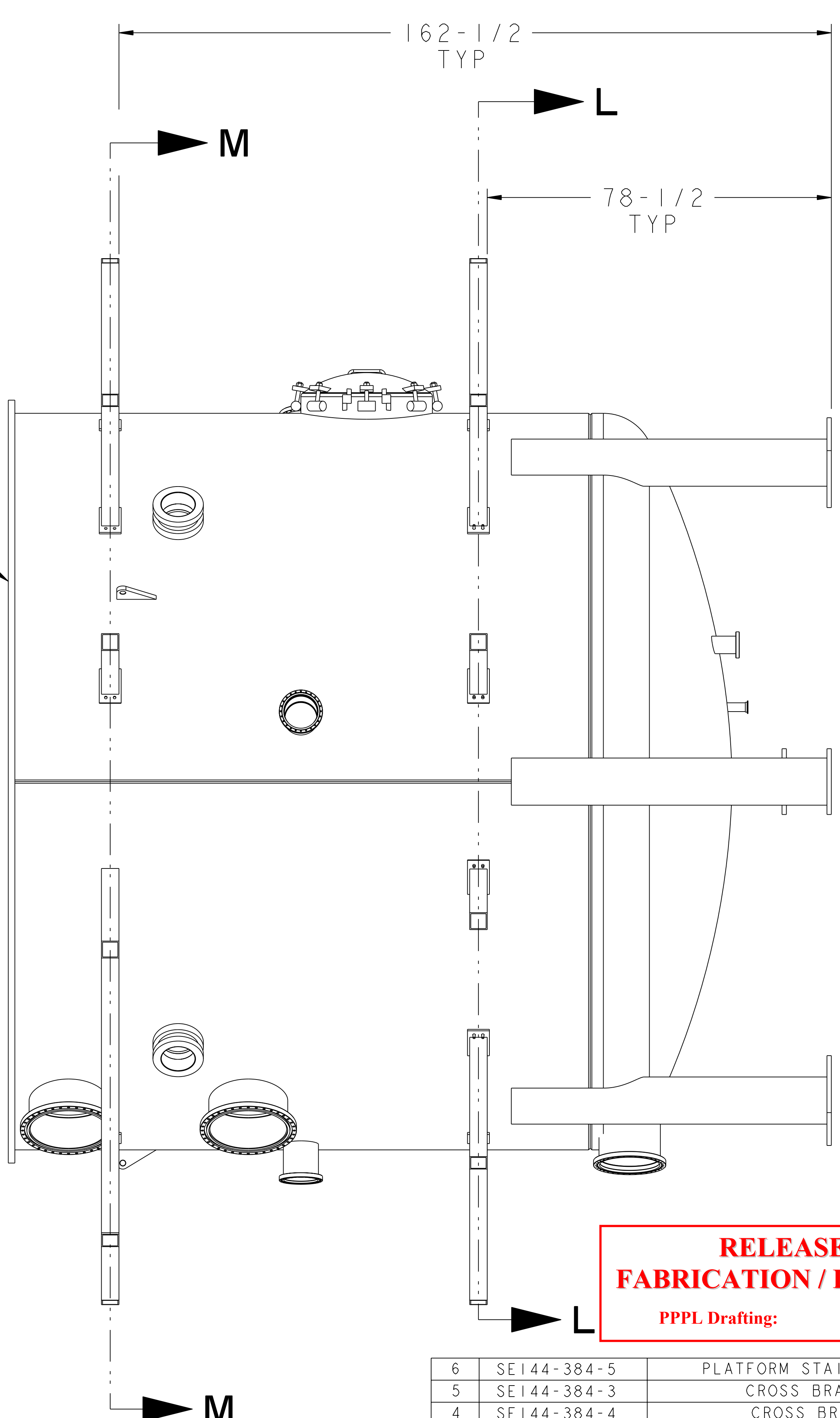
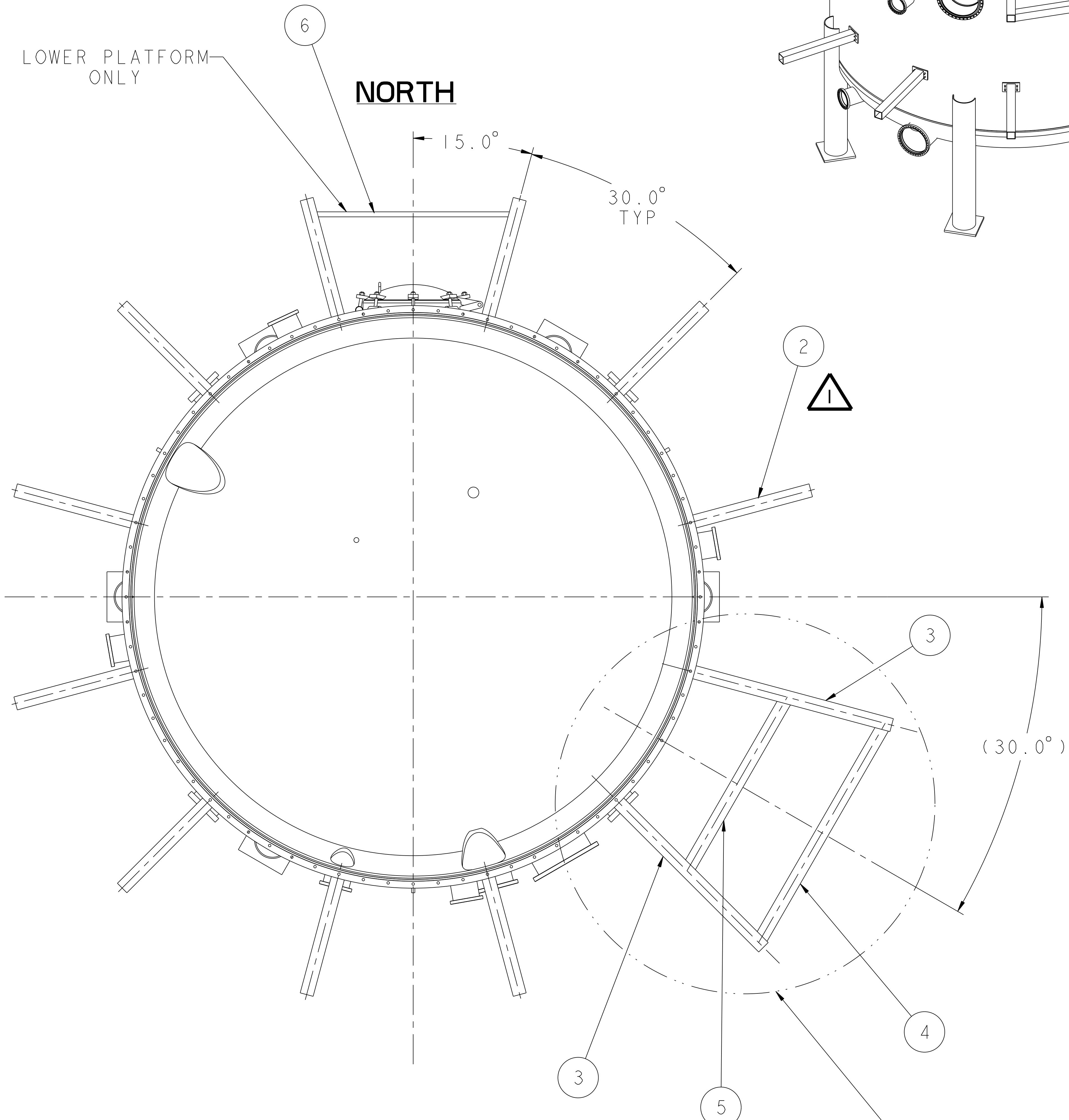
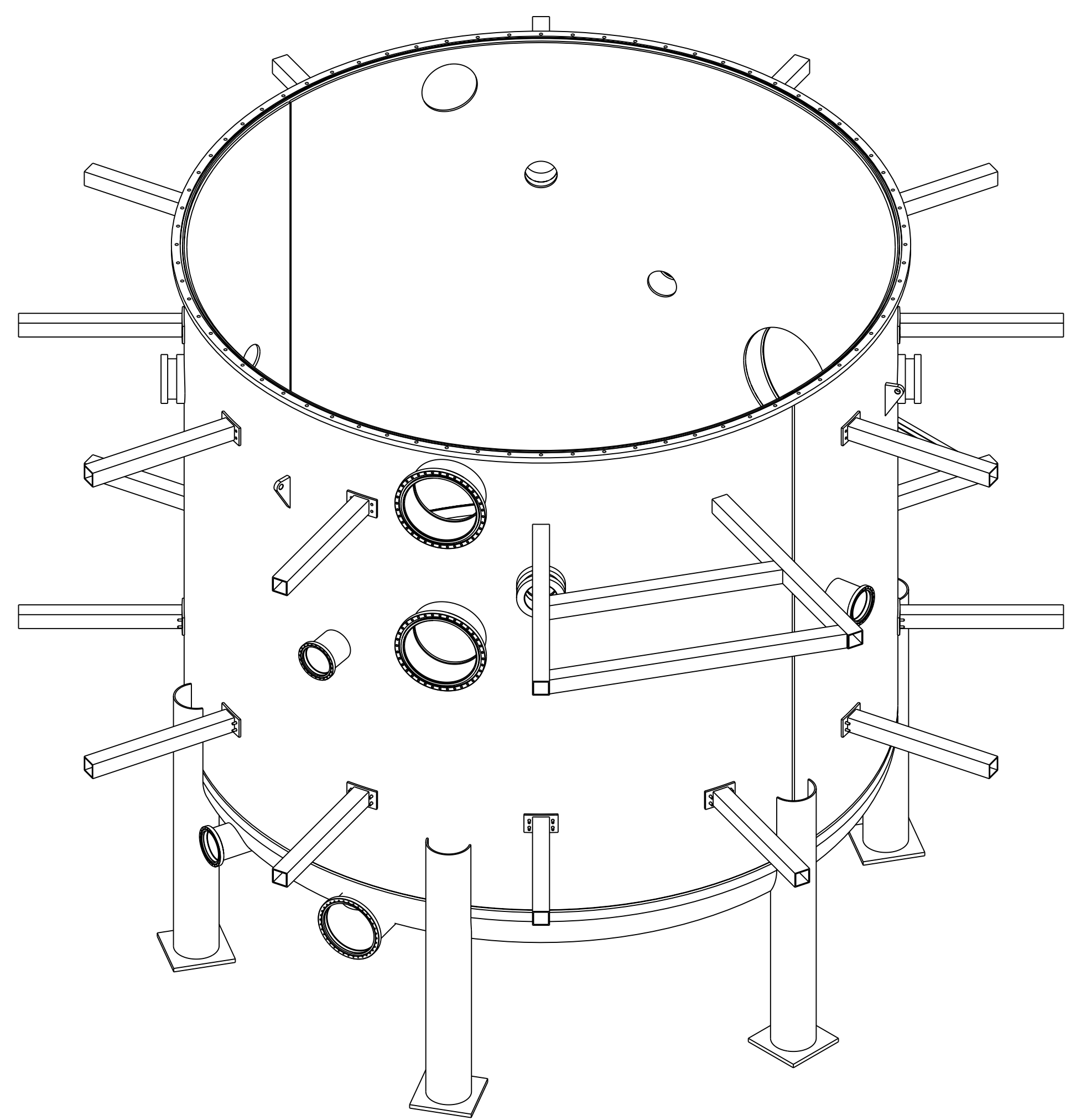


NO.	REVISION	BY	CH	SUP	APPROVED	DATE
1	REVISED PER ECN #4852	JDR	JC	JS	S. RAFTOPOULOS	4/30/04

NOTE

1. WELDING SHALL BE PERFORMED IN ACCORDANCE WITH PPPL PROCEDURE EM-002.
2. VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH ACCEPTANCE CRITERIA OF ASME B31.3 CATEGORY "D".
3. NOTE ORIENTATION OF ALL PARTS BEFORE WELDING.



RELEASED FOR FABRICATION / INSTALLATION
PPPL Drafting:

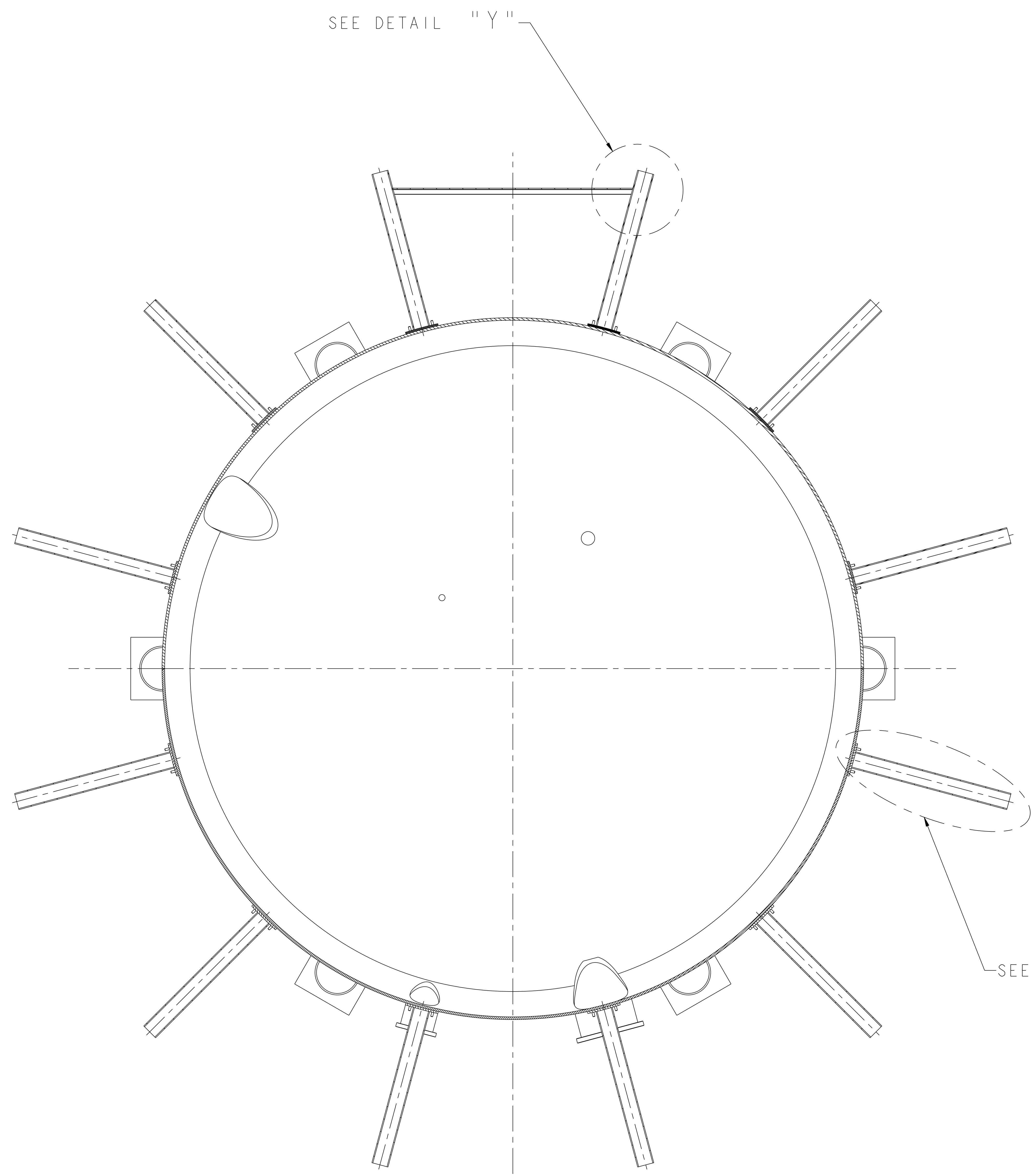
PART NO.	DRAWING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY	REOD
6	SE144-384-5	PLATFORM STAIRS CONNECTOR	STN STL	1	
5	SE144-384-3	CROSS BRACE SHORT	STN STL	1	
4	SE144-384-4	CROSS BRACE LONG	STN STL	1	
3	SE144-384-2	RADIAL SUPPORT BEAM LONG	STN STL	2	
2	SE144-360	RADIAL SUPPORT BEAM BOLTED	STN STL	22	
1	SE144-308	VESSEL & PORTS ASSEMBLY	STN STL	1	

COMPUTER GENERATED DRAWING		CENTRAL FILES:	PRINCETON PLASMA PHYSICS LABORATORY	
MANUAL CHANGES NOT PERMITTED		UNLESS OTHERWISE SPECIFIED	PRINCETON UNIVERSITY	
Pro E		DIMENSIONS ARE IN INCHES	NATIONAL COMPACT STELLARATOR EXPERIMENT	
DO NOT VERIFY INFORMATION BY SCALING DRAWING		BREAK SHARP EDGES .005/ .020	STELLARATOR CORE	
SCALE 0.062		TOLERANCES NON-CUMULATIVE	MODULAR COIL WINDING FACILITY	
NEXT ASSEMBLY		DECIMAL-INCH FRACTIONS	CHK: J. CHRZANOWSKI	DRAWING NO:
		.XX ±.000	ENGR: S. RAFTOPOULOS	SE144-304
		.XXX ±.005	SUPV: J. SIEGEL	SHEET 1 OF 4
		ANGULAR ±.0°-15°		REV I

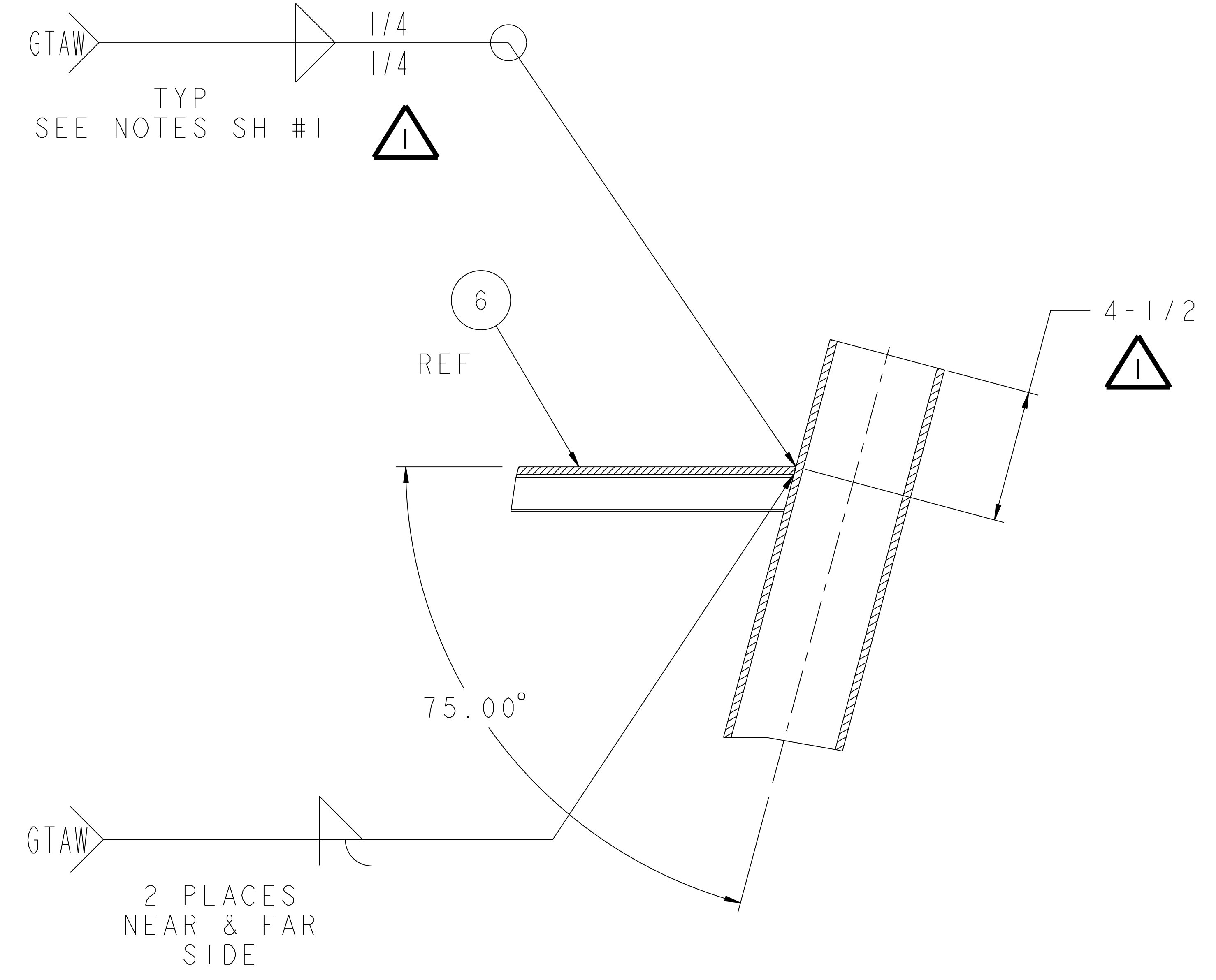
WEIGHT: 28135.2 lbs
MODEL NAME: SE144-304
RELEASE LEVEL: As Built
DWG VERSION NO: 0

NCSX-SE144-304

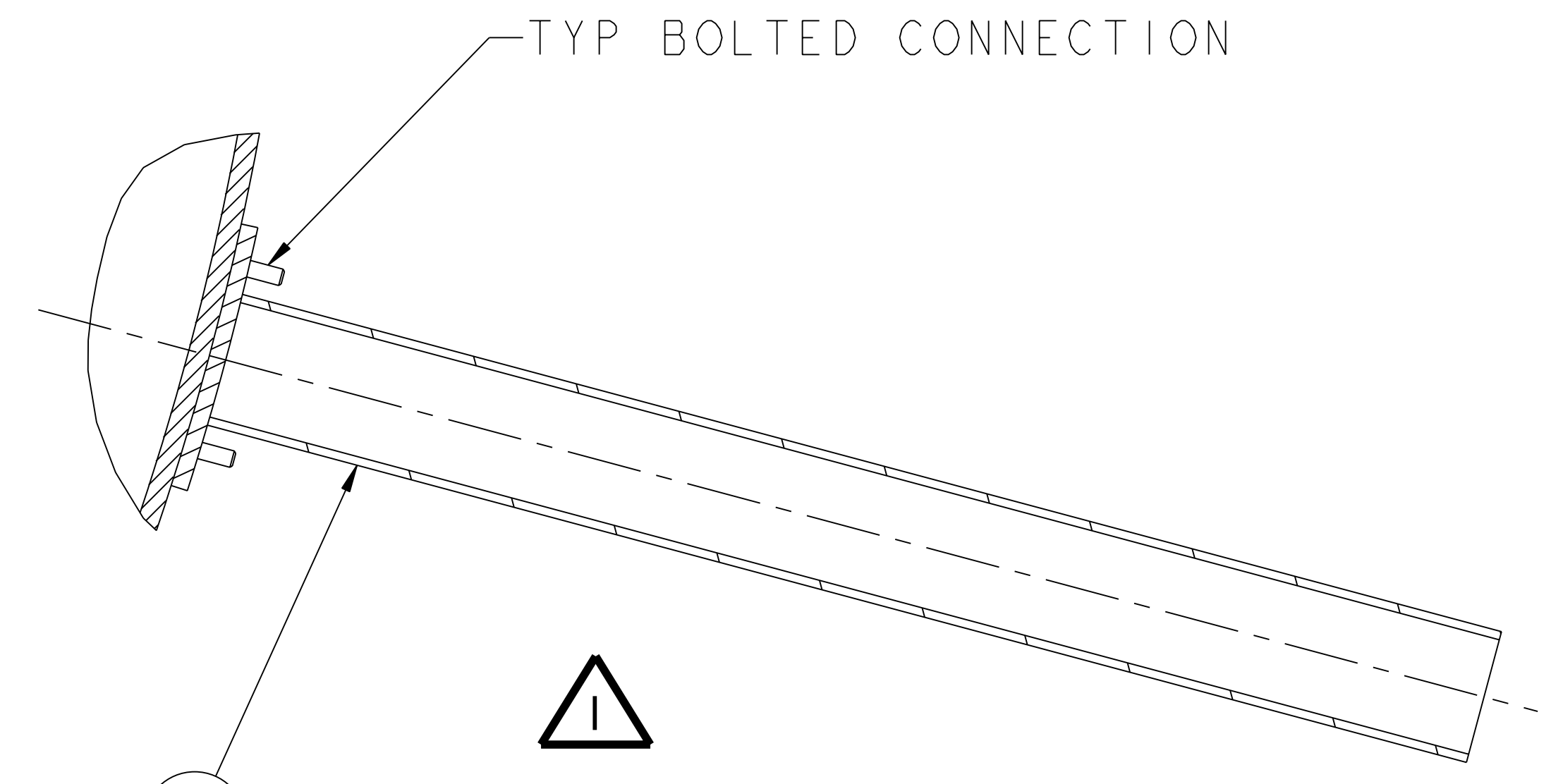
NO.	REVISION	BY	CH	SUP	APPROVED	DATE
1	REVISED PER ECN #4852	JDR	JC	JS	S. RAFTOPOULOS	5/03/04



SECTION L-L
SCALE 0.090
SHOWING LOWER PLATFORM RADIAL BEAMS



DETAIL "Y"
SCALE 0.375



DETAIL "Z"
SCALE 0.250
TYP ALL RADIAL BEAMS
SHOWN PRIOR TO INSTALLING HARDWARE

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

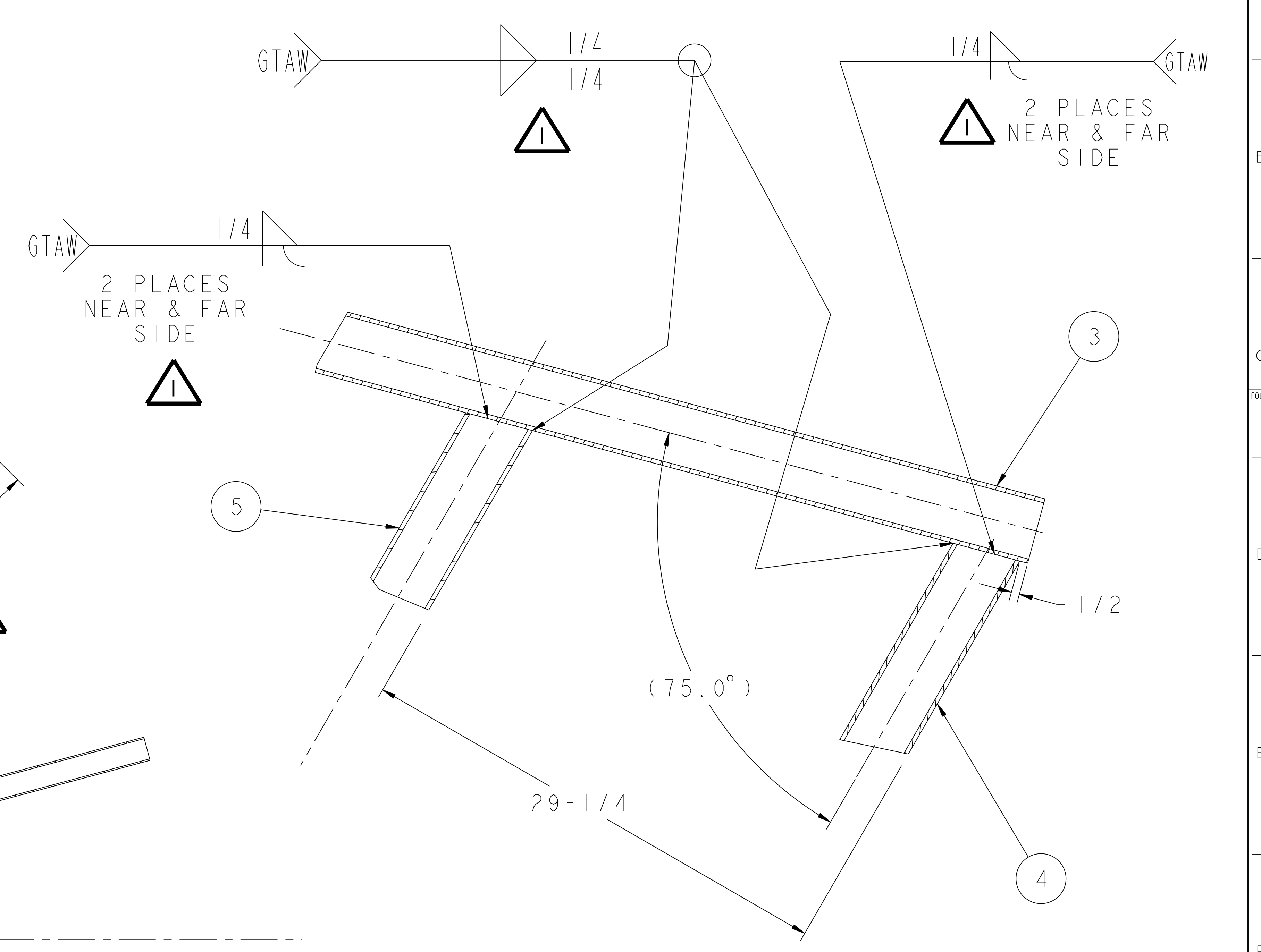
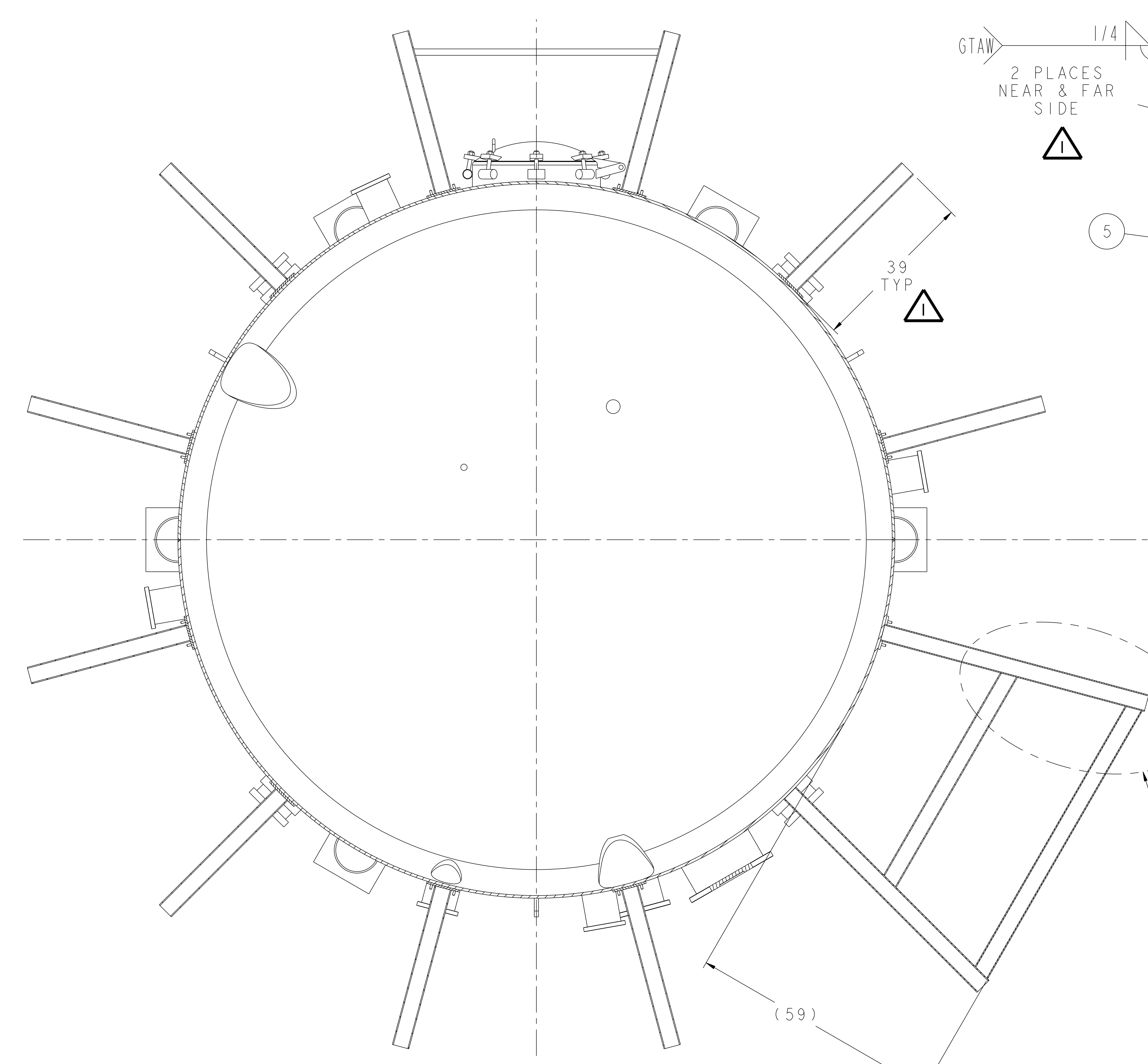
RELEASE LEVEL: As Built
DWG VERSION NO: 0

WEIGHT
28135.2 lbs
MODEL NAME
SE144-304

1	SE144-370-1	EXTERNAL SUPPORT PLATFORM LOWER ASSEMBLY	STN STL	1
PART NO.	DRAWING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY REOD
PARTS LIST				
COMPUTER GENERATED DRAWING MANUAL 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 BREAK SHARP EDGES .005/.020	NATIONAL COMPACT STELLARATOR EXPERIMENT	
NEXT ASSEMBLY		TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX +/- .030 .XXX +/- .005 ANGULAR +/- .05	DSN: J. RUSHINSKI CHK: J. CHRZANOWSKI ENGR: S. RAFTOPOULOS SUPV: J. SIEGEL	DRAWING NO: SE144-304
			SHEET 2 OF 4	REV 1

NCSX-SE144-304

NO.	REVISION	BY	CH	SUP	APPROVED	DATE
1	REVISED PER ECN #4852	JDR	JC	JS	S. RAFTOPOULOS	5/03/04

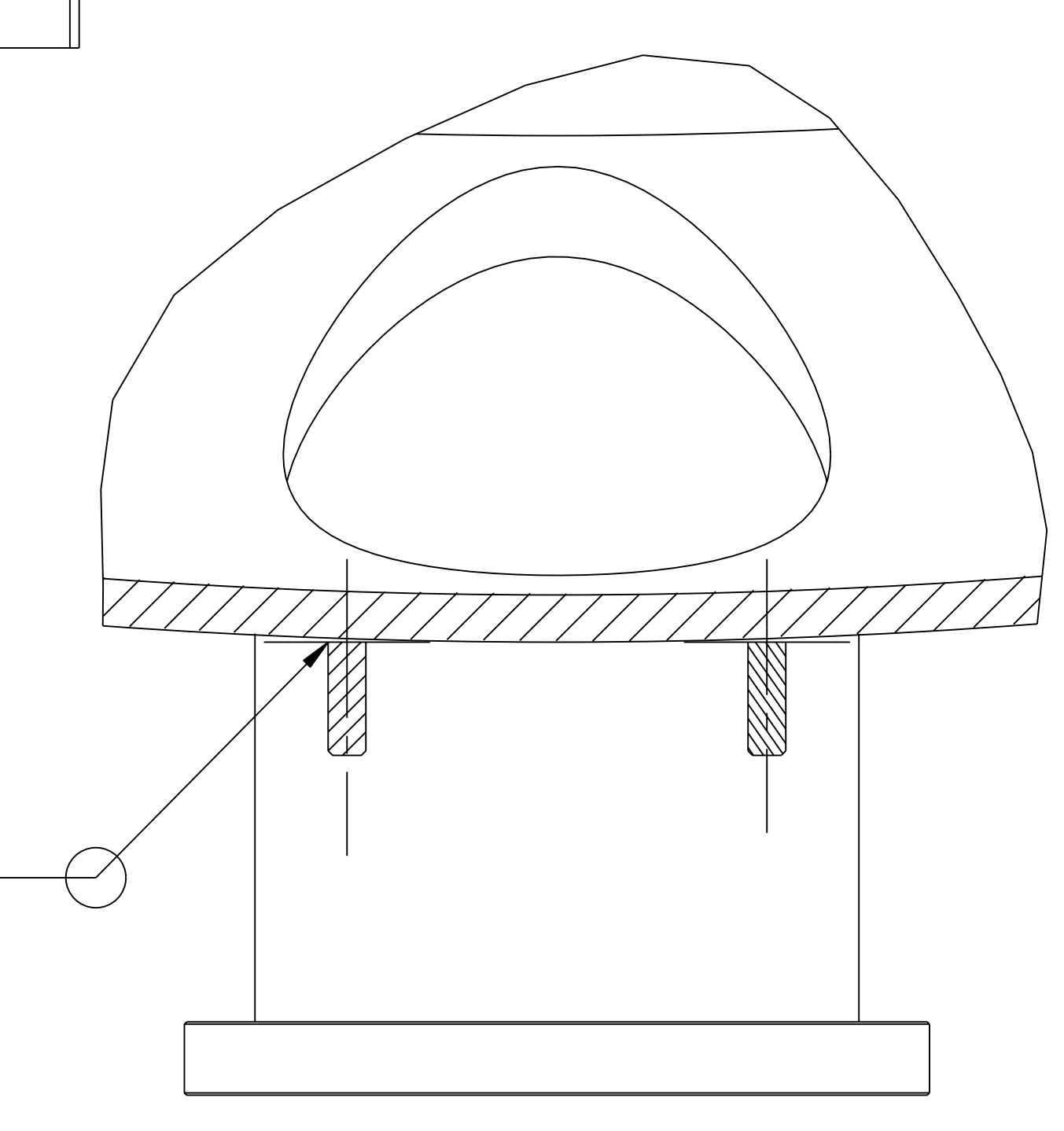
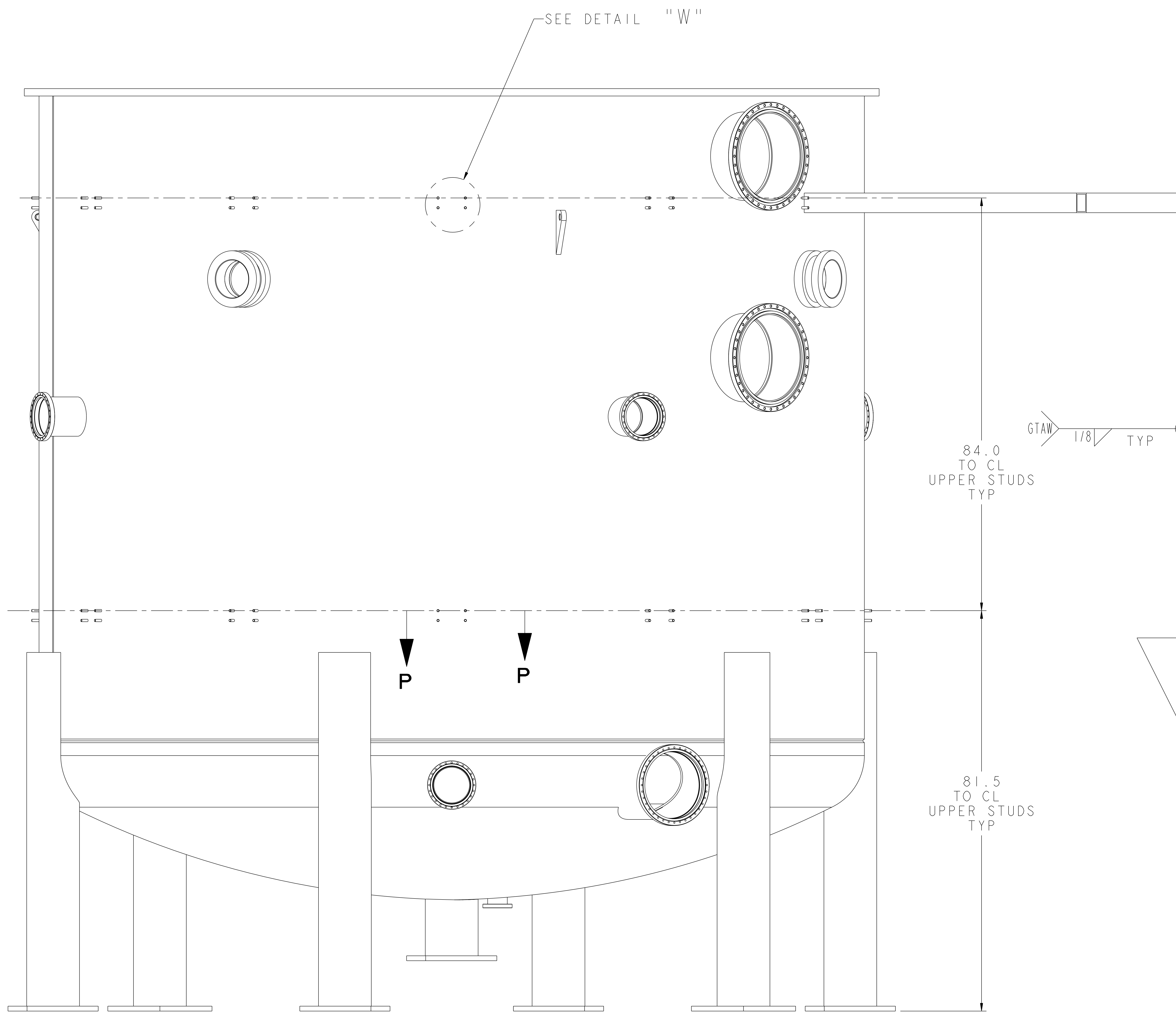


**RELEASED FOR
FABRICATION / INSTALLATION**
PPPL Drafting:

2	SE144-370-1	EXTERNAL SUPPORT PLATFORM LOWER ASSEMBLY	STN STL	1
1	4_STUDS	--	--	1
PART NO.	DRAWING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY REOD
PARTS LIST				
COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY NATIONAL COMPACT STELLARATOR EXPERIMENT		
Pro E	DIMENSIONS ARE IN INCHES MACHINE SURFACES	STELLARATOR CORE MODULAR COIL WINDING FACILITY UPPER PLATFORM WELDING DETAILS		
DO NOT VERIFY INFORMATION BY SCALING DRAWING	BREAK SHARP EDGES .005/.020	DRAWING NO: SE144-304		
TOLERANCES NON-CUMULATIVE	DECIMAL-INCH FRACTIONS	DSN: J. RUSHINSKI	SHEET 3 OF 4	
NEXT ASSEMBLY	.XX ±.000 0"-.125" ±.1250 .XX ±.000 12"-.125" ±.1250 .XX ±.005 12"-.125" ±.1250 ANGULAR ±.0°-.15° OVER 120° ±.125	CHK: J. CHRZANOWSKI	REV I	
WEIGHT	28135.2 lbs	ENGR: S. RAFTOPOULOS	SUPERVISOR: J. SIEGEL	
MODEL NAME	SE144-304	DATE: 5/03/04		
WELDING ENGINEER		SHEET 3 OF 4		
RELEASE LEVEL: As Built	DWG VERSION NO: 0	NCSX-SE144-304		

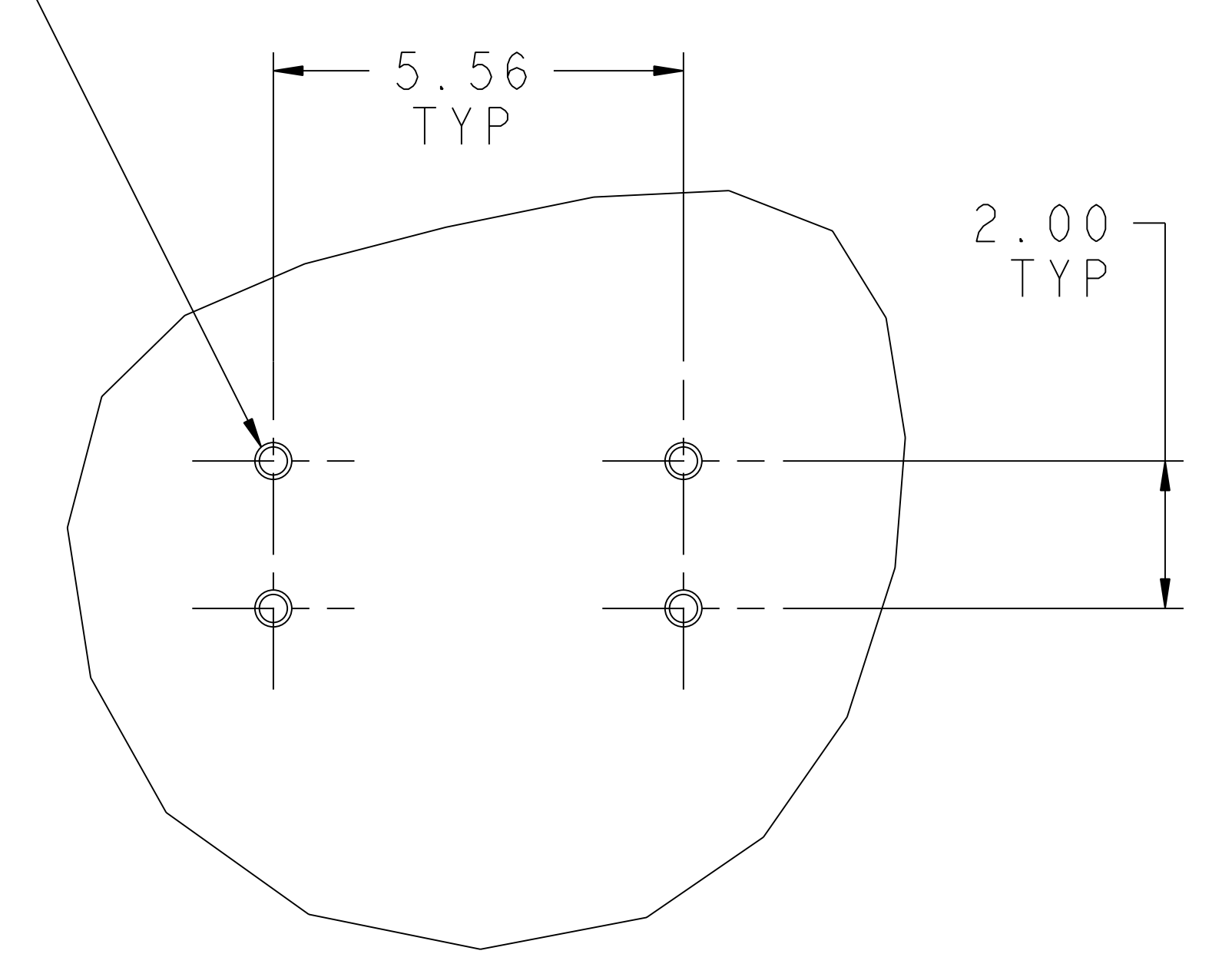
NCSX-SE144-304

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



SECTION P-P
SCALE 0.500

1/2" - 13 X 1 1/2" LG
STN STL STUDS WELDED
TO VESSEL WALL ALIGNED
WITH RADIAL BEAMS AT
LOCATIONS SHOWN



DETAIL "W"
SCALE 0.500

NEW SHEET CREATED
AS A RESULT
OF ECN #4852

**RELEASED FOR
FABRICATION / INSTALLATION**

PPPL Drafting:

RELEASE LEVEL: As Built
DWG VERSION NO: 0

WEIGHT
46766.5 lbs

MODEL NAME
SEI44-304

WELDING
ENGINEER

PART NO.	DRAWING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY RECD
PARTS LIST				
COMPUTER GENERATED DRAWING CHANGES NOT PERMITTED		CENTRAL FILES:	PRINCETON PLASMA PHYSICS LABORATORY	
Pro E		UNLESS OTHERWISE SPECIFIED	PRINCETON UNIVERSITY	
DO NOT VERIFY INFORMATION IS QUALITY DRAWING 2.5		DIMENSIONS ARE IN INCHES MACHINE SURFACES	NATIONAL COMPACT STELLARATOR EXPERIMENT	
NEXT ASSEMBLY		BREAK SHARP EDGES .005/.020	STELLARATOR CORE MODULAR COIL WINDING FACILITY WELD STUD LOCATIONS DETAILS	
		TOLERANCES NON-CUMULATIVE	DSN: J. RUSHINSKI	DRAWING NO:
		DECIMAL-INCH FRACTIONS	CHK: J. CHRZANOWSKI	SEI44-304
		.XX +/- .030	ENGR: S. RAFTOPOULOS	SHEET 4 OF 4
		.XXX +/- .005	SUPV: J. SIEGEL	REV
		ANGULAR +/- 0°-15'		

NCSX-SEI44-304