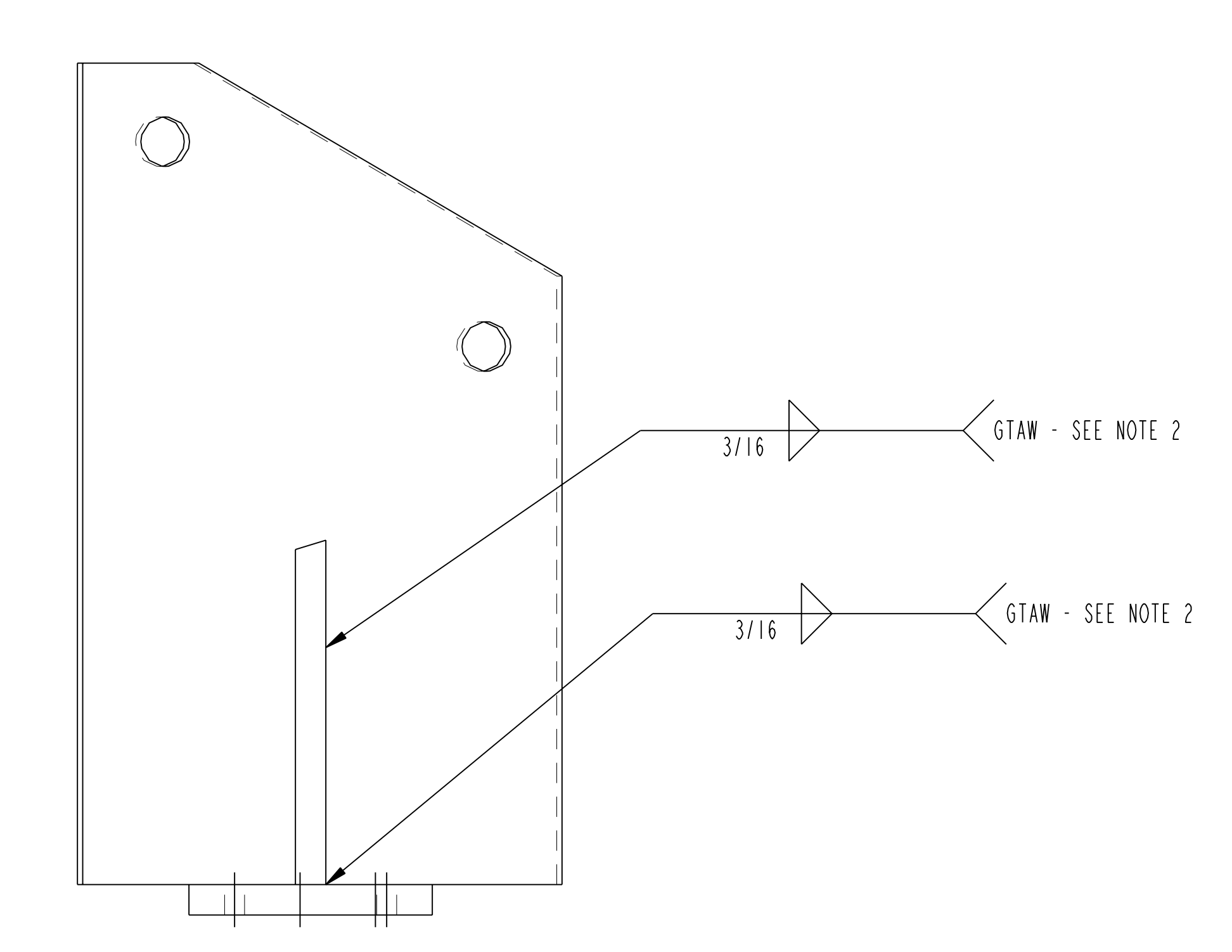
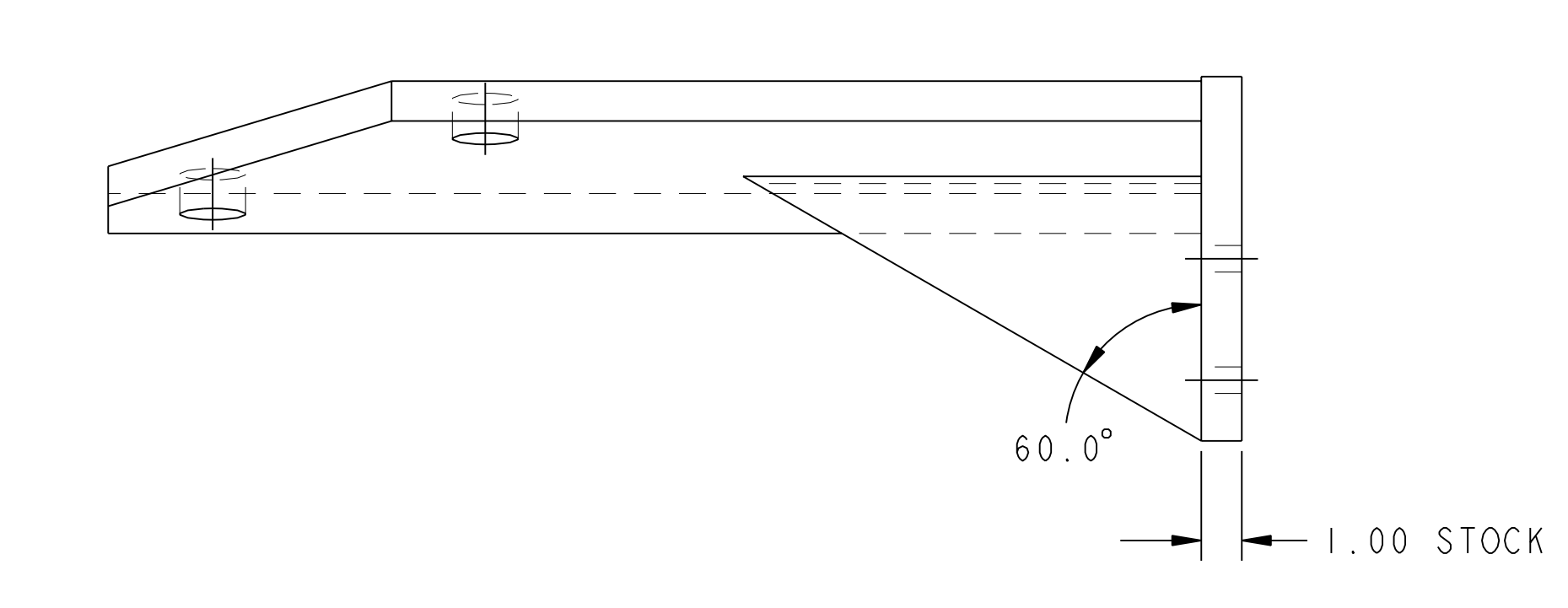
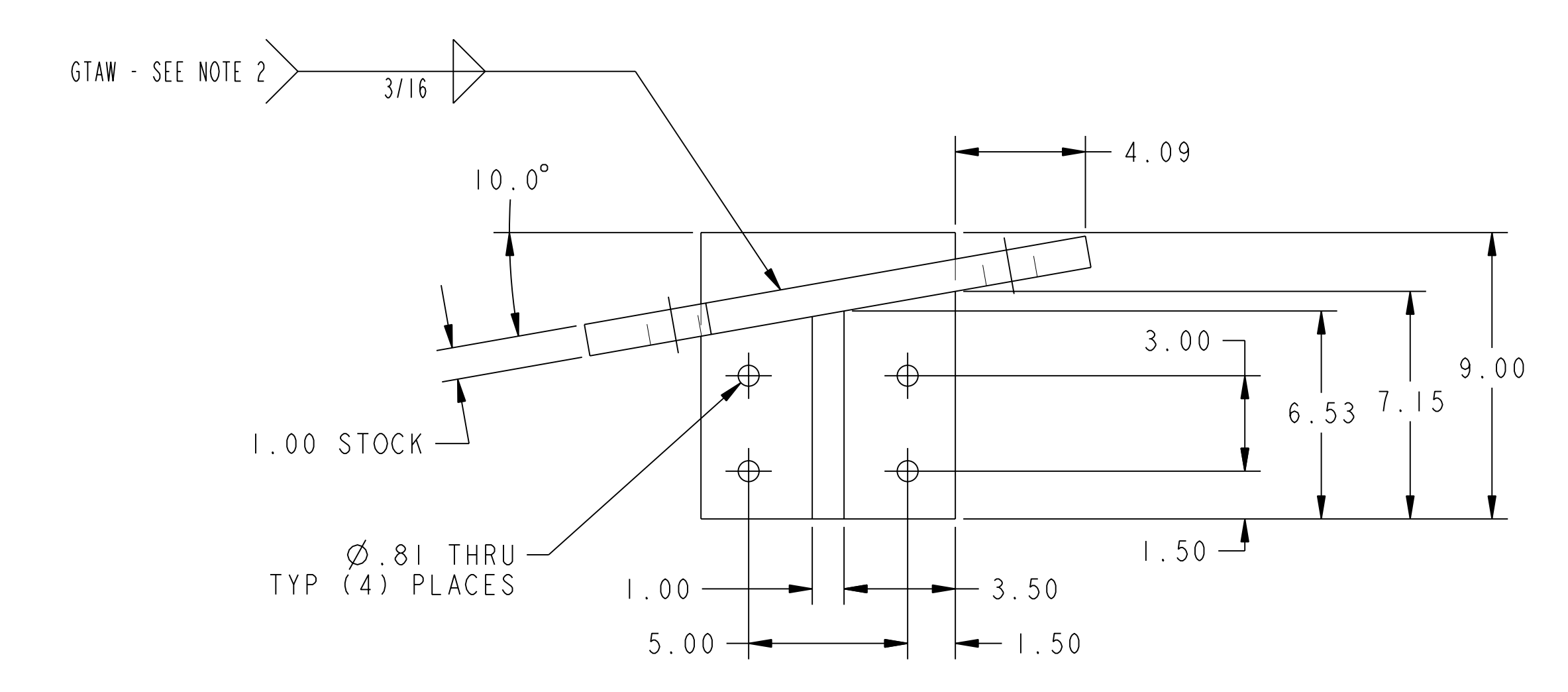
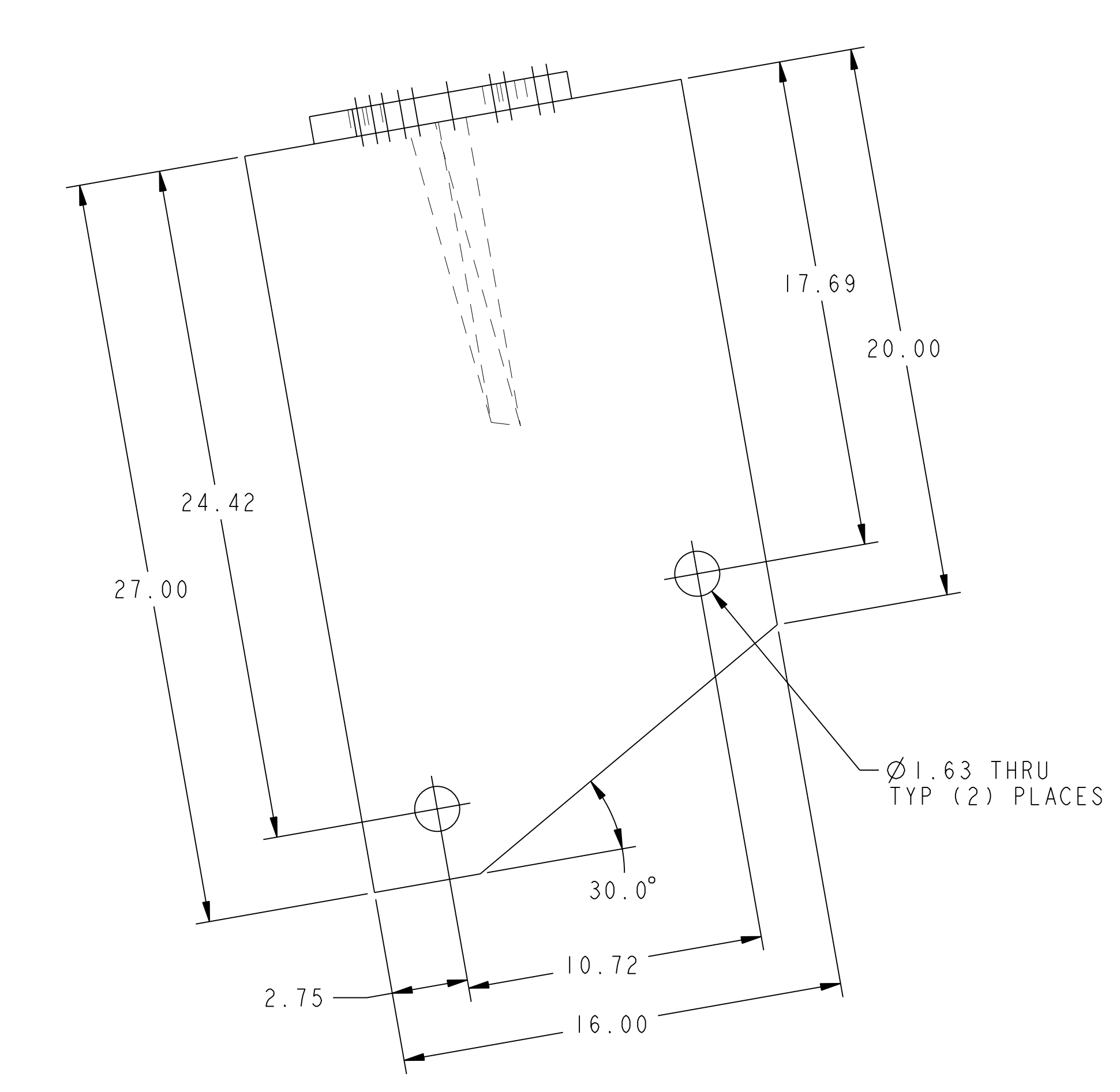
FOR BILL OF MATERIAL AND NOTES SEE SHEET 1

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

WEIGHT  
67.9 lbs  
MODEL NAME  
SEI44-056-07  
WELDING ENGINEER  
R. PARSELLS 8-30-04

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY <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 TYPE "B" WINDING FORM SUPPORT BRACKET WELDMENTS			
NEXT ASSEMBLY	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX ±.000 .XXX ±.005 ANGULAR ±.0°-15°	DSN: L. MORRIS	8-30-04	DRAWING NO: <b>SEI44-056</b>	
		CHK: S. RAFTOPOULOS	8-30-04		
		ENGR: J. CHRZANOWSKI	8-30-04		
		SUPV: J. SIEGEL	8-30-04	SHEET 4 OF 6	REV 0

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



**RELEASED FOR  
FABRICATION / INSTALLATION**

PPPL Drafting:

08 ASSEMBLY SUPPORT BRACKET WELDMENT - TYPE "H"

FOR BILL OF MATERIAL AND NOTES SEE SHEET 1

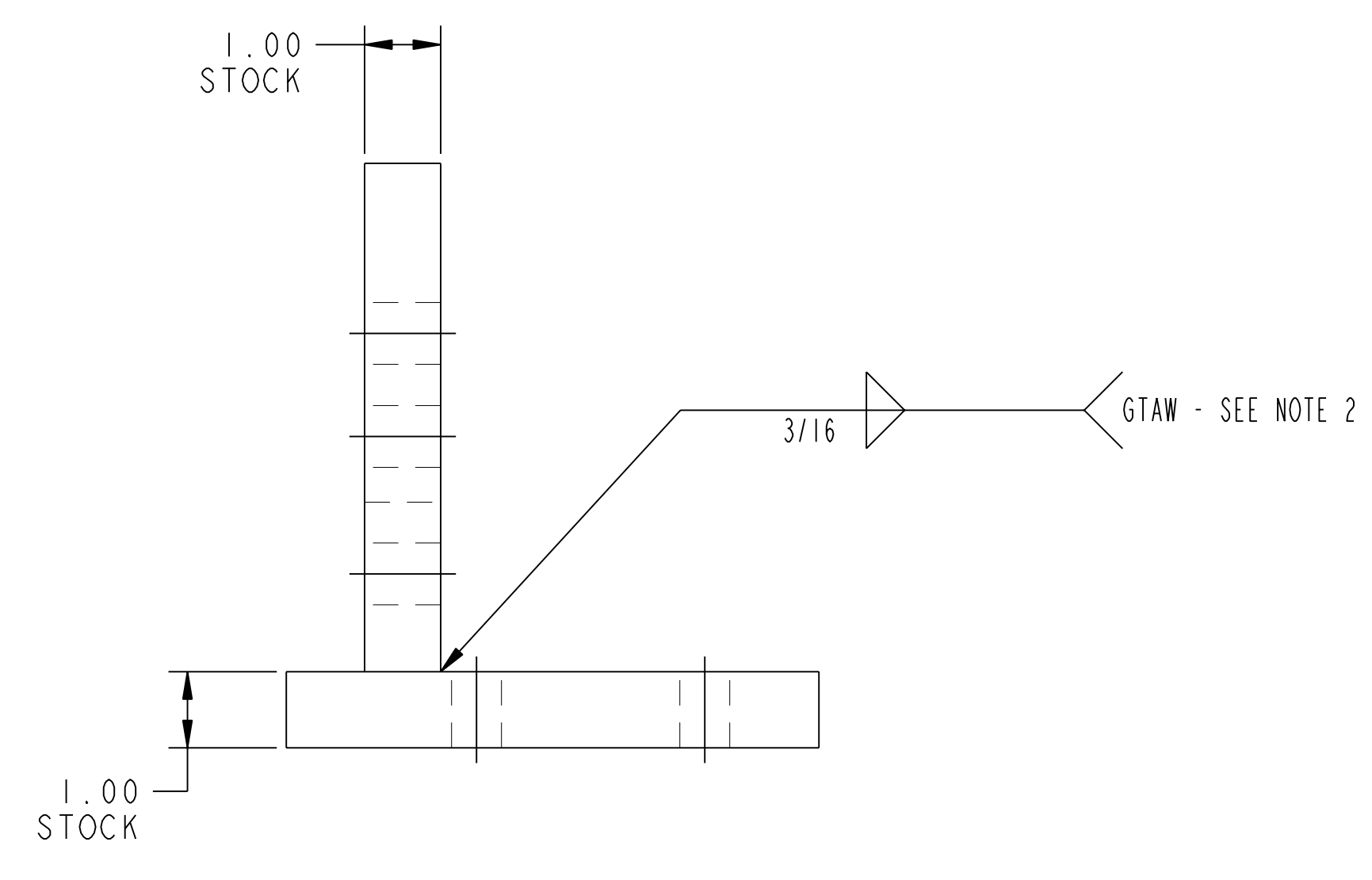
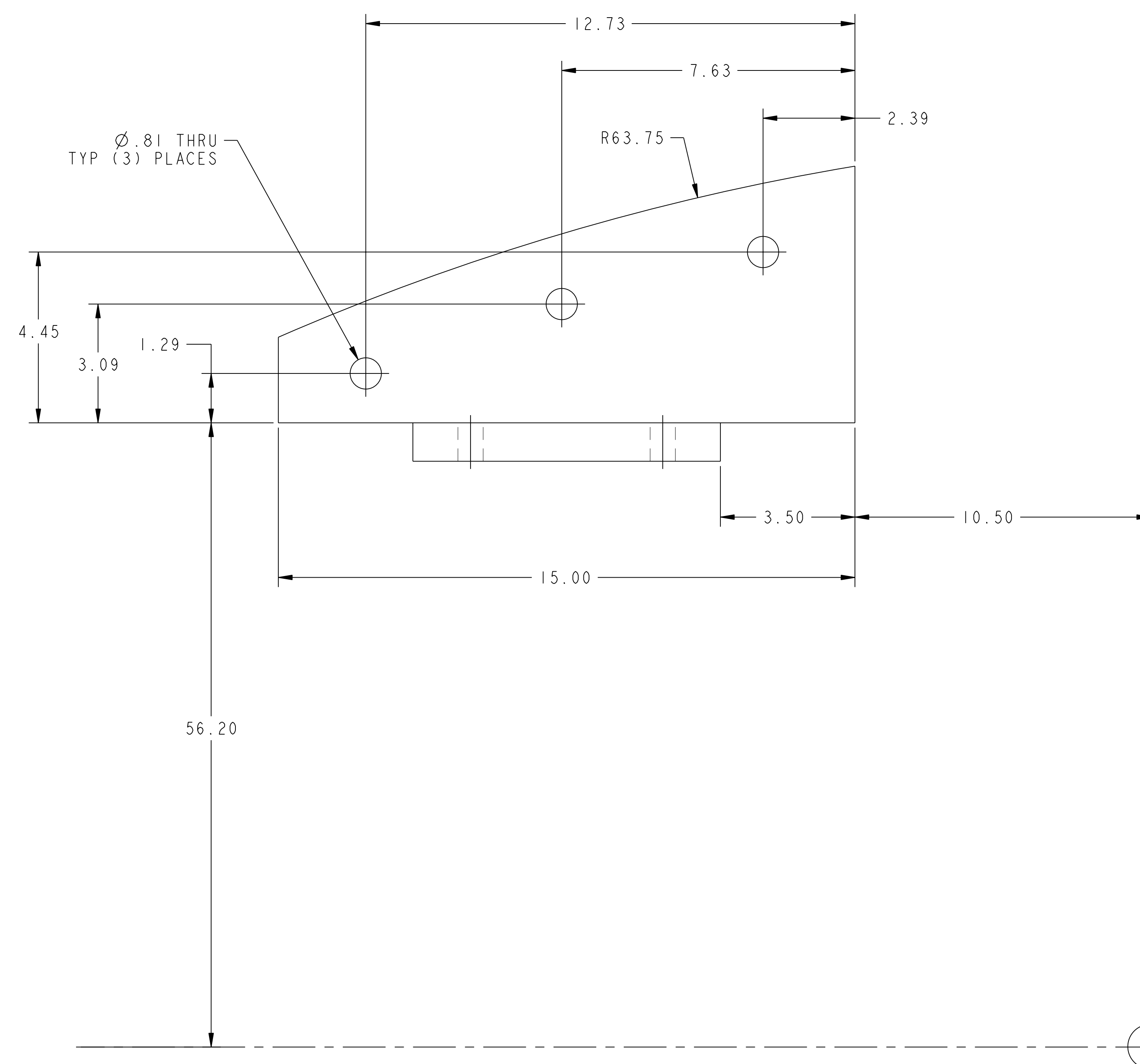
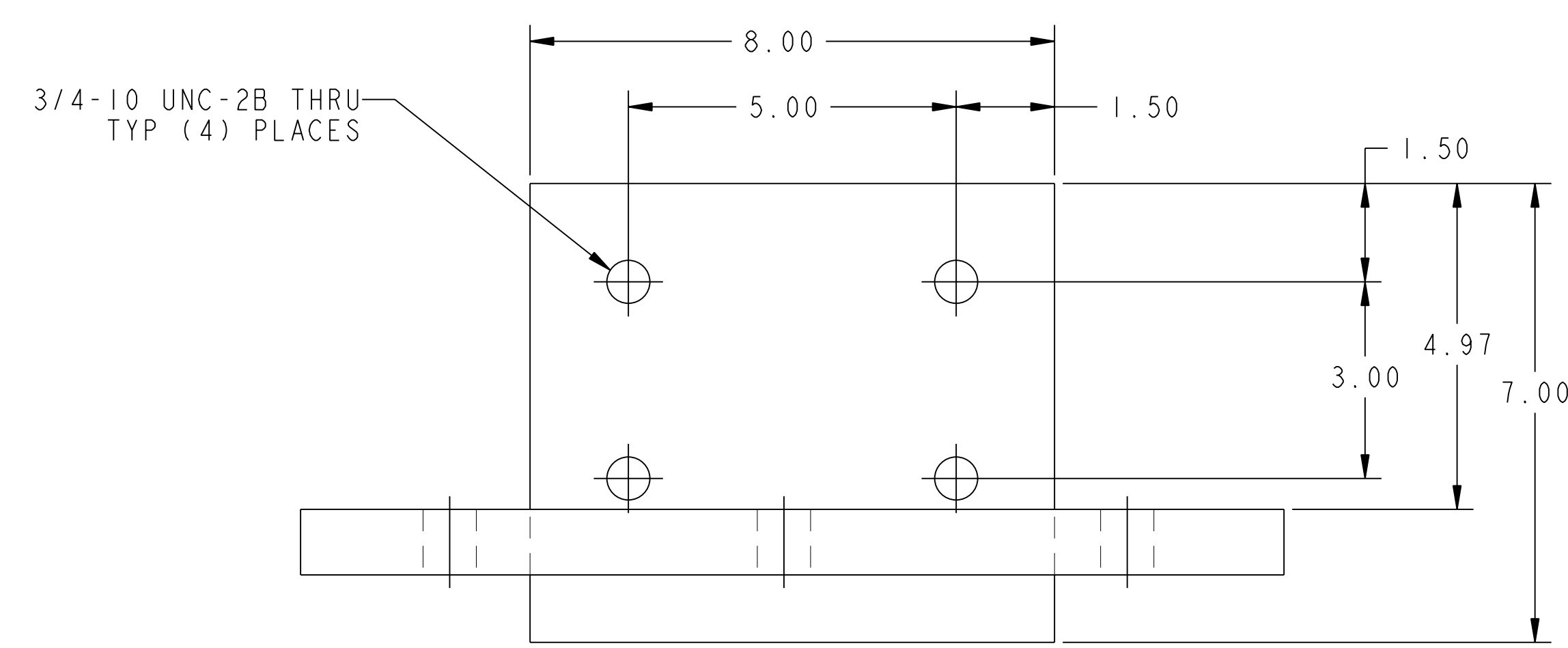
**RELEASE LEVEL: Fabrication**  
**DWG VERSION NO: 1**

WEIGHT	124.9 lbs
MODEL NAME	SE144-056-10
WELDING ENGINEER	R. PARSELLS 8-30-04

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY NATIONAL COMPACT STELLARATOR EXPERIMENT	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	MODULAR COIL ASSEMBLY WINDING RING ASSEMBLY TYPE "B" WINDING FORM SUPPORT BRACKET WELDMENTS	
NEXT ASSEMBLY	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX ±.000 .XXX ±.005 ANGULAR ±.0°-15°	DSN: L. MORRIS 8-30-04	DRAWING NO: <b>SE144-056</b>
		CHK: S. RAFTOPOULOS 8-30-04	ENGR: J. CHRZANOWSKI 8-30-04
		SUPV: J. SIEGEL 8-30-04	SHEET 5 OF 6 REV 0

NCSX-SE144-056

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



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FABRICATION / INSTALLATION**  
PPPL Drafting:

09 ASSEMBLY SUPPORT BRACKET WELDMENT - TYPE "J" (AS SHOWN)

010 ASSEMBLY SUPPORT BRACKET WELDMENT - TYPE "K" (OPPOSITE)

FOR BILL OF MATERIAL AND NOTES SEE SHEET 1

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES:	PRINCETON PLASMA PHYSICS LABORATORY NATIONAL COMPACT STELLARATOR EXPERIMENT			
	UNLESS OTHERWISE SPECIFIED	MODULAR COIL ASSEMBLY WINDING RING ASSEMBLY TYPE "B" WINDING FORM SUPPORT BRACKET WELDMENTS			
DO NOT VERIFY INFORMATION BY SCALING DRAWING	DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/ .020	DSN: L. MORRIS	8-30-04	DRAWING NO:	
TOLERANCES NON-CUMULATIVE	DECIMAL-INCH FRACTIONS	CHK: S. RAFTOPOULOS	8-30-04	SE144-056	
NEXT ASSEMBLY	.XX +/- .000 0°-12° +/- .010 .XX +/- .000 12°-12° +/- .010 .XX +/- .005 12°-120° +/- .010 ANGULAR +/- .0°-15° OVER 120° +/- .120	ENGR: J. CHRZANOWSKI	8-30-04	REV 0	
WEIGHT	124.9 lbs	SUPV: J. SIEGEL	8-30-04	SHEET 6 OF 6	REV 0
MODEL NAME	SE144-056-09				
WELDING ENGINEER	R. PARSELLS 8-30-04				

RELEASE LEVEL: Fabrication  
DWG VERSION NO: 1

NCSX-SE144-056