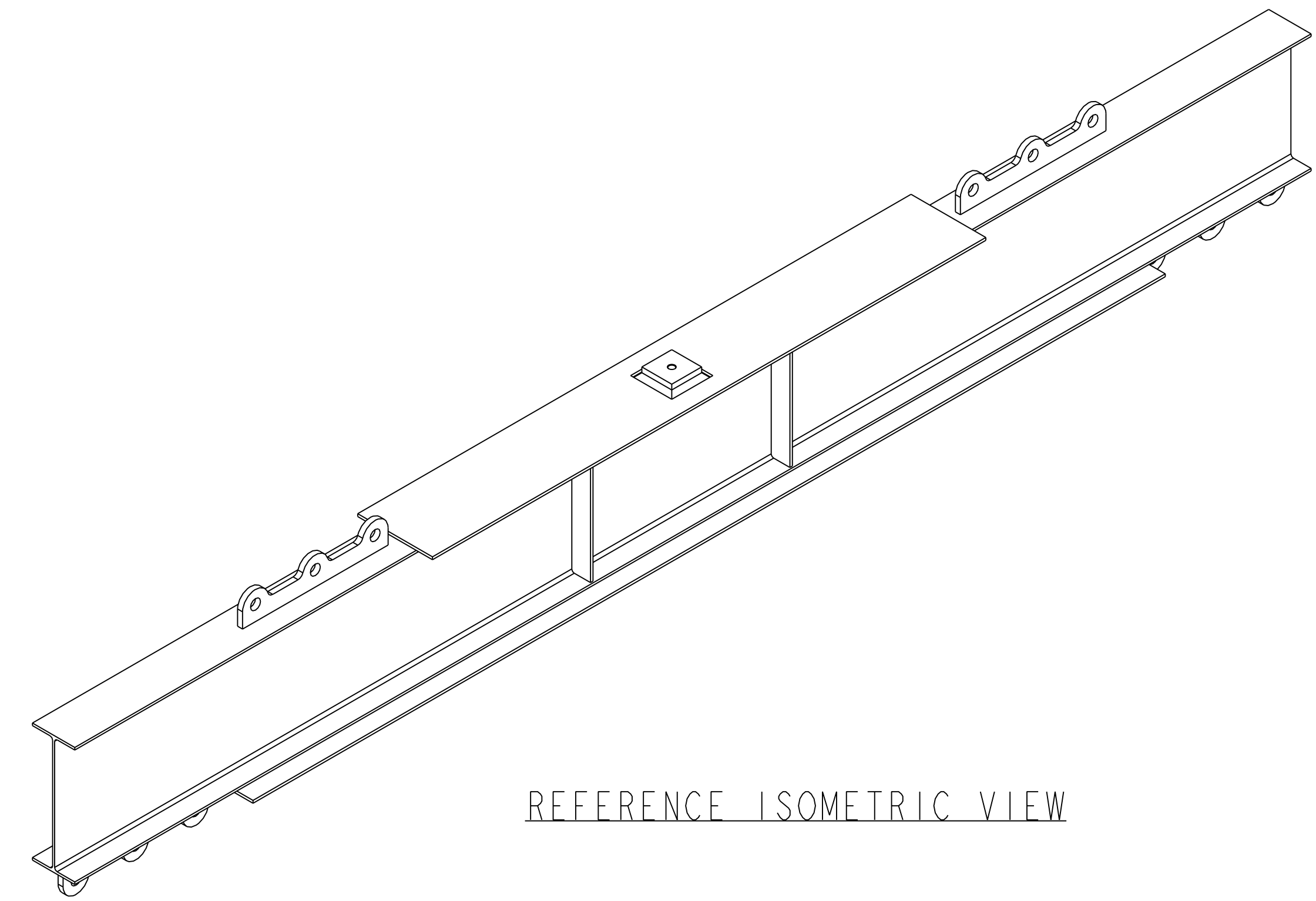


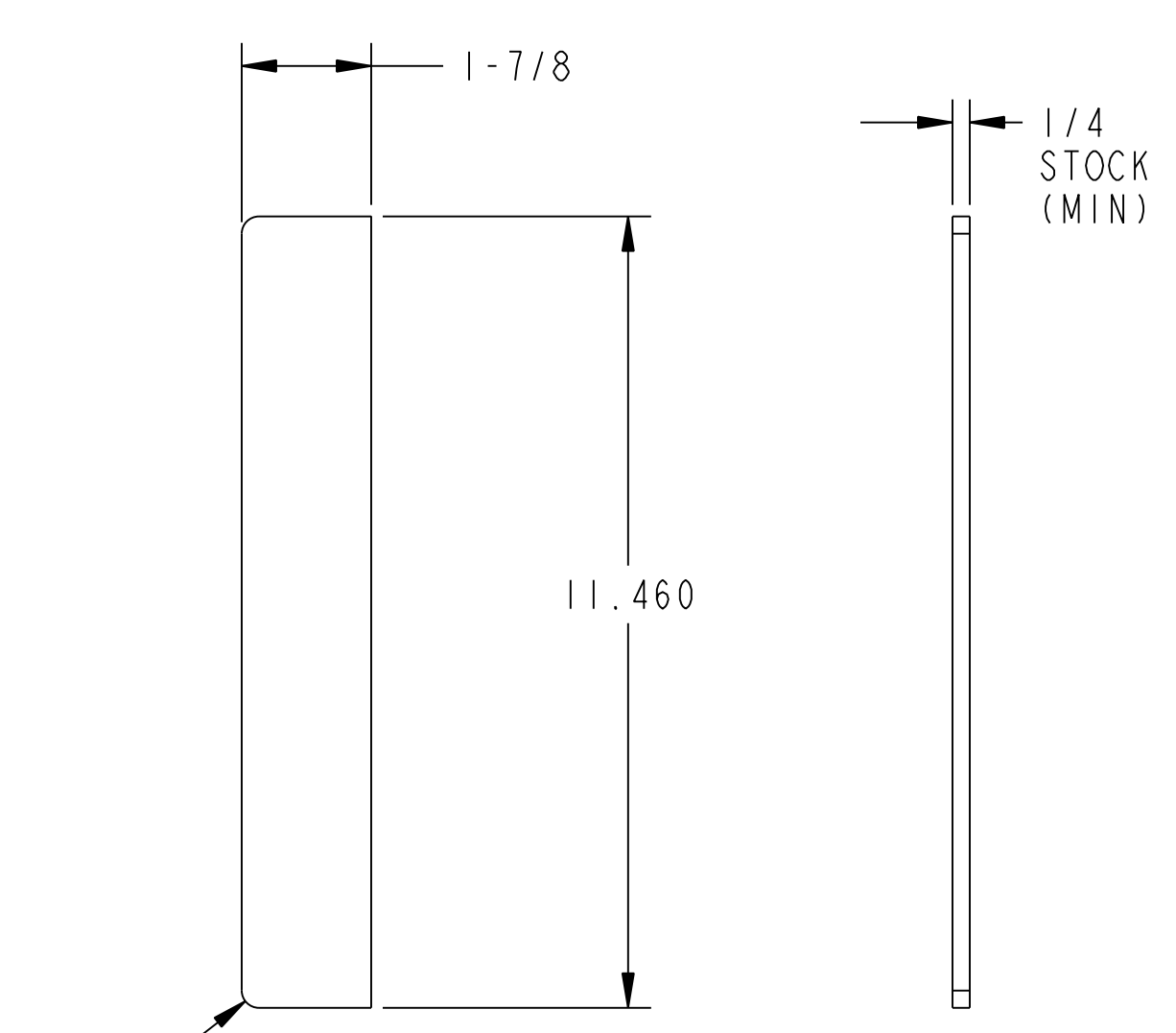
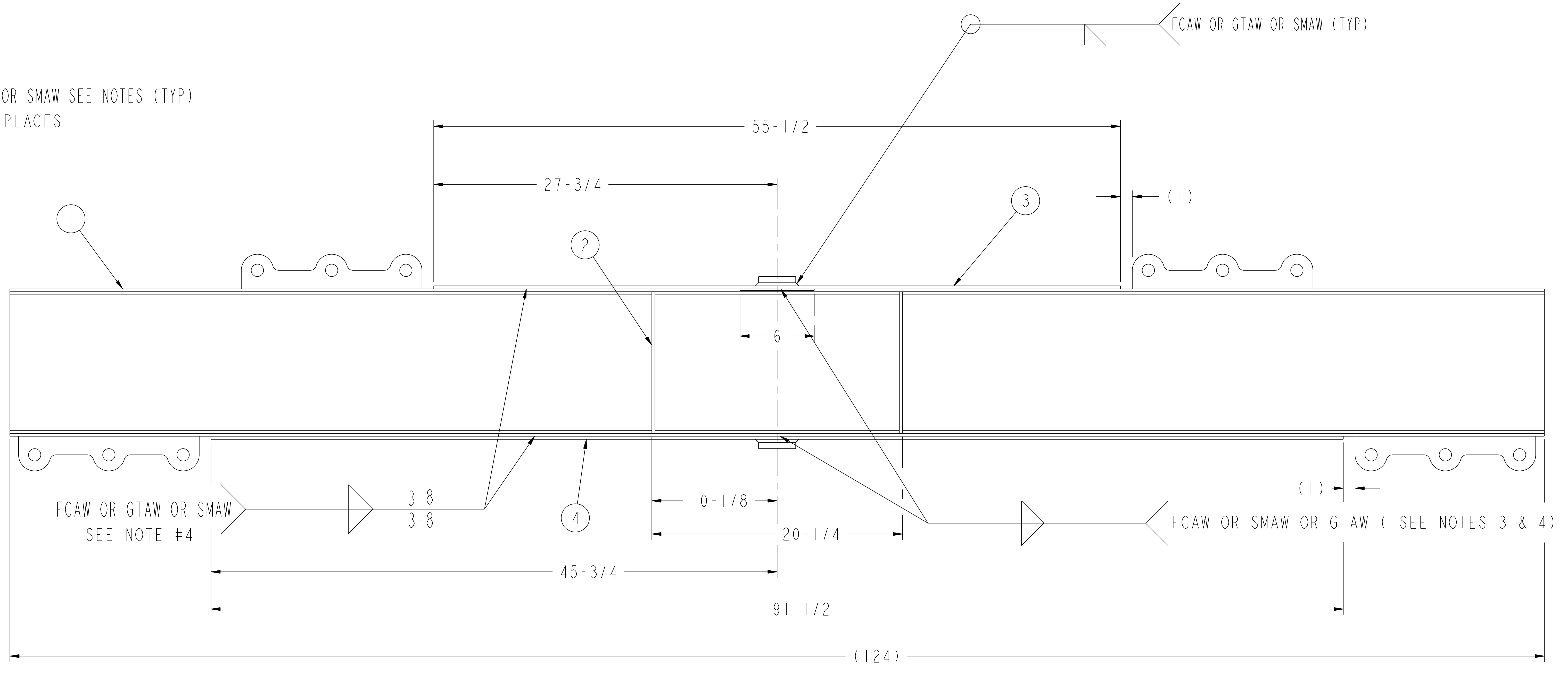
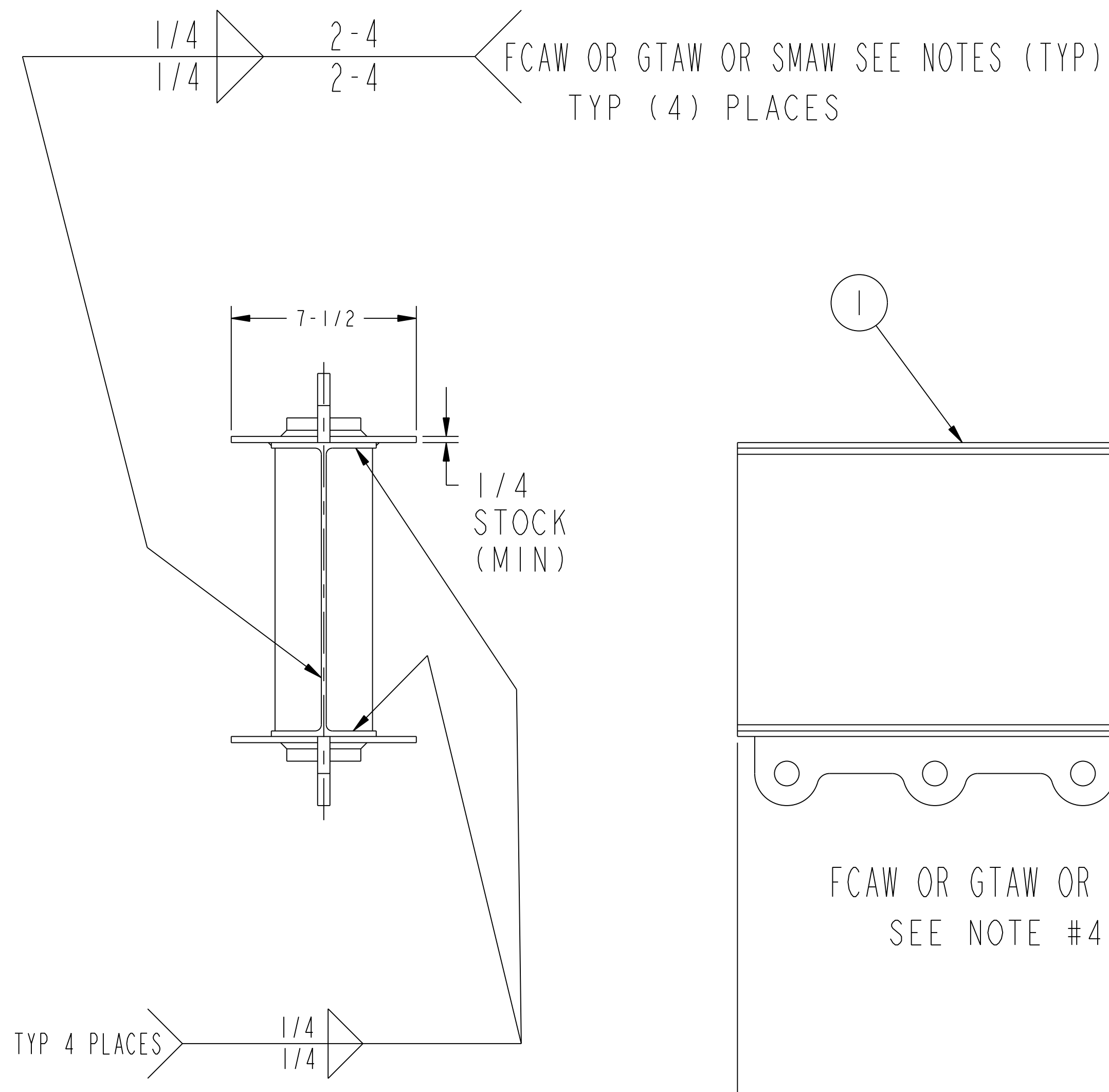
④ LOWER STIFFENER PLATE



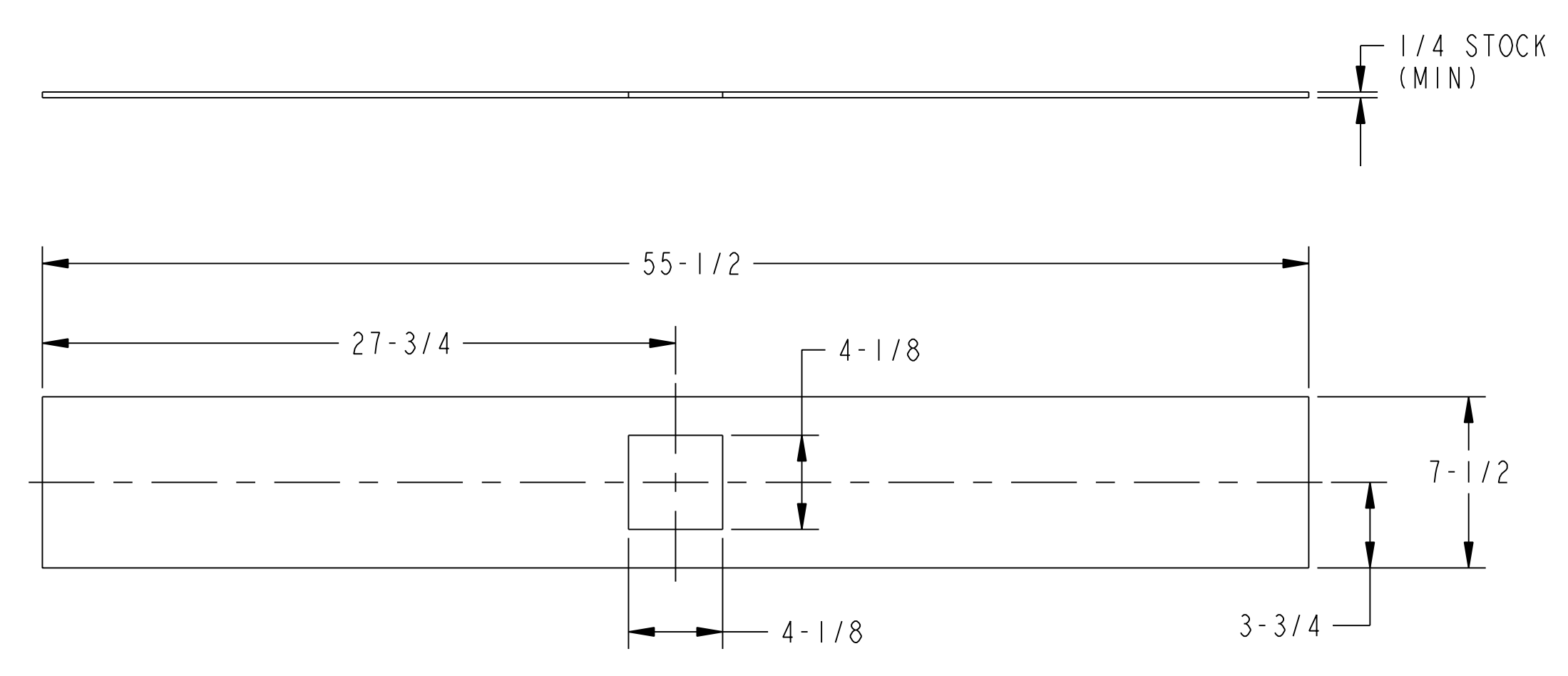
REFERENCE ISOMETRIC VIEW

NOTES

1. WELDING SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF PPPL PROCEDURE ENG-037.
2. VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH THE ACCEPTANCE CRITERIA OF AWS D1.1.
3. USE CONTINUOUS WELD 6" ON CENTER OF BEAM, TYP BOTH SIDES TOP AND BOTTOM.
4. WELDS TO FLANGES ARE TO BE FULL SIZE FILLETS THE THICKNESS OF THE FLANGE.



② STIFFENER



③ UPPER STIFFENER PLATE

RELEASED FOR FABRICATION/INSTALLATION  
PPPL Drafting

01 ASSY	PART NO.	DRAWING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY RECD
	4	THIS DWG	LOWER STIFFENER PLATE	ASTM A36	
	3	THIS DWG	UPPER STIFFENER PLATE	ASTM A36	
	2	THIS DWG	LIFTING BEAM STIFFENER 1/4 STOCK	ASTM A36	
	1	SE185-121	MODULAR COIL LIFTING BEAM	SEE DWG	
		THIS DWG	MODULAR COIL LIFTING BEAM WELDMENT		

PARTS LIST

COMPUTER GENERATED DRAWING CHANGES NOT PERMITTED	CENTRAL FILES:	PRINCETON PLASMA PHYSICS LABORATORY	
Pro E	UNLESS OTHERWISE SPECIFIED	PRINCETON UNIVERSITY	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	DIMENSIONS ARE IN INCHES MACHINE SURFACES	NATIONAL COMPACT STELLARATOR EXPERIMENT	
	BREAK SHARP EDGES .005/.020	FIELD PERIOD ASSEMBLY	
	TOLERANCES NON-CUMULATIVE	MODULAR COIL LIFTING BEAM	
	DECIMAL-INCH FRACTIONS	MODULAR COIL LIFTING BEAM WELDMENT	
	DSN: L. MORRIS	7-21-2008	DRAWING NO:
	ENGR: M. SMITH/ M. VIOLA	7-21-2008	SE185-122
	ENGR: M. SMITH/ M. VIOLA	7-21-2008	
	SUPV: J. SEIGEL	7-21-2008	SHEET 1 OF 1
			REV 0

RELEASE LEVEL: Fabrication  
DWG VERSION NO: 2

WEIGHT: 416.2 lbs  
MODEL NAME: SE185-123  
WELDING ENGINEER: M. DENAULT 7-21-2008