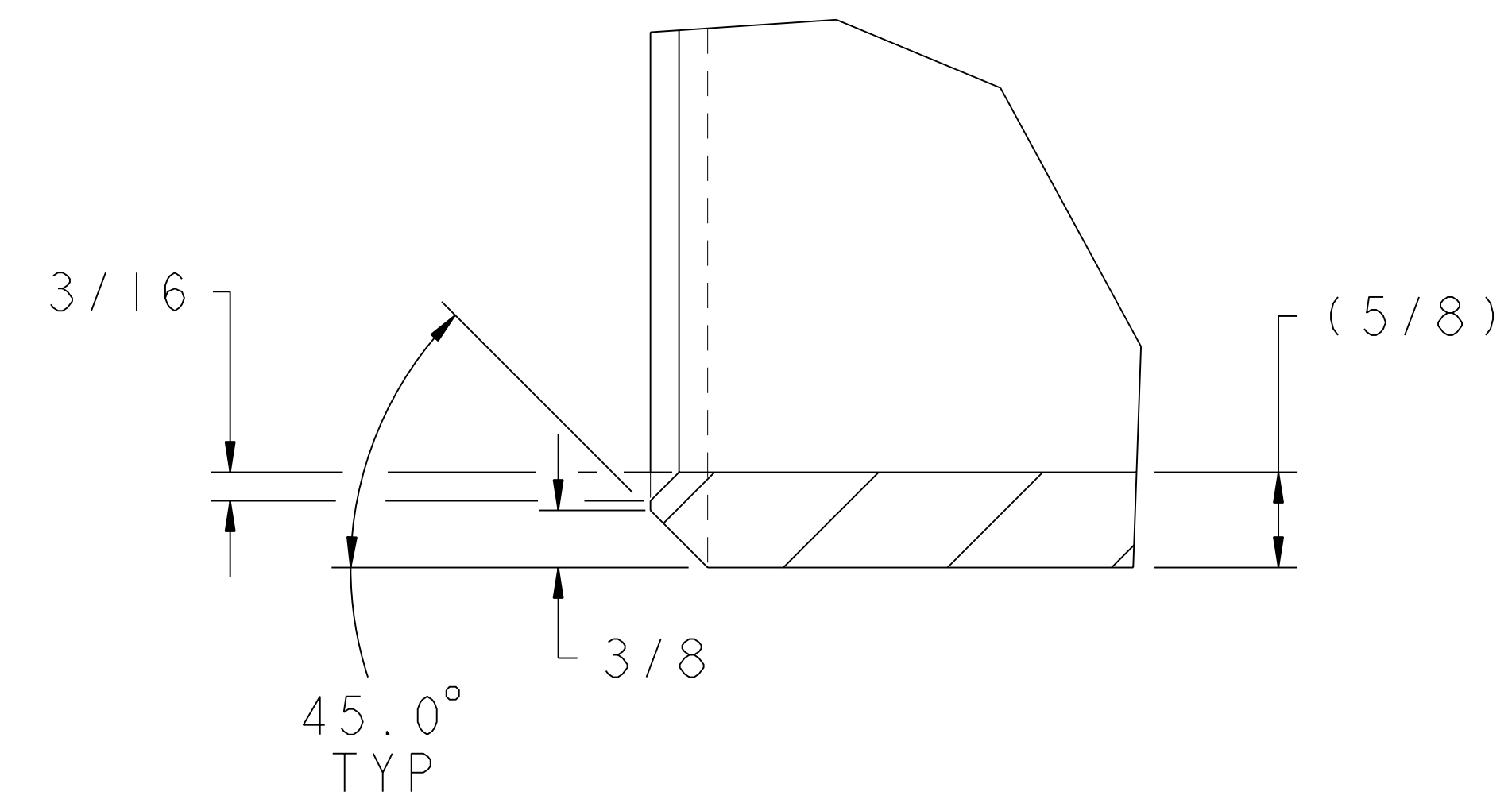
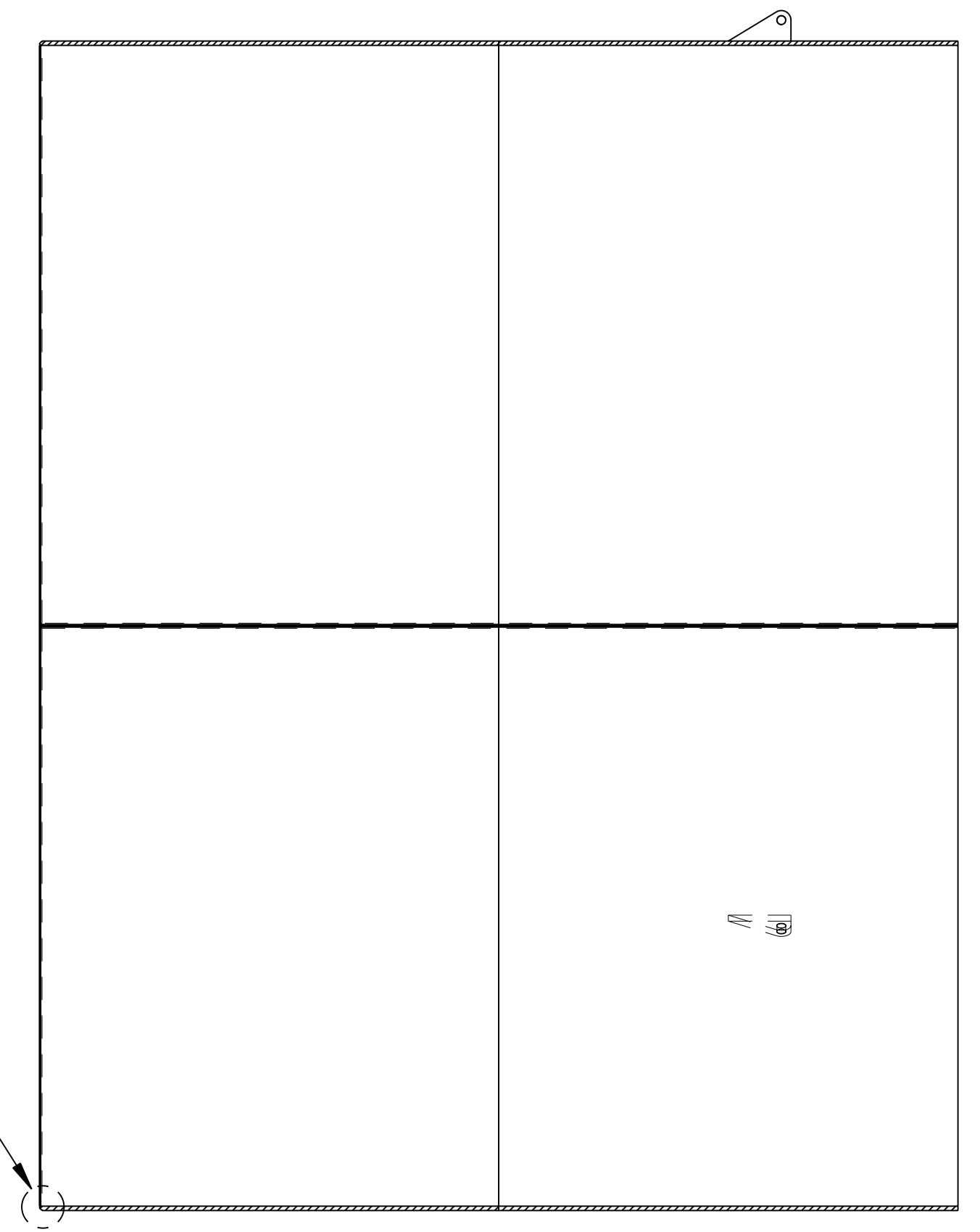


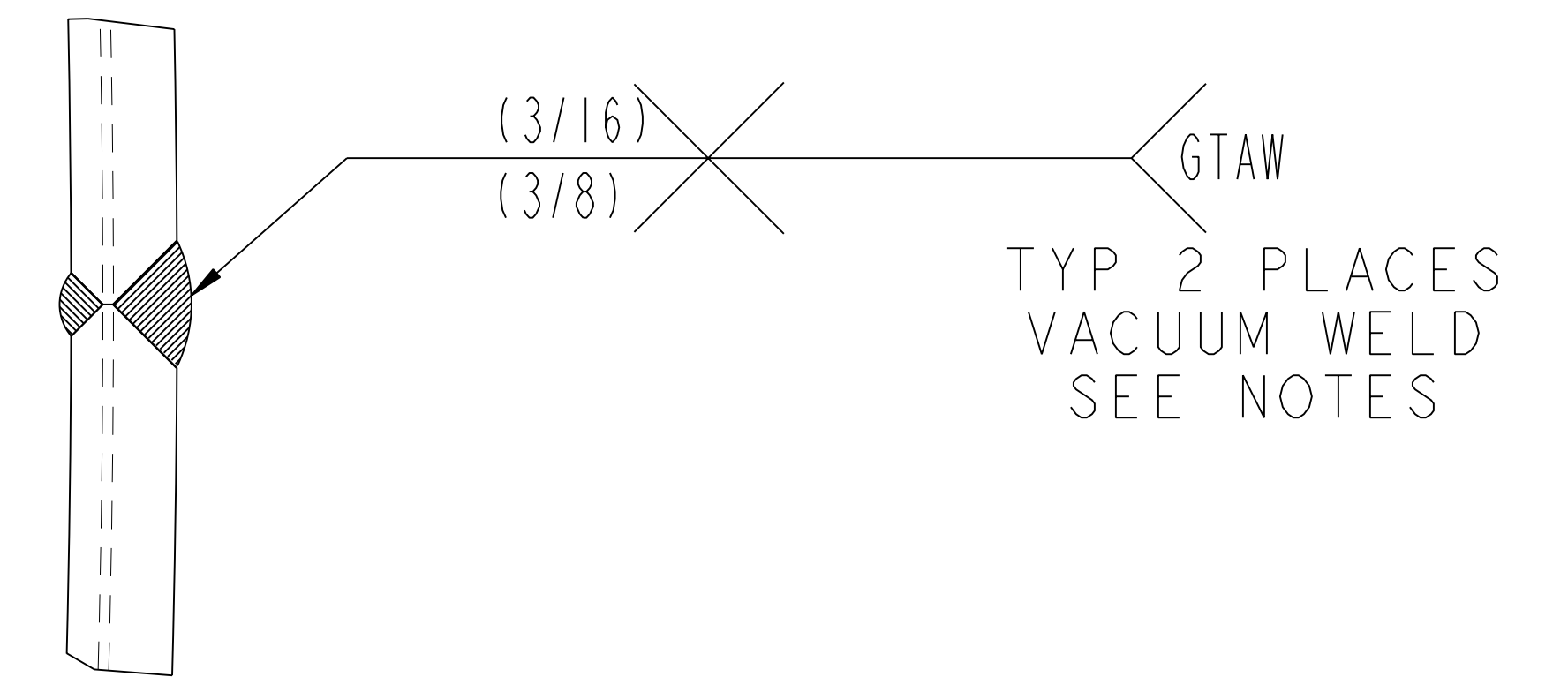
NO.	REVISION	BY	CH	SUP	APPROVED	DATE
1	REVISED PER ECN-4796	LM				8-20-03



DETAIL "X"
WELD PREP DETAIL
THIS END ONLY
SCALE 1.000

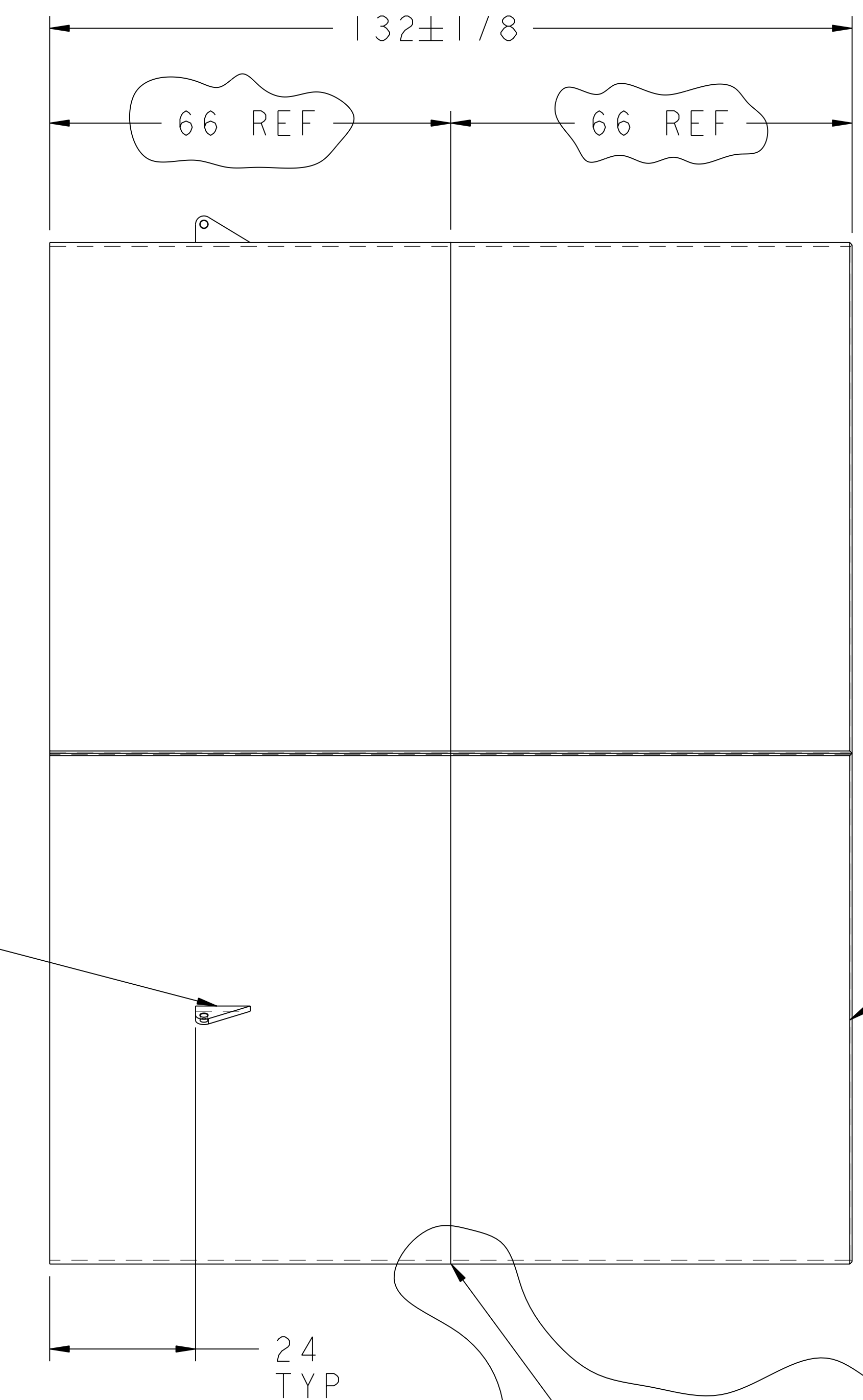


SECTION "A"- "A"
SCALE 0.050



DETAIL "Z"
SCALE 1.000
TYP

SEE DETAIL "X"
THIS END ONLY



Ø 168 ± 1/16
OUTSIDE

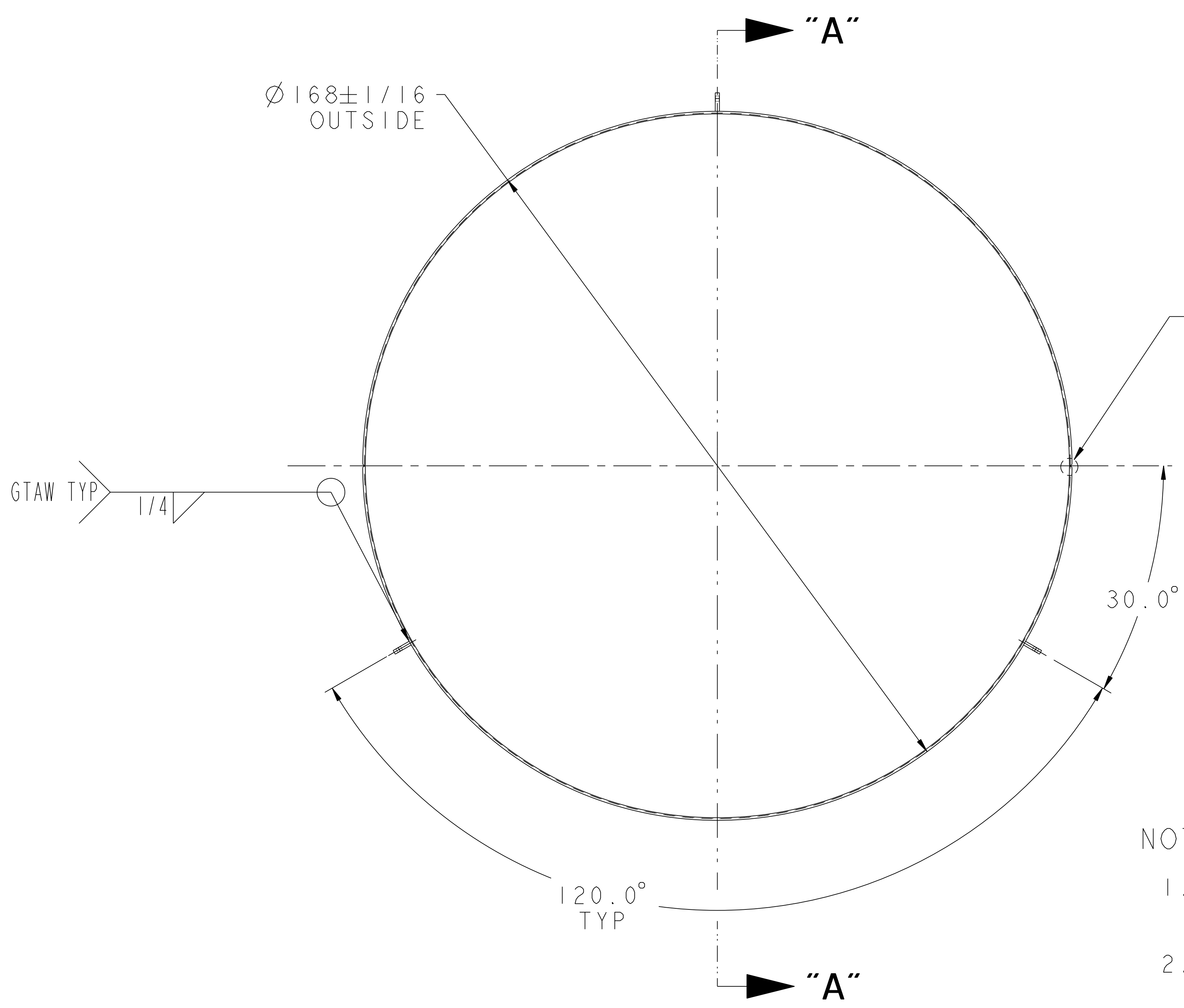
SECTION "A"- "A"
SCALE 0.050

SEE DETAIL "Z"

NOTE:
THIS WELD REQ'D IF VENDOR PROVIDES
66" LG ROLLED SEGMENTS AS INDICATED
ON DRAWING SE144-310. WELD PREP
MATING ENDS AS PER DETAIL "X"

WORK THIS DRAWING WITH DRAWING SE144-310

APPROX WT 12,650 LBS



NOTE

- WELDERS MUST BE CERTIFIED TO SECTION IX OF ASME CODE.
- WELD PROCEDURES MUST BE IN ACCORDANCE WITH SECTION IX.
- VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH ACCEPTANCE CRITERIA OF AWS D1.6
- NOTE ORIENTATION OF ALL PARTS BEFORE WELDING.
- LEAK RATE SHALL NOT EXCEED 1×10^{-5} torr-1/sec
- FULL PENETRATION JOINTS WELDED FROM BOTH SIDES SHALL HAVE THE VACUUM SIDE WELDED USING THE GTAW PROCESS FOLLOWED BY BACK-GRINDING TO SOUND METAL AND 8X VISUAL EXAMINATION ON THE NON-VACUUM SIDE PRIOR TO COMPLETION OF THE JOINT.

**RELEASED FOR
FABRICATION / INSTALLATION**

PART NO.	DRAWING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY RECD
2	SE144-312	CENTER SECTION LIFTING LUG	304 STN STL	3
1	SE144-310	180 DEG ROLLED CENTER SECTION	304 STN STL	2

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 UNLESS OTHERWISE SPECIFIED	NATIONAL COMPACT STELLARATOR EXPERIMENT	
SCALE 0.062	TOLERANCES NON-CUMULATIVE	STELLARATOR CORE	DRAWING NO:
NEXT ASSEMBLY	DECIMAL-INCH FRACTIONS	MODULAR COIL WINDING FACILITY	SE144-311
WELDING ENGINEER R. PARSELLS 6-16-03	CHK: J. CHRZANOWSKI	AUTOCLAVE CENTER SECTION WELD ASSEMBLY	SHEET 1 OF 1
	ENGR: S. RAFTOPOULOS		REV 1
	SUPV: J. SIEGEL		

RELEASE LEVEL: Fabrication
DWG VERSION NO: 2

NCSX-SE144-311