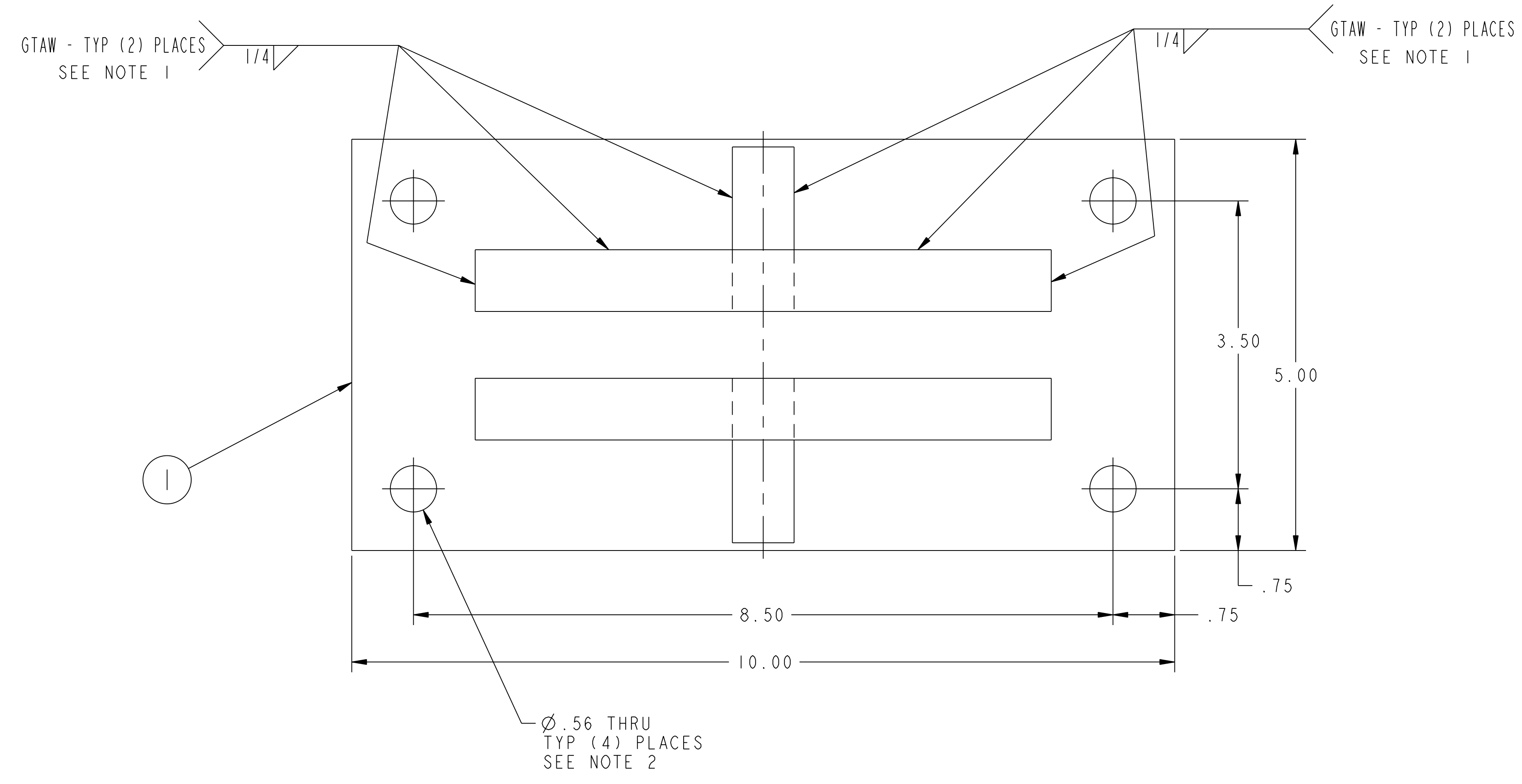
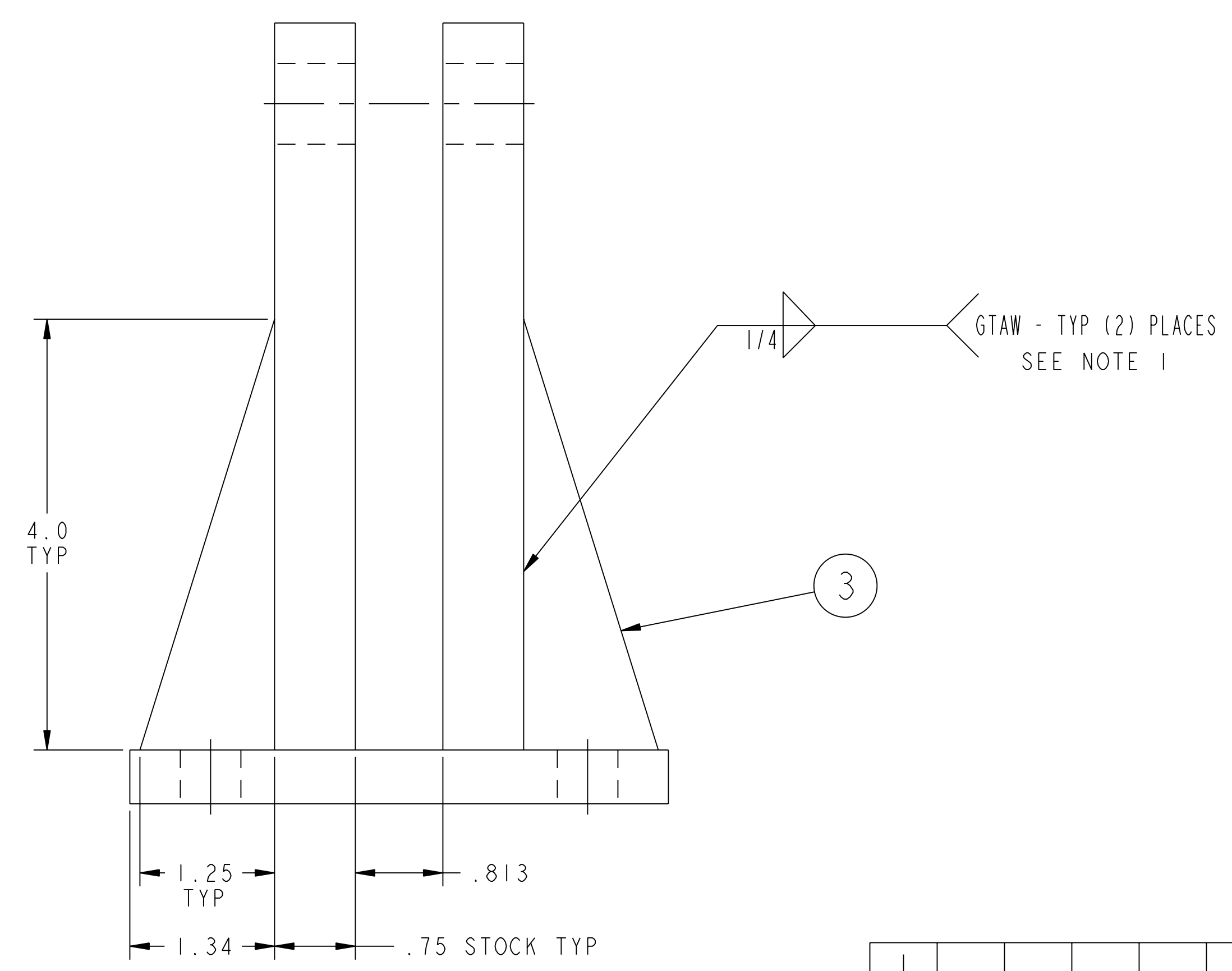
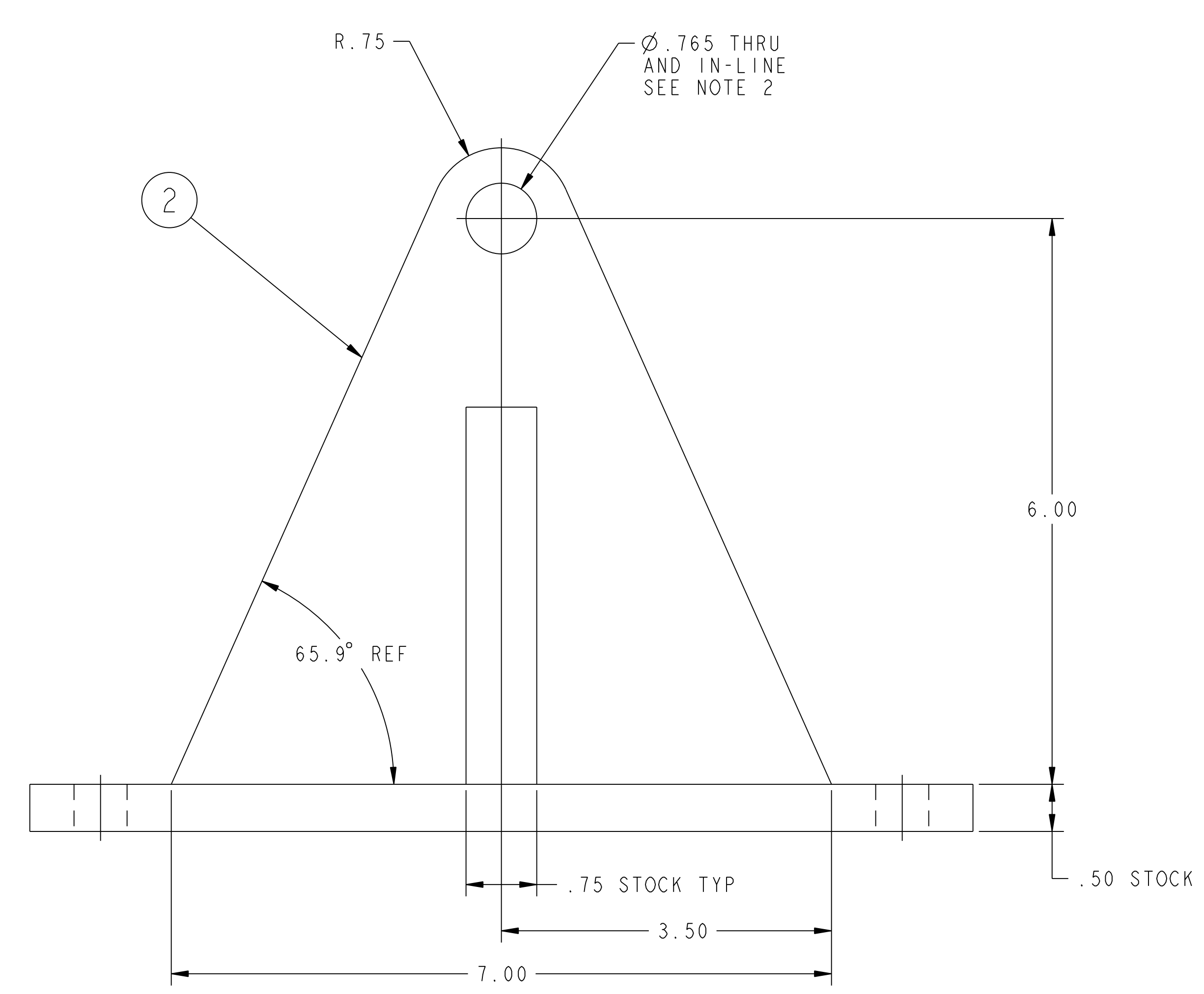


NO.	REVISION	BY	CH	SUP	APPROVED	DATE



- 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. MACHINE ALL HOLES AFTER ALL WELDING IS COMPLETE.



RELEASED FOR FABRICATION / INSTALLATION

01 ASSEMBLY - TURNTABLE CLEVIS BRACKET WELDMENT

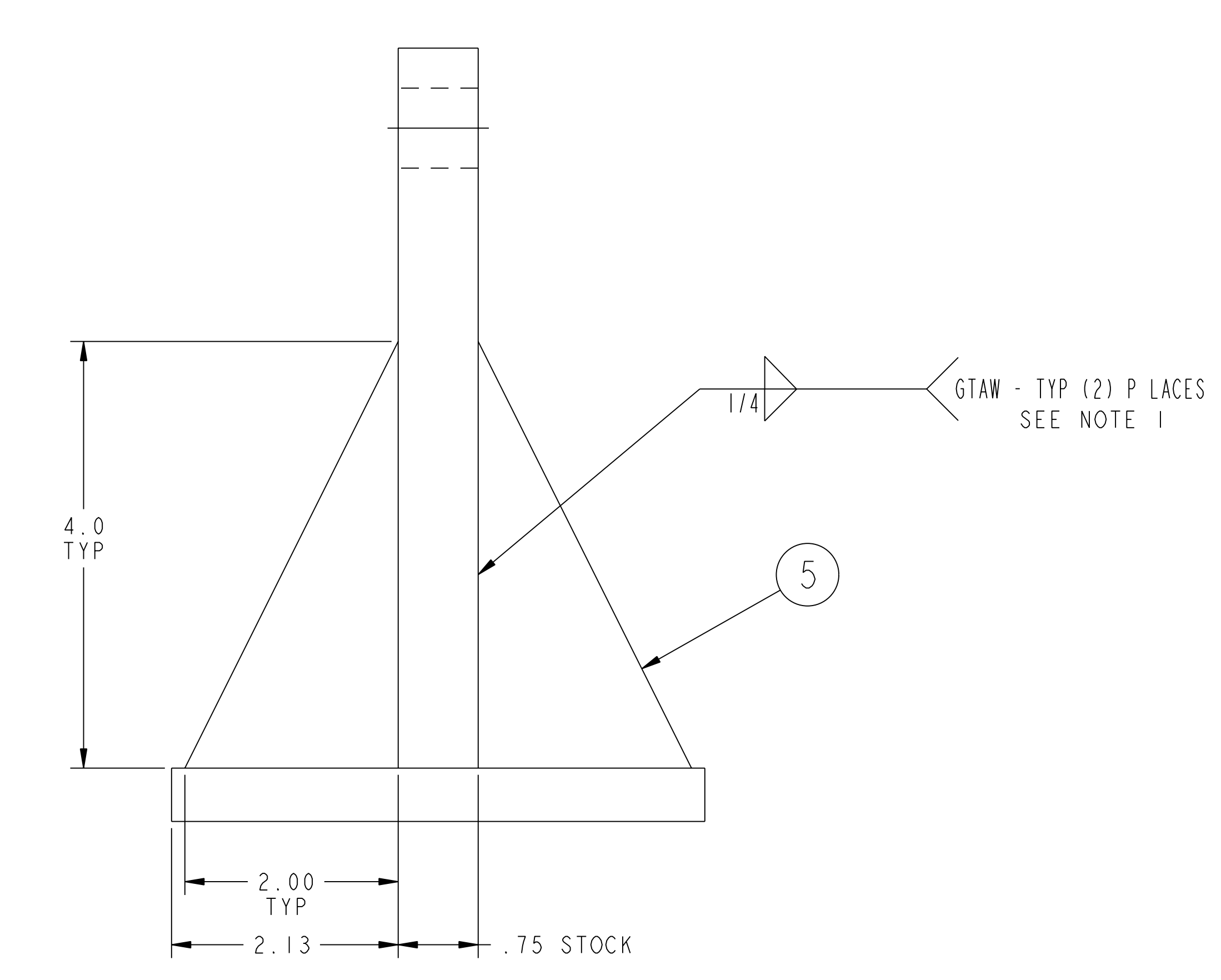
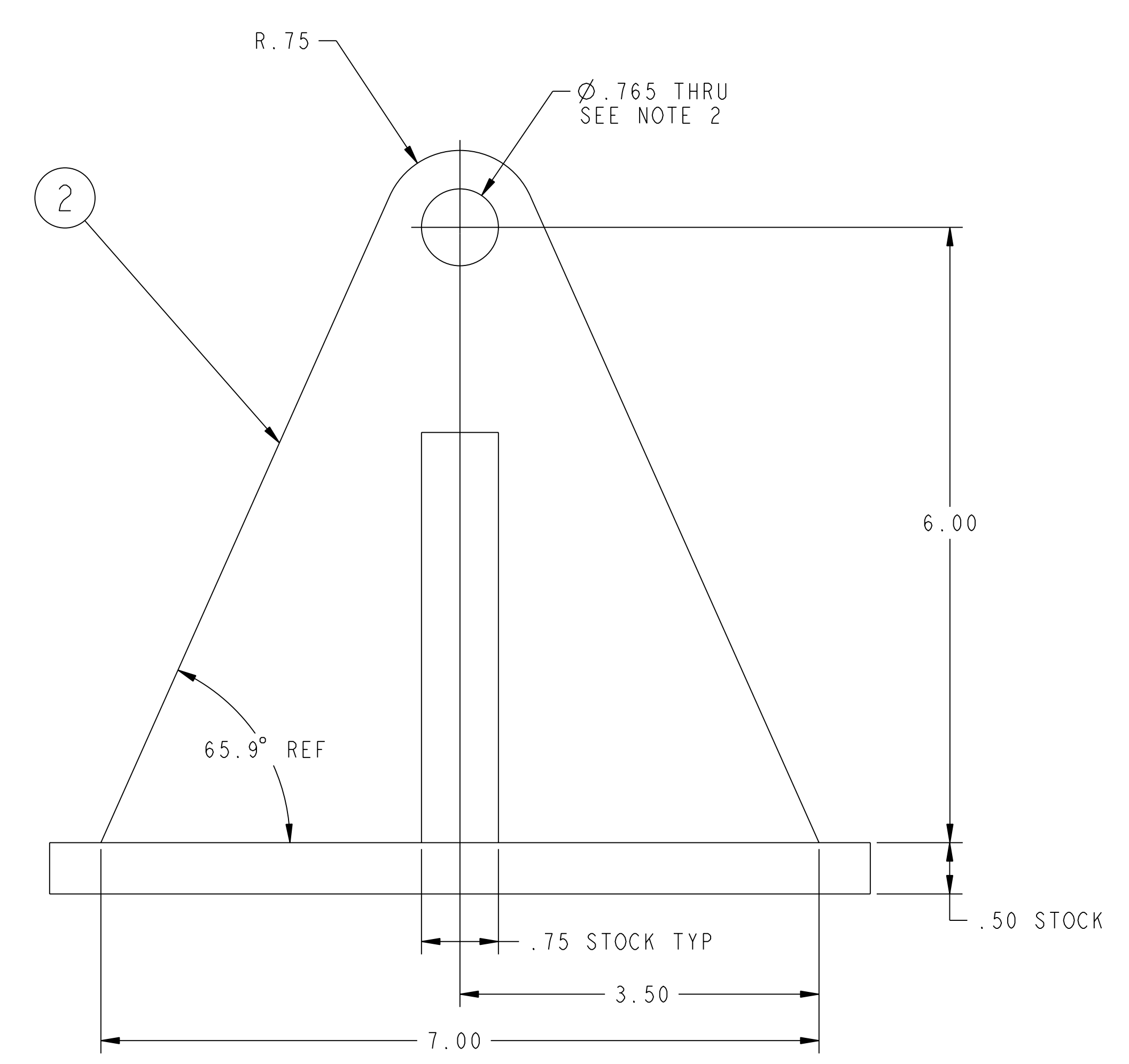
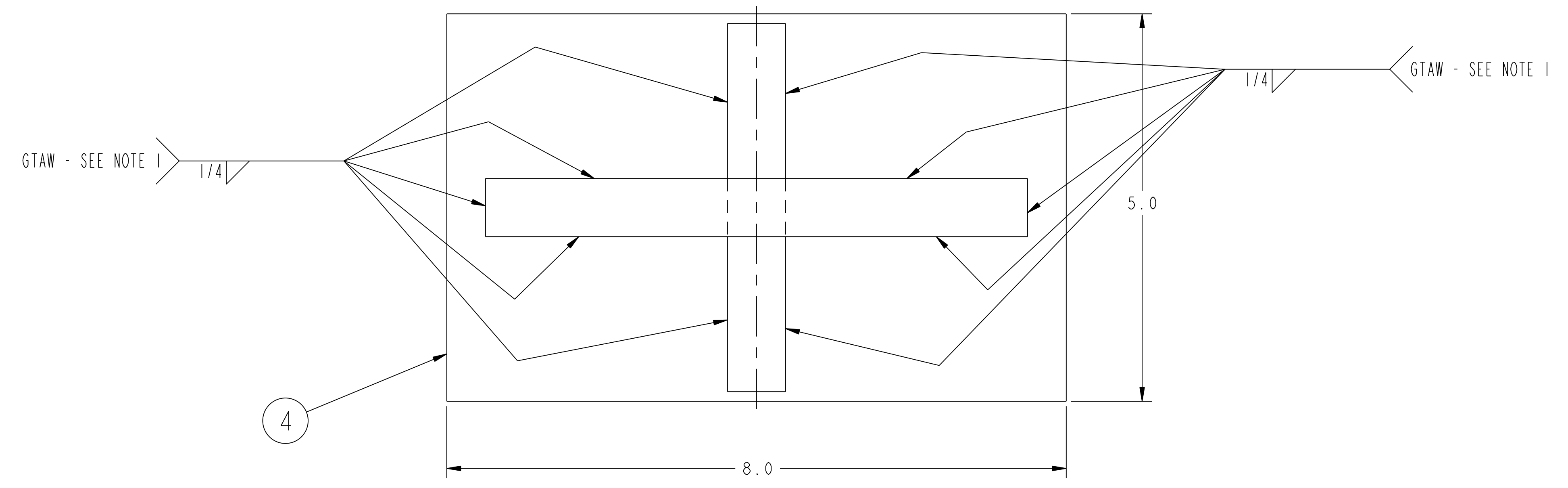
ASSY	NO.	QTY	PART NO.	DRAWING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY REQ'D
10					THIS DWG STOP BLOCK	ASTM A569	
9					THIS DWG MOUNTING PLATE	ASTM A569	
8					THIS DWG MOUNTING PLATE	ASTM A569	
7					THIS DWG CLEVIS PLATE	ASTM A569	
6					THIS DWG MOUNTING PLATE	ASTM A569	
5					THIS DWG GUSSET	ASTM A569	
4					THIS DWG MOUNTING PLATE	ASTM A569	
3					THIS DWG GUSSET	ASTM A569	
2					THIS DWG CLEVIS PLATE	ASTM A569	
1					THIS DWG MOUNTING PLATE	ASTM A569	
					THIS DWG JACK CLEVIS TONGUE BRACKET WELDMENT - TYPE B		1
					THIS DWG JACK CLEVIS TONGUE BRACKET WELDMENT - TYPE A		1
					THIS DWG JACK CLEVIS BRACKET WELDMENT		2
					THIS DWG PLATFORM CLEVIS BRACKET WELDMENT		2
					THIS DWG TURNTABLE CLEVIS BRACKET WELDMENT		2

WEIGHT 19.0 lbs	COMPUTER GENERATED DRAWING CHANGES NOT PERMITTED	CENTRAL FILES:	PRINCETON PLASMA PHYSICS LABORATORY	
	DO NOT VERIFY INFORMATION BY SCALING DRAWING	UNLESS OTHERWISE SPECIFIED	NATIONAL COMPACT STELLARATOR EXPERIMENT	
MODEL NAME SE144-126	Pro E	DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	MODULAR COIL WINDING FACILITY COPPER SPOOLS MANIPULATOR CLEVIS WELDMENTS	
WELDING ENGINEER	NEXT ASSEMBLY	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX +/- .000 0°-12° +/- .010 .XXX +/- .005 12°-120° +/- .010 ANGULAR +/- 0°-15° OVER 120° +/- .125	DSN: L. MORRIS CHK: S. RAFTOPOULOS ENGR: J. CHRZANOWSKI SUPV: J. SIEGEL	DRAWING NO: SE144-126 SHEET 1 OF 3 REV 0

RELEASE LEVEL: Fabrication
DWG VERSION NO: 4

NCSX-SE144-126

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



02 ASSEMBLY - PLATFORM CLEVIS BRACKET WELDMENT

RELEASED FOR FABRICATION / INSTALLATION

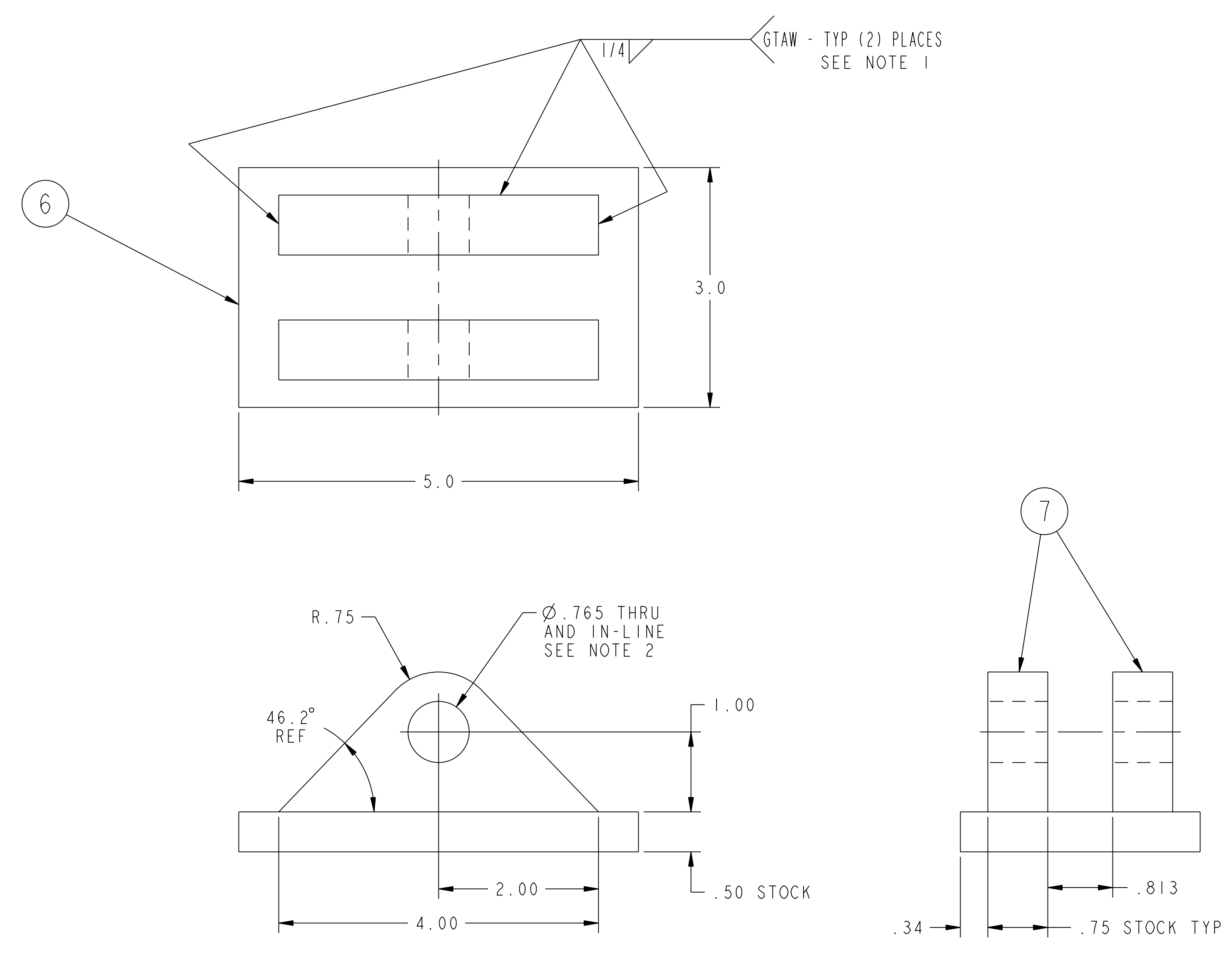
FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

RELEASE LEVEL: Fabrication
DWG VERSION NO: 4

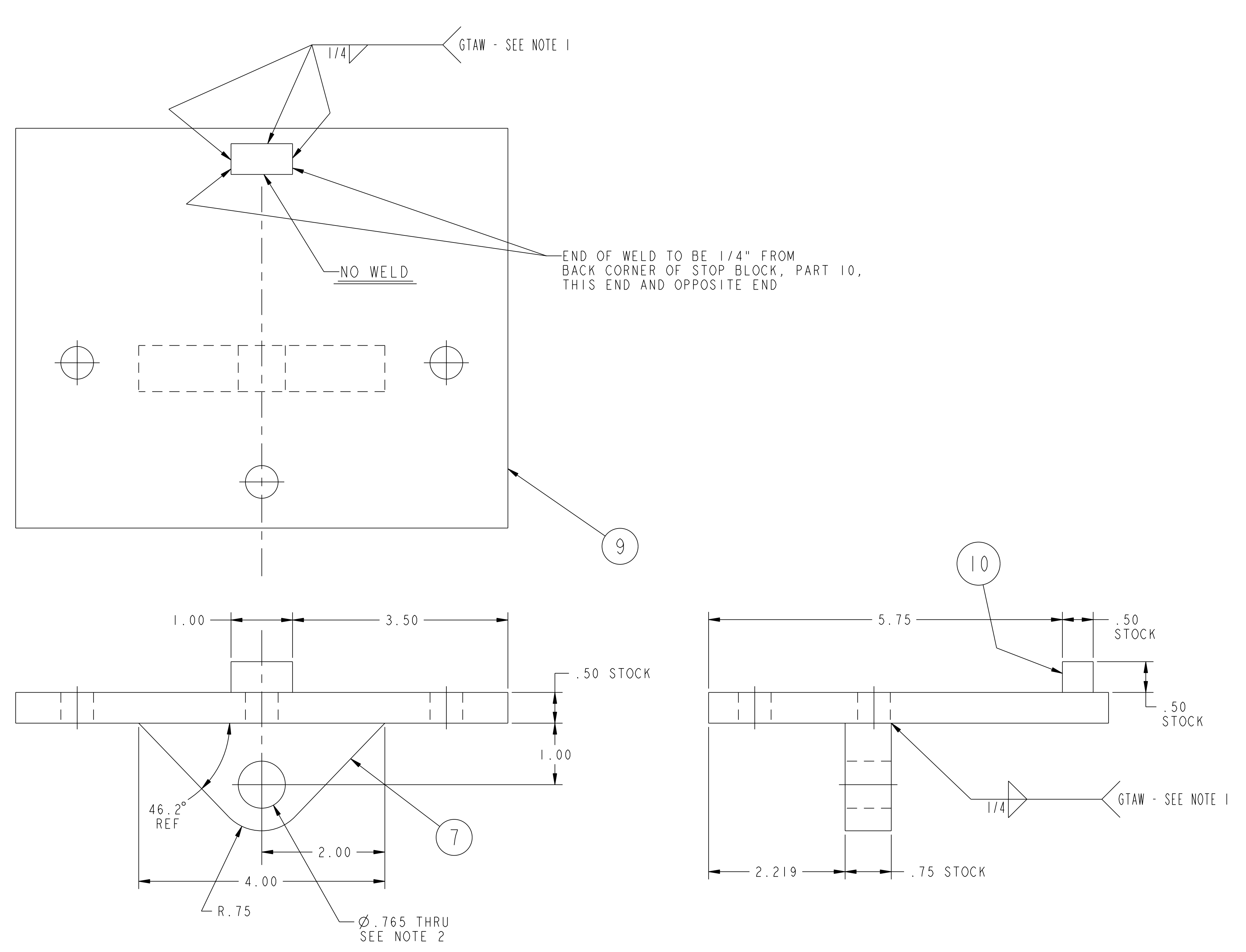
WEIGHT
19.0 lbs
MODEL NAME
SE144-126
WELDING
ENGINEER

COMPUTER GENERATED DRAWING CHANGES NOT PERMITTED Pro E DO NOT VERIFY INFORMATION BY SCALING DRAWING	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY NATIONAL COMPACT STELLARATOR EXPERIMENT MODULAR COIL WINDING FACILITY COPPER SPOOLS MANIPULATOR CLEVIS WELDMENTS	
NEXT ASSEMBLY	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX +/- .000 0°-120° +/- .010 .XXX +/- .005 120°-120° +/- .010 ANGULAR +/- 0°-15° OVER 120° +/- .125	DSN: L. MORRIS CHK: S. RAFTOPOULOS ENGR: J. CHRZANOWSKI SUPV: J. SIEGEL	DRAWING NO: SE144-126 SHEET 2 OF 3 REV 0

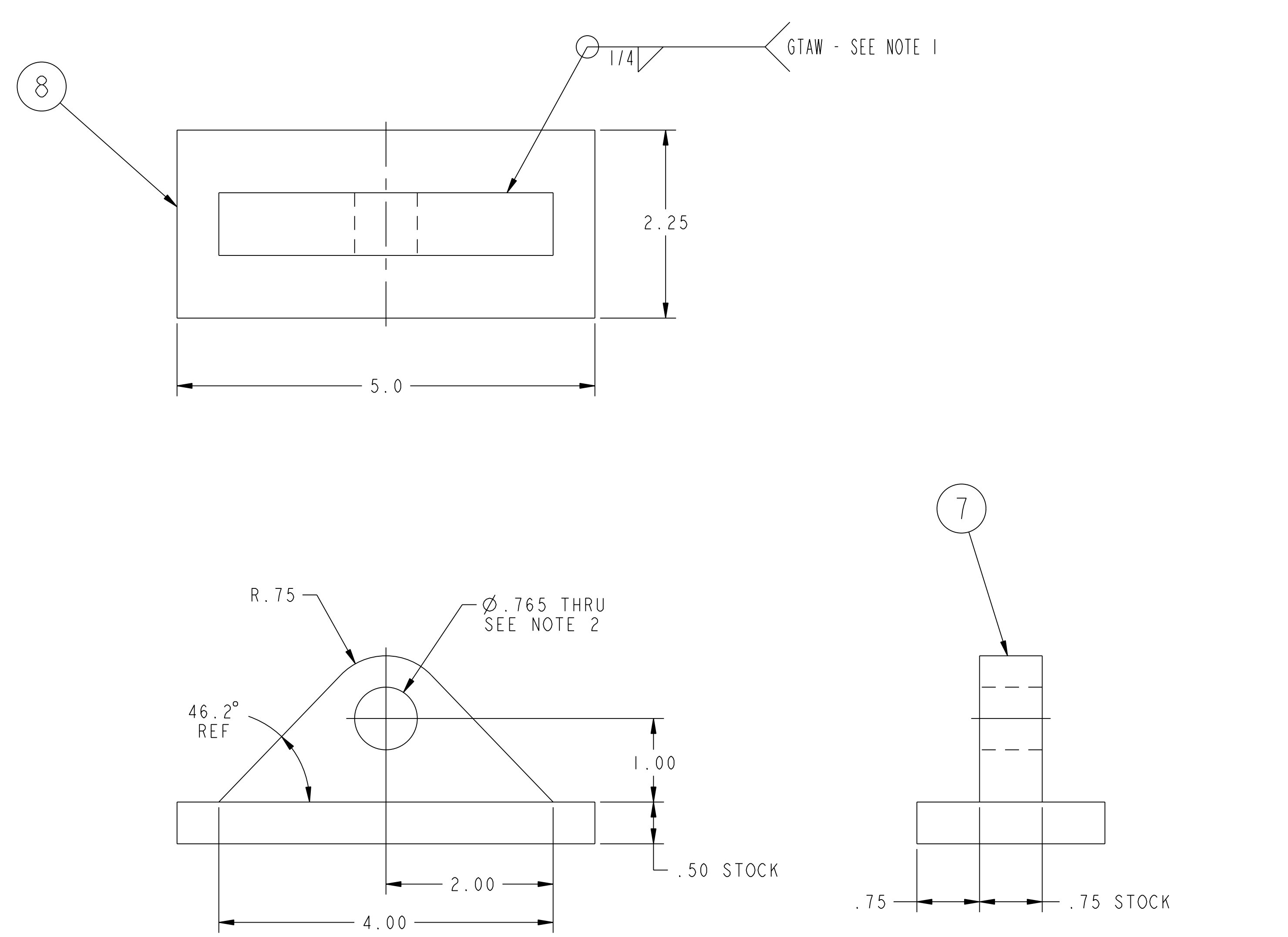
NO.	REVISION	BY	CH	SUP	APPROVED	DATE



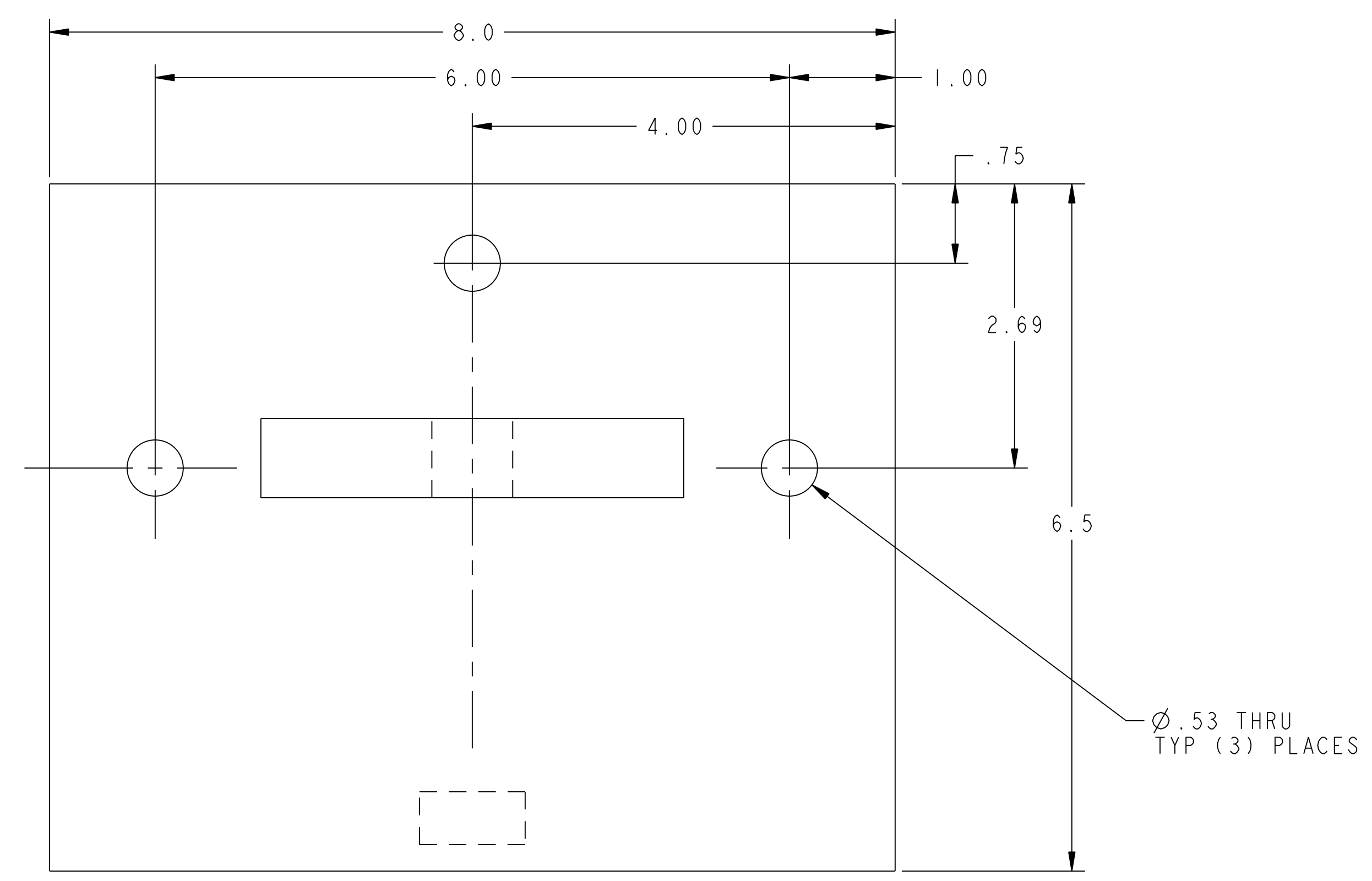
03 ASSEMBLY - JACK CLEVIS BRACKET WELDMENT



05 ASSEMBLY - JACK CLEVIS TONGUE BRACKET WELDMENT - TYPE B



04 ASSEMBLY - JACK CLEVIS TONGUE BRACKET WELDMENT - TYPE A



RELEASED FOR FABRICATION / INSTALLATION

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

RELEASE LEVEL: Fabrication
DWG VERSION NO: 4

COMPUTER GENERATED DRAWING CHANGES NOT PERMITTED Pro E DO NOT VERIFY INFORMATION BY SCALING DRAWING	CENTRAL FILES:	PRINCETON PLASMA PHYSICS LABORATORY NATIONAL COMPACT STELLARATOR EXPERIMENT	
	UNLESS OTHERWISE SPECIFIED	MODULAR COIL WINDING FACILITY COPPER SPOOLS MANIPULATOR CLEVIS WELDMENTS	
WEIGHT 12.8 lbs	DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	TOLERANCES NON-CUMULATIVE	DSN: L. MORRIS DRAWING NO: SE144-126
MODEL NAME SE144-126	DECIMAL-INCH FRACTIONS	CHK: S. RAFTOPOULOS ENGR: J. CHRZANOWSKI	REVISIONS
WELDING ENGINEER	XXX +/- .005 ANGULAR +/- 0°-15'	ENGR: J. CHRZANOWSKI SUPV: J. SIEGEL	SHEET 3 OF 3 REV 0