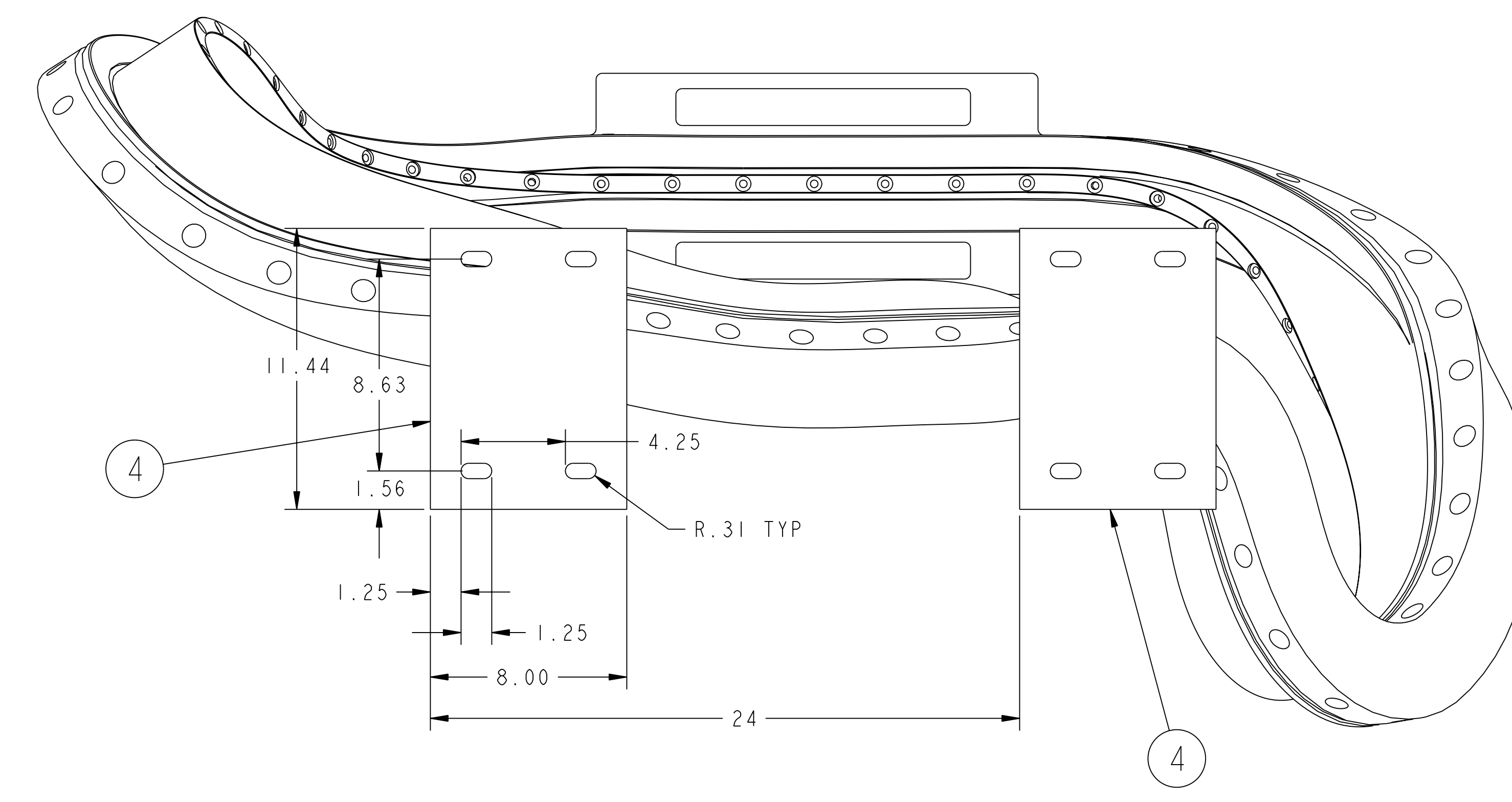
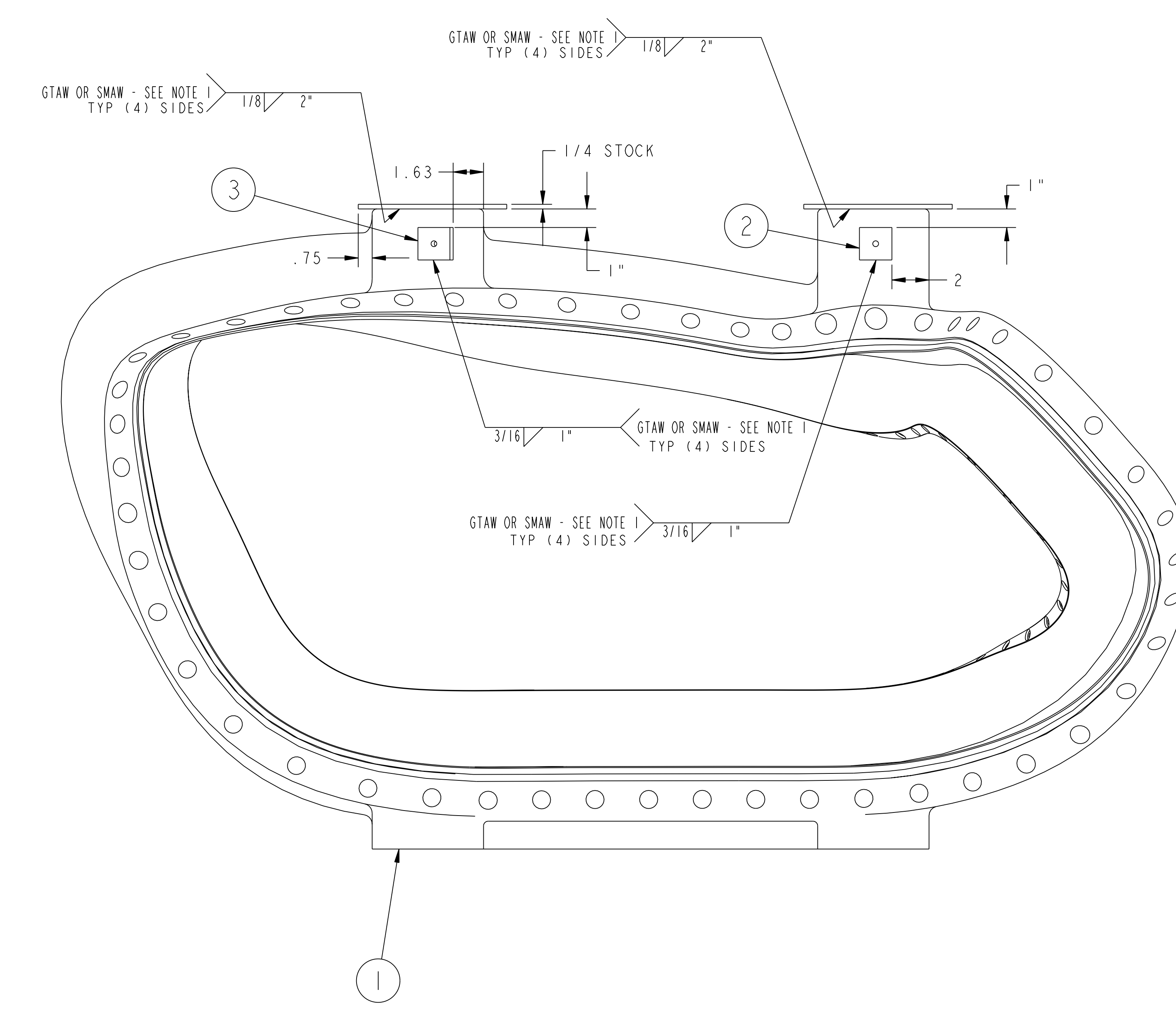
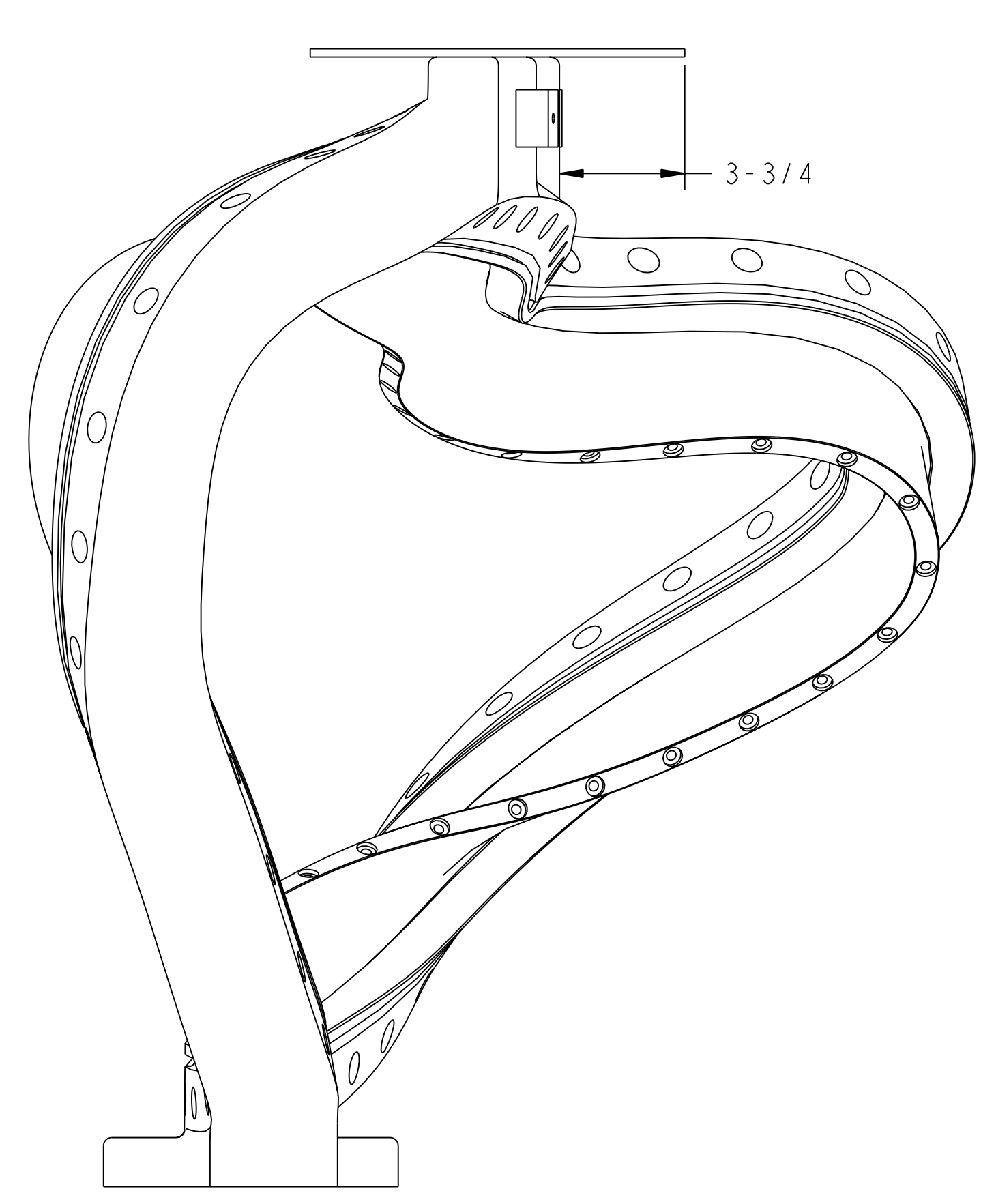


NO.	REVISION	BY	CH	SUP	APPROVED	DATE



NOTE
 1. WELDING TO BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF AWS D1.6 AND PPPL PROCEDURE EM-002. VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH THE ACCEPTANCE CRITERIA OF AWS D1.6.



RELEASED FOR FABRICATION / INSTALLATION
 PPPL Drafting:

QTY	PART NO.	DESCRIPTION	UNIT
2	4	THIS DWG	SUPPORT PLATE
1	3	SE144-208-2	LIFTING LUG - TYPE 2
1	2	SE144-208-1	LIFTING LUG - TYPE 1
1	1	SE140-080	TWISTED RACETRACK ASSEMBLY
1	—	THIS DWG	TWISTED RACETRACK LIFTING LUG AND SUPPORT PLATE WELDMENT
1	—	—	—

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E		CENTRAL FILES: UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES MACHINE SURFACES UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY NATIONAL COMPACT STELLARATOR EXPERIMENT	
DO NOT VERIFY INFORMATION BY SCALING DRAWING		BREAK SHARP EDGES .005/.020	MODULAR COIL WINDING FACILITY TWISTED RACETRACK WINDING TWISTED RACETRACK LIFTING LUG AND SUPPORT PLATE WELDMENT	
WEIGHT 706.5 lbs		TOLERANCES NON-CUMULATIVE	DSN: L. MORRIS 6-29-05 DRAWING NO:	
MODEL NAME SE144-209		DECIMAL-INCH FRACTIONS	CHK: G. GETTELFINGER 6-29-05	
NEXT ASSEMBLY		.XX ±.030 12°-12° ±.118	ENGR: G. GETTELFINGER 6-29-05	
WELDING ENGINEER L. DUDEK 6-29-05		.XXX ±.005 72°-120° ±.114 ANGULAR ±.0°-15°	OVER: 120°-122° SUPV: J. SIEGEL 6-29-05	
RELEASE LEVEL: Fabrication DWG VERSION NO: 0		SE144-209		SHEET 1 OF 1 REV 0

NCSX-SE144-209