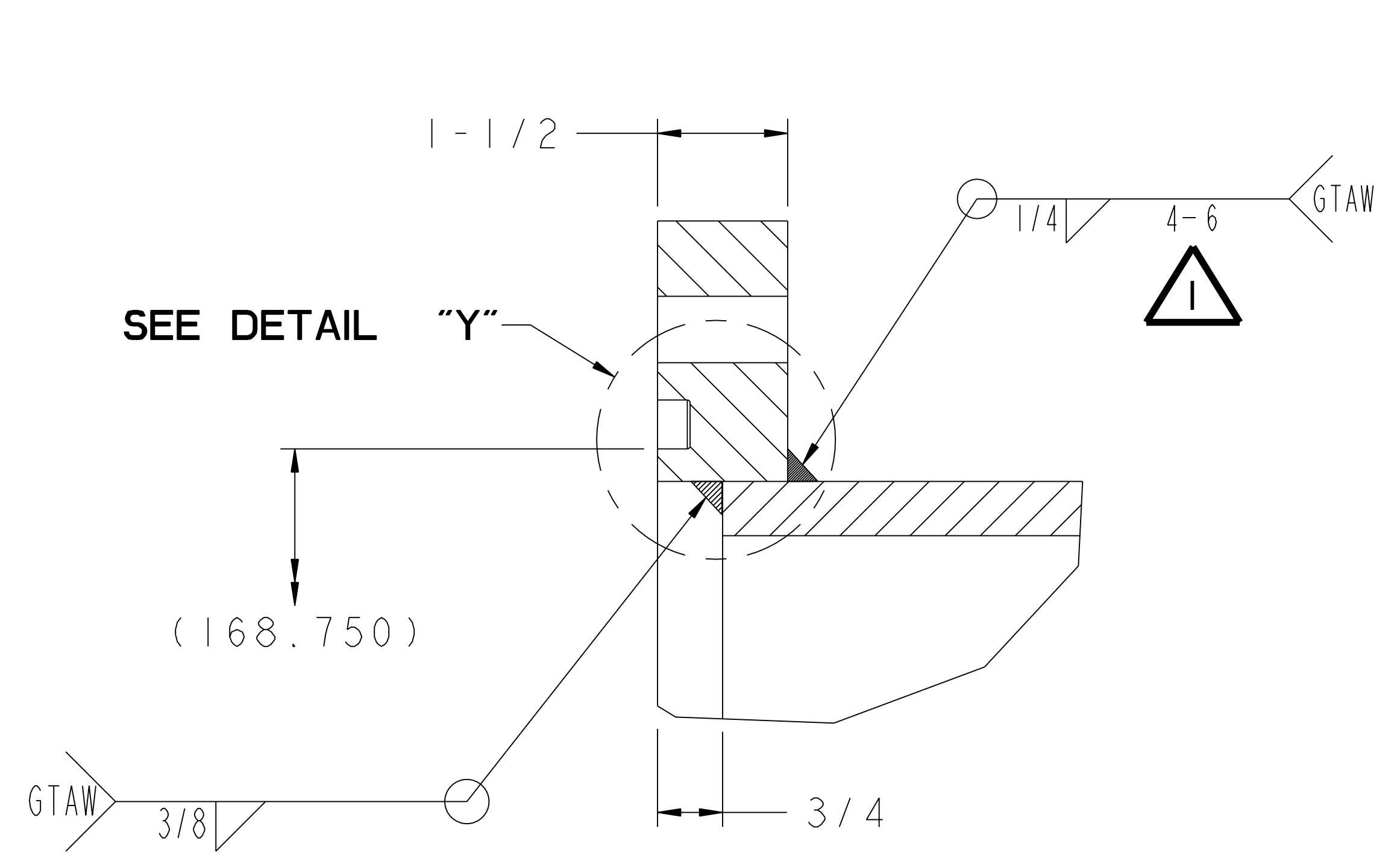
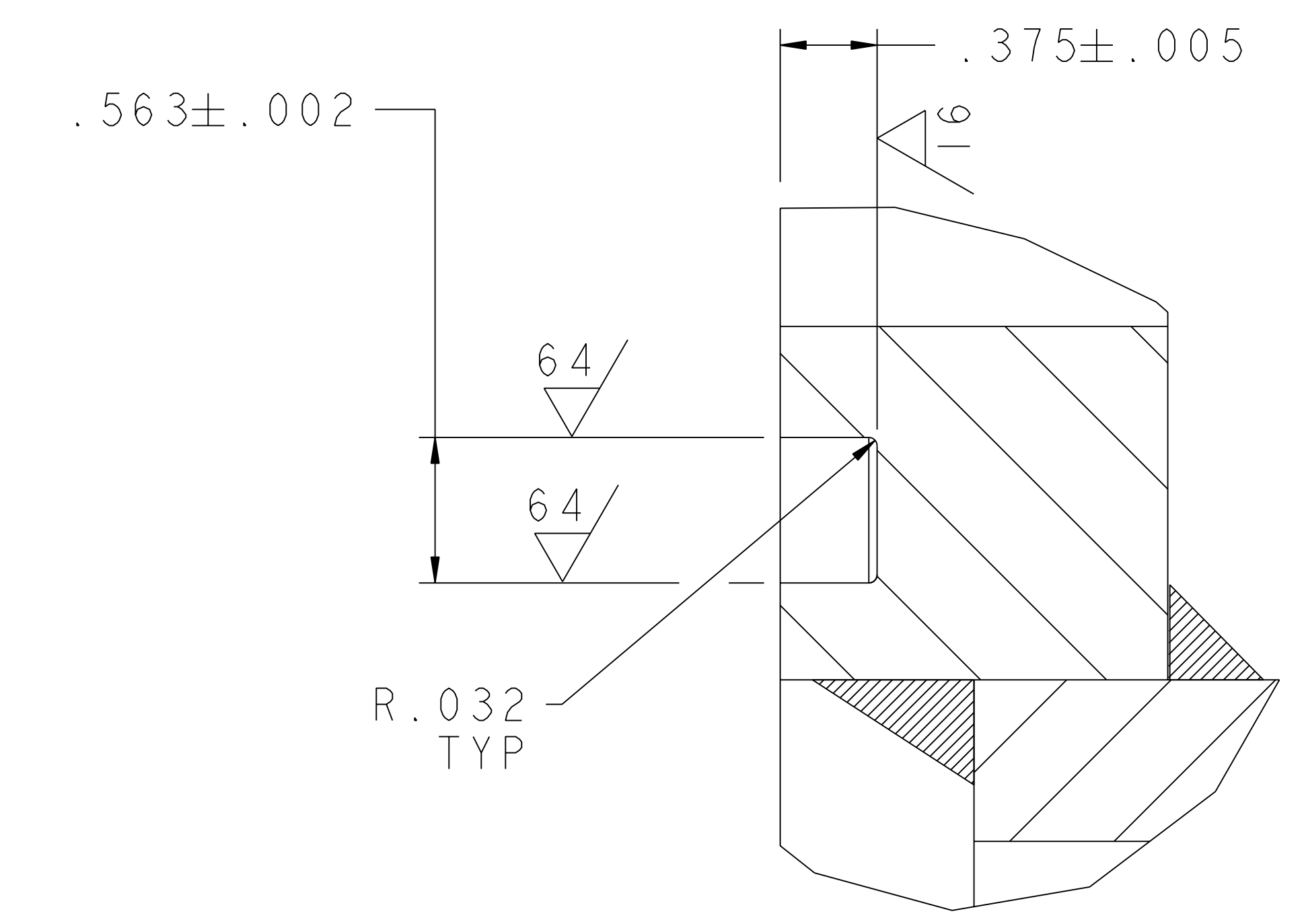


NO.	REVISION	BY	CH	SUP	APPROVED	DATE
1	REVISED PER ECN #4852	JDR	JC	JS	S. RAFTOPOULOS	4/22/04



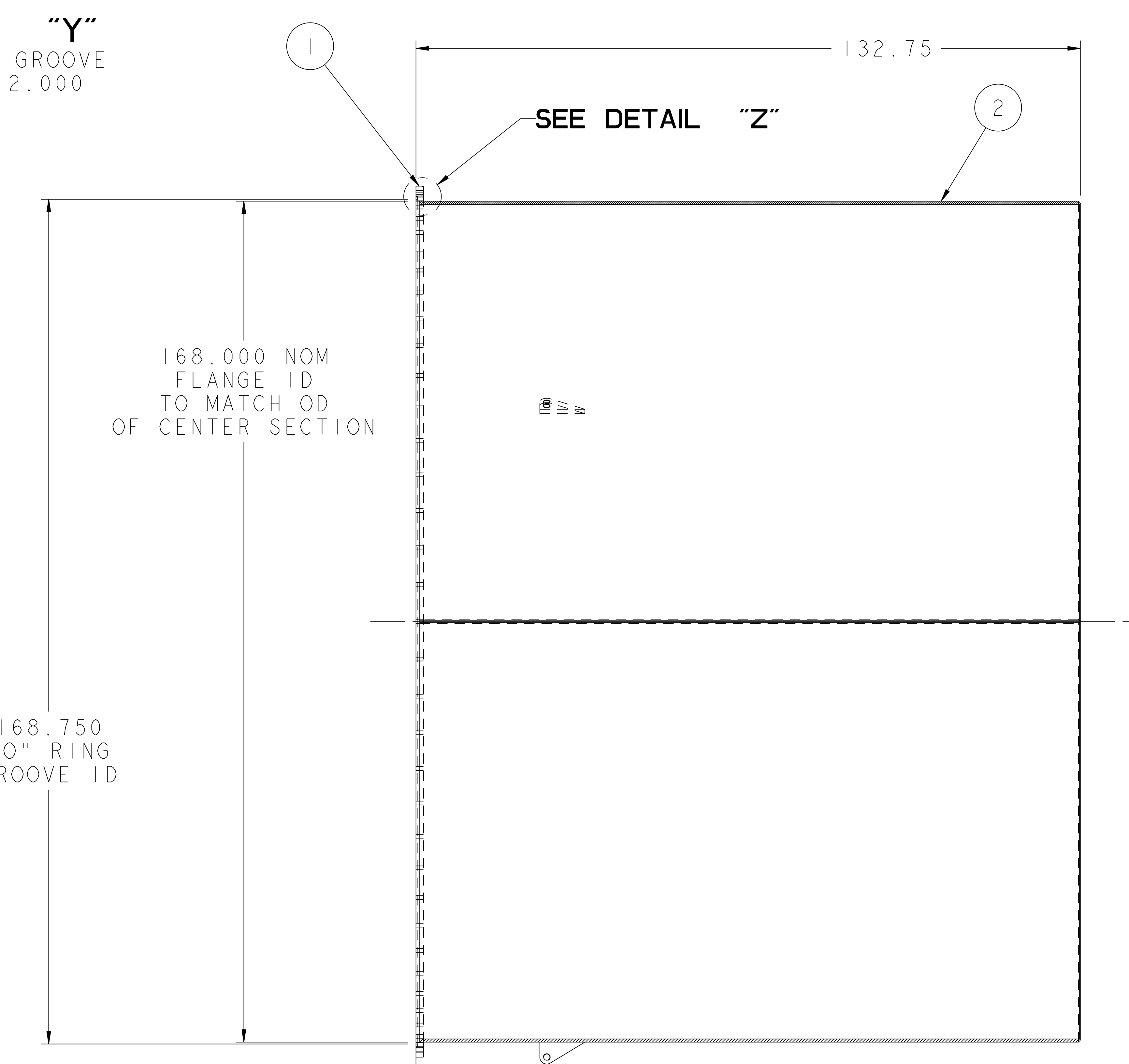
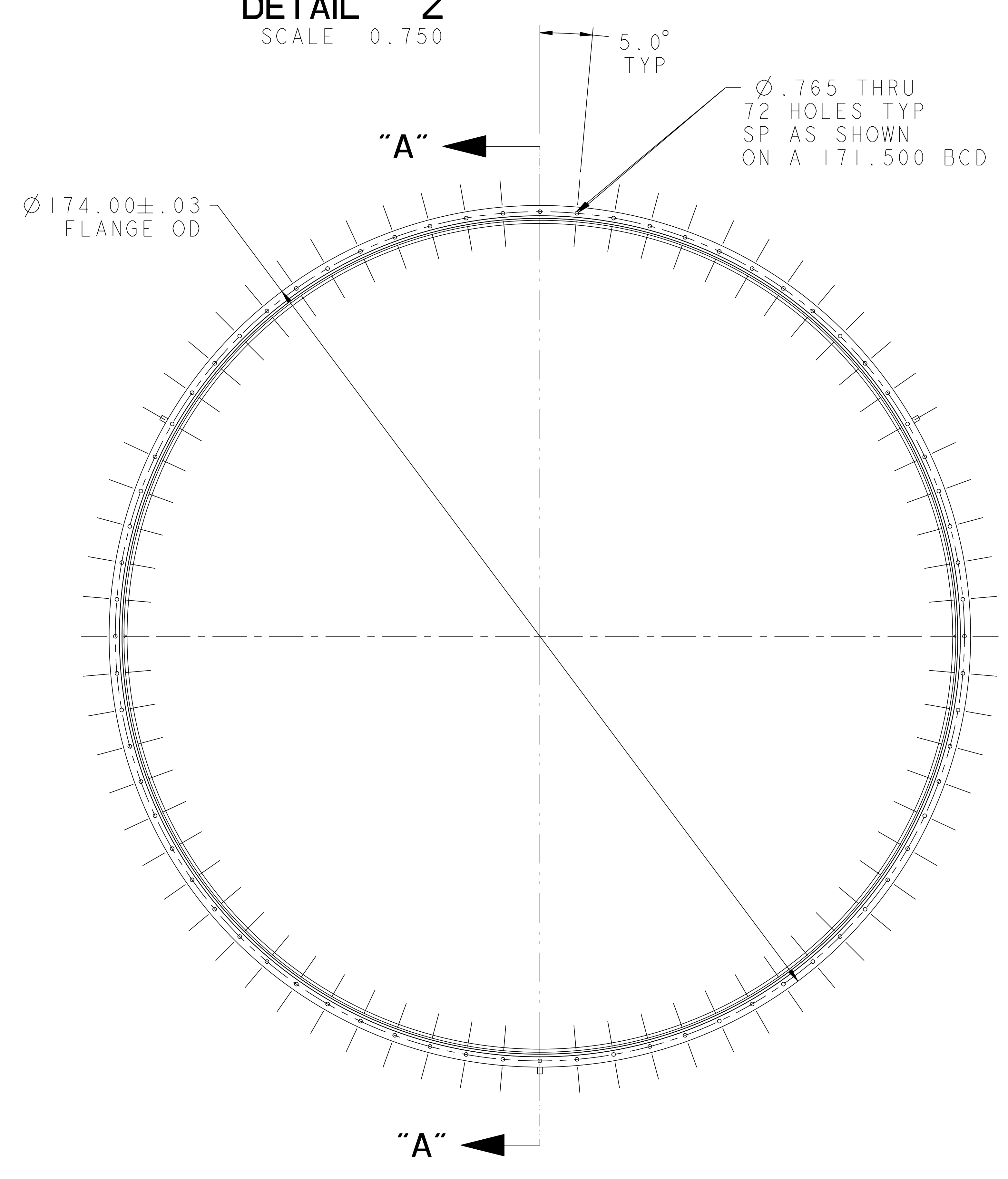
DETAIL "Z"
SCALE 0.750



DETAIL "Y"
"O" RING GROOVE
SCALE 2.000

NOTE

1. WELDERS MUST BE CERTIFIED TO SECTION IX OF ASME CODE.
2. WELD PROCEDURES MUST BE IN ACCORDANCE WITH SECTION IX.
3. VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH ACCEPTANCE CRITERIA OF AWS D1.6
4. NOTE ORIENTATION OF ALL PARTS BEFORE WELDING.
5. LEAK RATE SHALL NOT EXCEED 1×10^{-5} torr-l/sec



SECTION "A"- "A"
SCALE 0.080

	.020
	.060 A

RELEASED FOR FABRICATION / INSTALLATION
PPPL Drafting:

APPROX WT 13,300 LBS

RELEASE LEVEL: Fabrication
DWG VERSION NO: 0

WEIGHT	13273.4 lbs
MODEL NAME	SEI44-313
WELDING ENGINEER	R. PARSELLS

2	SEI44-311	CENTER SECTION WELD ASSEMBLY	STN STL	1
1	FLNG-THRU	CENTER SECTION MOUNTING FLANGE	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 NATIONAL COMPACT STELLARATOR EXPERIMENT	
Pro E		DIMENSIONS ARE IN INCHES MACHINE SURFACES	STELLARATOR CORE MODULAR COIL WINDING FACILITY AUTOCLAVE CENTER SECTION & FLANGE ASSEMBLY	
DO NOT VERIFY INFORMATION BY SCALING DRAWING		BREAK SHARP EDGES .005/.020	DRAWING NO: SEI44-313	
NEXT ASSEMBLY		TOLERANCES NON-CUMULATIVE	DSN: J. RUSHINSKI	ENGR: S. RAFTOPOULOS
		DECIMAL-INCH FRACTIONS	CHK: J. CHRZANOWSKI	SUPV: J. SIEGEL
		.X ±.100 0°-120° ±.100	SHEET 1 OF 1	
		.XX ±.030 120°-120° ±.100	REV 1	
		.XXX ±.005 72°-120° ±.100		
		ANGULAR ±.0°-15° OVER 120° ±.100		

NCSX-SEI44-313