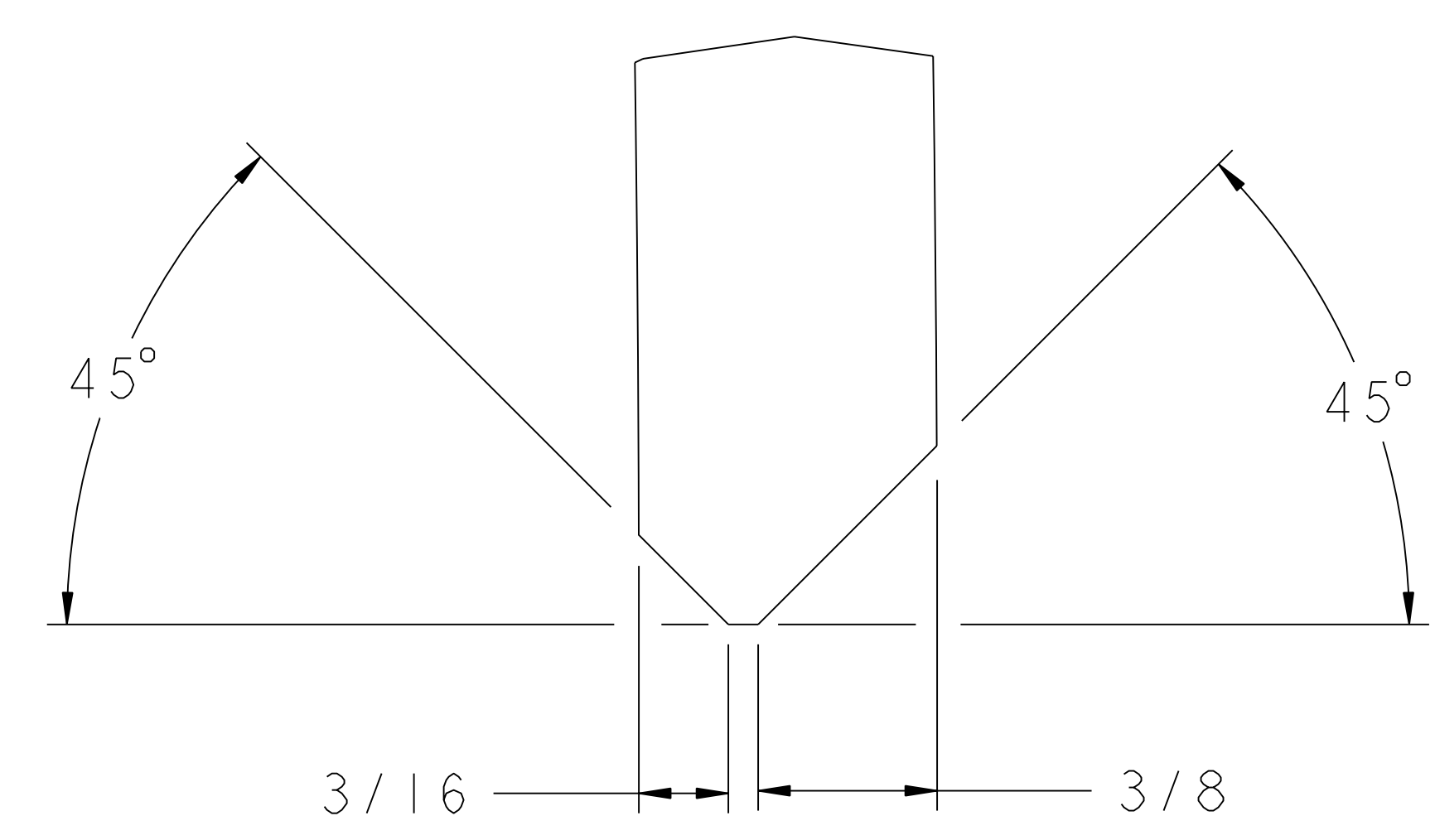


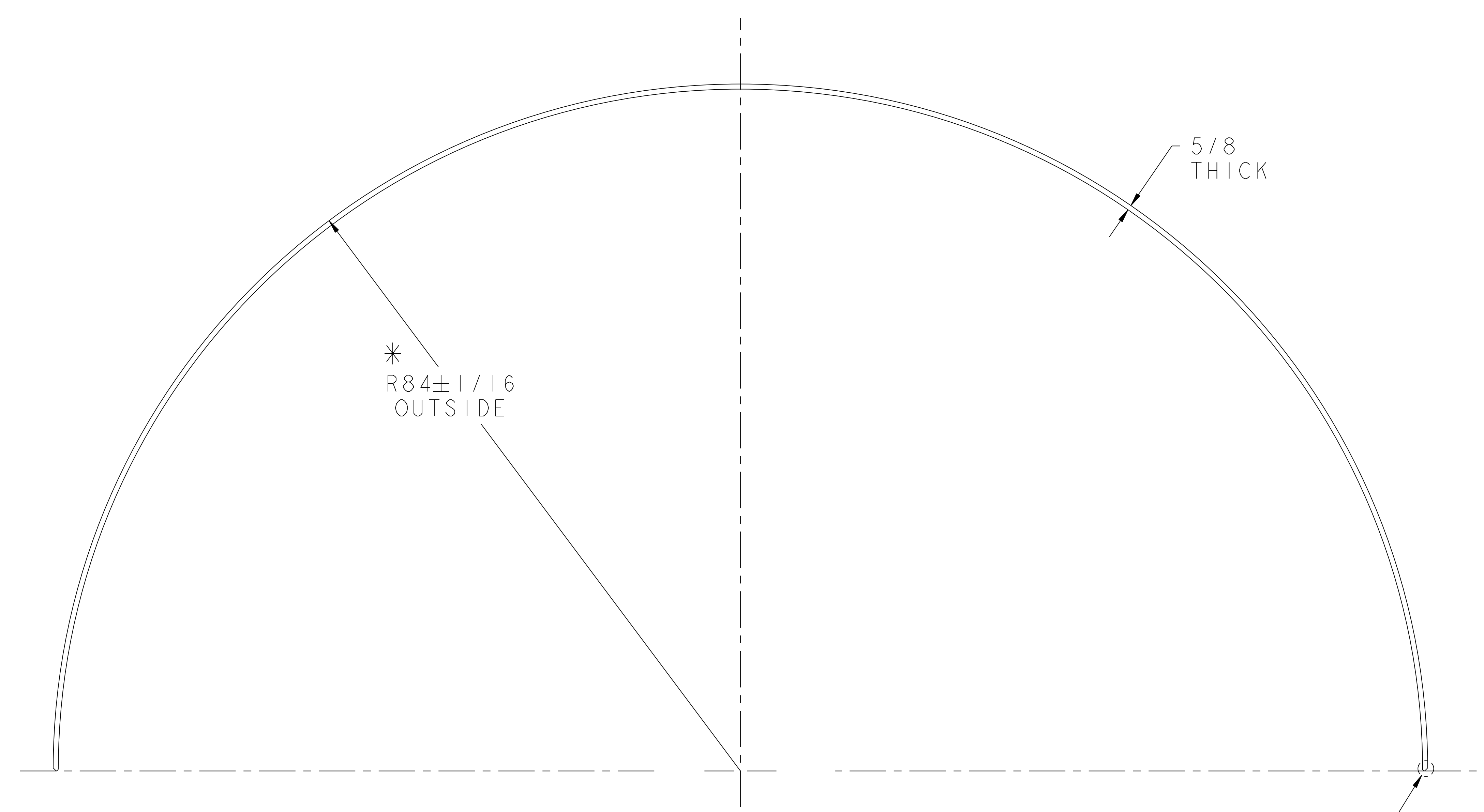
| NO. | REVISION             | BY | CH | SUP | APPROVED | DATE    |
|-----|----------------------|----|----|-----|----------|---------|
| 1   | REVISED PER ECN-4796 | LM |    |     |          | 8-20-03 |



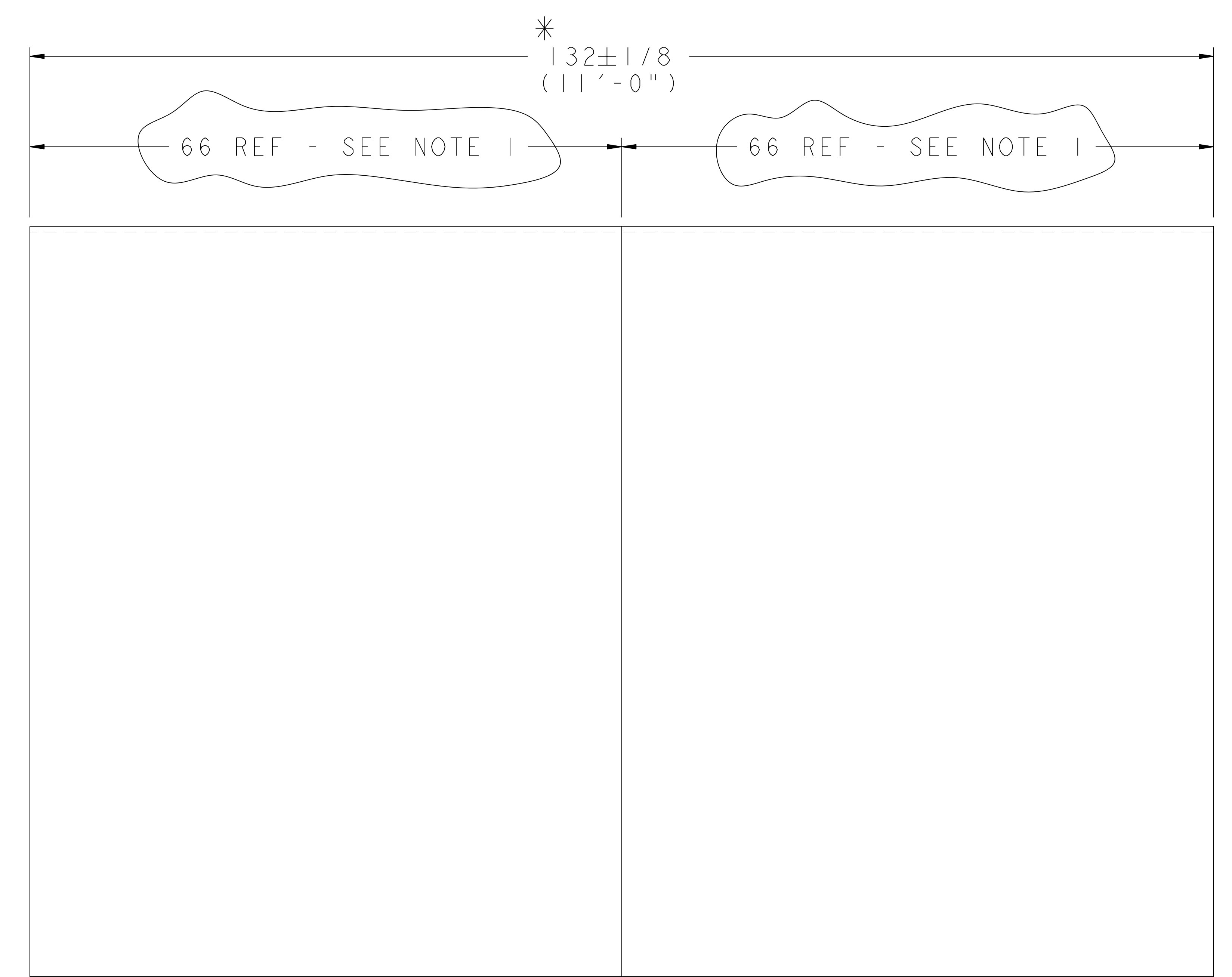
**DETAIL "Z"**  
SCALE 3.000  
WELD PREP DETAIL  
TYP

**NOTES**

1. AT VENDOR'S DISCRETION THIS ROLLED SECTION MAY BE CONSTRUCTED FROM (2) SHEETS WITH THE PROVISION THAT DIMENSIONS MARKED THUS \* ARE TO BE HELD.



SEE DETAIL "Z"



**RELEASED FOR  
FABRICATION / INSTALLATION**

WORK THIS DRAWING WITH DRAWING SEI44-311

APPROX WT 6,300 LBS

SEE NOTE 1

RELEASE LEVEL: Fabrication  
DWG VERSION NO: 2

| PART NO.                                                            | DRAWING NO | NOMENCLATURE OR DESCRIPTION                                                 | MATERIAL                                                                                     | QTY                                                            | RECD |
|---------------------------------------------------------------------|------------|-----------------------------------------------------------------------------|----------------------------------------------------------------------------------------------|----------------------------------------------------------------|------|
| 1                                                                   | SEI44-310  | 180 DEG ROLLED CENTER SECTION                                               | 304 STN STL                                                                                  | 2                                                              |      |
| PARTS LIST                                                          |            |                                                                             |                                                                                              |                                                                |      |
| COMPUTER GENERATED DRAWING<br>MANUAL CHANGES NOT PERMITTED<br>Pro E |            | CENTRAL FILES:<br>UNLESS OTHERWISE SPECIFIED                                | PRINCETON PLASMA PHYSICS LABORATORY<br>NATIONAL COMPACT STELLARATOR EXPERIMENT               |                                                                |      |
| DO NOT VERIFY INFORMATION BY SCALING DRAWING                        |            | DIMENSIONS ARE IN INCHES<br>MACHINE SURFACES<br>BREAK SHARP EDGES .005/.020 | STELLARATOR CORE<br>MODULAR COIL WINDING FACILITY<br>AUTOCLAVE CENTER SECTION ROLLING DETAIL |                                                                |      |
| WEIGHT<br>6283.4 lbs                                                |            | SCALE 0.125                                                                 | TOLERANCES NON-CUMULATIVE                                                                    | DSN: J. RUSHINSKI<br>DRAWING NO:                               |      |
| MODEL NAME<br>SEI44-310                                             |            | NEXT ASSEMBLY                                                               | DECIMAL-INCH FRACTIONS                                                                       | CHK: J. CHRZANOWSKI<br>ENGR: S. RAFTOPOULOS<br>SUPV: J. SIEGEL |      |
|                                                                     |            | WELDING ENGINEER                                                            | ANGULAR ±.0°-15° OVER 120° ±.1°-172°                                                         | SEI44-310<br>SHEET 1 OF 1 REV 1                                |      |

NCSX-SEI44-310