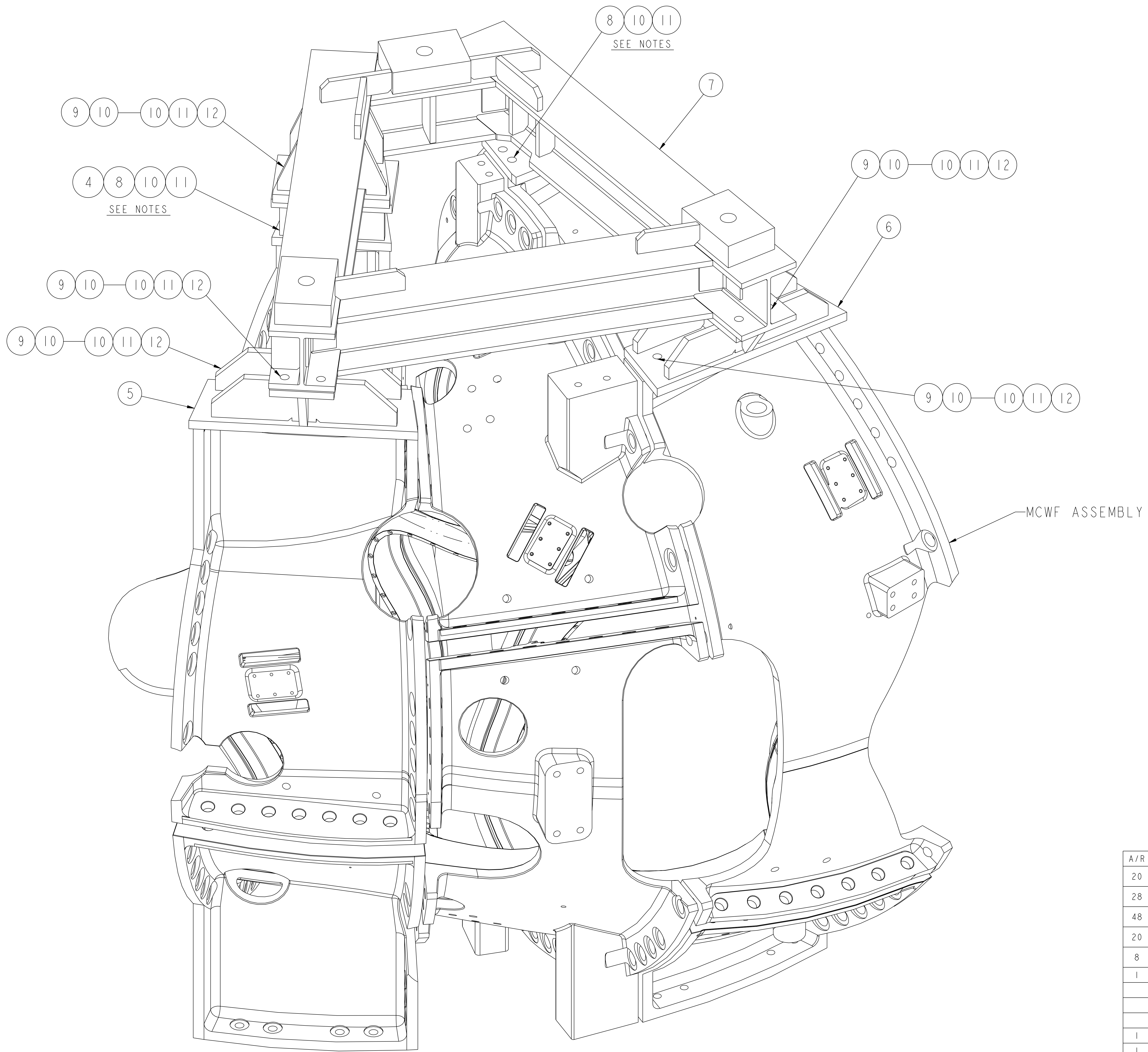


NO.	REVISION	BY	CH	SUP	APPROVED	DATE



**NOTES**

1. MOUNTING BRACKET HARDWARE IS TO BE TORQUED TO A VALUE OF 230-250 FT-LBS TO ENSURE A PRE-LOAD OF 20,000 LBS. ON THE MOUNTING BRACKETS.
2. LUBRICATE THREADS OF PART 8, HEX HEAD CAP SCREW, WITH PART 13, MOLYKOTE Z MOLY POWDER.

**NOTE**  
WORK THIS DRAWING WITH DRAWING SE185-302

**RELEASED FOR FABRICATION / INSTALLATION**  
PPPL Drafting

01 ASSEMBLY - LIFTING FIXTURE FRAME ASSEMBLY - LEFT HALF PERIOD MCWF

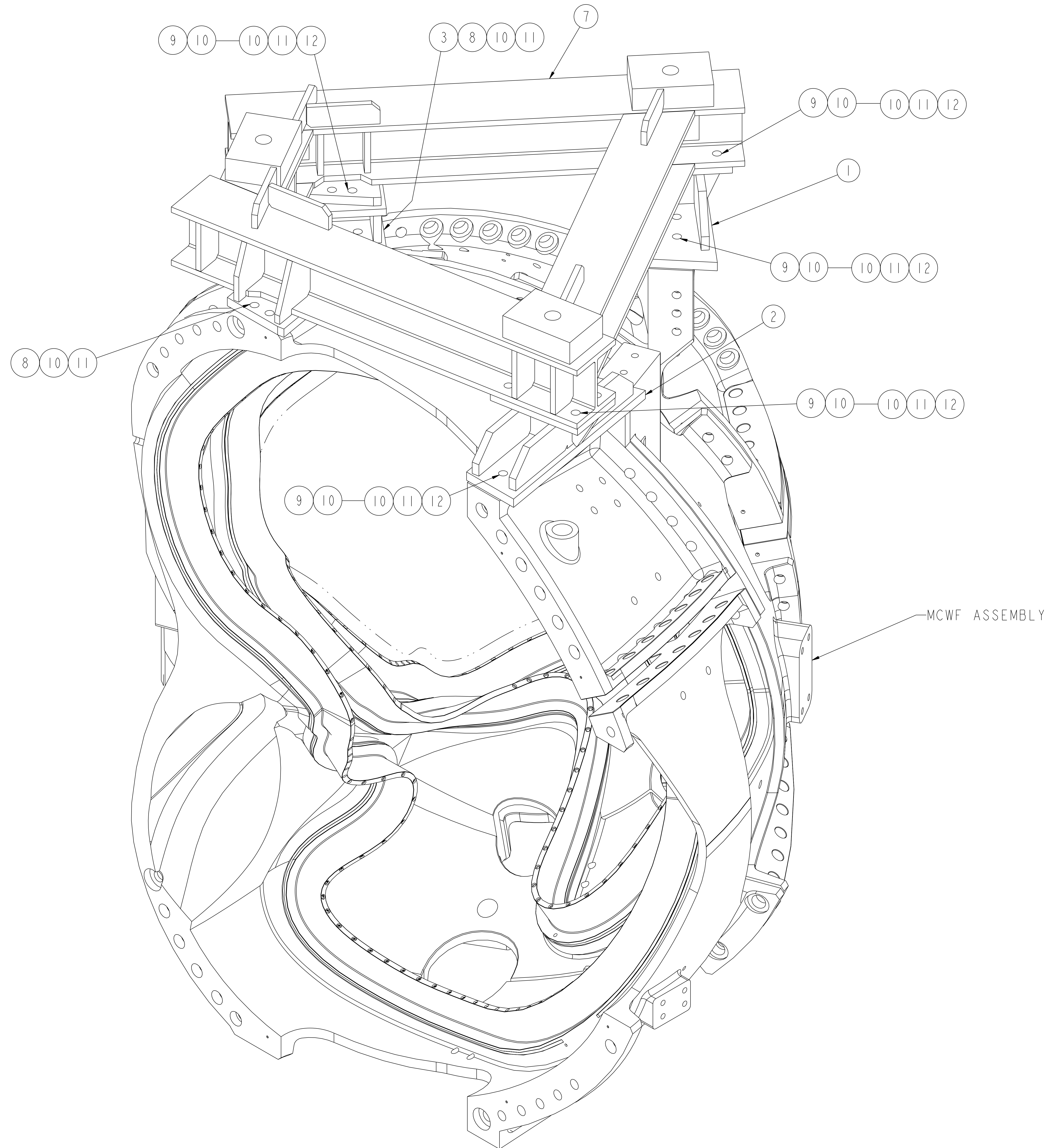
A/R	A/R	13	COMM	MOLYKOTE Z MOLY POWDER	
20	20	12	COMM	1"-8UNC-2B HEX NUT	ASTM A193 GRADE 8
28	28	11	COMM	1" SPLIT LOCK WASHER	C'STL - ZN PLT GRADE 8
48	48	10	COMM	1" FLAT WASHER	C'STL - ZN PLT GRADE 8
20	20	9	COMM	1"-8UNC-2A x 4 1/2" LG HEX HEAD CAP SCREW	SAE J429 GRADE 8
8	8	8	COMM	1"-8UNC-2A x 3 1/2" LG HEX HEAD CAP SCREW	SAE J429 GRADE 8
1	1	7	SE185-316-01	LIFTING FIXTURE FRAME WELDMENT	SEE DWG
1	1	6	SE185-315-06	MOUNTING BRACKET WELDMENT - TYPE "F"	SEE DWG
1	1	5	SE185-315-05	MOUNTING BRACKET WELDMENT - TYPE "E"	SEE DWG
1	1	4	SE185-315-04	MOUNTING BRACKET WELDMENT - TYPE "D"	SEE DWG
1	1	3	SE185-315-03	MOUNTING BRACKET WELDMENT - TYPE "C"	SEE DWG
1	1	2	SE185-315-02	MOUNTING BRACKET WELDMENT - TYPE "B"	SEE DWG
1	1	1	SE185-315-01	MOUNTING BRACKET WELDMENT - TYPE "A"	SEE DWG
				THIS DWG	LIFTING FIXTURE FRAME ASSEMBLY - RIGHT HALF PERIOD
					LIFTING FIXTURE FRAME ASSEMBLY - LEFT HALF PERIOD

02 ASSY	01 ASSY	PART NO.	DRAWING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY RECD

WEIGHT	COMPUTER GENERATED DRAWING CHANGES NOT PERMITTED	CENTRAL FILES:	PRINCETON PLASMA PHYSICS LABORATORY	
	Pro E	UNLESS OTHERWISE SPECIFIED	NATIONAL COMPACT STELLARATOR EXPERIMENT	
MODEL NAME SE185-314	DO NOT VERIFY INFORMATION BY SCALING DRAWING	DIMENSIONS ARE IN INCHES MACHINE SURFACES	FIELD PERIOD ASSEMBLY	
	NEXT ASSEMBLY	BREAK SHARP EDGES .005/.020	MCWF HALF PERIOD LIFTING FIXTURE FRAME ASSEMBLIES	
WELDING ENGINEER	TOLERANCES NON-CUMULATIVE	DECIMAL-INCH FRACTIONS	DSN: L. MORRIS	11-26-07 DRAWING NO:
		.XX +/- .000 0"-.125" +/- .010	CHK: M. COLE	11-26-07
RELEASE LEVEL: Fabrication DWG VERSION NO: 5		.XXX +/- .005 12"-.125" +/- .010	ENGR: T. BROWN	11-26-07
		ANGULAR +/- .015" OVER 120" +/- .112	SUPV: J. SIEGEL	11-26-07

NCSX-SE185-314

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



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FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

02 ASSEMBLY - LIFTING FIXTURE FRAME ASSEMBLY - RIGHT HALF PERIOD MCWF

**RELEASE LEVEL: Fabrication**  
**DWG VERSION NO: 5**

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 MCWF HALF PERIOD LIFTING FIXTURE FRAME ASSEMBLIES	
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	CHK: M. COLE	11-26-07
	DECIMAL-INCH FRACTIONS	ENGR: T. BROWN	11-26-07
	.XX +/- .000 0°-120° +/- .010	SUPV: J. SIEGEL	11-26-07
	.XXX +/- .005 120°-120° +/- .010		
	ANGULAR +/- .0°-15° OVER 120° +/- .010		
WEIGHT	MODEL NAME SE185-314	DRAWING NO:	<b>SE185-314</b>
	WELDING ENGINEER		SHEET 2 OF 2
			REV D, I

NCSX-SE185-314