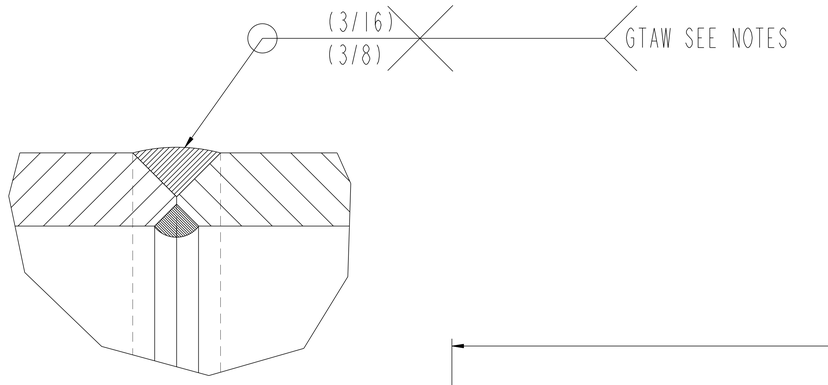
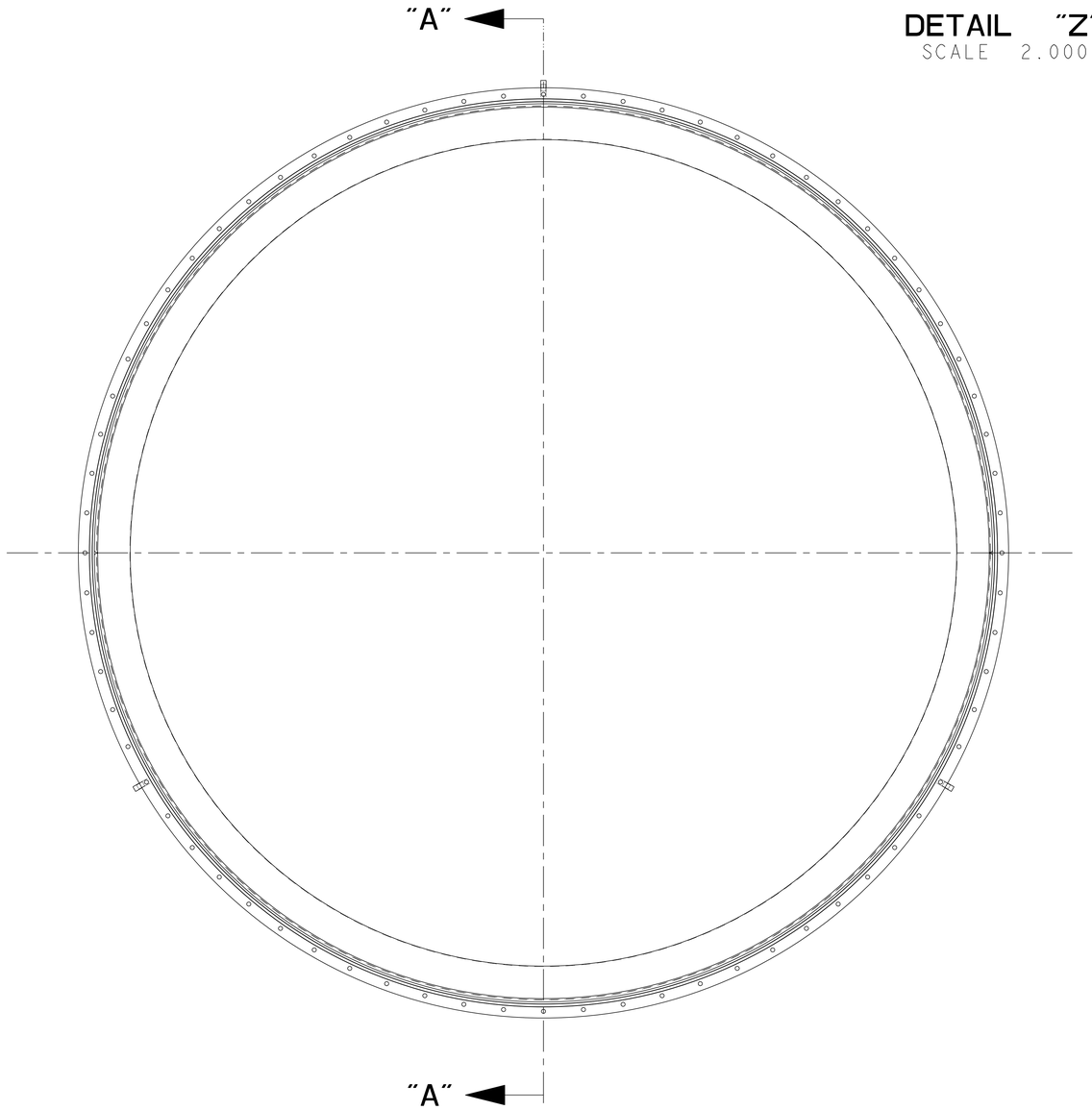
NO.	REVISION	BY	CH	SUP	APPROVED	DATE

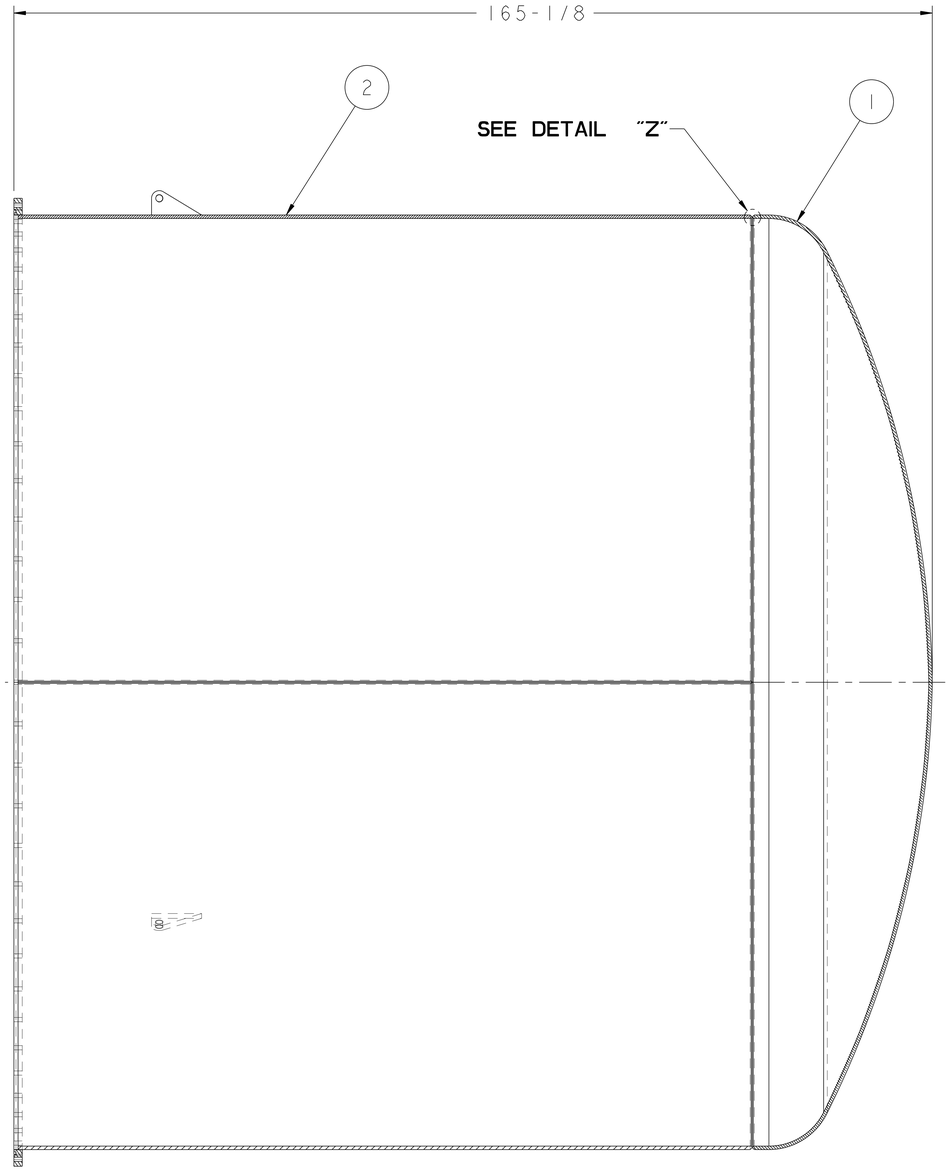
NOTE

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 X 10^{-5} torr-l/sec
6. 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.



DETAIL "Z"
SCALE 2.000





SECTION "A"-"A"
SCALE 0.095

RELEASED FOR FABRICATION / INSTALLATION

APPROX WT 18,400 LBS

RELEASE LEVEL: Fabrication
DWG VERSION NO: 3

WEIGHT
18305.8 lbs
MODEL NAME
SE144-316
WELDING ENGINEER: Robert F Parsells

PART NO.	DRAWING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY REQD
2	SE144-313	CENTER SECTION FLANGE ASSEMBLY	STN STL	1
1	SE144-379-1	ASME DISHED HEAD 168" OD X 5/8" THK LOWER DOME	STN STL	1

PARTS LIST

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED

Pro E

DO NOT VERIFY INFORMATION BY SCALING DRAWING

NEXT ASSEMBLY

CENTRAL FILES: UNLESS OTHERWISE SPECIFIED

DIMENSIONS ARE IN INCHES MACHINE SURFACES

BREAK SHARP EDGES .005/.020

TOLERANCES NON-CUMULATIVE

DECIMAL-INCH: .X +/-.100, .XX +/-.030, .XXX +/-.005, ANGULAR +/-0°-15'

FRACTIONS: 0°-12° +/-1/16, 12°-72° +/-1/8, 72°-120° +/-1/4, OVER 120° +/-1/2

PRINCETON PLASMA PHYSICS LABORATORY
PRINCETON UNIVERSITY
NATIONAL COMPACT STELLARATOR EXPERIMENT
STELLARATOR CORE
MODULAR COIL WINDING FACILITY
LOWER DONE TO CENTER SECTION WELDING ASSEMBLY

DSN: J. RUSHINSKI — Joseph Rushinski
CHK: Jim Chrzanowski
ENGR: S. RAFTOPOULOS — Steve Raftopoulos
SUPV: Jerry Siegel

DRAWING NO: **SE144-316**

SHEET 1 OF 1 REV

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NCSX-SE144-316