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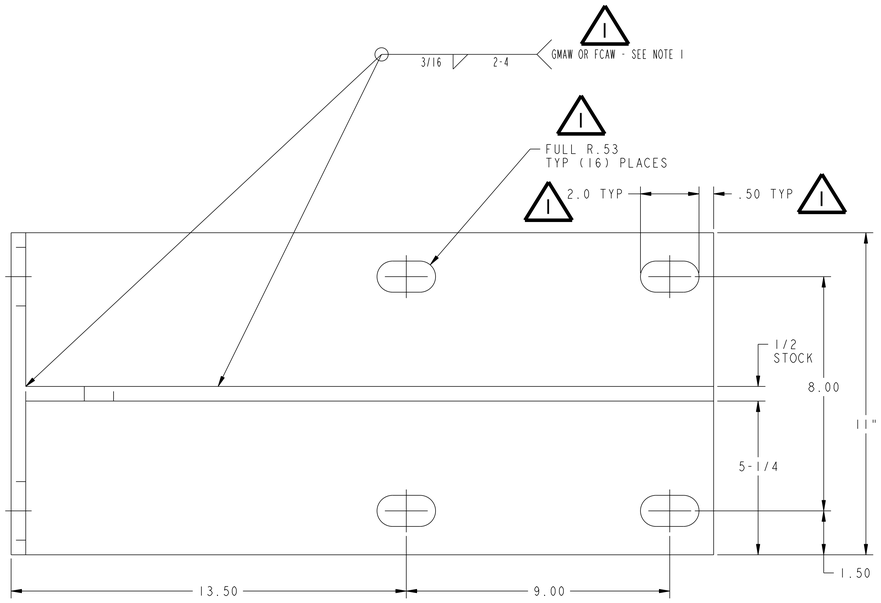
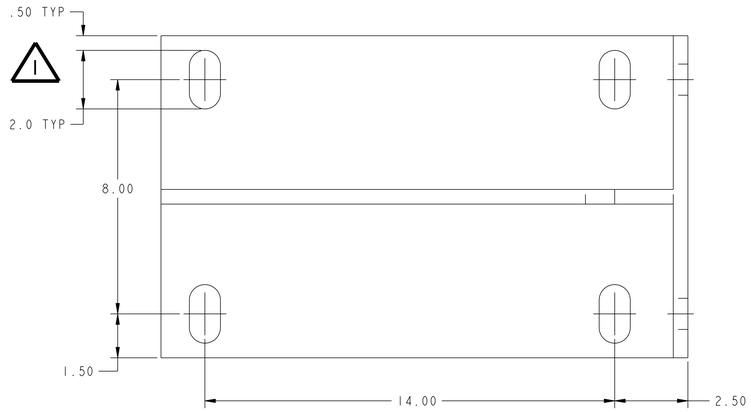
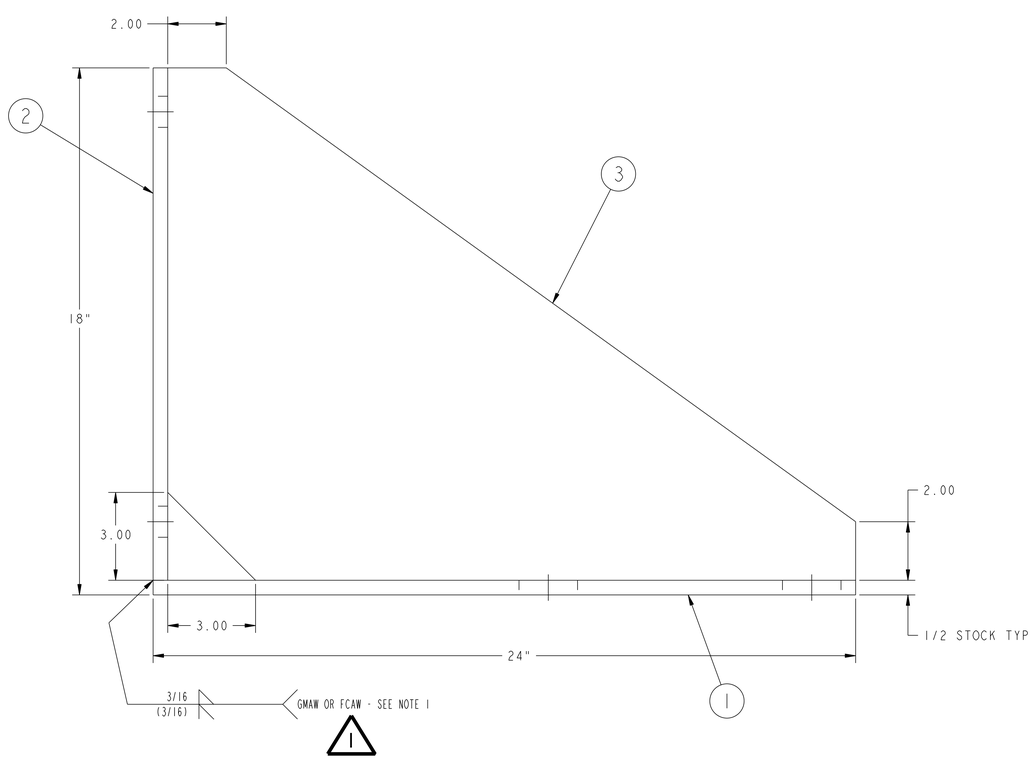
1	REVISED PER ECN-5371	LM	TB	JS	T. BROWN	6-17-08







01 ASSEMBLY

(1) REQ'D

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.

RELEASED FOR FABRICATION / INSTALLATION
PPPL Drafting: jerome siegel
Digitally signed by jerome siegel
DN: cn=jerome siegel, o=PPPL, ou=engineering, email=jsiegel@pppl.gov, c=US
Date: 2008.06.23 10:16:57 -04'00'

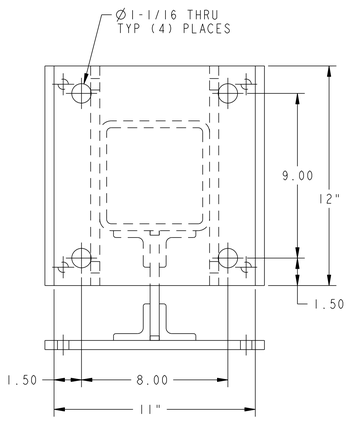
03 ASSY	02 ASSY	01 ASSY	PART NO.	DRAWING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY REQD
1			12	THIS DWG	OUTRIGGER TIE PLATE	ASTM A36	
1			11	THIS DWG	FOOT PLATE	ASTM A36	
1			10	THIS DWG	OUTRIGGER TUBE - 6" x 6" x 3/8 STRUCT TUBE	ASTM A36	
	4		9	THIS DWG	MOUNTING CLIP ANGLE - 2 x 2 x 3/8 STRUCT ANGLE	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	
X	X		—	THIS DWG	OUTRIGGER WELDMENT	———	3
X	X		—	THIS DWG	VERTICAL SUPPORT WELDMENT	———	1
		X	—	THIS DWG	SUPPORT BRACKET WELDMENT	———	1

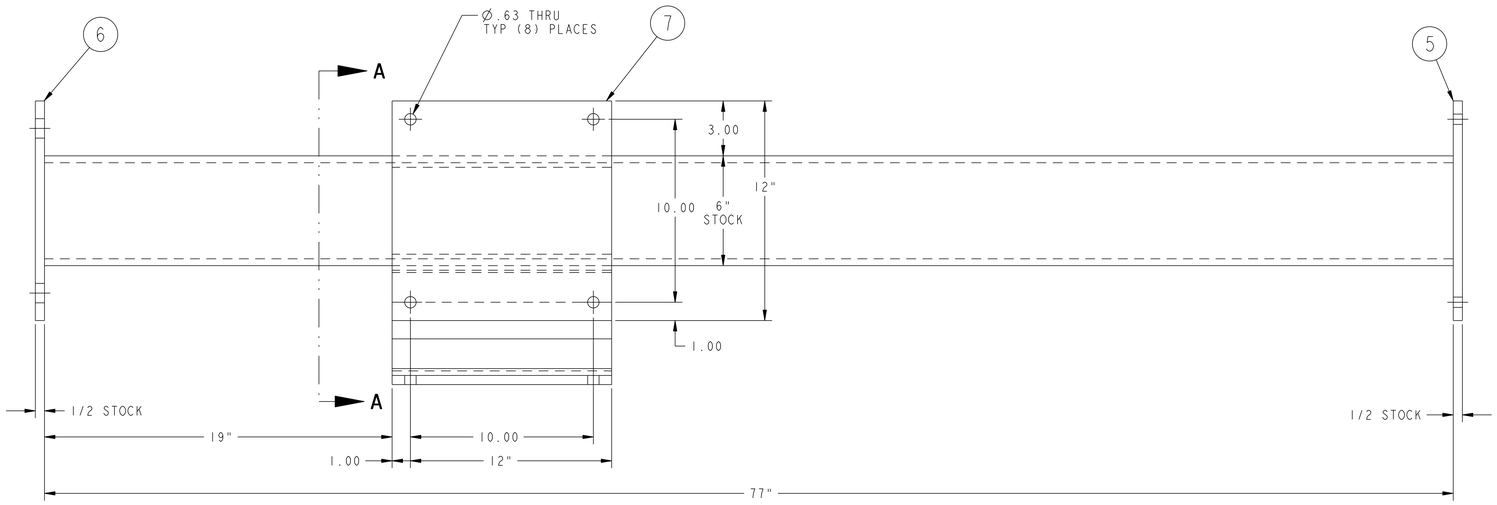
PARTS LIST

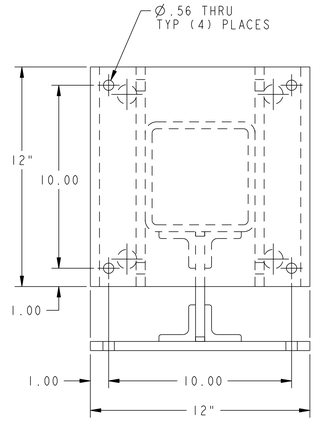
NCSX-SE184-056

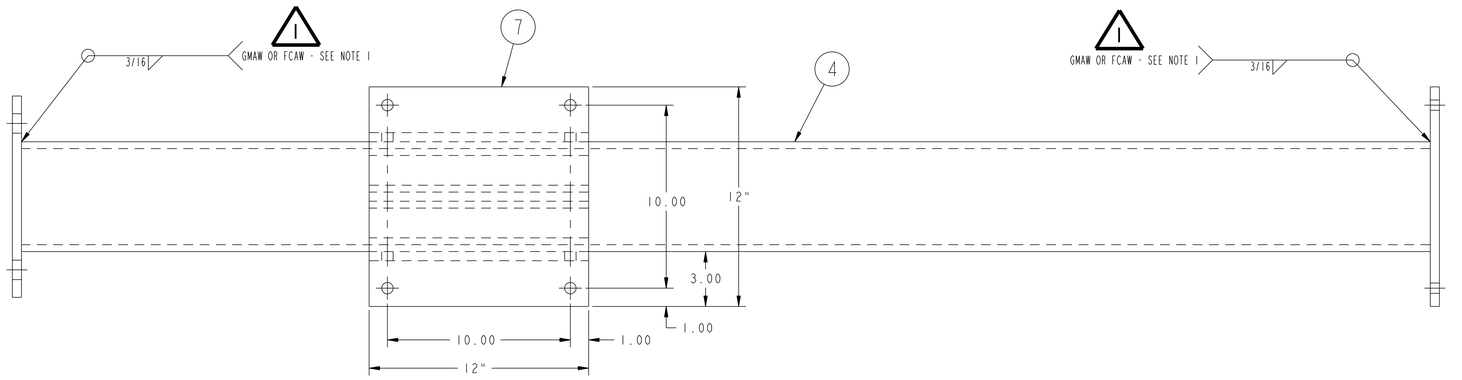
WEIGHT: 99.4 lbs	COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY, PRINCETON UNIVERSITY, NATIONAL COMPACT STELLARATOR EXPERIMENT
MODEL NAME: SE184-056-01	Pro E	DIMENSIONS ARE IN INCHES, MACHINE SURFACES 125	FIELD PERIOD ASSEMBLY, VACUUM VESSEL SUPPORT ASSEMBLY, VERTICAL SUPPORT WELDMENTS
WELDING ENGINEER: G.GETTELFINGER 8-2-2007	DO NOT VERIFY INFORMATION BY SCALING DRAWING	BREAK SHARP EDGES .005/.020	
NEXT ASSEMBLY		TOLERANCES NON-CUMULATIVE	DSN: L. MORRIS 8-2-2007 — DRAWING NO: SE184-056
		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: M. COLE 8-2-2007
			ENGR: T. BROWN 8-2-2007
RELEASE LEVEL: Fabrication			SUPV: J. SIEGEL 8-2-2007 — SHEET 1 OF 3 — REV 1
DWG VERSION NO: 0			NCSX_ASSY_FORMAT_E

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



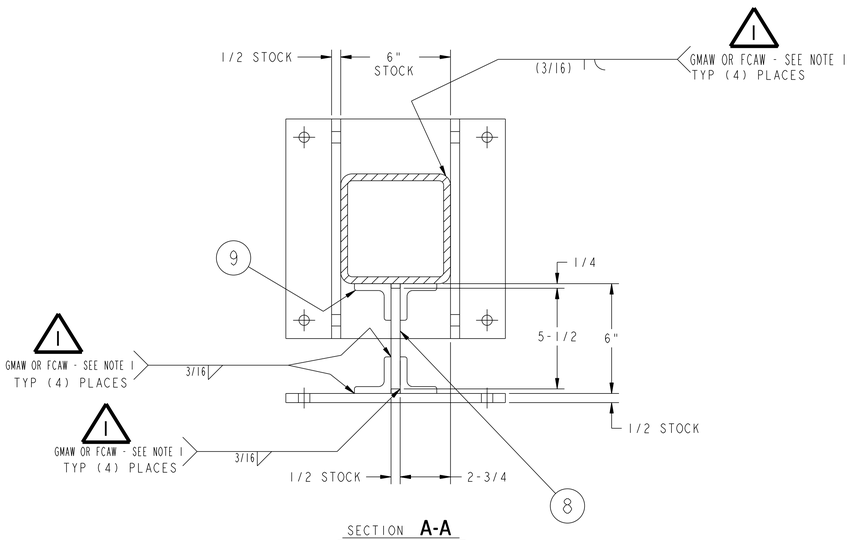






02 ASSEMBLY

(1) REQ'D



SECTION **A-A**

RELEASED FOR FABRICATION / INSTALLATION
PPPL Drafting: jerome siegel

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

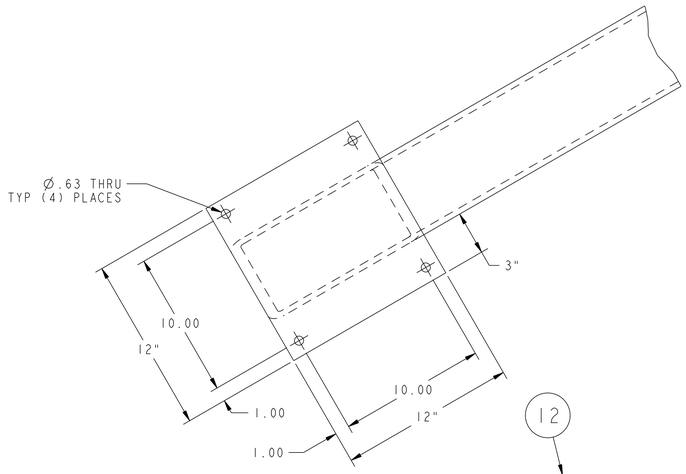
RELEASE LEVEL: Fabrication
DWG VERSION NO: 0

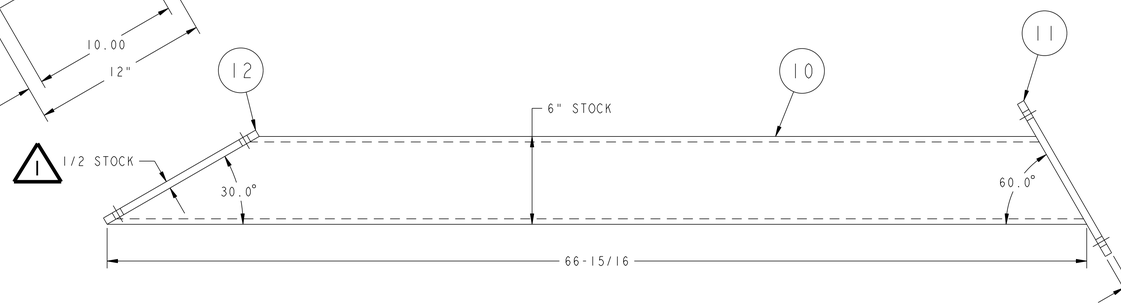
WEIGHT 99.4 lbs	COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY NATIONAL COMPACT STELLARATOR EXPERIMENT
MODEL NAME SE184-056-01	Pro E	DIMENSIONS ARE IN INCHES MACHINE SURFACES 125	FIELD PERIOD ASSEMBLY VACUUM VESSEL SUPPORT ASSEMBLY VERTICAL SUPPORT WELDMENTS
WELDING ENGINEER G.GETTELFINGER 8-2-2007	DO NOT VERIFY INFORMATION BY SCALING DRAWING	BREAK SHARP EDGES .005/.020	
	NEXT ASSEMBLY	TOLERANCES NON-CUMULATIVE	DSN: L. MORRIS 8-2-2007 — DRAWING NO:
		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: M. COLE 8-2-2007 — SE184-056
			ENGR: T. BROWN 8-2-2007
			SUPV: J. SIEGEL 8-2-2007 — SHEET 2 OF 3 — REV 0.1

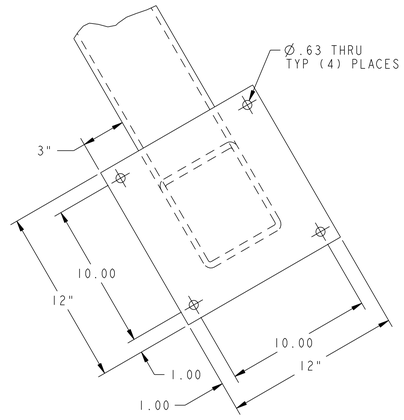
NCSX_ASSY_FORMAT_E

NCSX-SE184-056

NO.	REVISION	BY	CH	SUP	APPROVED	DATE







03 ASSEMBLY

(3) REQ'D

RELEASED FOR FABRICATION / INSTALLATION

PPPL Drafting: jerome siegel

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

RELEASE LEVEL: Fabrication
DWG VERSION NO: 6

WEIGHT	312.3 lbs	
MODEL NAME	SE184-056-02	
WELDING ENGINEER	G.GETTELFINGER	8-2-2007

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 125
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
FIELD PERIOD ASSEMBLY
VACUUM VESSEL SUPPORT ASSEMBLY
VERTICAL SUPPORT WELDMENTS

DSN: L. MORRIS	8-2-2007	DRAWING NO:
CHK: M. COLE	8-2-2007	SE184-056
ENGR: T. BROWN	8-2-2007	
SUPV: J. SIEGEL	8-2-2007	SHEET 3 OF 3 REV 1.1

NCSX_ASSY_FORMAT_E

NCSX-SE184-056