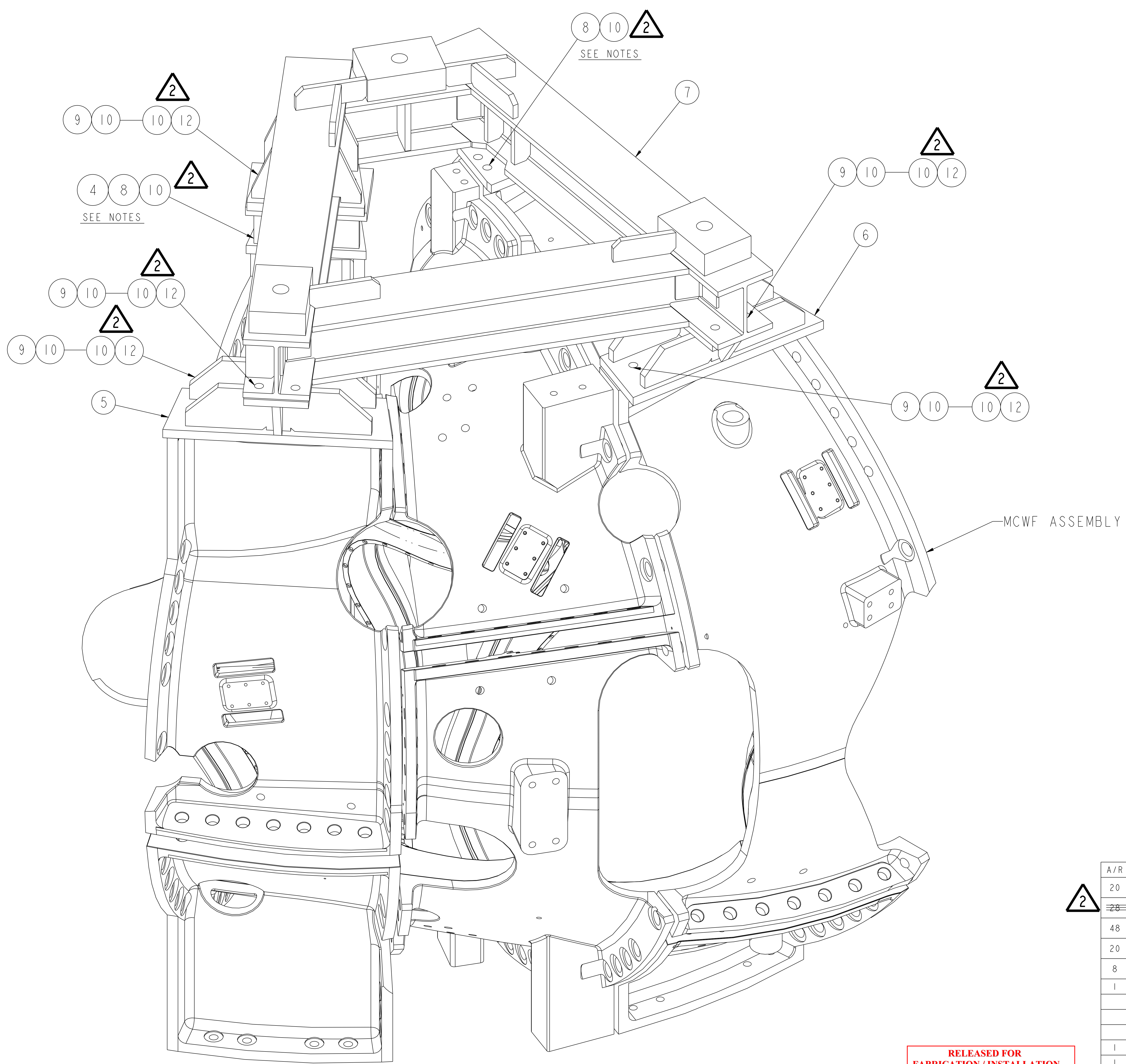


NO.	REVISION	BY	CH	SUP	APPROVED	DATE
1	REVISED PER ECN-5326	LM	TB	JS	T. BROWN	1-29-08
2	REVISED PER ECN-5371	LM	TB	JS	T. BROWN	6-18-08



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

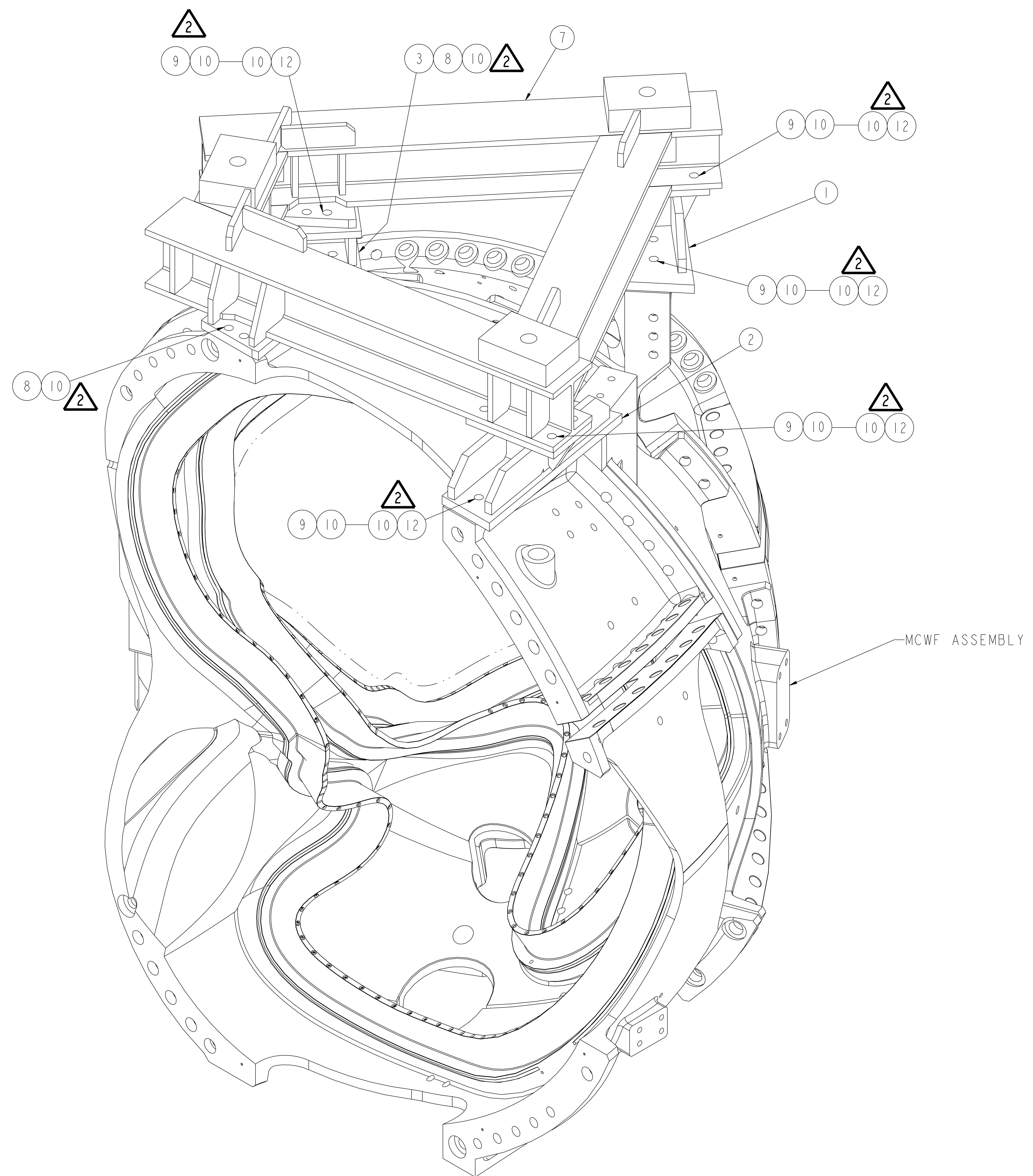
A/R	A/R	13	COMM	MOLYKOTE Z MOLY POWDER	
20	20	12	COMM	1"-8UNC-2B HEX NUT	SAE J995 GRADE 8
28	28	11	COMM	1" SPLIT LOCK WASHER (GRADE 8 COMPATIBLE)	C'SIL - ZN PLE
48	48	10	COMM	1" FLAT WASHER (GRADE 8 COMPATIBLE)	ASTM F436
20	20	9	COMM	1"-8UNC-2A x 4 1/2" LG HEX HEAD CAP SCREW	SAE J429 GRADE 8
8	8	8	COMM	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
				THIS DWG	LIFTING FIXTURE FRAME ASSEMBLY - LEFT HALF PERIOD
02	01	PART	DRAWING NO.	NOMENCLATURE OR DESCRIPTION	
ASSY	ASSY	NO.		MATERIAL	QTY RECD

2

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
	RELEASE LEVEL: Fabrication DWG VERSION NO: 5	CHK: M. COLE	11-26-07	DRAWING NO: SE185-314
	XXX +/- .005 72"-120" +/- .124	ENGR: T. BROWN	11-26-07	SHEET 1 OF 2
	ANGULAR +/- .015	SUPV: J. SIEGEL	11-26-07	REV 2.0

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 CHANGES NOT PERMITTED Pro E DO NOT VERIFY INFORMATION BY SCALING DRAWING	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	
WEIGHT	DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	DSN: L. MORRIS	11-26-07
MODEL NAME SE185-314	TOLERANCES NON-CUMULATIVE	CHK: M. COLE	11-26-07
WELDING ENGINEER	DECIMAL-INCH FRACTIONS	ENGR: T. BROWN	11-26-07
	.XX +/- .000 0°-120° +/- 15.0° .XX +/- .005 120°-120° +/- 15.0° ANGULAR +/- 0°-15° OVER 120° +/- 15.0°	SUPV: J. SIEGEL	11-26-07
	NEXT ASSEMBLY	DRAWING NO:	SE185-314
		SHEET 2 OF 2	REV 2.0

NCSX-SE185-314