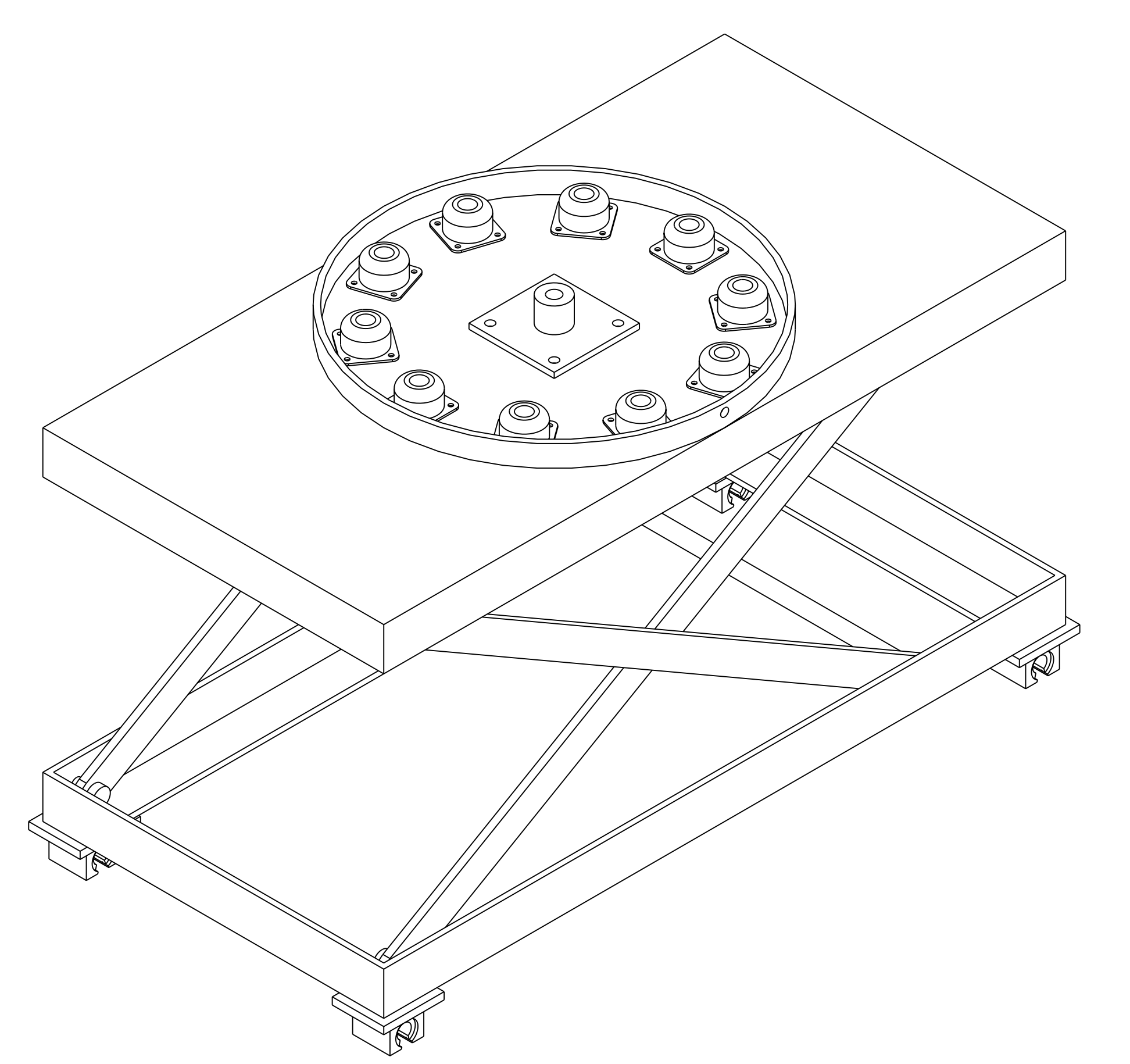
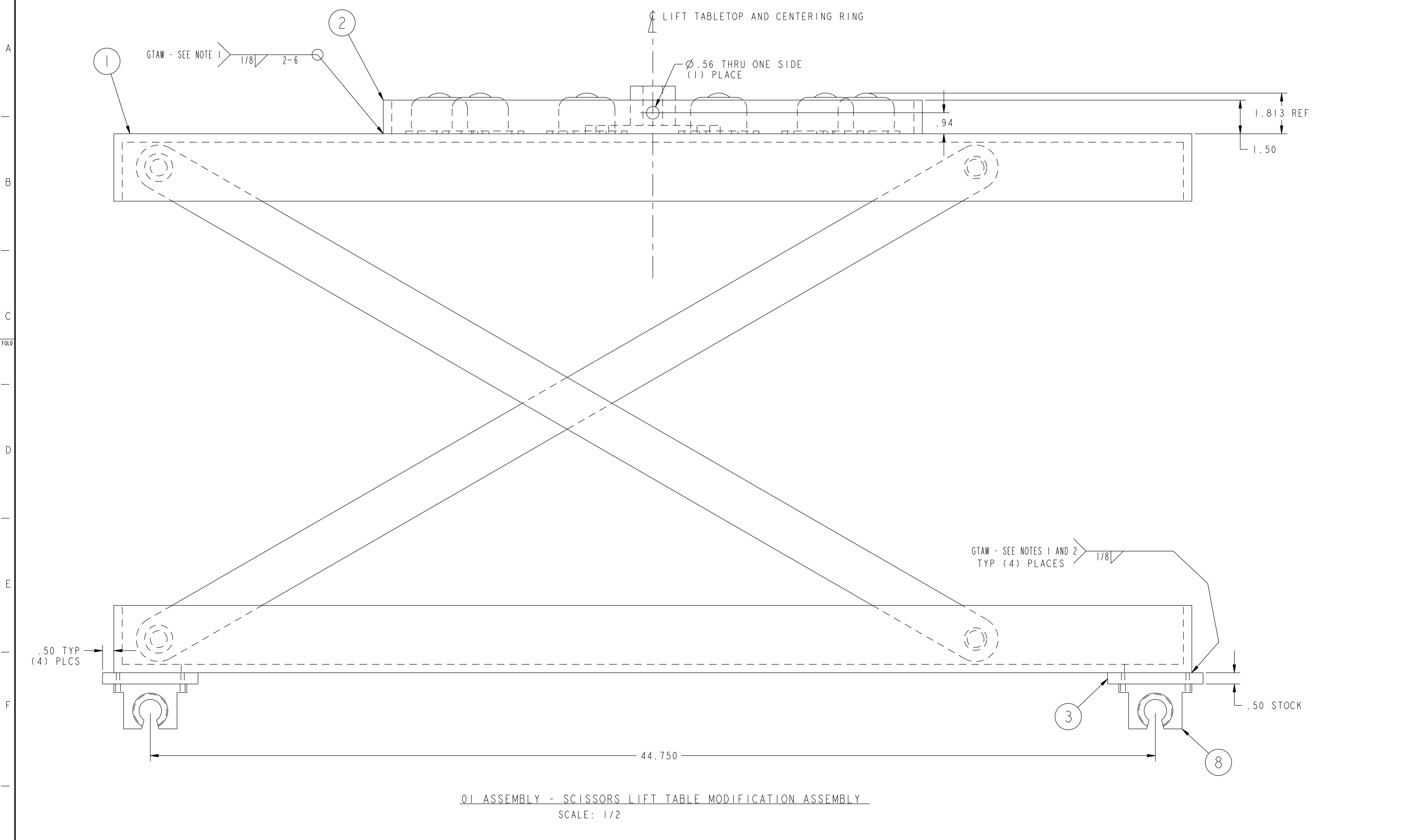


NO.	REVISION	BY	CH	SUP	APPROVED	DATE

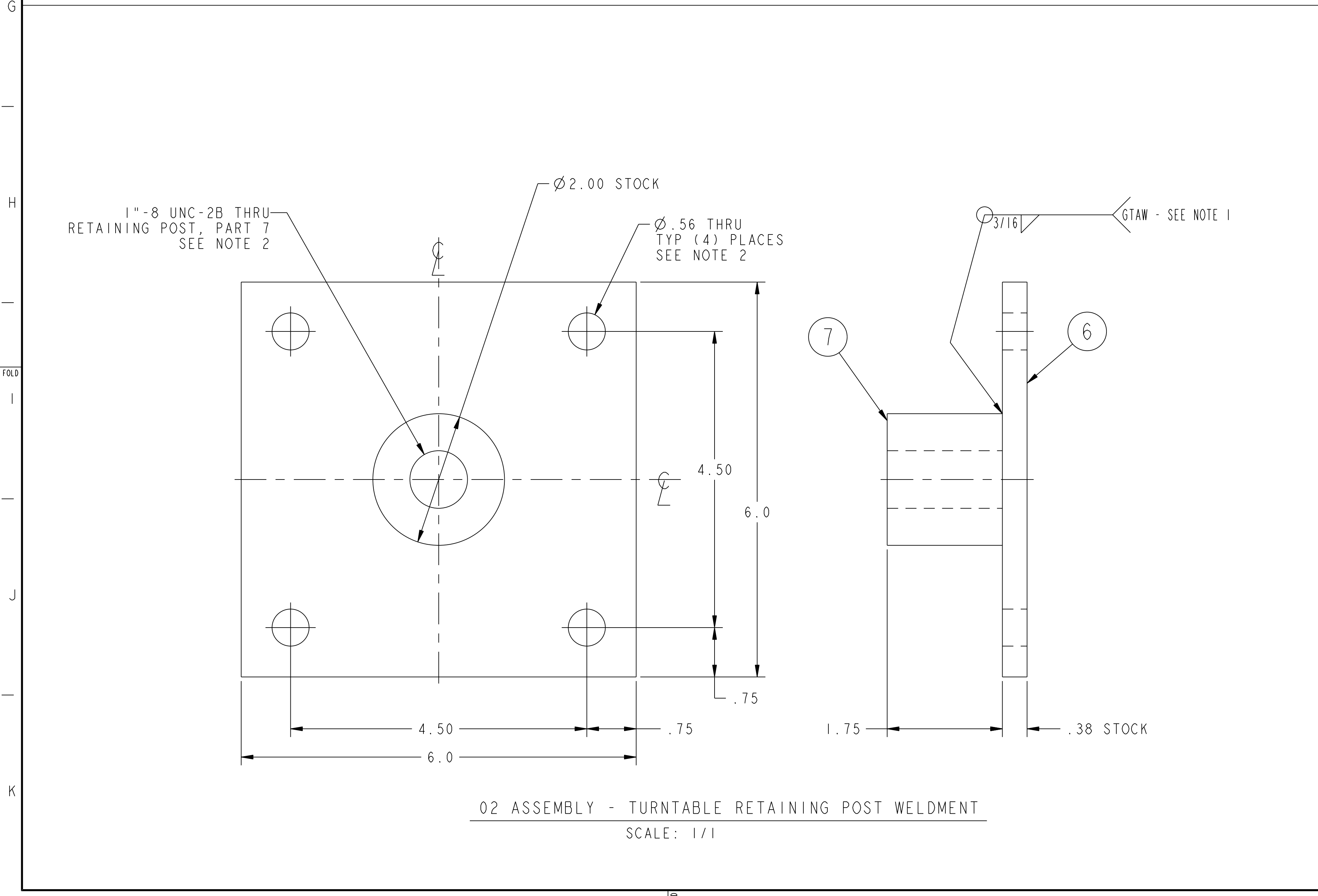


REFERENCE ISOMETRIC

NOTES

1. 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.
2. ALL HOLES ARE TO BE MACHINED AFTER ALL WELDING IS COMPLETE.

01 ASSEMBLY - SCISSORS LIFT TABLE MODIFICATION ASSEMBLY
SCALE: 1/2



02 ASSEMBLY - TURNTABLE RETAINING POST WELDMENT
SCALE: 1/1

RELEASED FOR FABRICATION / INSTALLATION

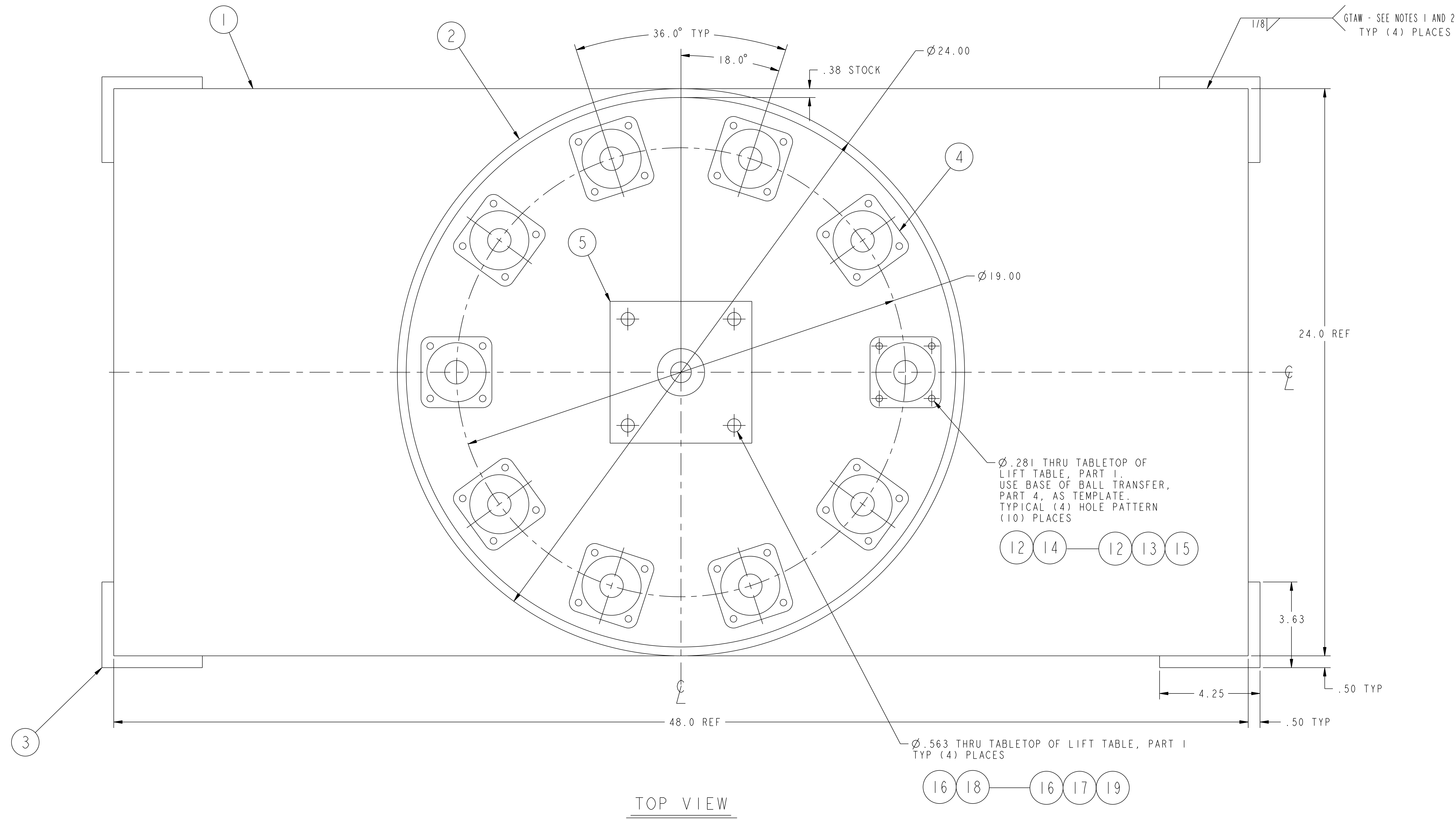
QTY	PART NO.	DESCRIPTION	MATERIAL	QTY REQD		
4	19	COMM 1/2-13 UNC-2B HEX NUT	C' STL - ZN PLT			
4	18	COMM 1/2-13 UNC-2A X 1 1/2" LG HEX HEAD CAP SCREW	C' STL - ZN PLT			
4	17	COMM 1/2 SPLIT LOCK WASHER	C' STL - ZN PLT			
8	16	COMM 1/2 FLAT WASHER	C' STL - ZN PLT			
40	15	COMM 1/4-20 UNC-2B HEX NUT	C' STL - ZN PLT			
40	14	COMM 1/4-20 UNC-2A X 1" LG SOCKET HD CAP SCR	C' STL - ZN PLT			
40	13	COMM 1/4 SPLIT LOCK WASHER	C' STL - ZN PLT			
80	12	COMM 1/4 FLAT WASHER	C' STL - ZN PLT			
16	11	COMM #10-24 UNC-2A X 7/8" LG SOCKET HD CAP SCR	C' STL - ZN PLT			
16	10	COMM #10 (.190 NOM DIA) SPLIT LOCK WASHER	C' STL - ZN PLT			
16	9	COMM #10 (.190 NOM DIA) FLAT WASHER	C' STL - ZN PLT			
4	8	COMM 1" NOM DIA. PILLOWBLOCK ASSEMBLY - OPEN TYPE				
1	7	THIS DWG RETAINING POST	ASTM A569			
1	6	THIS DWG RETAINING POST MOUNTING PLATE	ASTM A36			
1	5	THIS DWG TURNTABLE RETAINING POST WELDMENT		1		
10	4	COMM 1 1/2" DIA. TRANSFER BALL - 250# CAP.	STEEL			
4	3	THIS DWG PILLOWBLOCK MOUNTING PAD	ASTM A569			
1	2	THIS DWG TURNTABLE CENTERING RING	ASTM A569			
1	1	THIS DWG HYDRAULIC SCISSORS LIFT TABLE - 2000# CAP.				
1		THIS DWG LIFT TABLE MODIFICATION ASSEMBLY		1		
02 ASSY	01 ASSY	PART NO.	DRAWING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY REQD

PARTS LIST

COMPUTER GENERATED DRAWING CHANGES NOT PERMITTED	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	DIMENSIONS ARE IN INCHES MACHINE SURFACES UNLESS SHOWN OTHERWISE	NATIONAL COMPACT STELLARATOR EXPERIMENT	
WEIGHT 372.7 lbs	TOLERANCES NON-CUMULATIVE	DSN: L. MORRIS	DRAWING NO: SE144-122
MODEL NAME SE144-122	DECIMAL-INCH FRACTIONS	CHK: S. RAFTOPOULOS	ENGR: J. CHRZANOWSKI
RELEASE LEVEL: Fabrication	NEXT ASSEMBLY	SUPV: J. SIEGEL	SHEET 1 OF 3
DWG VERSION NO:	WELDING ENGINEER		REV 0

NCSX-SE144-122

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



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FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

RELEASE LEVEL: Fabrication
DWG VERSION NO: 3

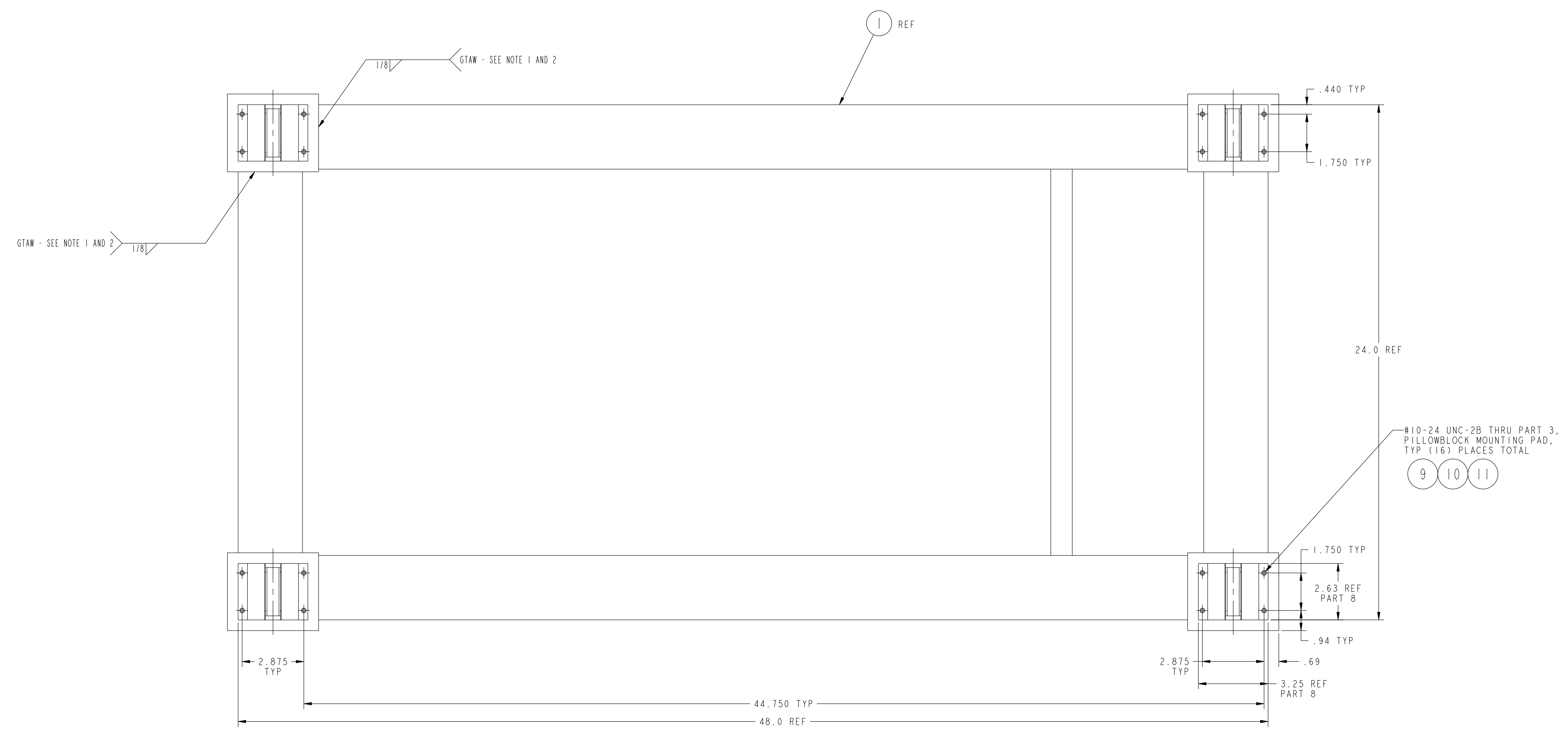
WEIGHT
372.7 lbs

MODEL NAME
SE144-122

WELDING ENGINEER

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E DO NOT VERIFY INFORMATION BY SCALING DRAWING	CENTRAL FILES:	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY	
	UNLESS OTHERWISE SPECIFIED	NATIONAL COMPACT STELLARATOR EXPERIMENT	
NEXT ASSEMBLY	DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	MODULAR COIL WINDING FACILITY COPPER SPOOLS MANIPULATOR LIFT TABLE MODIFICATION ASSEMBLY	
	TOLERANCES NON-CUMULATIVE	DSN: L. MORRIS	DRAWING NO:
	DECIMAL-INCH FRACTIONS	CHK: S. RAFTOPOULOS	SE144-122
	.X +/- .100 0°-120° +/- .124	ENGR: J. CHRZANOWSKI	SHEET 2 OF 3
	.XX +/- .030 12°-120° +/- .116	SUPV: J. SIEGEL	REV 0
	.XXX +/- .005 72°-120° +/- .114 ANGULAR +/- .0°-15° OVER 120° +/- .112		

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



BOTTOM VIEW

**RELEASED FOR
FABRICATION / INSTALLATION**

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

RELEASE LEVEL: Fabrication
DWG VERSION NO: 3

WEIGHT
372.7 lbs

MODEL NAME
SE144-122

WELDING
ENGINEER

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY NATIONAL COMPACT STELLARATOR EXPERIMENT	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	MODULAR COIL WINDING FACILITY COPPER SPOOLS MANIPULATOR LIFT TABLE MODIFICATION ASSEMBLY	
NEXT ASSEMBLY	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .X +/- .100 0°-120° +/- .100 .XX +/- .030 120°-120° +/- .100 .XXX +/- .005 120°-120° +/- .100 ANGULAR +/- .0°-15° OVER 120° +/- .100	DSN: L. MORRIS CHK: S. RAFTOPOULOS ENGR: J. CHRZANOWSKI SUPV: J. SIEGEL	DRAWING NO: SE144-122 SHEET 3 OF 3 REV 0

NCSX-SE144-122