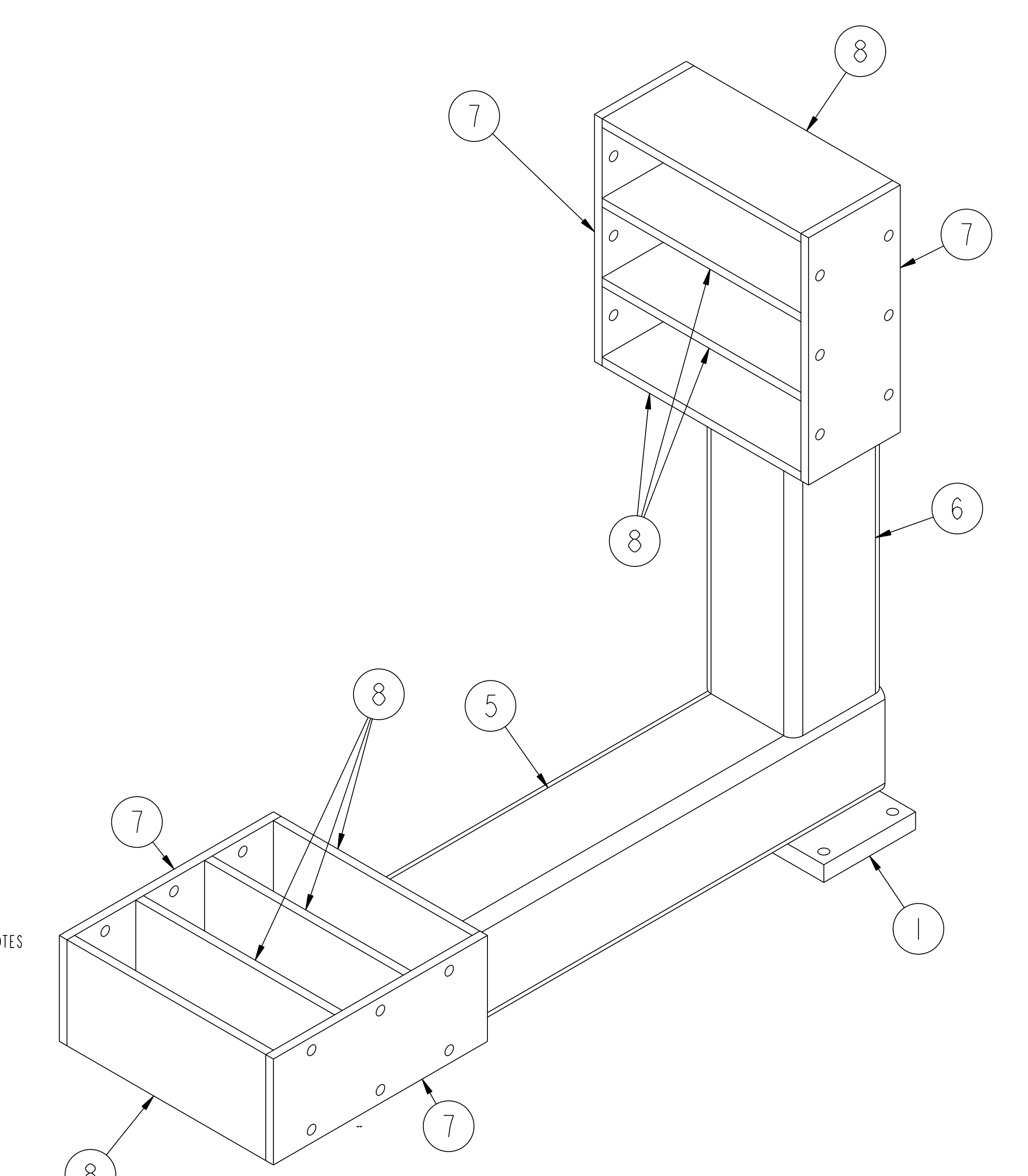
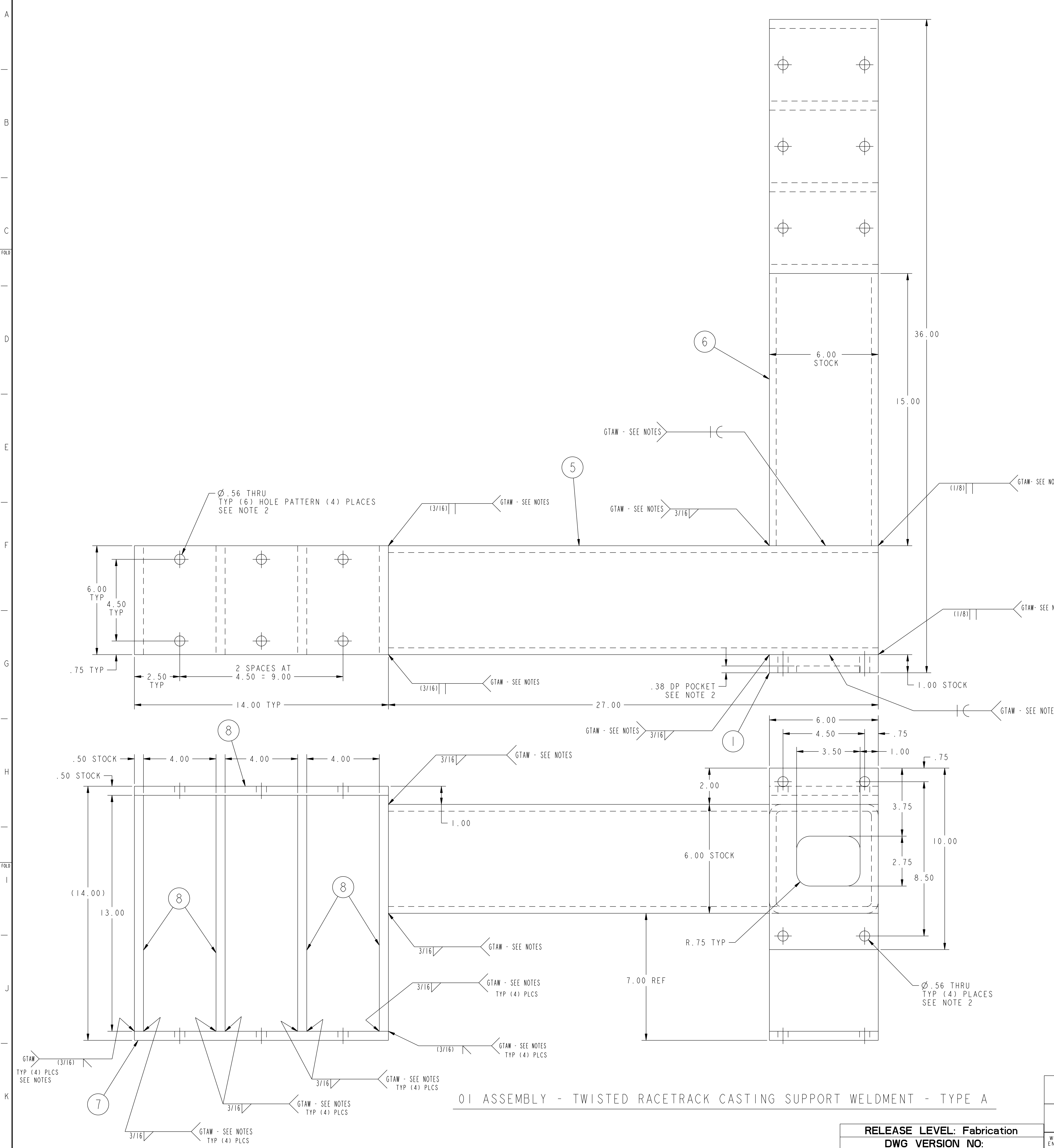


NO.	REVISION	BY	CH	SUP	APPROVED	DATE



REFERENCE ISOMETRIC

NOTES

1. WELDING SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS AWS D1.1 SECTION 6 AND PPLP PROCEDURE EM-002. VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH THE ACCEPTANCE CRITERIA OF AWS D1.1 SECTION 6.
2. ALL HOLES AND POCKET TO BE MACHINED AFTER ALL WELDING IS COMPLETE.

RELEASED FOR FABRICATION / INSTALLATION

QTY	PART NO.	DRAWING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY REQD
8	8	8	THIS DWG	SUPPORT RIB	ASTM A569
4	4	4	THIS DWG	SUPPORT SIDE PLATE	ASTM A569
1	1	1	THIS DWG	SUPPORT TUBE - TYPE B (6" SO STRUCT TUBE X 3/8" WALL)	ASTM A36
1	1	1	THIS DWG	SUPPORT TUBE - TYPE A (6" SO STRUCT TUBE X 3/8" WALL)	ASTM A36
1	1	1	THIS DWG	SUPPORT ADAPTER PLATE - TYPE D	ASTM A569
1	1	1	THIS DWG	SUPPORT ADAPTER PLATE - TYPE C	ASTM A569
1	1	1	THIS DWG	SUPPORT ADAPTER PLATE - TYPE B	ASTM A569
1	1	1	THIS DWG	SUPPORT ADAPTER PLATE - TYPE A	ASTM A569
1	1	1	THIS DWG	TWISTED RACETRACK CASTING SUPPORT WELDMENT - TYPE D	
1	1	1	THIS DWG	TWISTED RACETRACK CASTING SUPPORT WELDMENT - TYPE C	
1	1	1	THIS DWG	TWISTED RACETRACK CASTING SUPPORT WELDMENT - TYPE B	
1	1	1	THIS DWG	TWISTED RACETRACK CASTING SUPPORT WELDMENT - TYPE A	

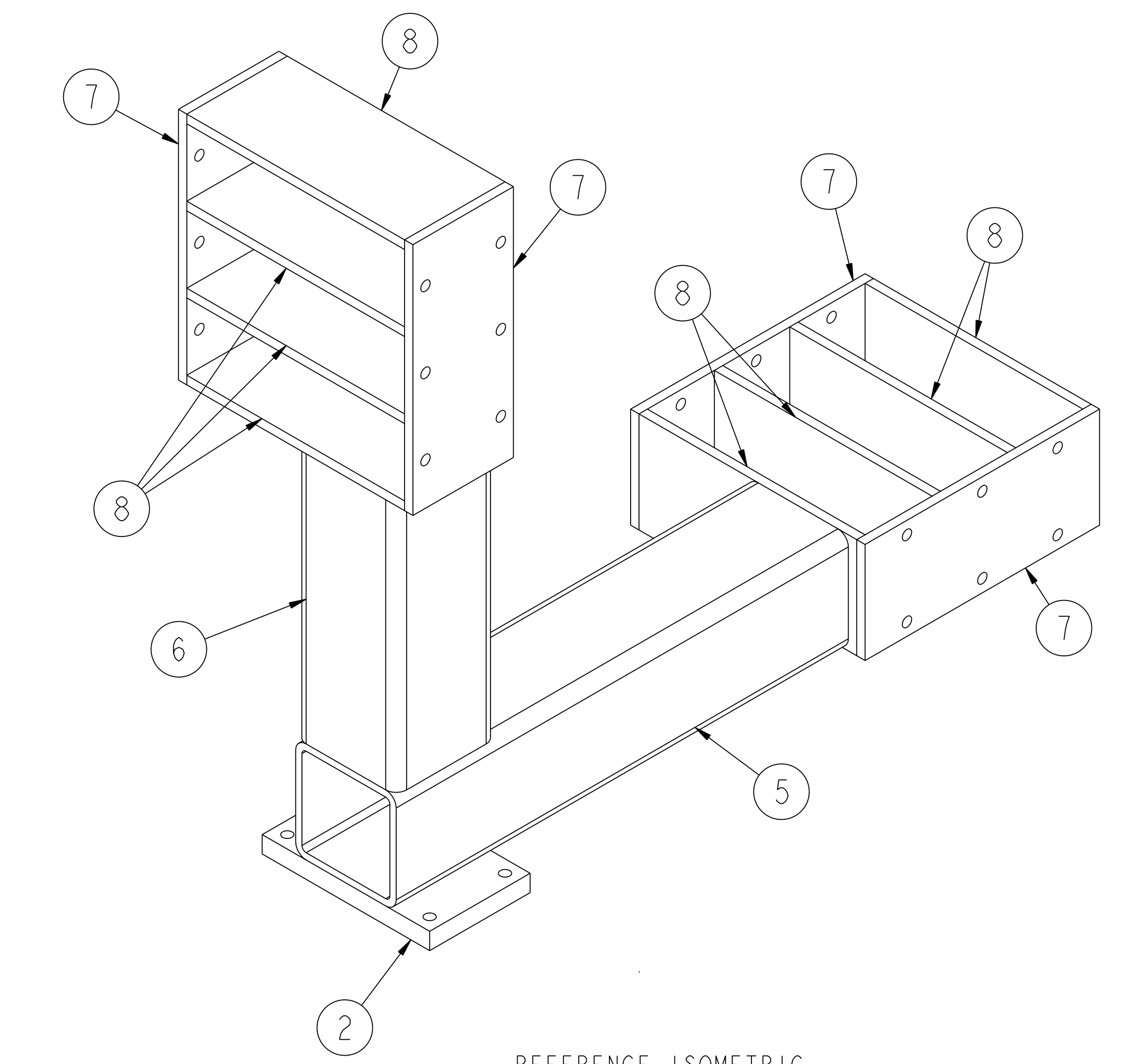
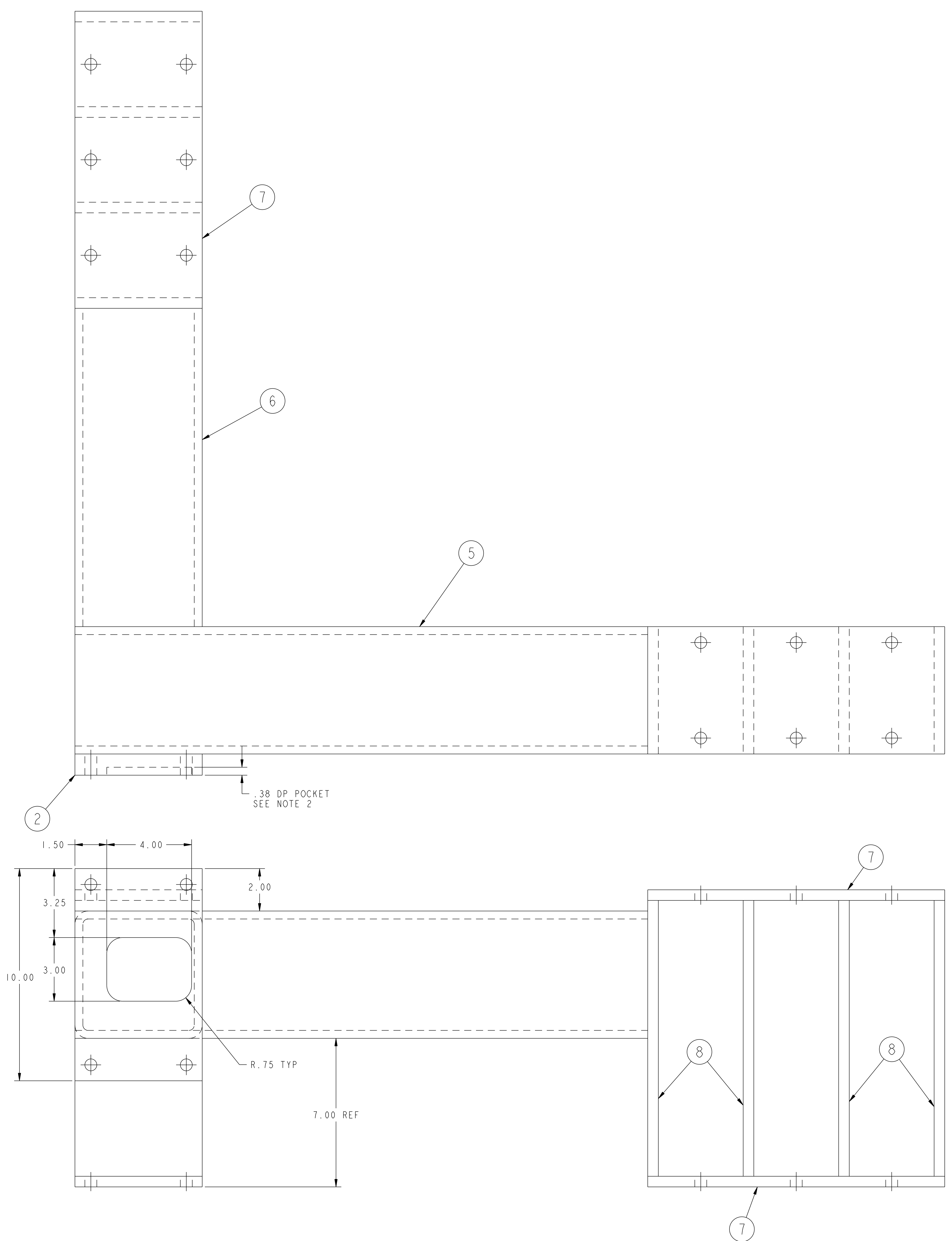
PARTS LIST

WEIGHT	245.0 lbs	MODEL NAME	SE144-201	WELDING ENGINEER	
COMPUTER GENERATED DRAWING CHANGES NOT PERMITTED		CENTRAL FILES:	UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY NATIONAL COMPACT STELLATOR EXPERIMENT	
DO NOT VERIFY INFORMATION BY SCALING DRAWING		DIMENSIONS ARE IN INCHES	MACHINE SURFACES	MODULAR COIL WINDING FACILITY TWISTED RACETRACK WINDING	
		BREAK SHARP EDGES .005/.020		TWISTED RACETRACK CASTING SUPPORT WELDMENTS	
		TOLERANCES NON-CUMULATIVE		DSN: L. MORRIS	DRAWING NO:
		DECIMAL-INCH FRACTIONS		CHK: S. RAFTOPOULOS	SE144-201
		.XX ±.000	0"-.125 ±.010	ENGR: J. CHRZANOWSKI	
		.XXX ±.005	.125-.250 ±.015	SUPV: J. SIEGEL	SHEET 1 OF 4
		ANGULAR ±.015	OVER .125 ±.010		REV 0

01 ASSEMBLY - TWISTED RACETRACK CASTING SUPPORT WELDMENT - TYPE A

RELEASE LEVEL: Fabrication
DWG VERSION NO:

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



REFERENCE ISOMETRIC

NOTE:
THIS WELDMENT IS IDENTICAL TO WELDMENT - TYPE A SHOWN ON SHEET 1 EXCEPT AS INDICATED HEREON.

RELEASED FOR FABRICATION / INSTALLATION

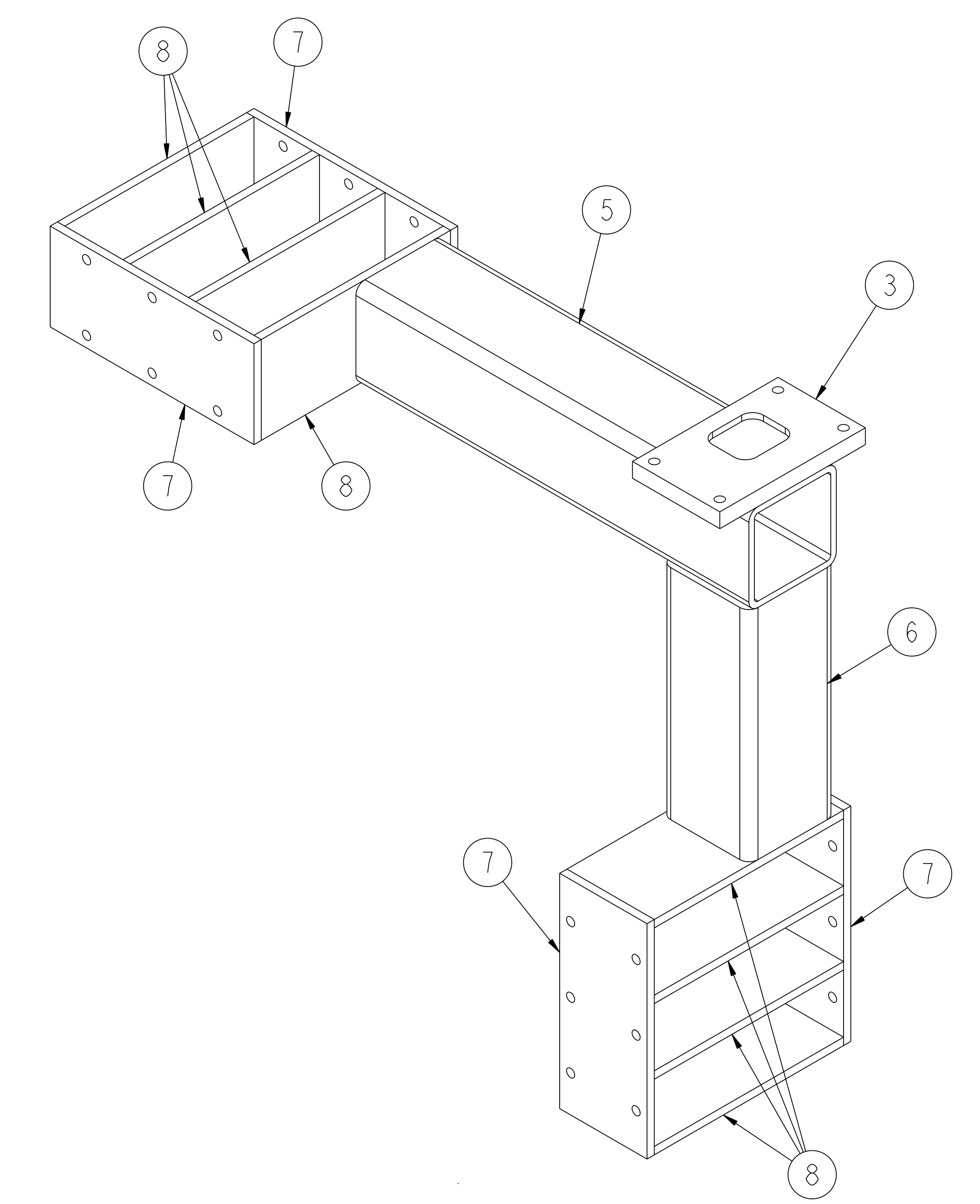
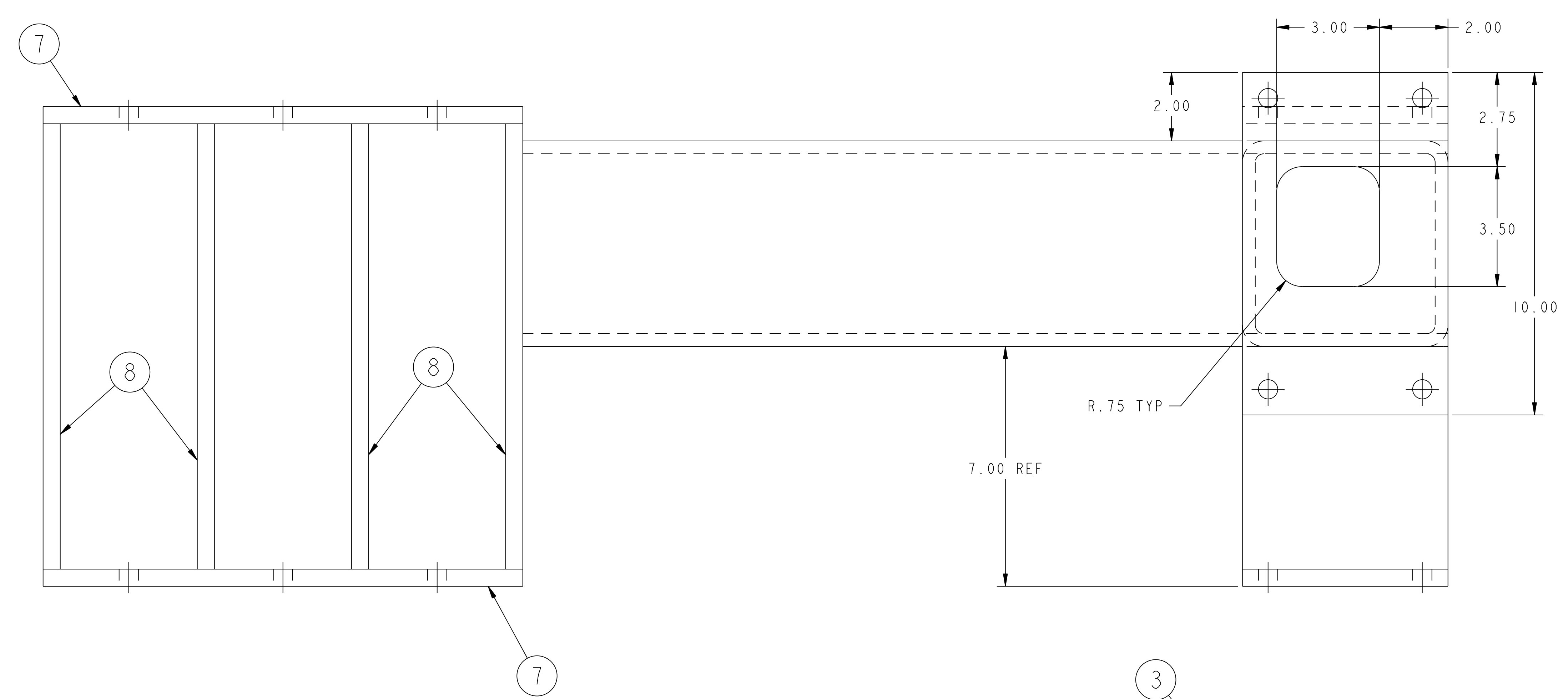
FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

02 ASSEMBLY - TWISTED RACETRACK CASTING SUPPORT WELDMENT - TYPE B

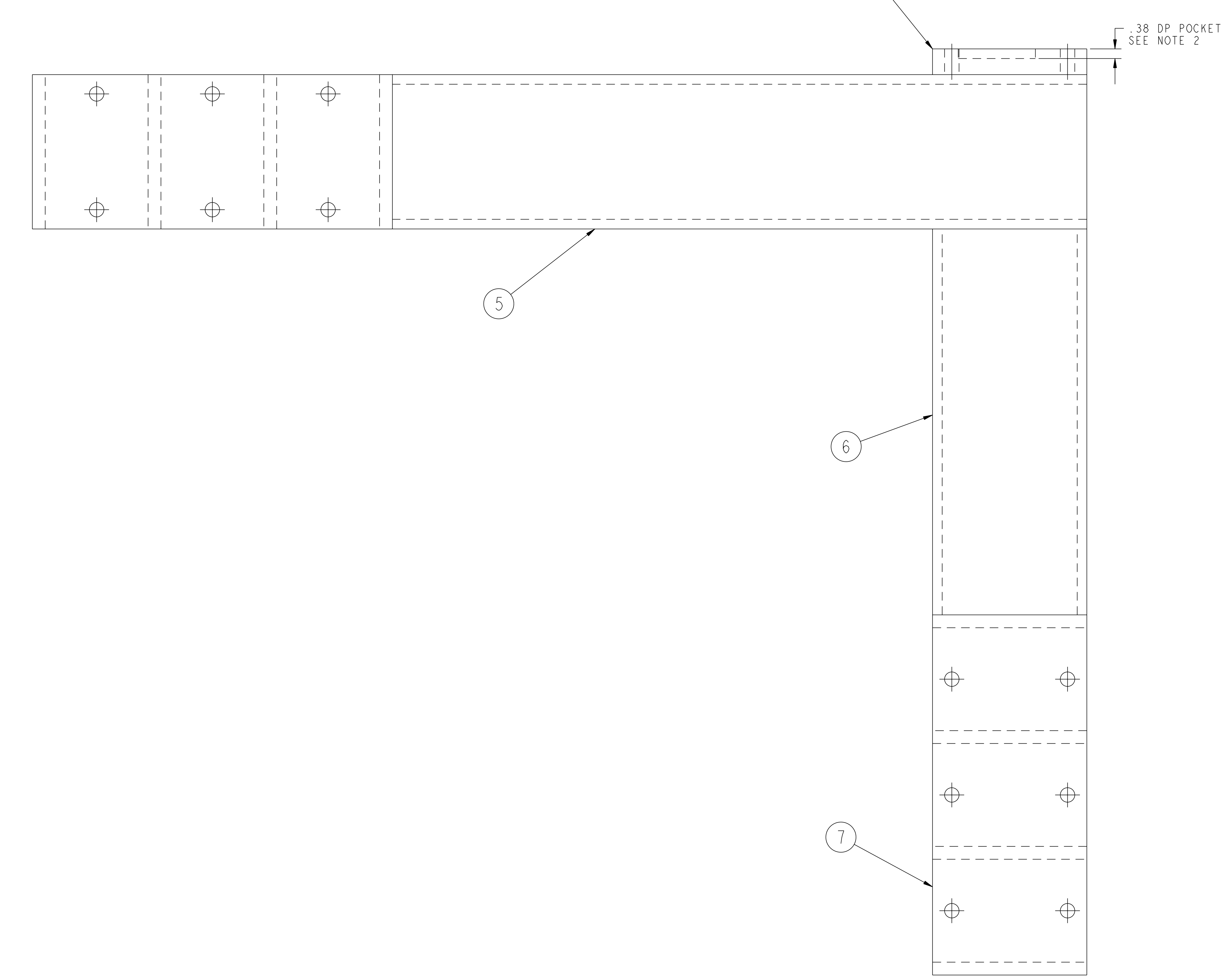
RELEASE LEVEL: Fabrication
DWG VERSION NO: 1

COMPUTER GENERATED DRAWING CHANGES NOT PERMITTED Pro E	CENTRAL FILES:	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY	
	UNLESS OTHERWISE SPECIFIED	NATIONAL COMPACT STELLARATOR EXPERIMENT	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	DIMENSIONS ARE IN INCHES MACHINE SURFACES	MODULAR COIL WINDING FACILITY TWISTED RACETRACK WINDING	
NEXT ASSEMBLY	BREAK SHARP EDGES .005/.020	TWISTED RACETRACK CASTING SUPPORT WELDMENTS	
WELDING ENGINEER	TOLERANCES NON-CUMULATIVE	DSN: L. MORRIS	DRAWING NO:
	DECIMAL - INCH FRACTIONS	CHK: S. RAFTOPOULOS	SE144-201
	.X ±.100 0°-120° ±.100 .XX ±.030 120°-120° ±.100 .XXX ±.005 72°-120° ±.100 ANGULAR ±.0°-15° OVER 120° ±.100	ENGR: J. CHRZANOWSKI	SHEET 2 OF 4
		SUPV: J. SIEGEL	REV 0

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



REFERENCE ISOMETRIC



NOTE:
THIS WELDMENT IS IDENTICAL TO WELDMENT - TYPE A SHOWN ON SHEET 1 EXCEPT AS INDICATED HEREON.

RELEASED FOR FABRICATION / INSTALLATION

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

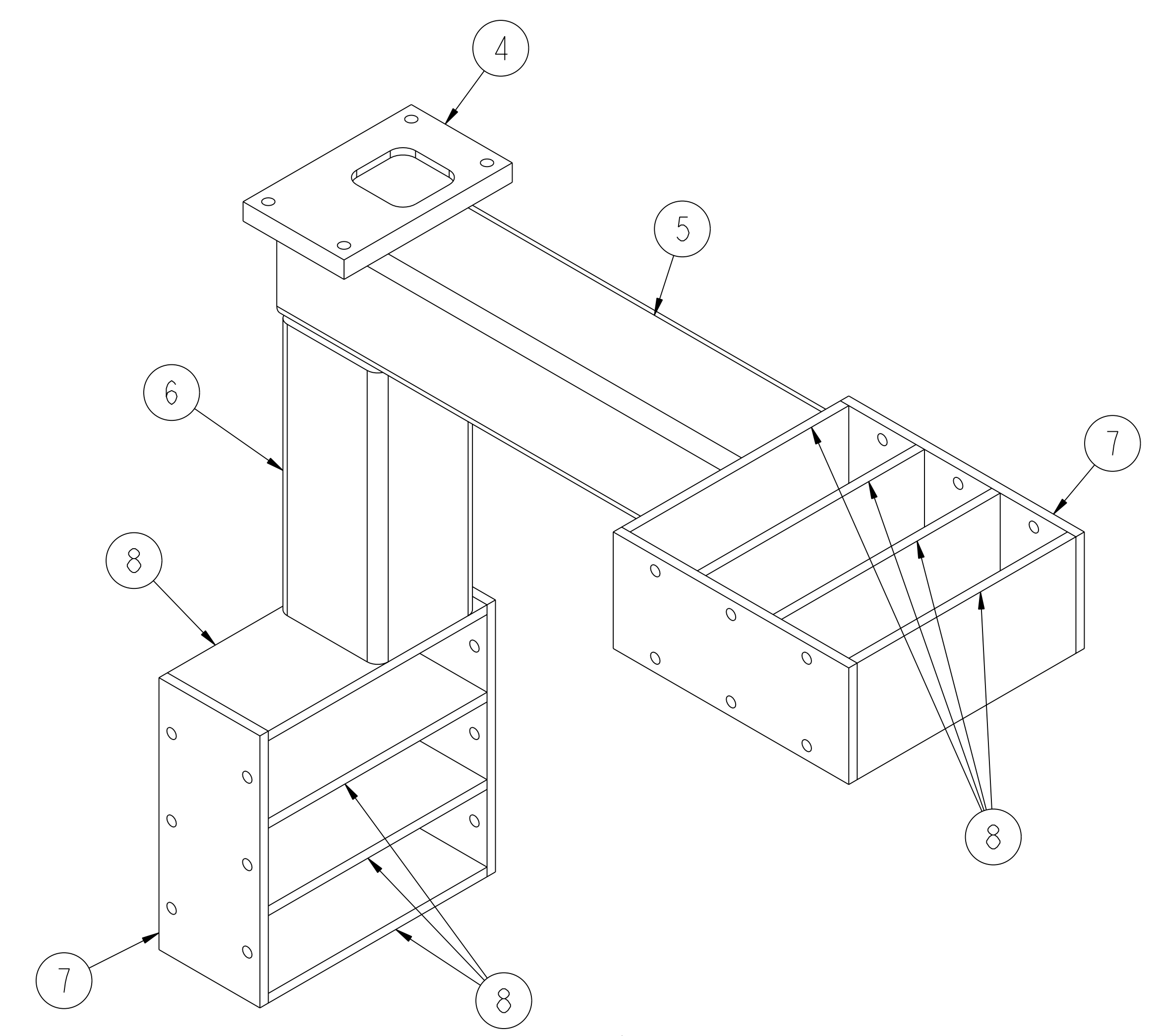
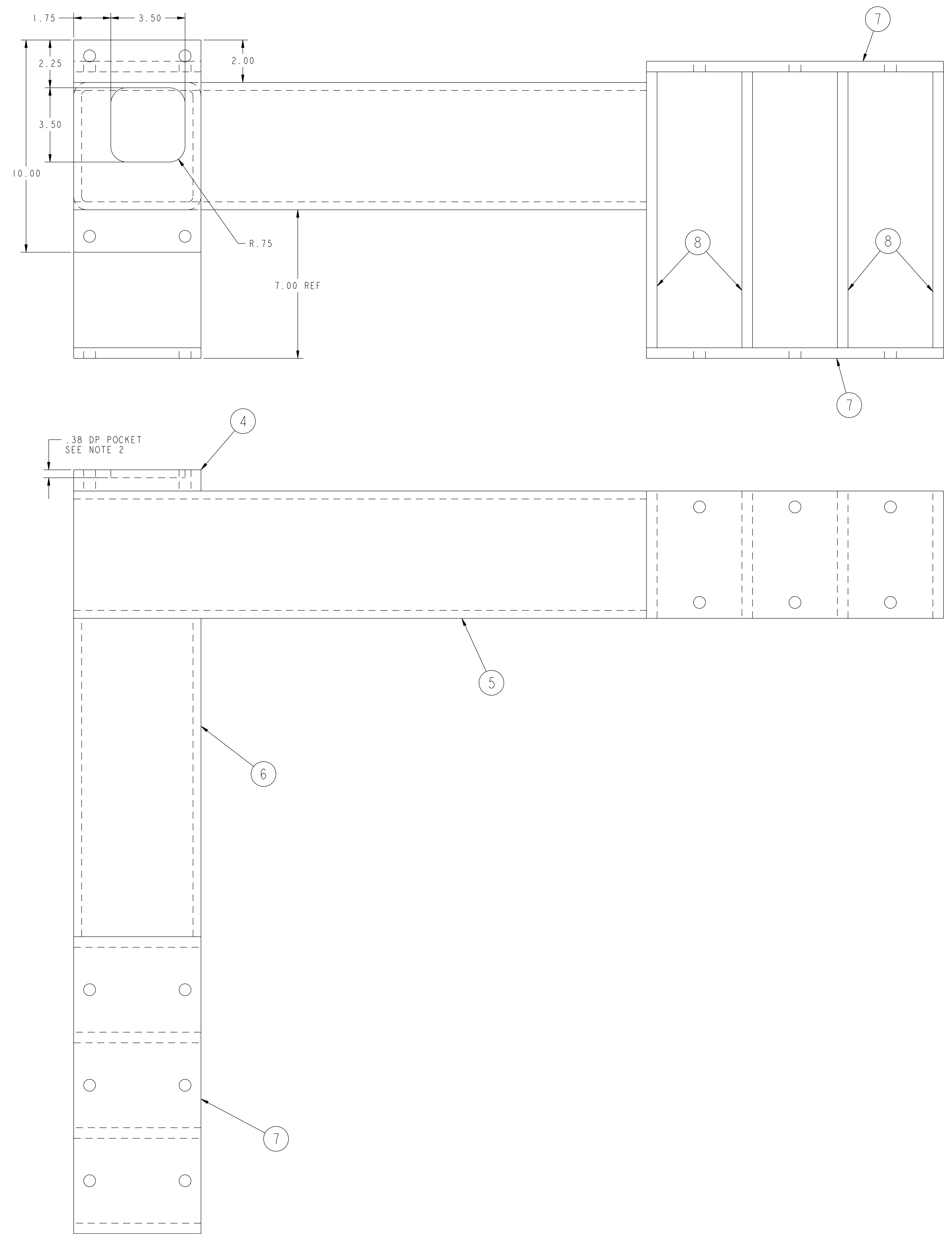
03 ASSEMBLY - TWISTED RACETRACK CASTING SUPPORT WELDMENT - TYPE C

RELEASE LEVEL: Fabrication
DWG VERSION NO: 1

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES:	PRINCETON PLASMA PHYSICS LABORATORY NATIONAL COMPACT STELLARATOR EXPERIMENT	
	UNLESS OTHERWISE SPECIFIED	DIMENSIONS ARE IN INCHES MACHINE SURFACES	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	BREAK SHARP EDGES .005/.020	TOLERANCES NON-CUMULATIVE	DSN: L. MORRIS
NEXT ASSEMBLY	DECIMAL-INCH FRACTIONS	CHK: S. RAFTOPOULOS	DRAWING NO:
WELDING ENGINEER	.XX +/- .000 0°-120° +/- 15.0 .XXX +/- .005 120°-120° +/- 15.0 ANGULAR +/- 0°-15° OVER 120° +/- 15.0	ENGR: J. CHRZANOWSKI	SE144-201
		SUPV: J. SIEGEL	SHEET 3 OF 4 REV 0

NCSX-SE144-201

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



REFERENCE ISOMETRIC

NOTE:
THIS WELDMENT IS IDENTICAL TO WELDMENT - TYPE A SHOWN ON SHEET 1 EXCEPT AS INDICATED HEREON.

RELEASED FOR FABRICATION / INSTALLATION

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

04 ASSEMBLY - TWISTED RACETRACK CASTING SUPPORT WELDMENT - TYPE D

RELEASE LEVEL: Fabrication
DWG VERSION NO: 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 WINDING FACILITY TWISTED RACETRACK WINDING TWISTED RACETRACK CASTING SUPPORT WELDMENTS	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	DIMENSIONS ARE IN INCHES MACHINE SURFACES	BREAK SHARP EDGES .005/.020	DSN: L. MORRIS
NEXT ASSEMBLY	TOLERANCES NON-CUMULATIVE	DECIMAL-INCH FRACTIONS	CHK: S. RAFTOPOULOS
		.XX +/- .030 .XXX +/- .005 ANGULAR +/- .05	ENGR: J. CHRZANOWSKI SUPV: J. SIEGEL
WEIGHT	244.9 lbs	MODEL NAME	SE144-201
WELDING ENGINEER		DRAWING NO:	SE144-201
		SHEET 4 OF 4	REV 0