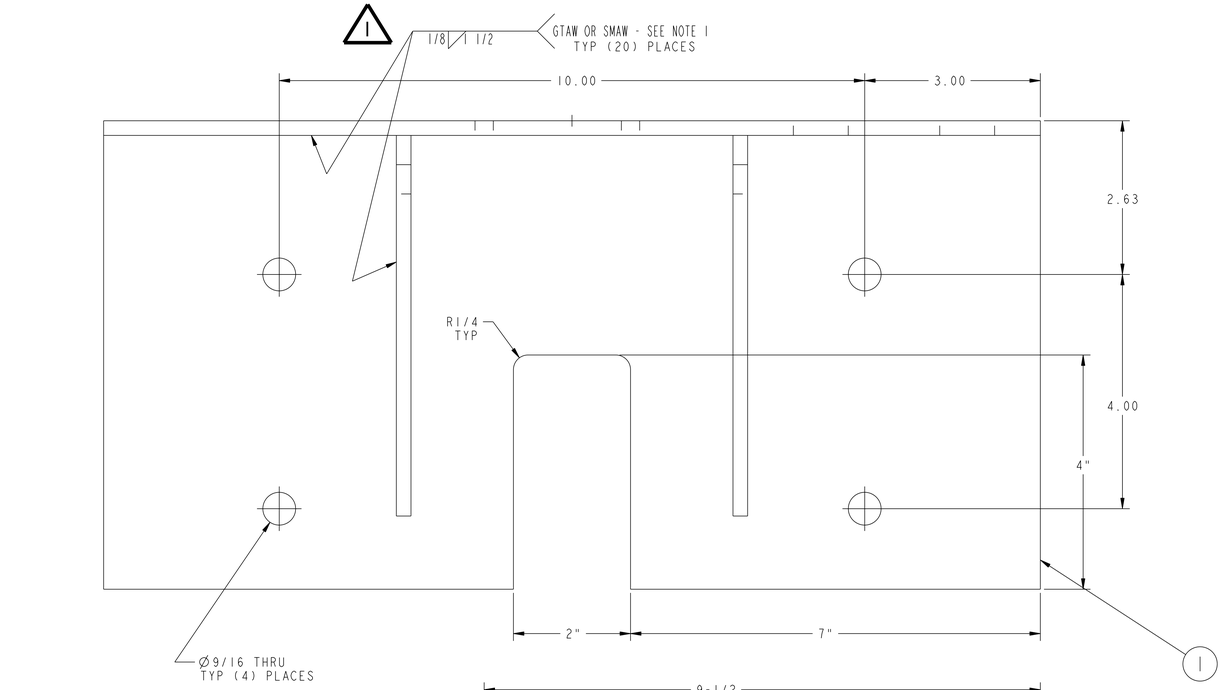
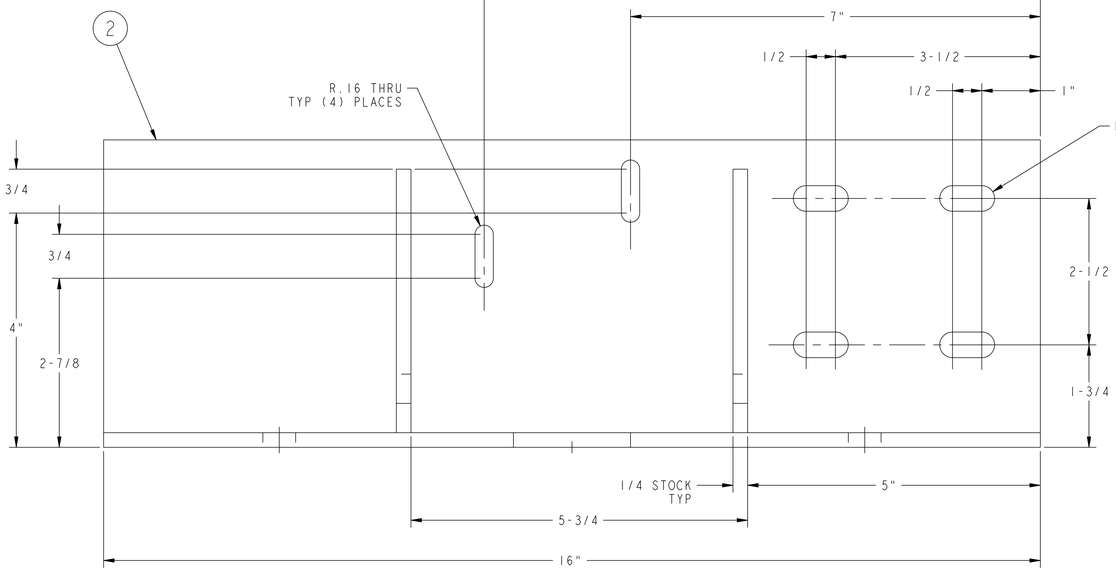
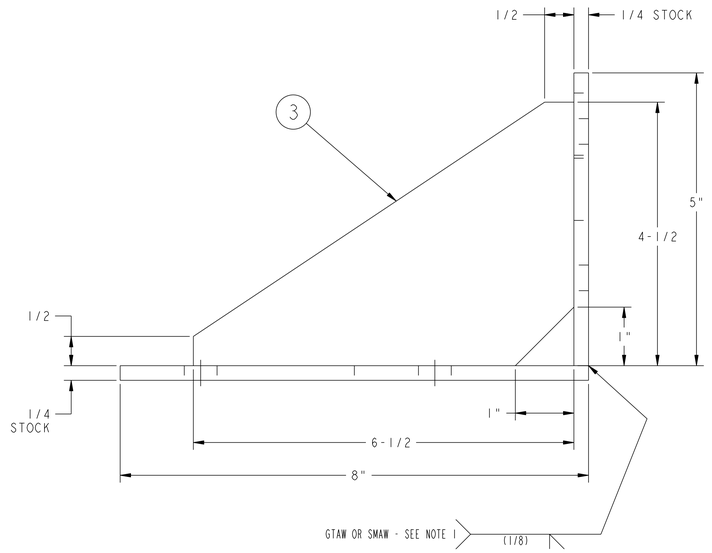
NO.	REVISION	BY	CH	SUP	APPROVED	DATE
1	REVISED PER ECN-5091	LM	TB	JS	T. BROWN	3-10-06







01 ASSEMBLY PAWL SUPPORT BRACKET WELDMENT - TYPE "A"

NOTES

1. WELDING SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF AWS D1.1 AND PPPL PROCEDURE ENG-037. VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH THE ACCEPTANCE CRITERIA OF AWS D1.1 SECTION 6.

01 ASSY	02 ASSY	02 ASSY	01 ASSY	PART NO	DRAWING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY REQD
2				10	SE184-006-5	SPRING POST	ASTM A36	4
2				9	SE184-006-4	PAWL	ASTM A36	4
	2			8	THIS DWG	AXLE	ASTM A36	4
	2			7	THIS DWG	AXLE SUPPORT PLATE	ASTM A36	4
		2		6	THIS DWG	GUSSET	ASTM A36	4
		1		5	THIS DWG	VERTICAL PLATE - TYPE "B"	ASTM A36	2
		1		4	THIS DWG	BASE PLATE - TYPE "B"	ASTM A36	2
			2	3	THIS DWG	GUSSET	ASTM A36	4
			1	2	THIS DWG	VERTICAL PLATE - TYPE "A"	ASTM A36	2
			1	1	THIS DWG	BASE PLATE - TYPE "A"	ASTM A36	2
X				—	———	PAWL WELDMENT	———	4
	X			—	———	PAWL AXLE SUPPORT PLATE WELDMENT	———	4
		X		—	———	PAWL SUPPORT BRACKET WELDMENT - TYPE "B"	———	2
			X	—	———	PAWL SUPPORT BRACKET WELDMENT - TYPE "A"	———	2

PARTS LIST

NCSX-SE184-005

RELEASED FOR FABRICATION / INSTALLATION
PPPL Drafting: Jerry Siegel
2006.03.13 08:25:46 -05'00'

RELEASE LEVEL: FABRICATION
DWG VERSION NO: 0

WEIGHT
~~16.7 lbs~~
MODEL NAME
SE184-005-01
WELDING ENGINEER L. DUDEK 2-15-06

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

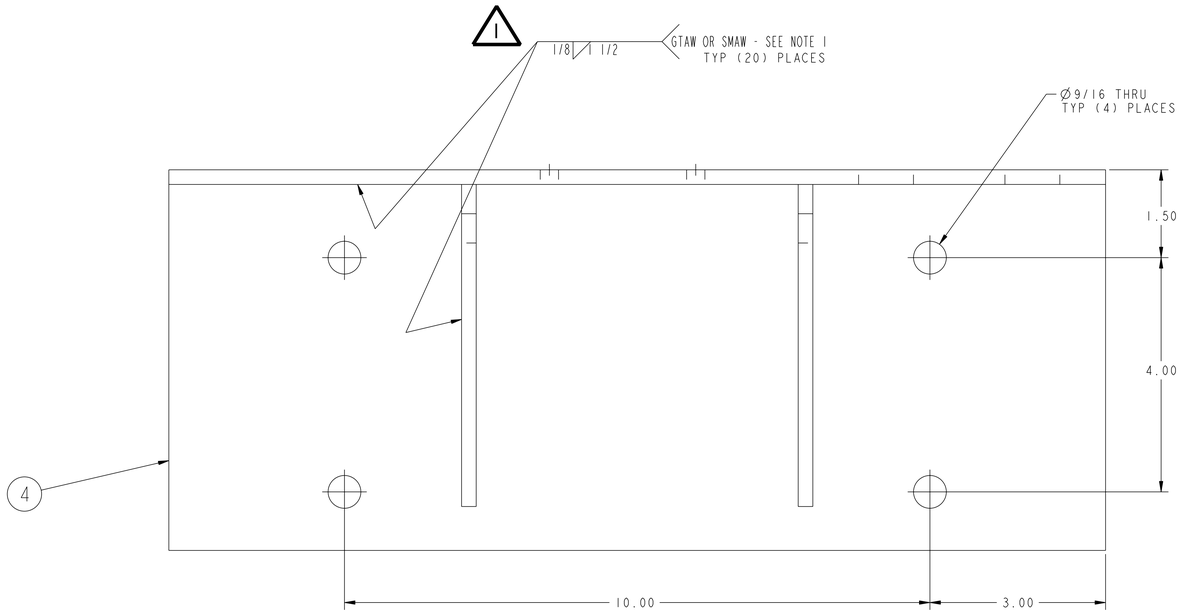
DECIMAL-INCH	FRACTIONS
.X +/-.100	0°-12° +/-1/16
.XX +/-.030	12°-72° +/-1/8
.XXX +/-.005	72°-120° +/-1/4
ANGULAR +/-0°-15'	OVER 120° +/-1/2

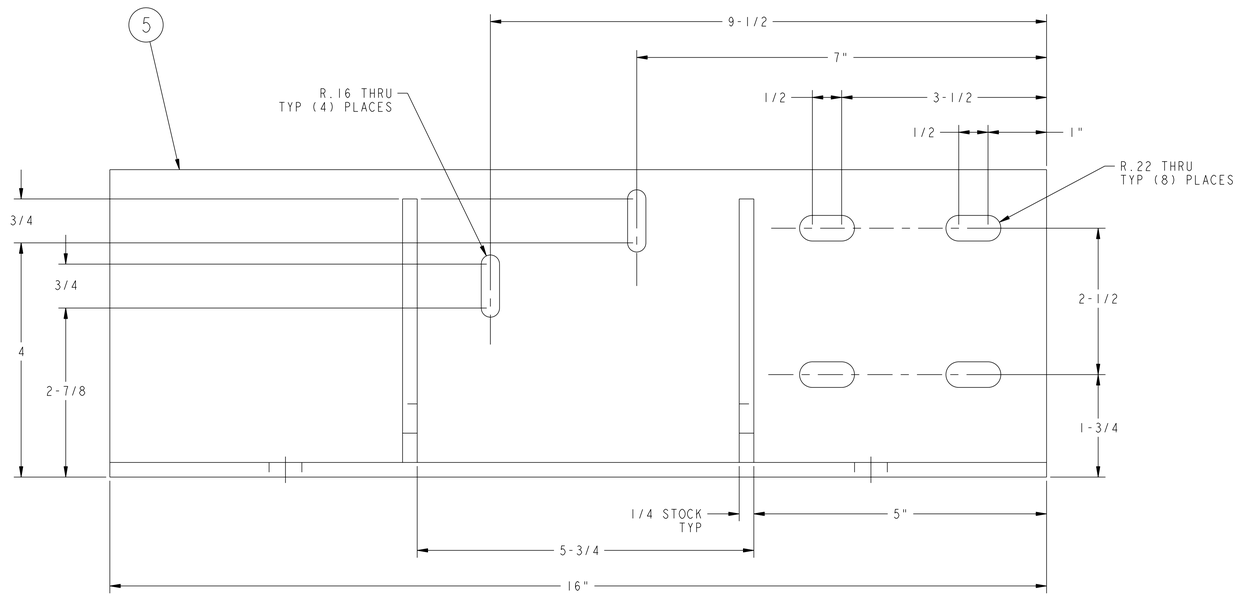
PRINCETON PLASMA PHYSICS LABORATORY
PRINCETON UNIVERSITY
NATIONAL COMPACT STELLARATOR EXPERIMENT
EXTERNAL FLUX LOOPS
VACUUM VESSEL SUPPORT STAND
FIXTURE ASSEMBLY MISCELLANEOUS WELDMENTS

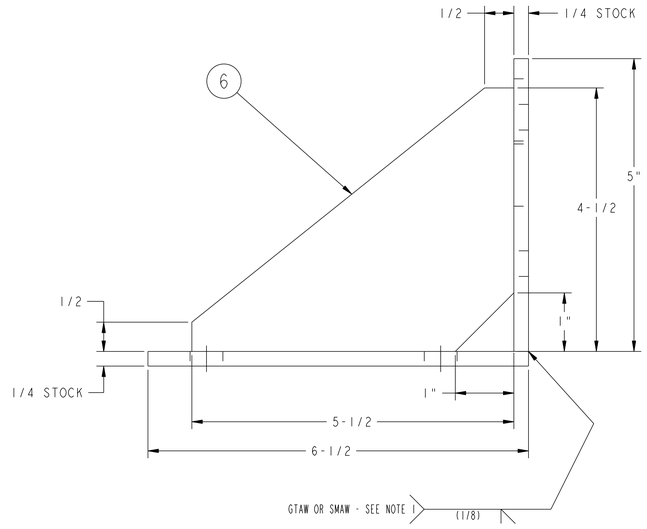
DSN: L. MORRIS	2-15-06	DRAWING NO:
CHK: T. BROWN	2-15-06	SE184-005
ENGR: T. BROWN	2-15-06	
SUPV: J. SIEGEL	2-15-06	SHEET 1 OF 3 REV 1

NCSX_ASSY_FORMAT_E

NO.	REVISION	BY	CH	SUP	APPROVED	DATE







02 ASSEMBLY PAWL SUPPORT BRACKET WELDMENT - TYPE "B"

1

RELEASED FOR FABRICATION / INSTALLATION
PPPL Drafting: Jerry Siegel 2006.03.13 08:25:46 -05'00'

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

RELEASE LEVEL: Fabrication	WEIGHT ~~16.7 lbs~~	COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED
DWG VERSION NO: 0	MODEL NAME SE184-005-01	Pro E	DIMENSIONS ARE IN INCHES MACHINE SURFACES
	WELDING ENGINEER L. DUDEK 2-15-06	DO NOT VERIFY INFORMATION BY SCALING DRAWING	BREAK SHARP EDGES .005/.020
		NEXT ASSEMBLY	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

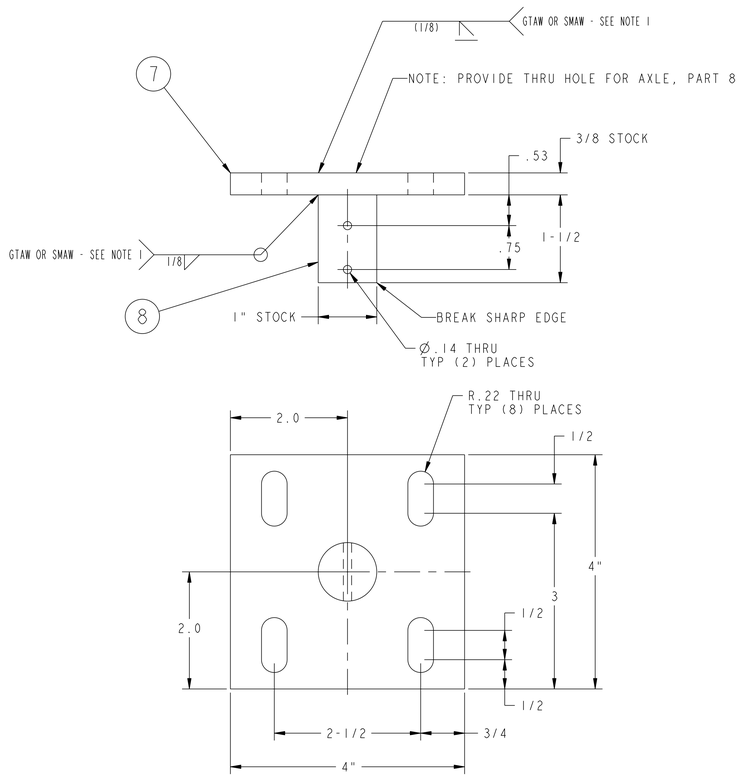
EXTERNAL FLUX LOOPS
VACUUM VESSEL SUPPORT STAND
FIXTURE ASSEMBLY MISCELLANEOUS WELDMENTS

DSN: L. MORRIS	2-15-06	DRAWING NO: SE184-005
CHK: T. BROWN	2-15-06	
ENGR: T. BROWN	2-15-06	
SUPV: J. SIEGEL	2-15-06	SHEET 2 OF 3 REV: 1

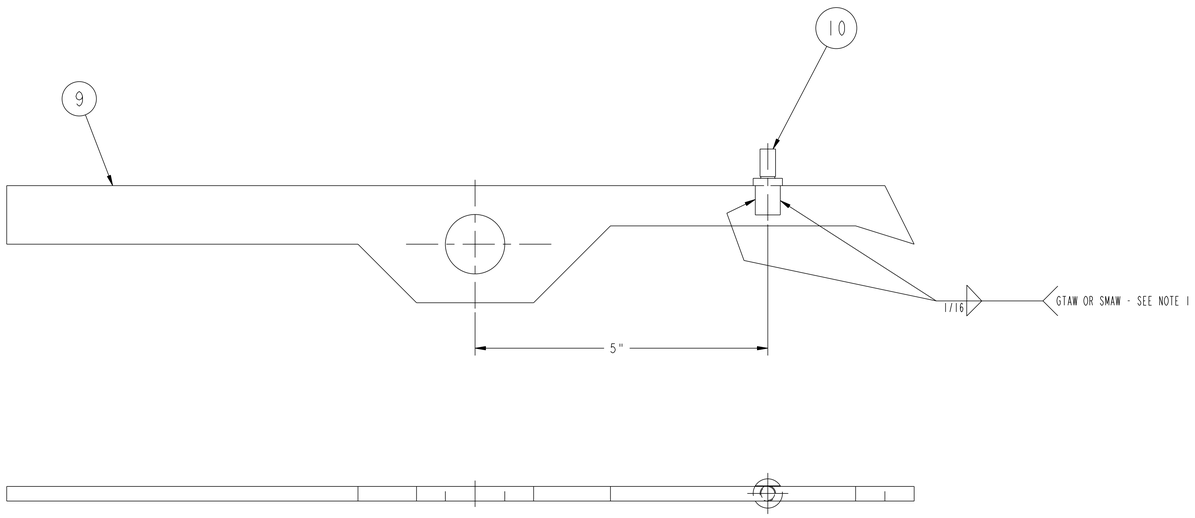
NCSX-SE184-005

NCSX_ASSY_FORMAT_E

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



03 ASSEMBLY PAWL AXLE SUPPORT PLATE WELDMENT



04 ASSEMBLY PAWL WELDMENT

RELEASED FOR FABRICATION / INSTALLATION

PPPL Drafting: Jerry Siegel 2006.03.13 08:25:46 -05'00'

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

RELEASE LEVEL: Fabrication

DWG VERSION NO: 0

WEIGHT ~~15.2 lbs~~

MODEL NAME SE184-005-02

WELDING ENGINEER L. DUDEK 2-15-06

NEXT ASSEMBLY

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED

Pro E

DO NOT VERIFY INFORMATION BY SCALING DRAWING

CENTRAL FILES: UNLESS OTHERWISE SPECIFIED

DIMENSIONS ARE IN INCHES MACHINE SURFACES

BREAK SHARP EDGES .005/.020

TOLERANCES NON-CUMULATIVE

DECIMAL-INCH	FRACTIONS
.X +/-.100	0°-12° +/-1/16
.XX +/-.030	12°-72° +/-1/8
.XXX +/-.005	72°-120° +/-1/4
ANGULAR +/-0°-15'	OVER 120° +/-1/2

PRINCETON PLASMA PHYSICS LABORATORY
PRINCETON UNIVERSITY
NATIONAL COMPACT STELLARATOR EXPERIMENT

EXTERNAL FLUX LOOPS
VACUUM VESSEL SUPPORT STAND
FIXTURE ASSEMBLY MISCELLANEOUS DETAILS

DSN: L. MORRIS	2-15-06	DRAWING NO: SE184-005
CHK: T. BROWN	2-15-06	
ENGR: T. BROWN	2-15-06	
SUPV: J. SIEGEL	2-15-06	SHEET 3 OF 3 REV 1

NCSX_ASSY_FORMAT_E

NCSX-SE184-005