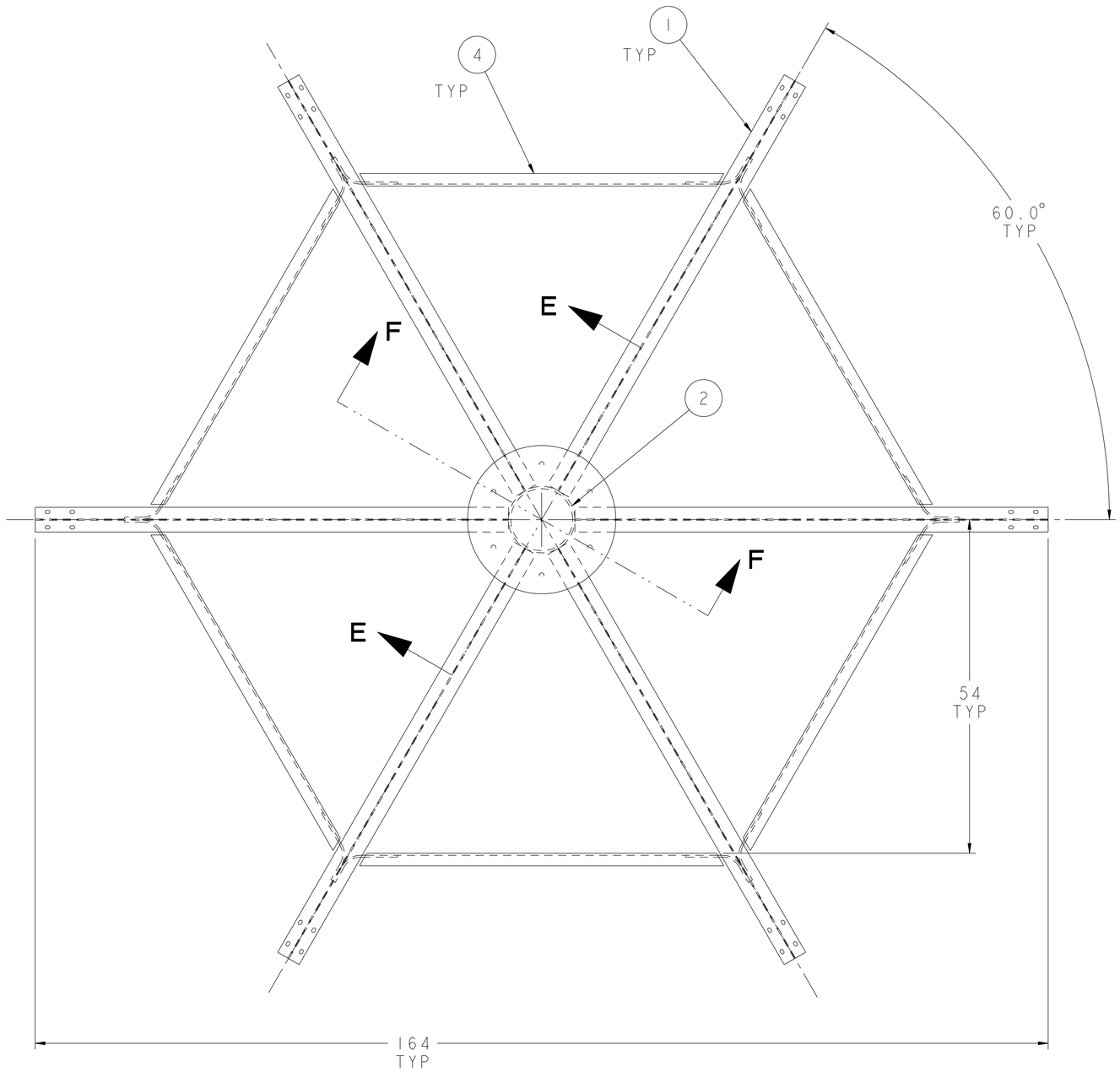
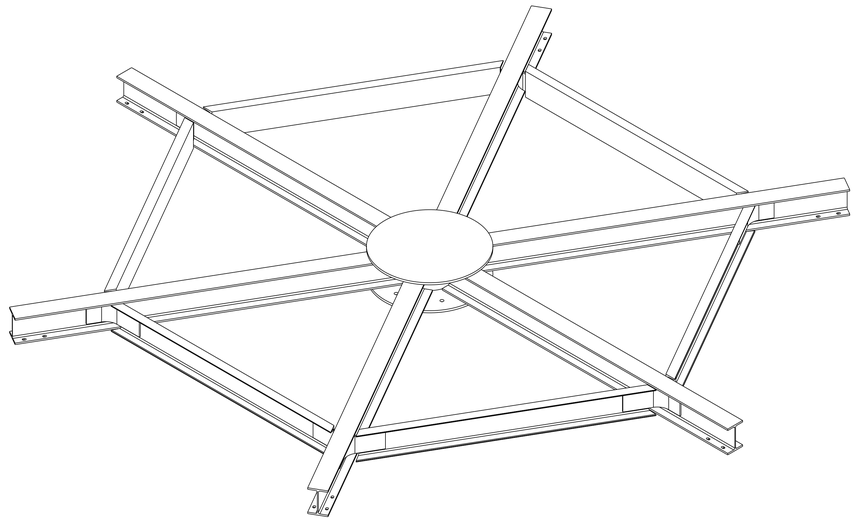
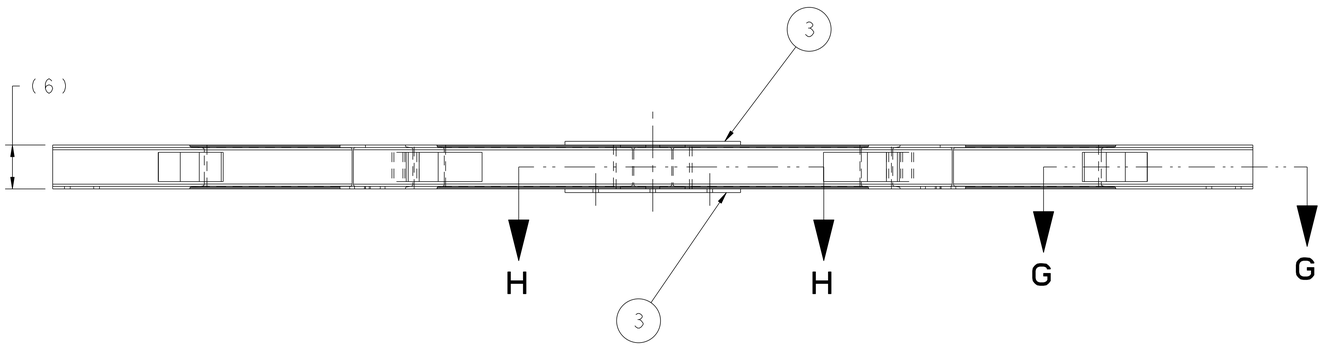
NO.	REVISION	BY	CH	SUP	APPROVED	DATE







NOTE

WELDING SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF AWS D1.2 (STRUCTURAL ALUMINUM WELDING)AND PPPL PROCEDURE EM-002. VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH THE ACCEPTANCE CRITERIA OF AWS D1.2.

NOTE ORIENTATION OF ALL PARTS BEFORE WELDING.

SEE SHEET #2 FOR ADDITIONAL INFORMATION

NCSX-SE144-383

PART NO.	DRAWING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY REQD
4	SE144-381-4	CROSS BRACE	ALUM	6
3	SE144-381-3	BEAM TIE PLATE	ALUM	1
2	SE144-381-2	BEAM TIE RING	ALUM	1
1	SE144-381-1	SUPPORT BEAM	ALUM	6

PARTS LIST

RELEASED FOR FABRICATION / INSTALLATION

PPPL Drafting: Jerry Siegel 2004.05.21 09:16:21 -05'00'

RELEASE LEVEL: As Built
DWG VERSION NO: 0

WEIGHT
28135.2 lbs

MODEL NAME
SE144-383

WELDING ENGINEER

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED

Pro E

DO NOT VERIFY INFORMATION BY SCALING DRAWING

SCALE 0.125

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

DSN: J. RUSHINSKI
CHK:
ENGR: S. RAFTOPOULOS
SUPV:

PRINCETON PLASMA PHYSICS LABORATORY
PRINCETON UNIVERSITY
NATIONAL COMPACT STELLARATOR EXPERIMENT

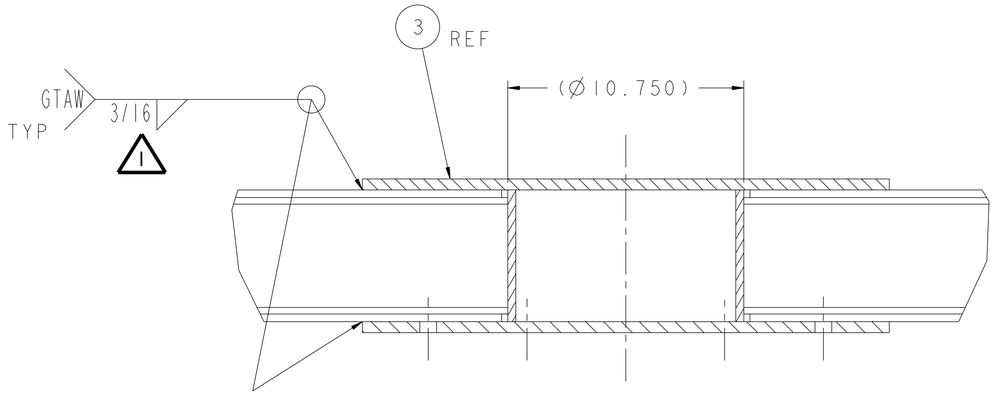
STELLARATOR CORE
MODULAR COIL WINDING FACILITY
COIL SUPPORT PLATFORM WELDING/ASSEMBLY

DRAWING NO:
SE144-383

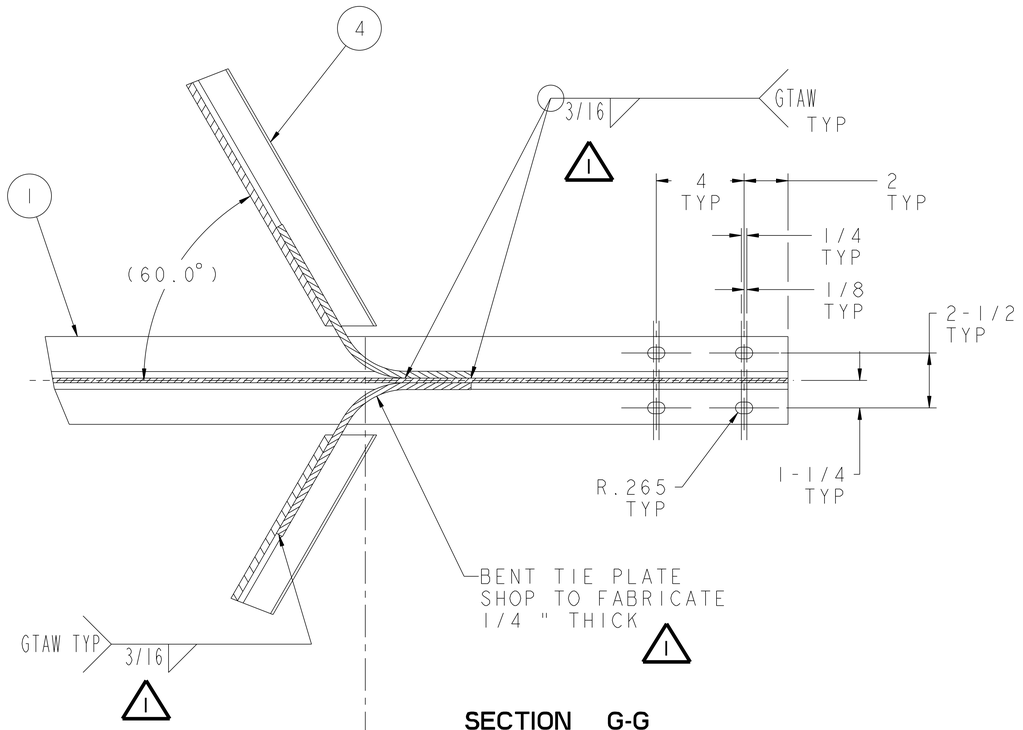
SHEET 1 OF 2 REV 0

NCSX_PART_FORMAT_E

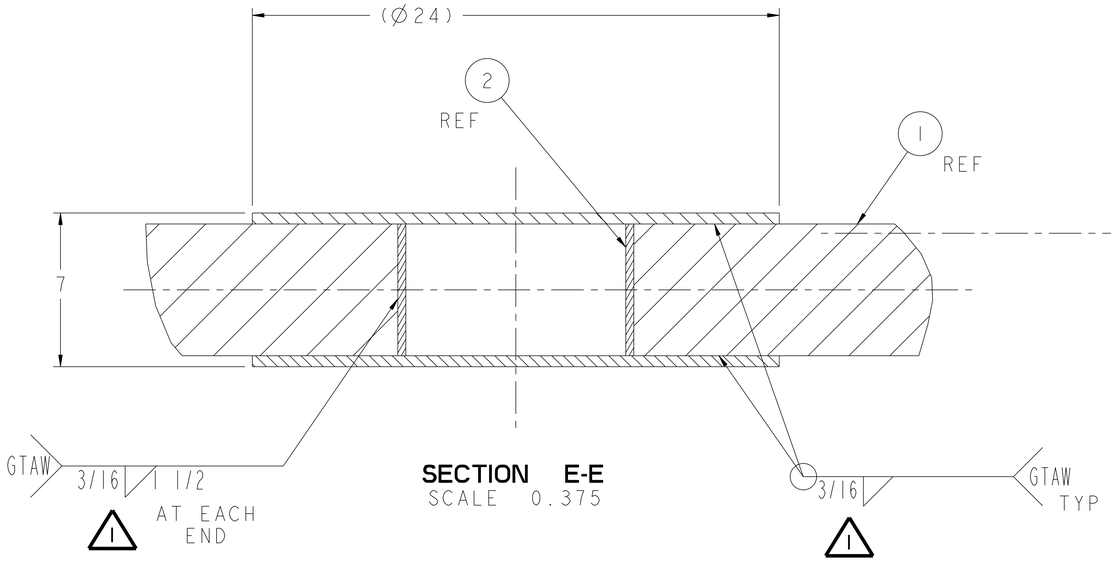
NO.	REVISION	BY	CH	SUP	APPROVED	DATE
1	REVISED PER ECN #4852	JDR	JC	JS	S. RAFTOPOULOS	5/05/04



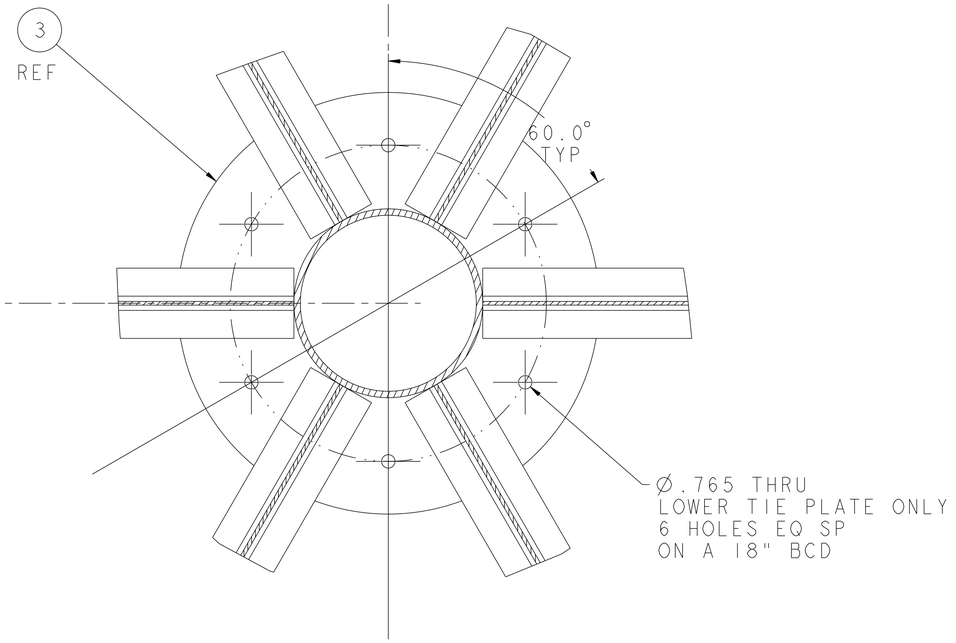
SECTION F-F
SCALE 0.375



SECTION G-G
SCALE 0.375



SECTION E-E
SCALE 0.375



SECTION H-H
SCALE 0.300

FOR NOTES ANS B/M SEE SHEET #1

RELEASED FOR FABRICATION / INSTALLATION
PPPL Drafting: Jerry Siegel
2004.05.21 09:16:21 -05'00'

PART NO.	DRAWING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY REQD

PARTS LIST

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY **NATIONAL COMPACT STELLARATOR EXPERIMENT**
Pro E	DIMENSIONS ARE IN INCHES MACHINE SURFACES 125	STELLARATOR CORE MODULAR COIL WINDING FACILITY COIL SUPPORT PLATFORM WELDING DETAILS
DO NOT VERIFY INFORMATION BY SCALING DRAWING	BREAK SHARP EDGES .005/.020	
	TOLERANCES NON-CUMULATIVE	DSN: J. RUSHINSKI
NEXT ASSEMBLY	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	CHK: J. CHRZANOWSKI ENGR: S. RAFTOPOULOS SUPV: J. SIEGEL
WEIGHT 28135.2 lbs	MODEL NAME SE144-383	WELDING ENGINEER
RELEASE LEVEL: As Built	DWG VERSION NO: 0	DRAWING NO: SE144-383 SHEET 2 OF 2 REV 1

NCSX-SE144-383

NCSX_PART_FORMAT_E