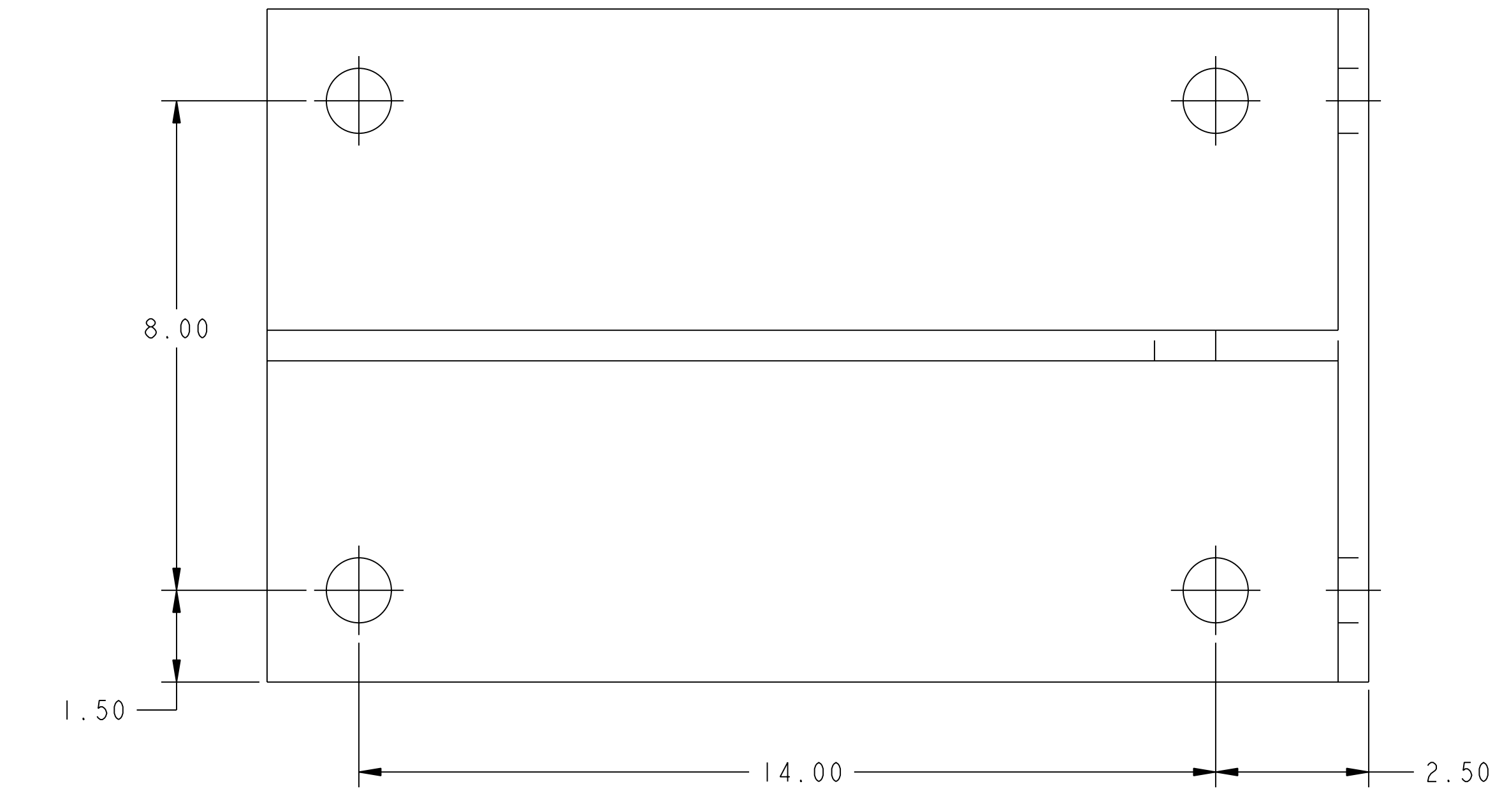
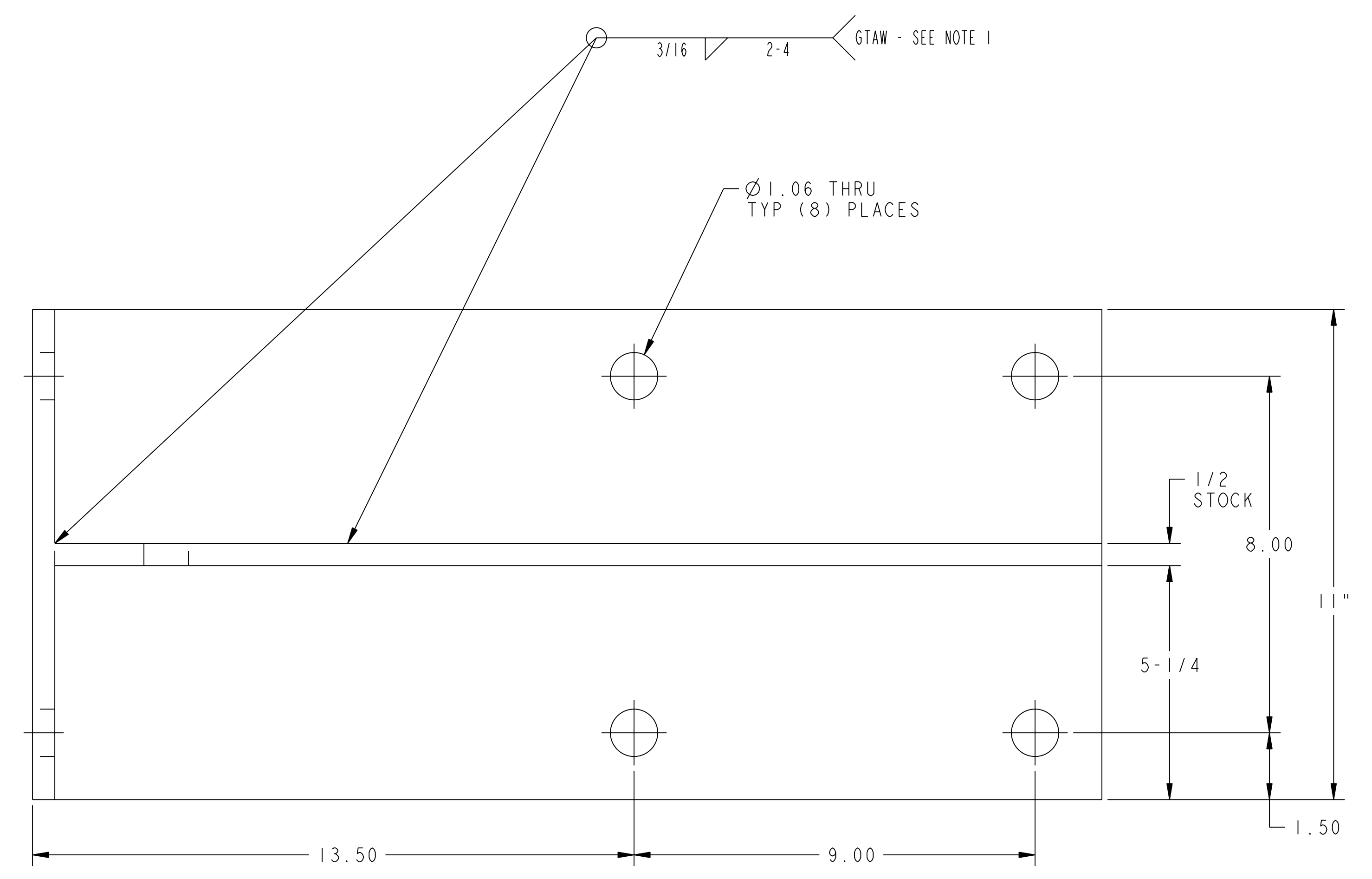


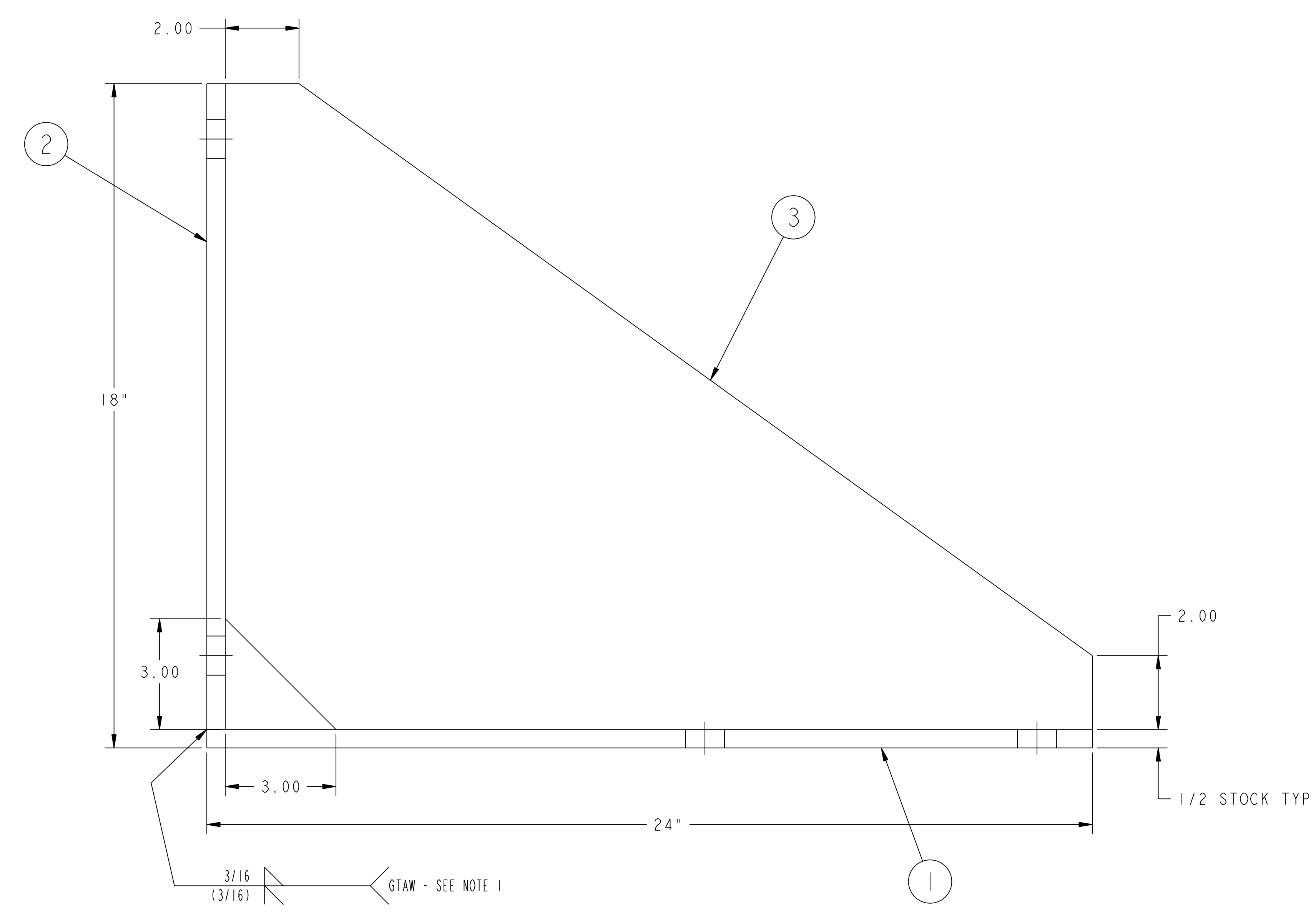
| NO. | REVISION | BY | CH | SUP | APPROVED | DATE |
|-----|----------|----|----|-----|----------|------|
| | | | | | | |



NOTES

1. WELDING SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF AWS D1.1 OR PPPL PROCEDURE ENG-037. VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH THE ACCEPTANCE CRITERIA OF AWS D1.1 Section 6.
2. ALL HOLES TO BE MACHINED AFTER ALL WELDS ARE COMPLETE.

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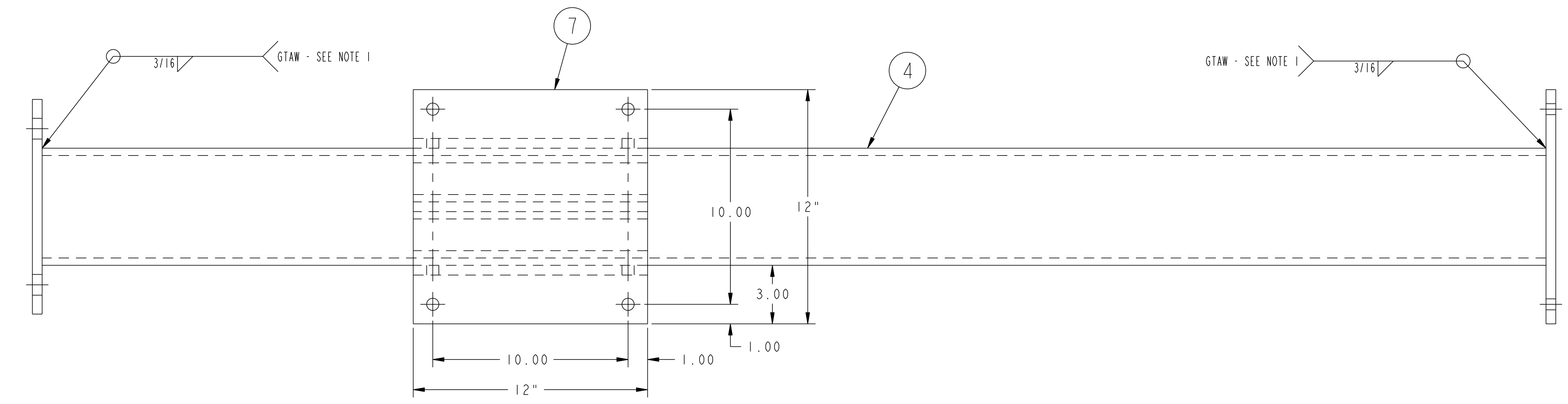
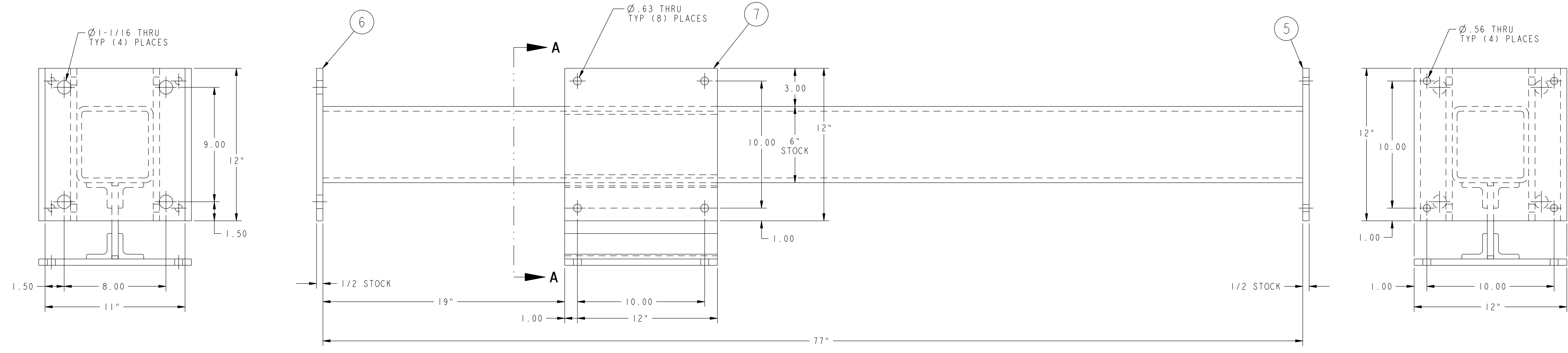
01 ASSEMBLY
(1) REQ'D

| REV | NO. | DESCRIPTION | MATERIAL | QTY | RECD | | |
|-----|-----|-------------|--|---------------------------|-----------------------------|----------|----------|
| 1 | 12 | THIS DWG | OUTRIGGER TIE PLATE | ASTM A36 | | | |
| 1 | 11 | THIS DWG | FOOT PLATE | ASTM A36 | | | |
| 1 | 10 | THIS DWG | OUTRIGGER TUBE - 6" x 6" x 3/8 STRUCT TUBE | ASTM A36 | | | |
| 4 | 9 | THIS DWG | MOUNTING CLIP ANGLE - 2 x 2 x 3/8 STRUCT ANGLE | ASTM A36 | | | |
| 1 | 8 | THIS DWG | SANDWICH PLATE | ASTM A36 | | | |
| 2 | 7 | THIS DWG | TIE PLATE | ASTM A36 | | | |
| 1 | 6 | THIS DWG | TOP PLATE | ASTM A36 | | | |
| 1 | 5 | THIS DWG | BASE PLATE | ASTM A36 | | | |
| 1 | 4 | THIS DWG | VERTICAL TUBE - 6" x 6" x 3/8 STRUCT TUBE | ASTM A36 | | | |
| | 1 | 3 | THIS DWG | GUSSET | ASTM A36 | | |
| | 1 | 2 | THIS DWG | VERTICAL PLATE | ASTM A36 | | |
| | 1 | 1 | THIS DWG | BASE PLATE | ASTM A36 | | |
| | | | THIS DWG | OUTRIGGER WELDMENT | 3 | | |
| | | | THIS DWG | VERTICAL SUPPORT WELDMENT | 1 | | |
| | | | THIS DWG | SUPPORT BRACKET WELDMENT | 1 | | |
| 03 | 02 | 01 | PART NO. | DRAWING NO. | NOMENCLATURE OR DESCRIPTION | MATERIAL | QTY RECD |

| | | | | |
|---|---|---|---|--|
| WEIGHT 100.0 lbs | COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E | CENTRAL FILES: UNLESS OTHERWISE SPECIFIED | PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY | |
| | DO NOT VERIFY INFORMATION BY SCALING DRAWING | DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020 | NATIONAL COMPACT STELLARATOR EXPERIMENT | |
| MODEL NAME SE184-056-01 | NEXT ASSEMBLY | TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX +/- .030 .XXX +/- .005 ANGULAR +/- .0°-15' | DSN: L. MORRIS CHK: M. COLE ENGR: T. BROWN SUPV: J. SIEGEL | 8-2-2007 8-2-2007 8-2-2007 8-2-2007 |
| RELEASE LEVEL: Fabrication DWG VERSION NO: 3 | WELDING ENGINEER G. GETTELFINGER 8-2-2007 | FIELD PERIOD ASSEMBLY VACUUM VESSEL SUPPORT ASSEMBLY VERTICAL SUPPORT WELDMENTS | | DRAWING NO: SE184-056 SHEET 1 OF 3 REV 0 |

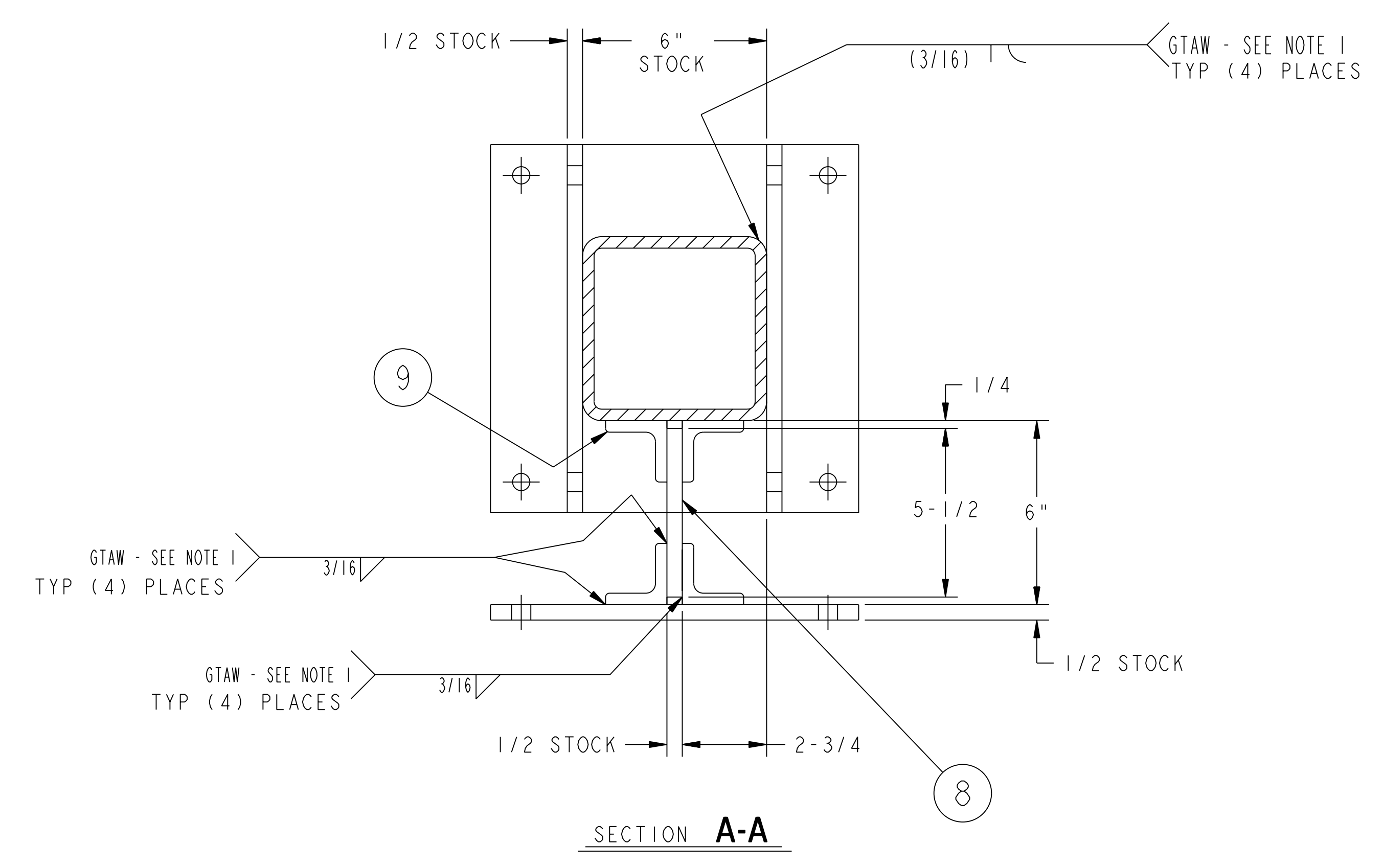
NCSX-SE184-056

| | | | | | | |
|-----|----------|----|----|-----|----------|------|
| NO. | REVISION | BY | CH | SUP | APPROVED | DATE |
| | | | | | | |



02 ASSEMBLY

(1) REQ'D



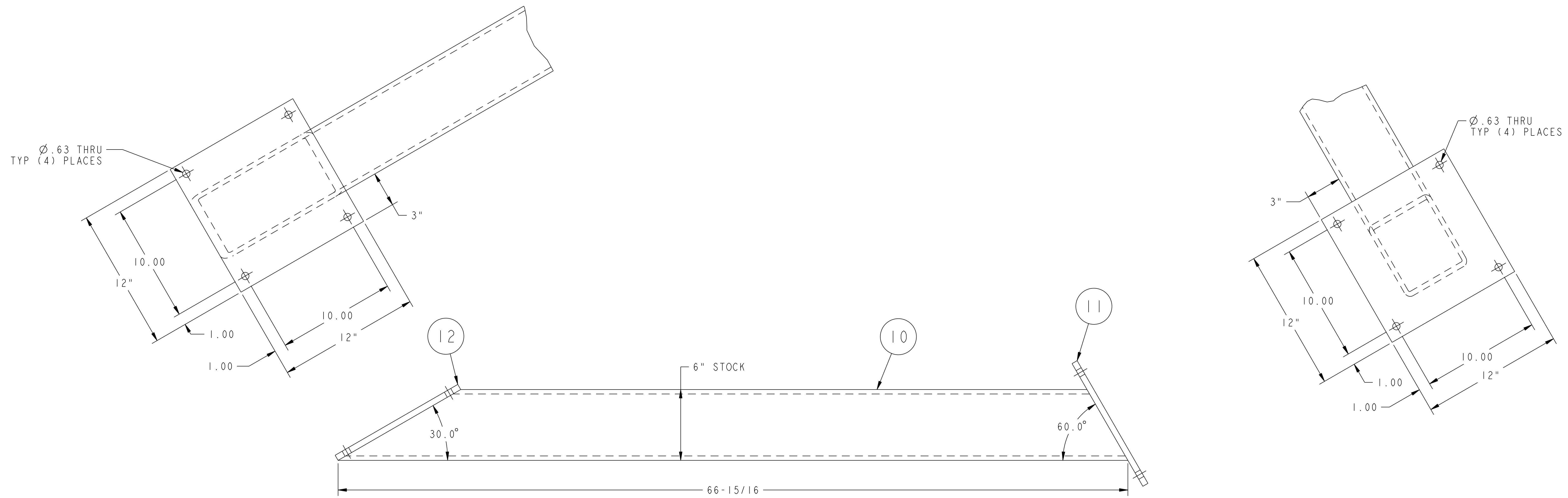
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PPPL Drafting

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

| | | | |
|---|---|---|----------------------|
| COMPUTER GENERATED DRAWING CHANGES NOT PERMITTED Pro E DO NOT VERIFY INFORMATION BY SCALING DRAWING | CENTRAL FILES: | PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY | |
| | UNLESS OTHERWISE SPECIFIED | NATIONAL COMPACT STELLARATOR EXPERIMENT | |
| NEXT ASSEMBLY | DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020 | FIELD PERIOD ASSEMBLY VACUUM VESSEL SUPPORT ASSEMBLY VERTICAL SUPPORT WELDMENTS | |
| | TOLERANCES NON-CUMULATIVE | DSN: L. MORRIS | 8-2-2007 DRAWING NO: |
| WEIGHT | DECIMAL-INCH FRACTIONS | CHK: M. COLE | 8-2-2007 |
| 100.0 lbs | .XX ±.000 0°-120° ±.010 .XX ±.030 12°-120° ±.010 .XX ±.005 72°-120° ±.010 ANGULAR ±.0°-15° OVER 120° ±.010 | ENGR: T. BROWN | 8-2-2007 |
| MODEL NAME | | SUPV: J. SIEGEL | 8-2-2007 |
| SE184-056-01 | | | SHEET 2 OF 3 |
| WELDING ENGINEER | G. GETTELFINGER 8-2-2007 | | REV D, 2 |

RELEASE LEVEL: Fabrication
DWG VERSION NO: 3

| NO. | REVISION | BY | CH | SUP | APPROVED | DATE |
|-----|----------|----|----|-----|----------|------|
| | | | | | | |



03 ASSEMBLY
(3) REQ'D

RELEASED FOR FABRICATION / INSTALLATION
PPPL Drafting

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

| | | | |
|---|---|--|----------------------|
| COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E | CENTRAL FILES: | PRINCETON PLASMA PHYSICS LABORATORY NATIONAL COMPACT STELLARATOR EXPERIMENT | |
| | UNLESS OTHERWISE SPECIFIED | FIELD PERIOD ASSEMBLY | |
| DO NOT VERIFY INFORMATION BY SCALING DRAWING | DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020 | VACUUM VESSEL SUPPORT ASSEMBLY VERTICAL SUPPORT WELDMENTS | |
| NEXT ASSEMBLY | TOLERANCES NON-CUMULATIVE | DSN: L. MORRIS | 8-2-2007 DRAWING NO: |
| DECIMAL-INCH FRACTIONS | .XX ±.030 | CHK: M. COLE | 8-2-2007 |
| .XXX ±.005 | 72°-120° ±.114 | ENGR: T. BROWN | 8-2-2007 |
| ANGULAR ±.0°-15° | OVER 120° ±.112 | SUPV: J. SIEGEL | 8-2-2007 |
| WEIGHT | 312.3 lbs | SHEET 3 OF 3 | |
| MODEL NAME | SE184-056-02 | REV D, 2 | |
| WELDING ENGINEER | G. GETTELFINGER 8-2-2007 | NCSX-SE184-056 | |

RELEASE LEVEL: Fabrication
DWG VERSION NO: 6