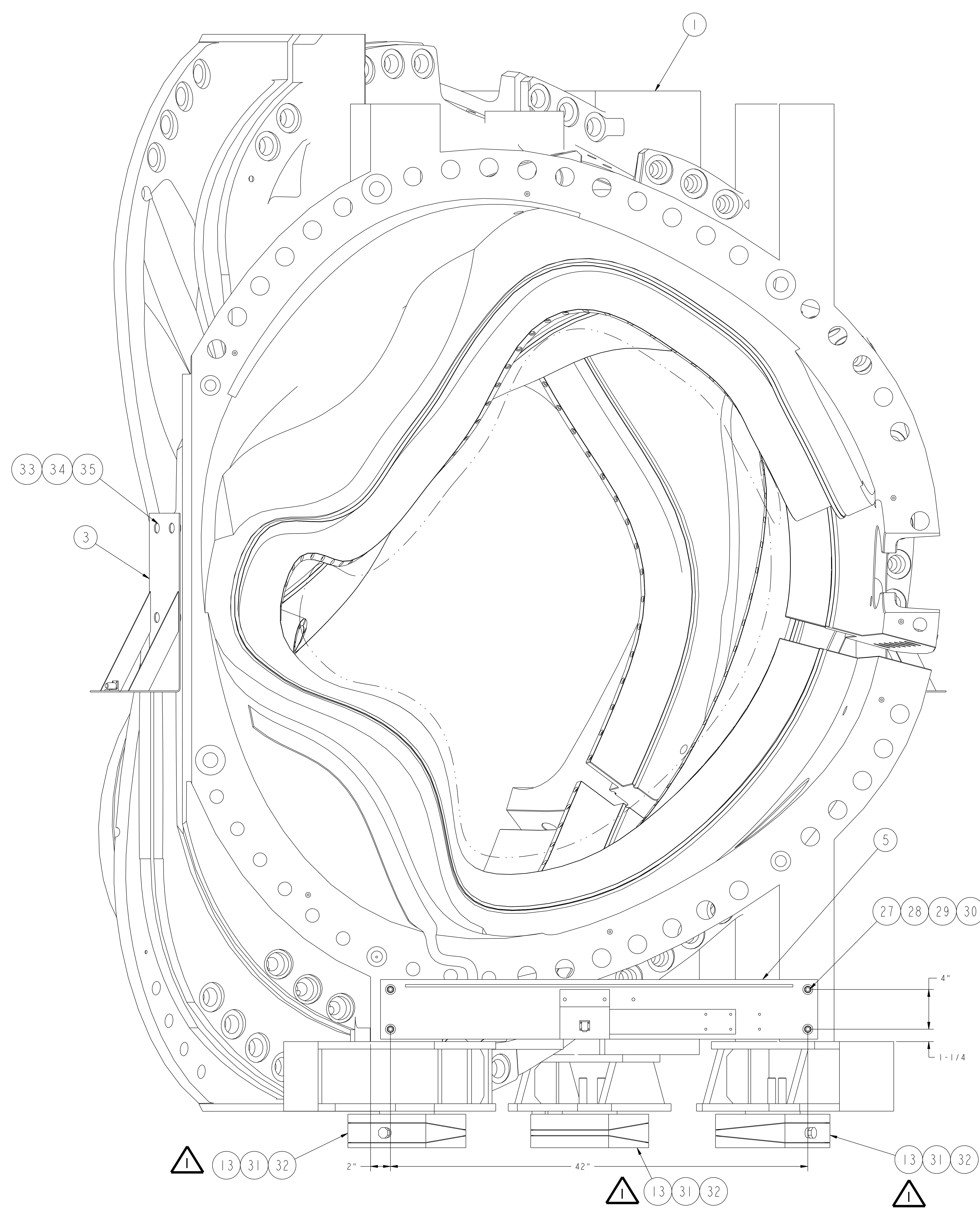


NO.	REVISION	BY	CH	SUP	APPROVED	DATE
1	REVISED PER ECN-5347	LM	TB	JS	T. BROWN	4-18-08

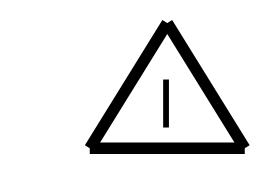
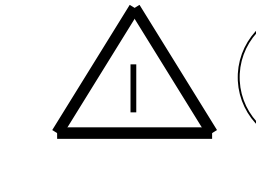
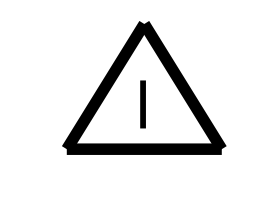
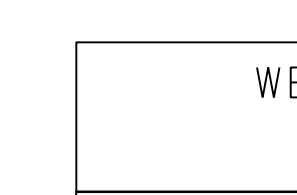
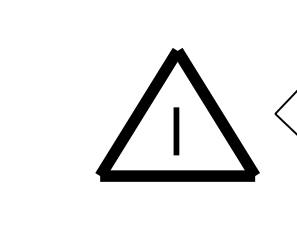


NOTE
WORK THIS DRAWING WITH DRAWING SE185-314

**RELEASED FOR
FABRICATION / INSTALLATION**
PPPL Drafting:

2	2	38	COMM	1"-8UNC-2B HEX NUT	C'STL - ZN PLT
4	4	37	COMM	1"-8UNC-2A x 4" LG HEX HD CAP SCREW	C'STL - ZN PLT
3	3	36	COMM	1"-8UNC-2A x 3" LG HEX HD CAP SCREW	C'STL - ZN PLT
8	8	35	COMM	1"-8UNC-2A x 1 1/2 LG HEX HD CAP SCREW	C'STL - ZN PLT
15	15	34	COMM	1" SPLIT LOCK WASHER	C'STL - ZN PLT
17	17	33	COMM	1" FLAT WASHER	C'STL - ZN PLT
6	6	32	COMM	M20 x 2.5MM PITCH METRIC CLASS 8 HEX NUT	C'STL - ZN PLT
6	6	31	COMM	3/4" SPHERICAL WASHER SET - McMASTER-CARR #91131A090	C'STL - ZN PLT
4	4	30	COMM	3/8-16UNC-2B HEX NUT	C'STL - ZN PLT
4	4	29	COMM	3/8" SPLIT LOCK WASHER	C'STL - ZN PLT
4	4	28	COMM	3/8" FLAT WASHER	C'STL - ZN PLT
4	4	27	COMM	WELD STUD - 3/8-16UNC-2A x 1 1/4"LG	C'STL
4	4	26	COMM	1/4-20UNC-2B HEX NUT	C'STL - ZN PLT
4	4	25	COMM	1/4-20UNC-2A x 1" LG HEX HD CAP SCREW	C'STL - ZN PLT
4	4	24	COMM	1/4" SPLIT LOCK WASHER	C'STL - ZN PLT
8	8	23	COMM	1/4" FLAT WASHER	C'STL - ZN PLT
12	12	22	COMM	#10-24UNC-2B HEX NUT	C'STL - ZN PLT
16	16	21	COMM	#10-24UNC-2A x 1" LG HEX SOCKET HD CAP SCREW	C'STL - ZN PLT
16	16	20	COMM	#10 SPLIT LOCK WASHER	C'STL - ZN PLT
32	32	19	COMM	#10 (Ø .190 NOM) FLAT WASHER	C'STL - ZN PLT
12	12	18	COMM	#4-40UNC-2B HEX NUT	C'STL - ZN PLT
12	12	17	COMM	#4 SPLIT LOCK WASHER	C'STL - ZN PLT
24	24	16	COMM	#4 FLAT WASHER	C'STL - ZN PLT
12	12	15	COMM	#4-40UNC-2A x 5/8 LG HEX HD MACH SCR	C'STL - ZN PLT
3	3	14	COMM	ADJUSTABLE-DOT LASER KIT - CLASS 1110 LASER - 110 VAC McMASTER-CARR #2055A21 OR EQUIVALENT	
3	3	13	COMM	AIRLOC WEDGMOUNT PRECISION LEVELER WITH SPHERICAL SEAT, BOLT-ON #1.36206.56-206-VRKC/903	
1	1	12	SE186-338-02	MCWF SEGMENT "C" SUPPORT BRACKET TYPE #2 WELDMENT - OPPOSITE	SEE DWG
1	1	11	SE186-338-01	MCWF SEGMENT "C" SUPPORT BRACKET TYPE #2 WELDMENT - AS SHOWN	SEE DWG
1	1	10	SE186-337-02	MCWF SEGMENT "C" SUPPORT BRACKET WELDMENT - OPPOSITE	SEE DWG
1	1	9	SE186-337-01	MCWF SEGMENT "C" SUPPORT BRACKET TYPE #1 WELDMENT - AS SHOWN	SEE DWG
1	1	8	SE186-336-02	MCWF SEGMENT "A" SUPPORT BRACKET WELDMENT - OPPOSITE	SEE DWG
1	1	7	SE186-336-01	MCWF SEGMENT "A" SUPPORT BRACKET WELDMENT - AS SHOWN	SEE DWG
1	1	6	SE185-311-8	VERTICAL LASER PEN MOUNTING BRACKET BRACE	SEE DWG
1	1	5	SE185-311-04	LASER PEN MOUNTING BRACKET SUPPORT PLATE WELDMENT	SEE DWG
1	1	4	SE185-311-03	VERTICAL LASER PEN MOUNTING BRACKET WELDMENT	SEE DWG
1	1	3	SE185-311-02	REAR LASER PEN MOUNTING BRACKET WELDMENT	SEE DWG
1	1	2	SE185-311-01	FRONT LASER PEN MOUNTING BRACKET WELDMENT	SEE DWG
1	1	1		MODULAR COIL HALF PERIOD ASSEMBLY	
1	1			THIS DWG	RIGHT HALF PERIOD ASSEMBLY
1	1			THIS DWG	LEFT HALF PERIOD ASSEMBLY

02 ASSY	01 ASSY	PART NO.	DRAWING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY REQ'D
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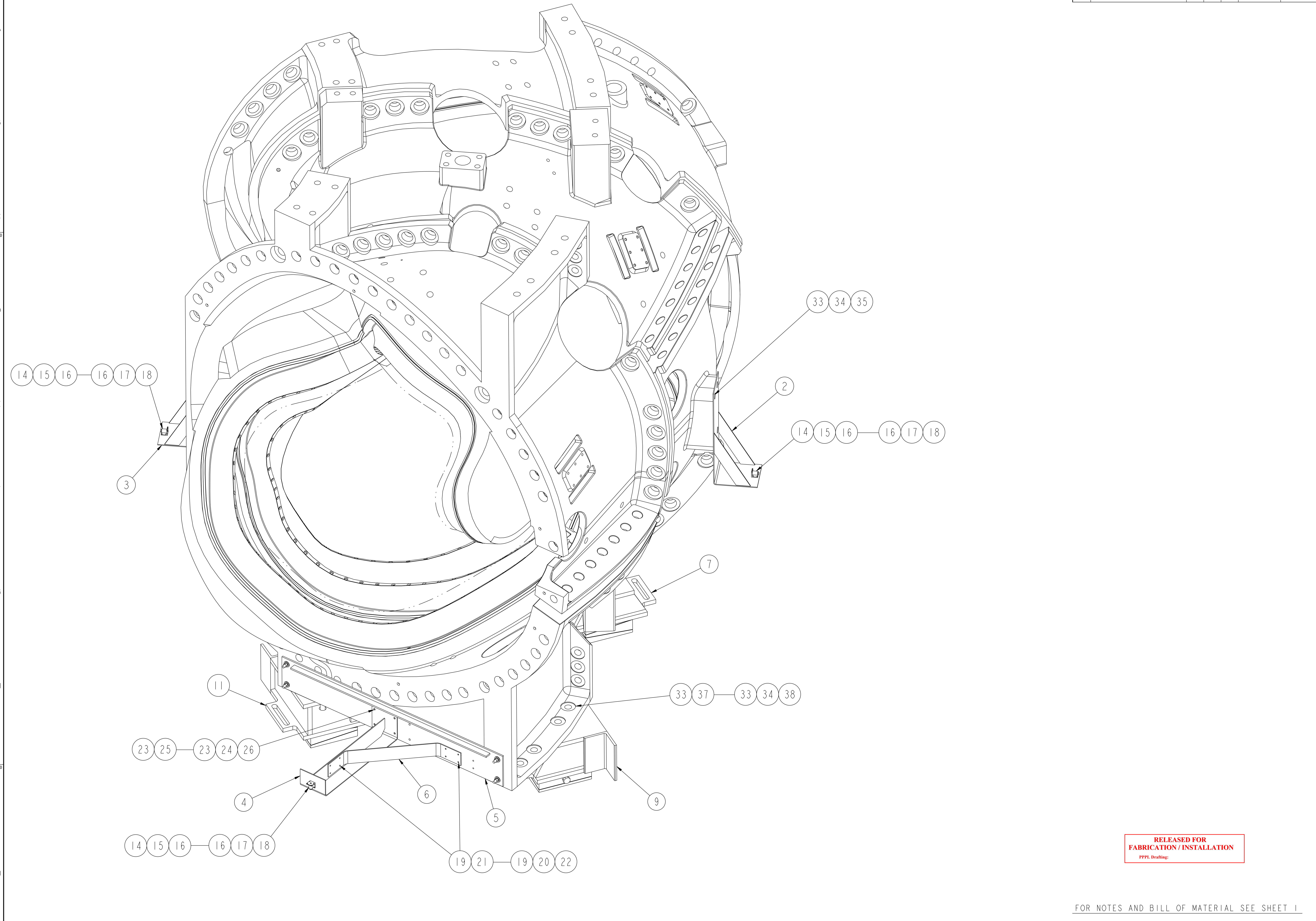
01 ASSEMBLY - LEFT HALF PERIOD ASSEMBLY

RELEASE LEVEL: Fabrication
DWG VERSION NO: 0

WEIGHT	COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED PRO E	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES MACHINE SURFACES UNLESS SHOWN OTHERWISE BREAK SHARP EDGES .005/.020	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY NATIONAL COMPACT STELLARATOR EXPERIMENT FIELD PERIOD ASSEMBLY FIELD PERIOD ASSEMBLY FIXTURE HALF FIELD PERIOD ASSEMBLY WITH SUPPORTS AND LASER PENS
MODEL NAME SE185-300	DO NOT VERIFY INFORMATION BY SCALING DRAWING	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX ±.000 .XXX ±.005 ANGULAR ±.05°	DSN: L. MORRIS 11-26-07 CHK: M. COLE 11-26-07 ENGR: T. BROWN 11-26-07 SUPV: J. SIEGEL 11-26-07
	NEXT ASSEMBLY		DRAWING NO: SE185-302 SHEET 1 OF 6 REV 1.1

NCSX-SE185-302

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



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 PPPL Drafting

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

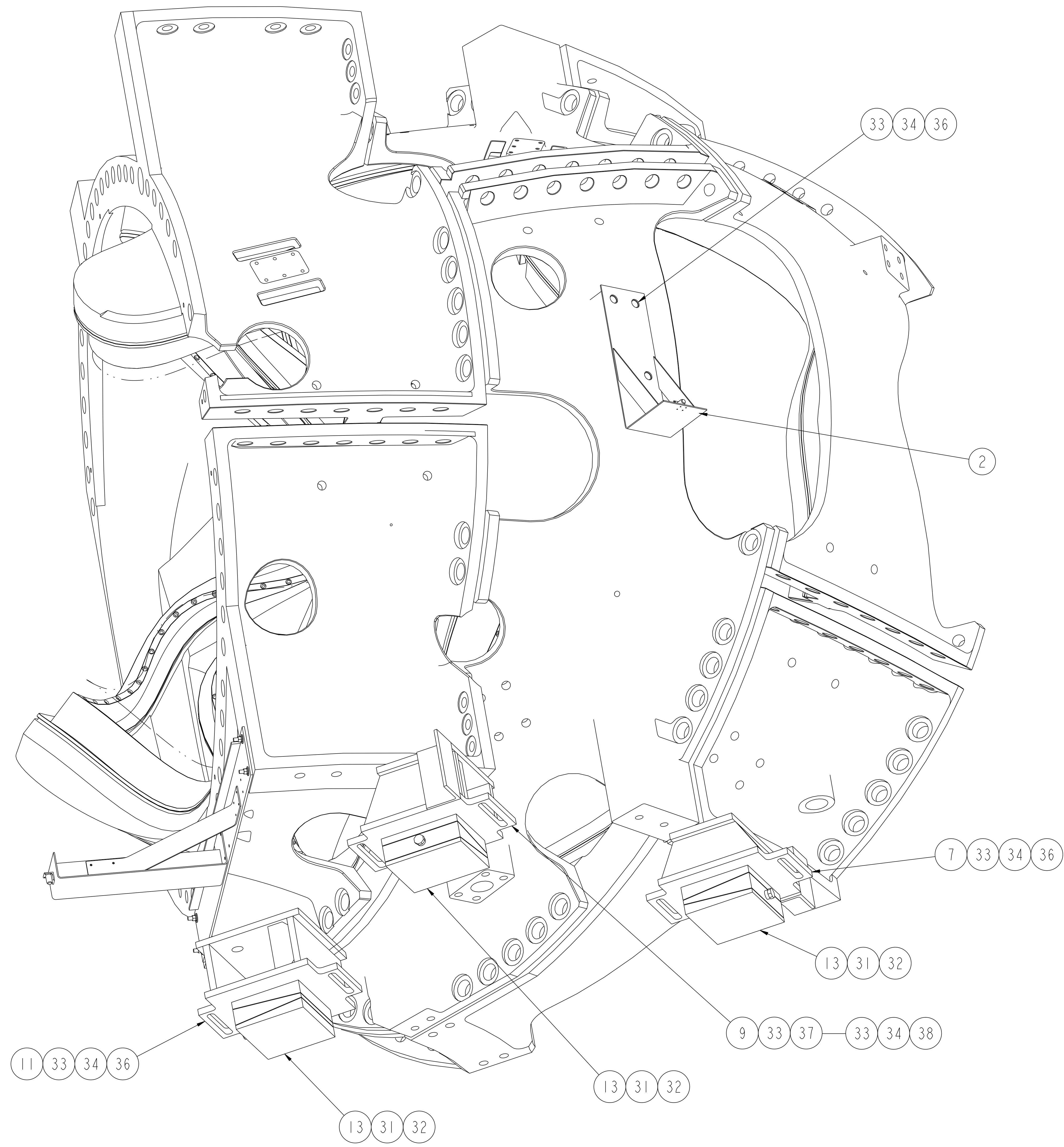
01 ASSEMBLY - LEFT HALF PERIOD ASSEMBLY

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 FIELD PERIOD ASSEMBLY FIXTURE HALF FIELD PERIOD ASSEMBLY WITH SUPPORTS AND LASER PENS	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	TOLERANCES NON-CUMULATIVE	DSN: L. MORRIS 11-26-07 DRAWING NO:
NEXT ASSEMBLY	DECIMAL-INCH FRACTIONS	CHK: M. COLE 11-26-07	ENGR: T. BROWN 11-26-07
WEIGHT	XXX +/- .005 72°-120° +/- .124 ANGULAR +/- 0°-15' OVER 120° +/- .124	SUPV: J. SIEGEL 11-26-07	SE185-302 SHEET 2 OF 6 REV 1.1
MODEL NAME SE185-300	WELDING ENGINEER		

RELEASE LEVEL: Fabrication
DWG VERSION NO: 0

NCSX-SE185-302

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



01 ASSEMBLY - BOTTOM ISOMETRIC VIEW

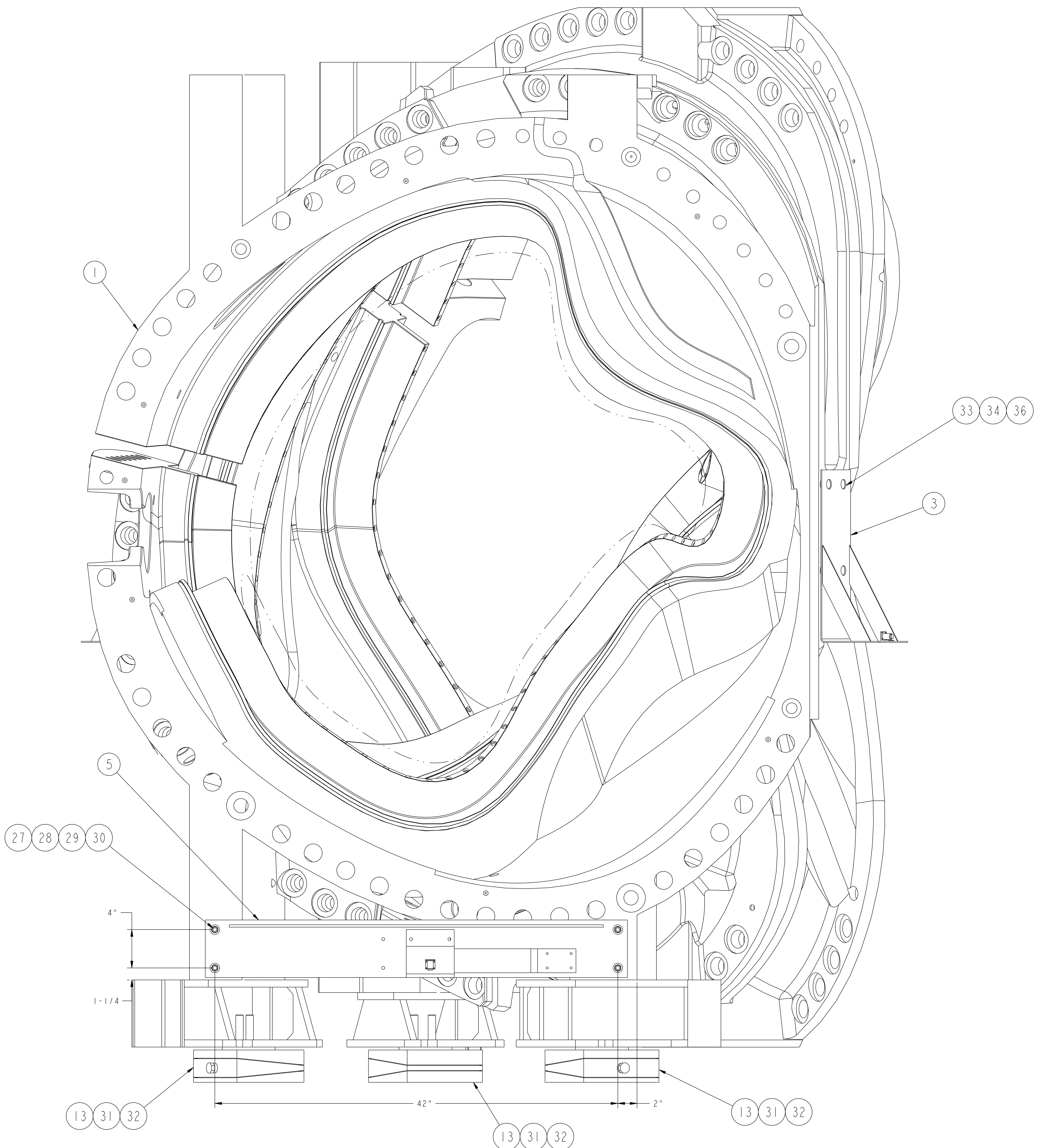
**RELEASED FOR
FABRICATION / INSTALLATION**
 PPPL Drafting

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES:	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY	
	UNLESS OTHERWISE SPECIFIED	NATIONAL COMPACT STELLARATOR EXPERIMENT	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	DIMENSIONS ARE IN INCHES MACHINE SURFACES	FIELD PERIOD ASSEMBLY FIELD PERIOD ASSEMBLY FIXTURE HALF FIELD PERIOD ASSEMBLY WITH SUPPORTS AND LASER PENS	
	BREAK SHARP EDGES .005/.020	DSN: L. MORRIS	11-26-07 DRAWING NO:
	TOLERANCES NON-CUMULATIVE	CHK: M. COLE	11-26-07
	DECIMAL-INCH FRACTIONS	ENGR: T. BROWN	11-26-07
	.XX +/- .000 0°-120° +/- 1/16	SUPV: J. SIEGEL	11-26-07
	.XXX +/- .005 120°-120° +/- 1/16		
	ANGULAR +/- 0°-15° OVER 120° +/- 1/16		
WEIGHT	MODEL NAME SE185-300	RELEASE LEVEL: Fabrication DWG VERSION NO: 0	SE185-302
WELDING ENGINEER			SHEET 3 OF 6 REV 1.1

NCSX-SE185-302

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



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FOR BILL OF MATERIAL AND NOTES SEE SHEET 1

02 ASSEMBLY - RIGHT HALF PERIOD ASSEMBLY

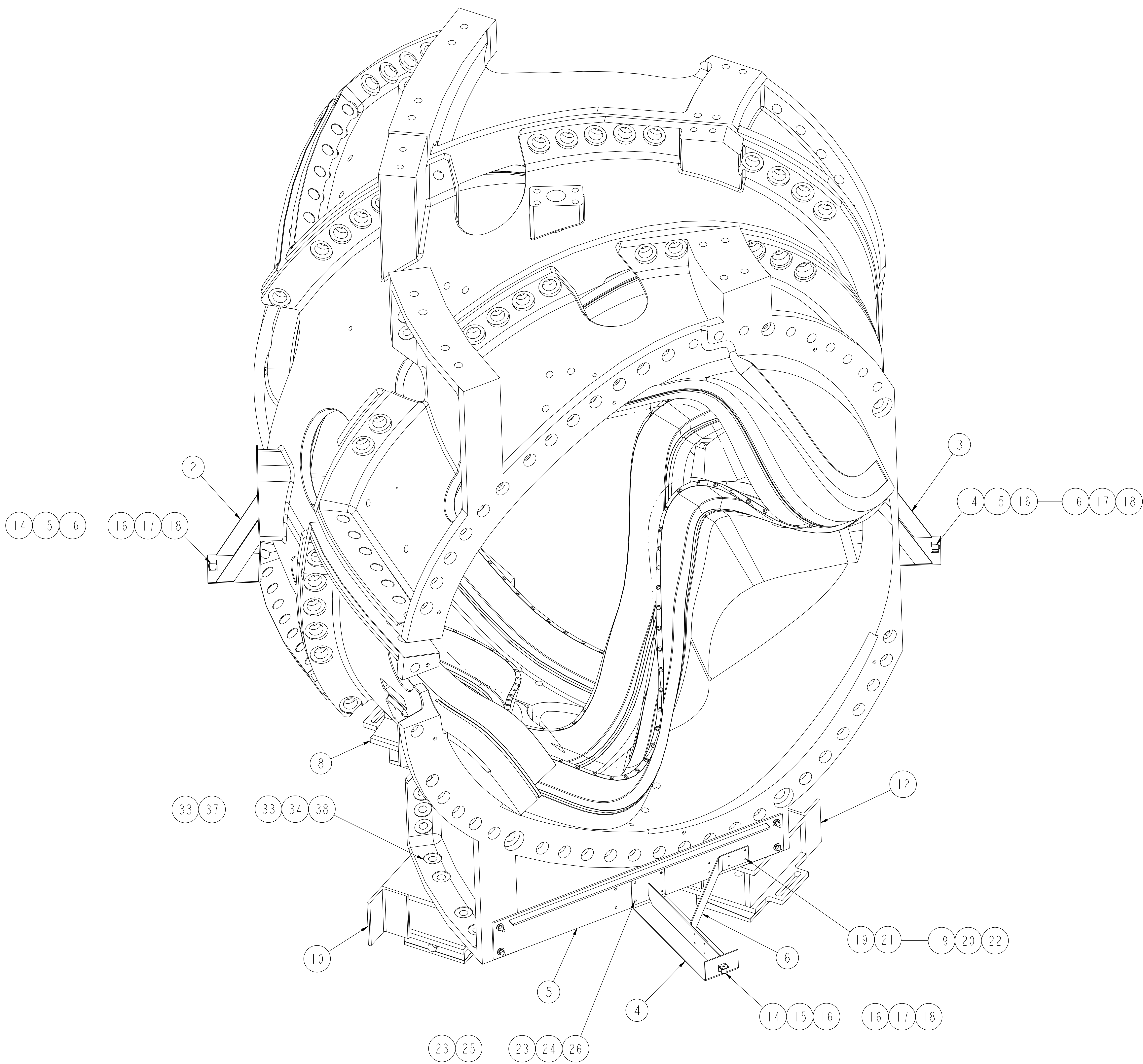
RELEASE LEVEL: Fabrication
 DWG VERSION NO: 0

WEIGHT
 MODEL NAME
 SE185-300
 WELDING ENGINEER

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	
NEXT ASSEMBLY	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX +/- .000 0°-120° +/- .010 .XXX +/- .005 120°-120° +/- .010 ANGULAR +/- .0°-15° OVER 120° +/- .1°	FIELD PERIOD ASSEMBLY FIELD PERIOD ASSEMBLY FIXTURE HALF FIELD PERIOD ASSEMBLY WITH SUPPORTS AND LASER PENS	DSN: L. MORRIS 11-26-07 CHK: M. COLE 11-26-07 ENGR: T. BROWN 11-26-07 SUPV: J. SIEGEL 11-26-07
		DRAWING NO: SE185-302	SHEET 4 OF 6 REV 1.1

NCSX-SE185-302

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



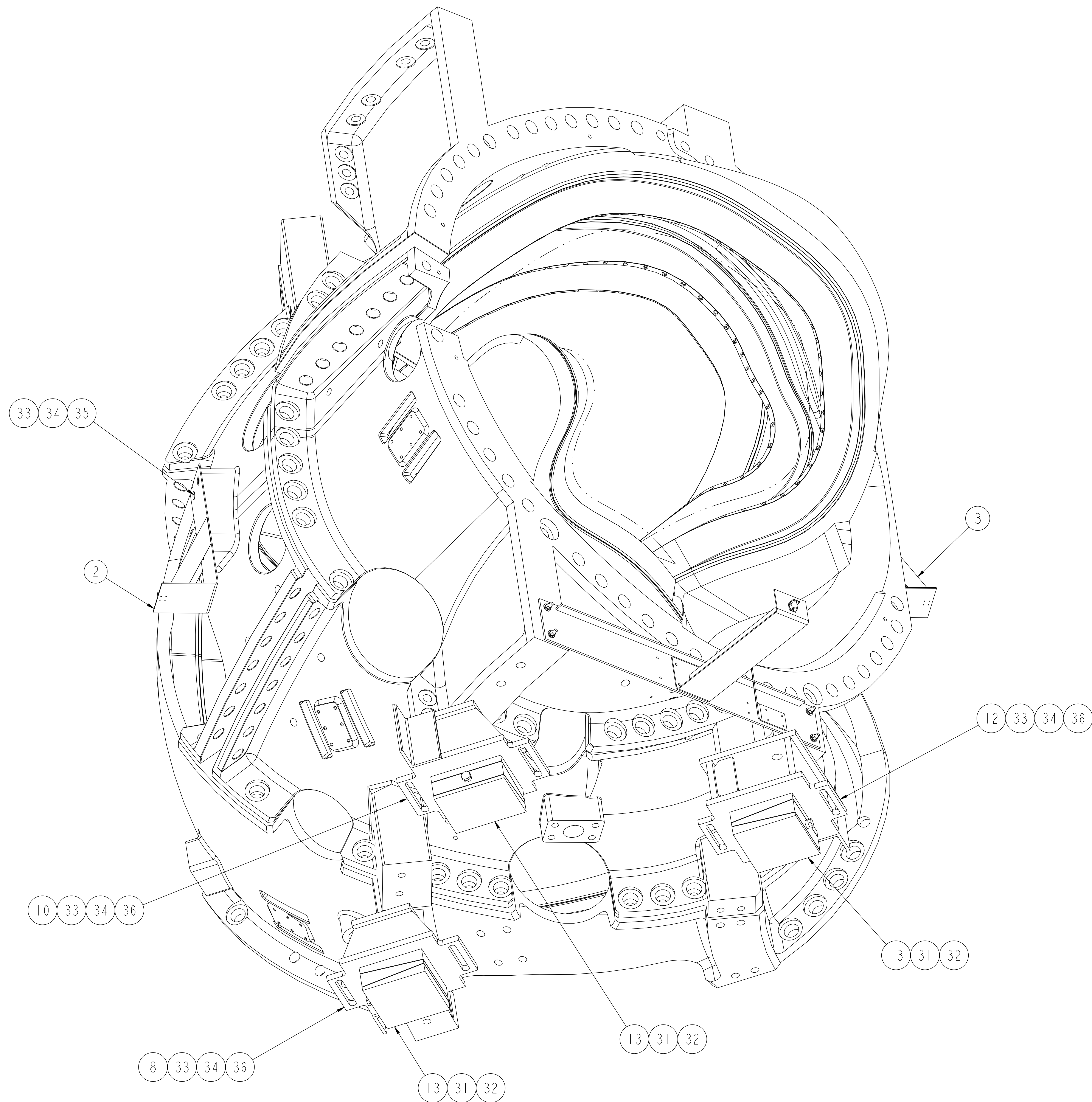
02 ASSEMBLY - RIGHT HALF PERIOD ASSEMBLY

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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 FIELD PERIOD ASSEMBLY FIXTURE HALF FIELD PERIOD ASSEMBLY WITH SUPPORTS AND LASER PENS	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	DSN: L. MORRIS	11-26-07
TOLERANCES NON-CUMULATIVE	DECIMAL-INCH FRACTIONS	CHK: M. COLE	11-26-07
NEXT ASSEMBLY	.XX ±.000 0°-120° ±.125° .XXX ±.005 72°-120° ±.125° ANGULAR ±.0°-15° OVER 120° ±.125°	ENGR: T. BROWN	11-26-07
WEIGHT		SUPV: J. SIEGEL	11-26-07
MODEL NAME SE185-300			DRAWING NO: SE185-302
WELDING ENGINEER			SHEET 5 OF 6
RELEASE LEVEL: Fabrication DWG VERSION NO: 0			REV 1.1

NCSX-SE185-302

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



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02 ASSEMBLY - BOTTOM ISOMETRIC VIEW

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

RELEASE LEVEL: Fabrication
DWG VERSION NO: 0

WEIGHT
MODEL NAME
SE185-300
WELDING
ENGINEER

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY NATIONAL COMPACT STELLARATOR EXPERIMENT	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	FIELD PERIOD ASSEMBLY FIELD PERIOD ASSEMBLY FIXTURE HALF FIELD PERIOD ASSEMBLY WITH SUPPORTS AND LASER PENS	
NEXT ASSEMBLY	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .X +/- .000 0°-12° +/- .010 .XX +/- .000 12°-72° +/- .010 .XXX +/- .005 72°-120° +/- .010 ANGULAR +/- .0°-15° OVER 120° +/- .10°	DSN: L. MORRIS CHK: M. COLE ENGR: T. BROWN SUPV: J. SIEGEL	11-26-07 11-26-07 11-26-07 11-26-07
		DRAWING NO: SE185-302	SHEET 6 OF 6 REV 1.1

NCSX-SE185-302