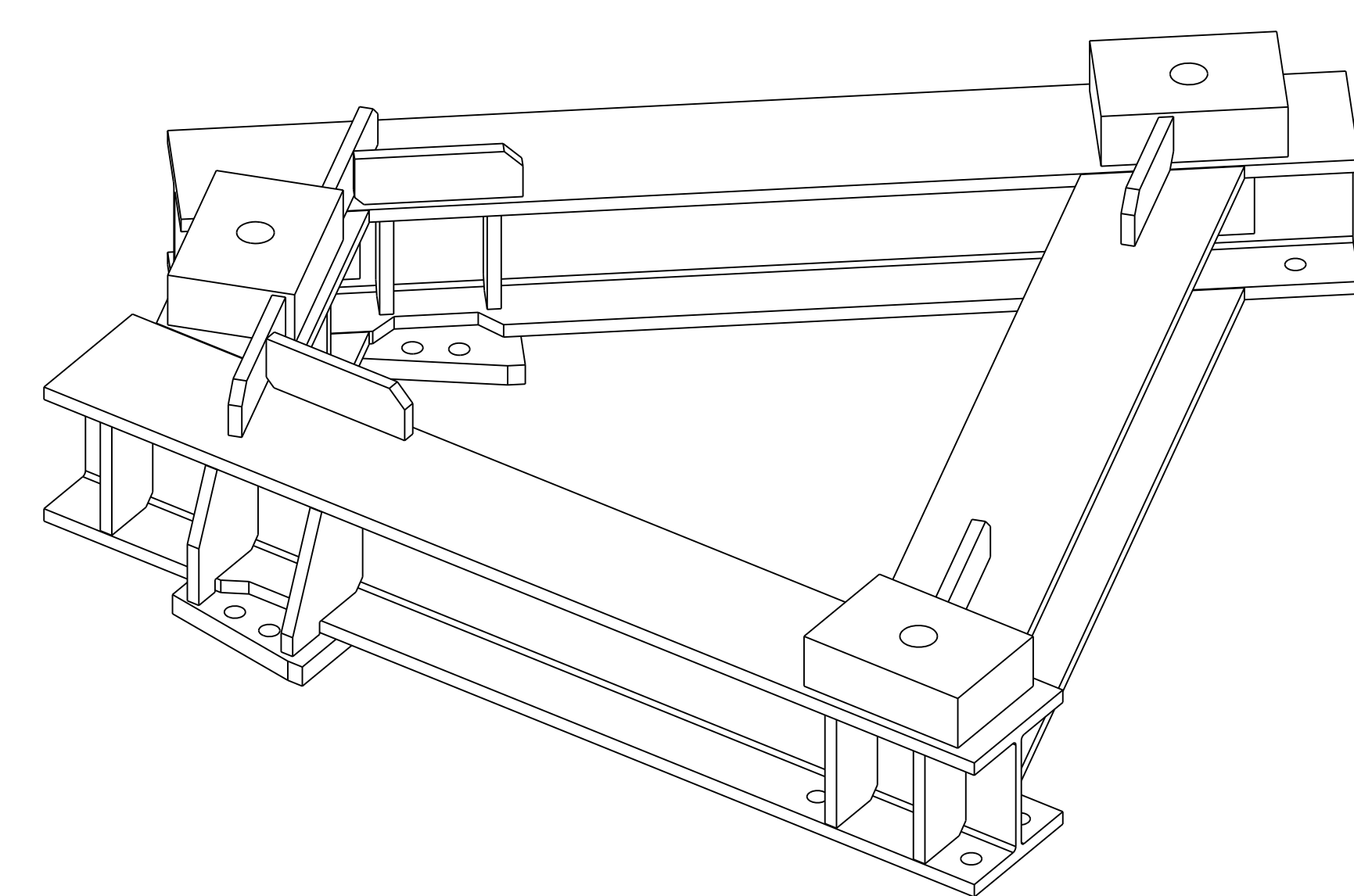
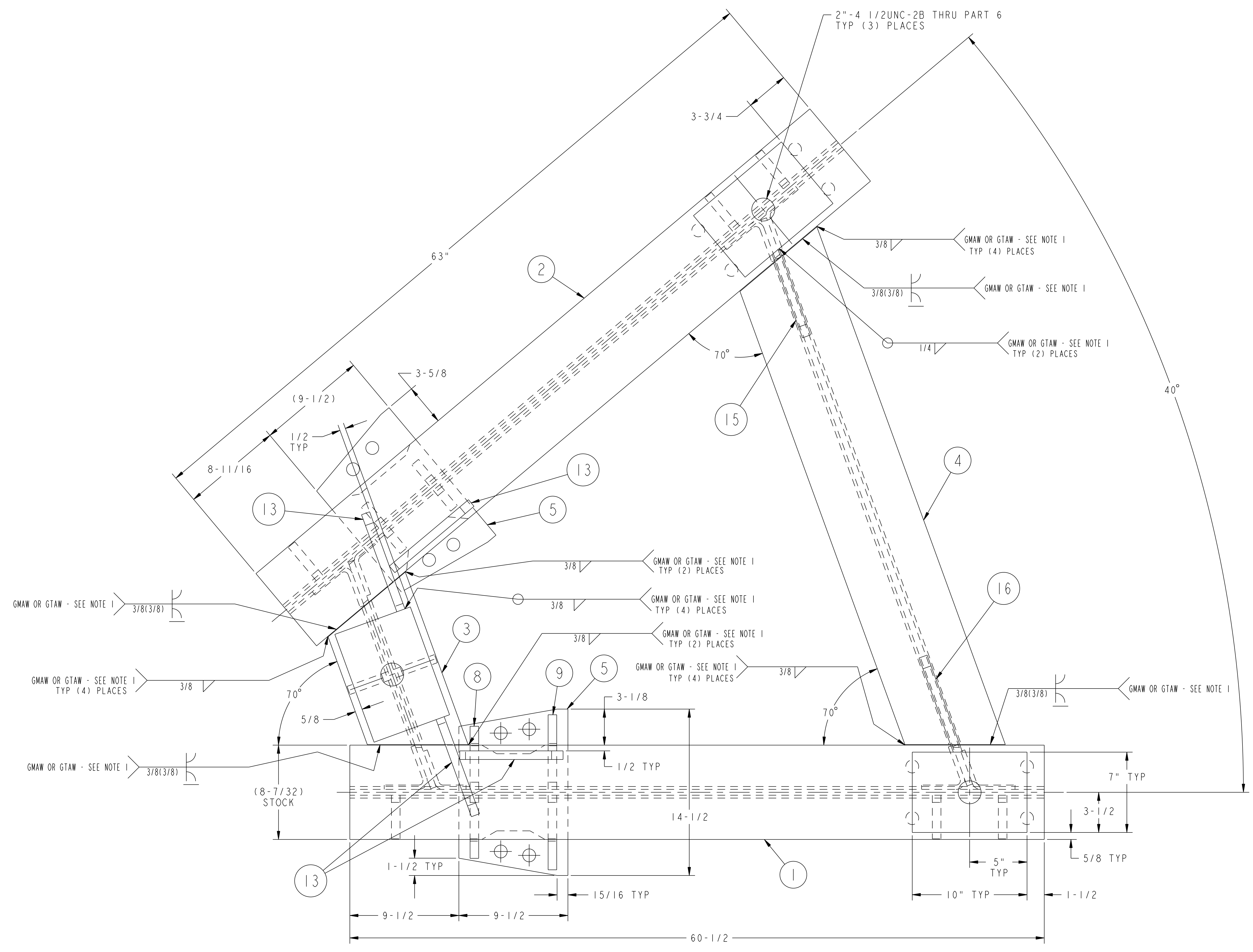


NO.	REVISION	BY	CH	SUP	APPROVED	DATE
1	REVISED PER ECN-5371	LM	TB	JS	T. BROWN	6-18-08

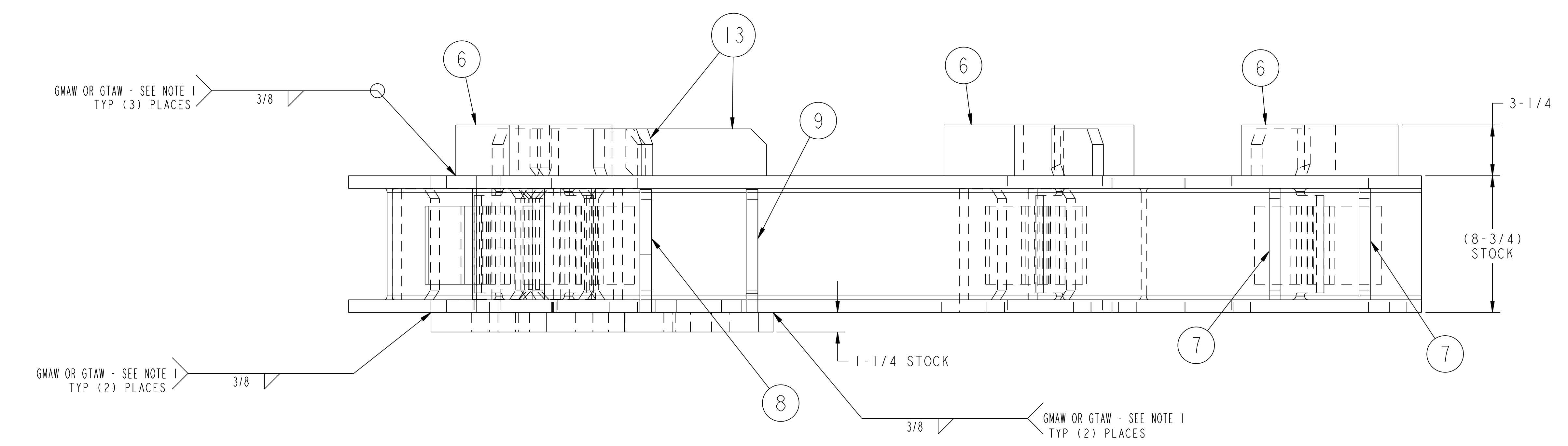


REFERENCE ISOMETRIC
SCALE 0.125

NOTES

1. WELDING SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF AWS D14.1 OR PPPL PROCEDURE ENG-037. VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH THE ACCEPTANCE CRITERIA OF AWS D1.1 Section 6.
2. LIFTING FIXTURE FRAME IS TO BE CLEARLY MARKED WITH THE FINISHED WEIGHT OF THE FIXTURE IN 1/4" HIGH LETTERS EITHER BY STAMPING OR PERMANENT INDELIBLE INK.

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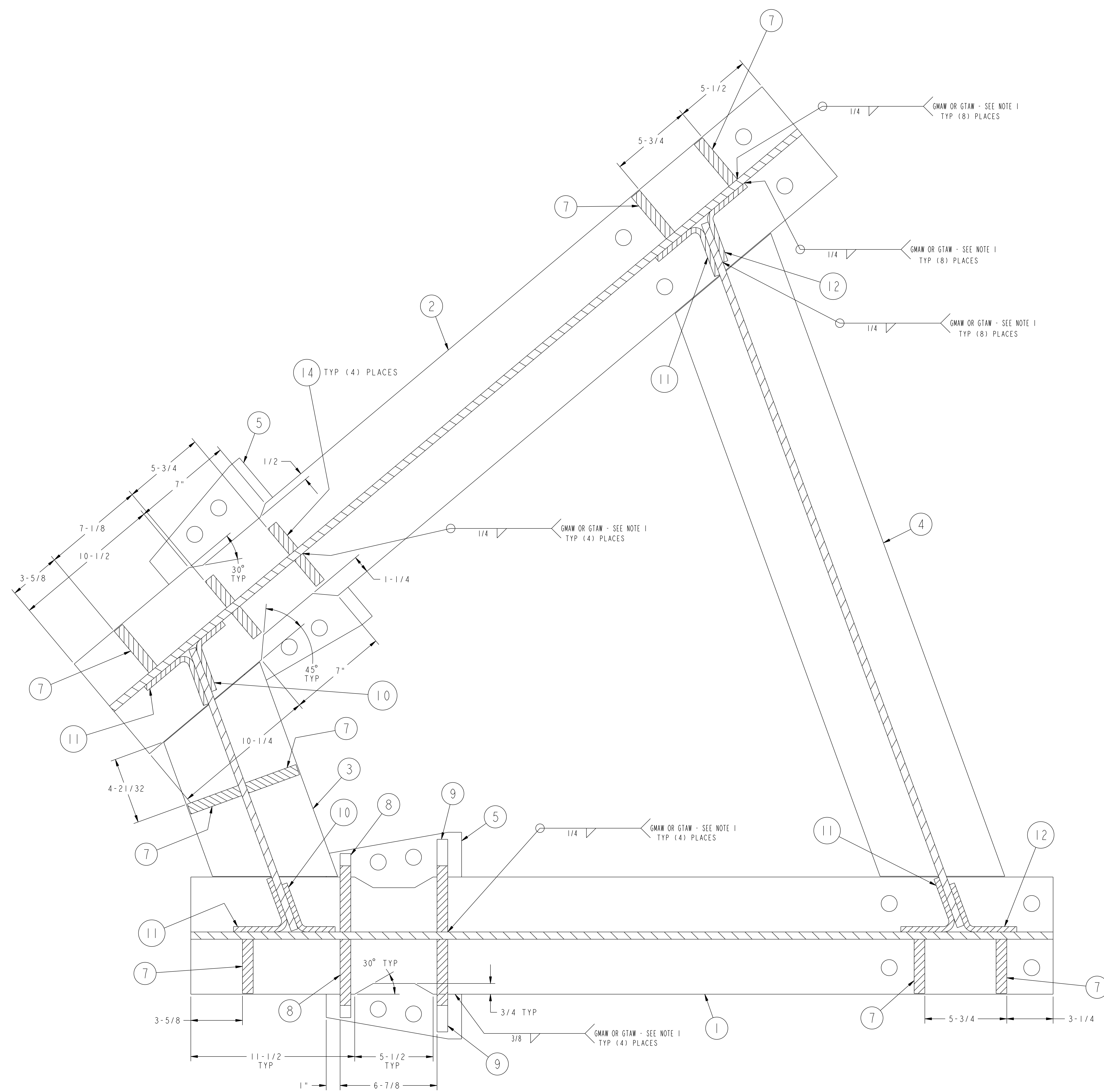
QTY	PART NO.	DRAWING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY REQD
1	16	THIS DWG	LIFTING BLOCK GUSSET - TYPE "C"	ASTM A36	
1	15	THIS DWG	LIFTING BLOCK GUSSET - TYPE "B"	ASTM A36	
4	14	THIS DWG	GUSSET - TYPE "D"	ASTM A36	
4	13	THIS DWG	LIFTING BLOCK GUSSET - TYPE "A"	ASTM A36	
2	12	THIS DWG	FORMED CLIP ANGLE - TYPE "C"	ASTM A36	
4	11	THIS DWG	FORMED CLIP ANGLE - TYPE "B"	ASTM A36	
2	10	THIS DWG	FORMED CLIP ANGLE - TYPE "A"	ASTM A36	
2	9	THIS DWG	GUSSET - TYPE "C"	ASTM A36	
2	8	THIS DWG	GUSSET - TYPE "B"	ASTM A36	
8	7	THIS DWG	GUSSET - TYPE "A"	ASTM A36	
3	6	THIS DWG	LIFTING EYE MOUNTING PLATE - 30000# CAP.	ASTM A36	
1	5	THIS DWG	LIFT MOUNT PLATE	ASTM A36	
1	4	THIS DWG	CONNECTING SUPPORT BEAM - LONG W8 x 58# WIDE FLANGE BEAM	ASTM A36	
1	3	THIS DWG	CONNECTING SUPPORT BEAM - SHORT W8 x 58# WIDE FLANGE BEAM	ASTM A36	
1	2	THIS DWG	LIFTING FRAME SUPPORT BEAM - TYPE "B" W8 x 58# WIDE FLANGE BEAM	ASTM A36	
1	1	THIS DWG	LIFTING FRAME SUPPORT BEAM - TYPE "A" W8 x 58# WIDE FLANGE BEAM	ASTM A36	
1		THIS DWG	LIFTING FIXTURE FRAME WELDMENT		1

PARTS LIST

COMPUTER GENERATED DRAWING CHANGES NOT PERMITTED	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY	
Pro E	DIMENSIONS ARE IN INCHES MACHINE SURFACES UNLESS OTHERWISE SPECIFIED	NATIONAL COMPACT STELLARATOR EXPERIMENT	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	BREAK SHARP EDGES .005/.020	FIELD PERIOD ASSEMBLY FIELD PERIOD ASSEMBLY FIXTURE MCWF HALF PERIOD LIFTING FIXTURE FRAME WELDMENT	
WEIGHT 228.9 lbs	TOLERANCES NON-CUMULATIVE	DSN: L. MORRIS	11-19-07 DRAWING NO:
MODEL NAME SE185-316-2	DECIMAL-INCH FRACTIONS	CHK: M. COLE	11-19-07
WELDING ENGINEER L. DUDEK 11-14-07	XXX +/- .005 OVER 120° +/- .124	ENGR: T. BROWN	11-19-07
	ANGULAR +/- .015 OVER 120° +/- .124	SUPV: J. SIEGEL	11-19-07

RELEASE LEVEL: Fabrication
DWG VERSION NO: 6

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



SECTION A-A

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FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

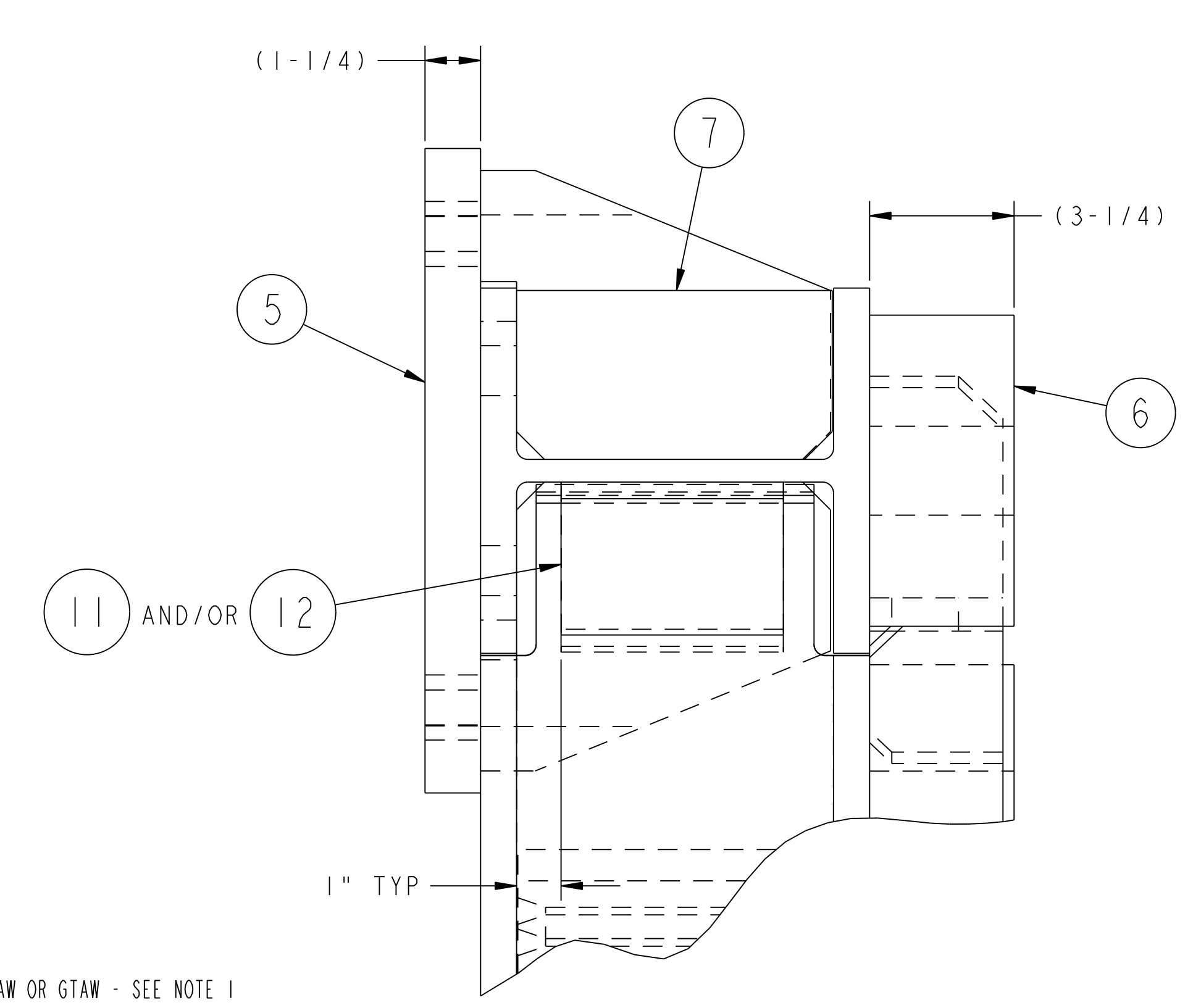
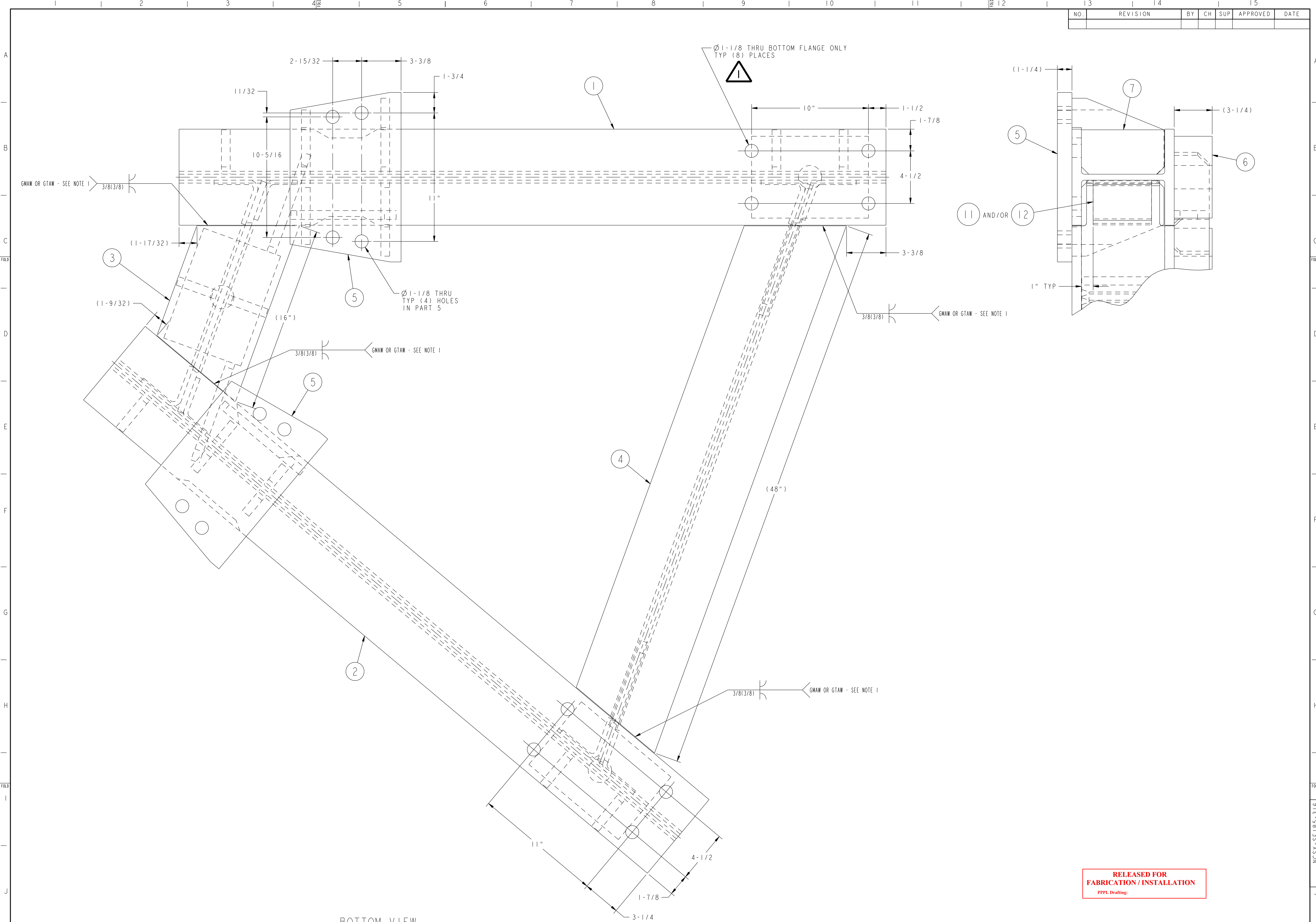
RELEASE LEVEL: FABRICATION
DWG VERSION NO: 24

WEIGHT	2072.5 lbs
MODEL NAME	LM_SE185-314_JUNK
WELDING ENGINEER	

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	PRINCETON PLASMA PHYSICS LABORATORY NATIONAL COMPACT STELLARATOR EXPERIMENT FIELD PERIOD ASSEMBLY FIXTURE MCWF HALF PERIOD LIFTING FIXTURE FRAME WELDMENT
DO NOT VERIFY INFORMATION BY SCALING DRAWING	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX ±.000 .XXX ±.005 ANGULAR ±.0°-15'	DSN: L. MORRIS 11-19-07 CHK: M. COLE 11-19-07 ENGR: T. BROWN 11-19-07 SUPV: J. SIEGEL 11-19-07
NEXT ASSEMBLY		DRAWING NO: SE185-316 SHEET 2 OF 5 REV 1.04

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NO.	REVISION	BY	CH	SUP	APPROVED	DATE



BOTTOM VIEW

RELEASED FOR
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FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

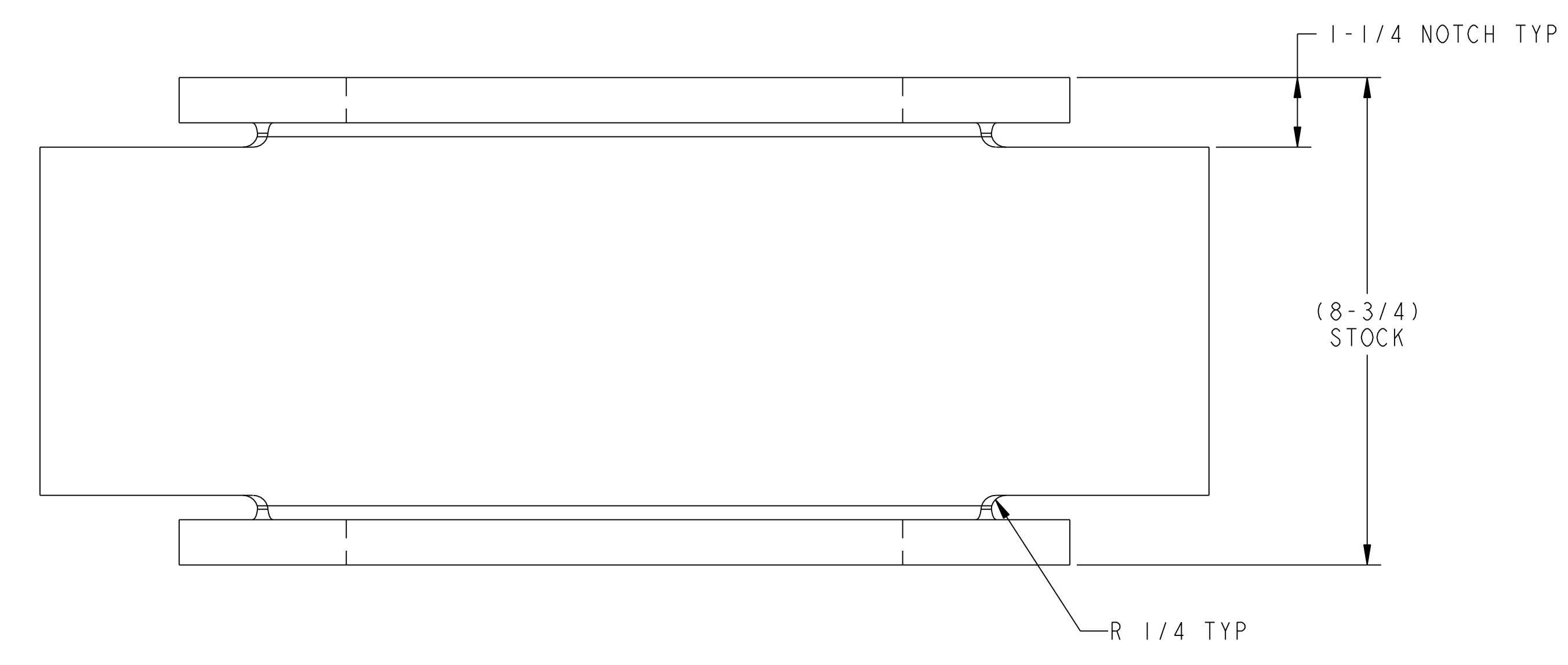
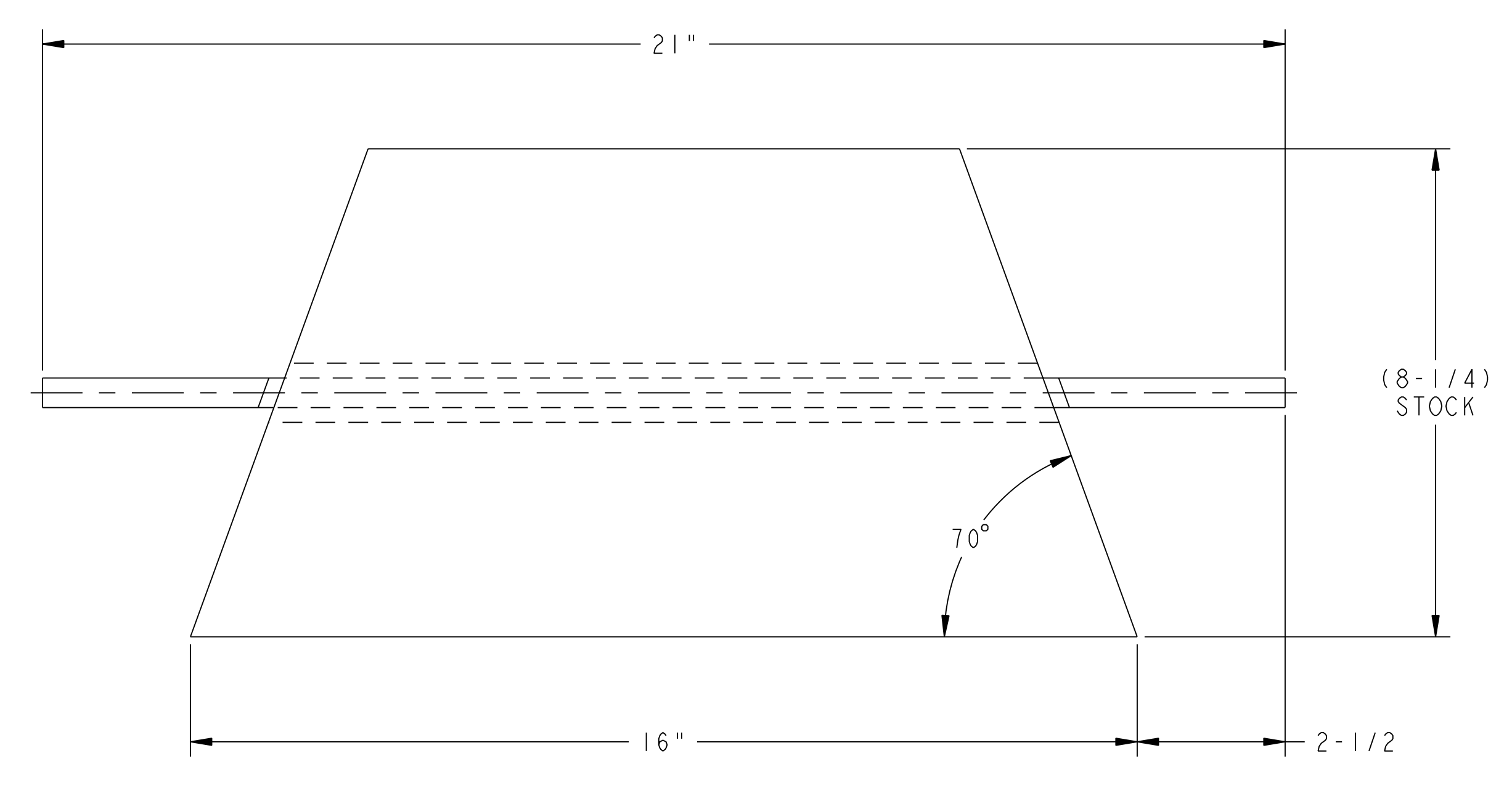
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	UNLESS OTHERWISE SPECIFIED	NATIONAL COMPACT STELLARATOR EXPERIMENT	
	DIMENSIONS ARE IN INCHES	FIELD PERIOD ASSEMBLY	
	MACHINE SURFACES	FIELD PERIOD ASSEMBLY FIXTURE	
	BREAK SHARP EDGES .005/.020	MCWF HALF PERIOD LIFTING FIXTURE FRAME WELDMENT	
	TOLERANCES NON-CUMULATIVE	DSN: L. MORRIS	11-19-07
	DECIMAL-INCH FRACTIONS	CHK: M. COLE	11-19-07
	.XX ±.000	ENGR: T. BROWN	11-19-07
	.XXX ±.005	SUPV: J. SIEGEL	11-19-07
	ANGULAR ±.0°-15°		

RELEASE LEVEL: Fabrication
 DWG VERSION NO: 6

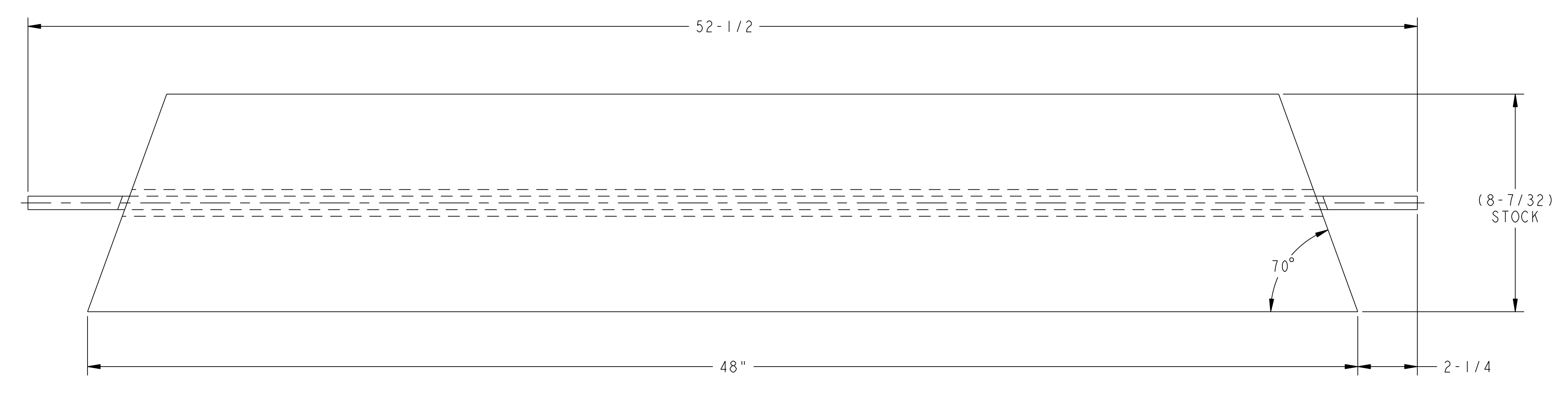
DRAWING NO: SE185-316
 SHEET 3 OF 5
 REV 1.04

NCSX-SE185-316

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



3 CONNECTING SUPPORT BEAM - SHORT



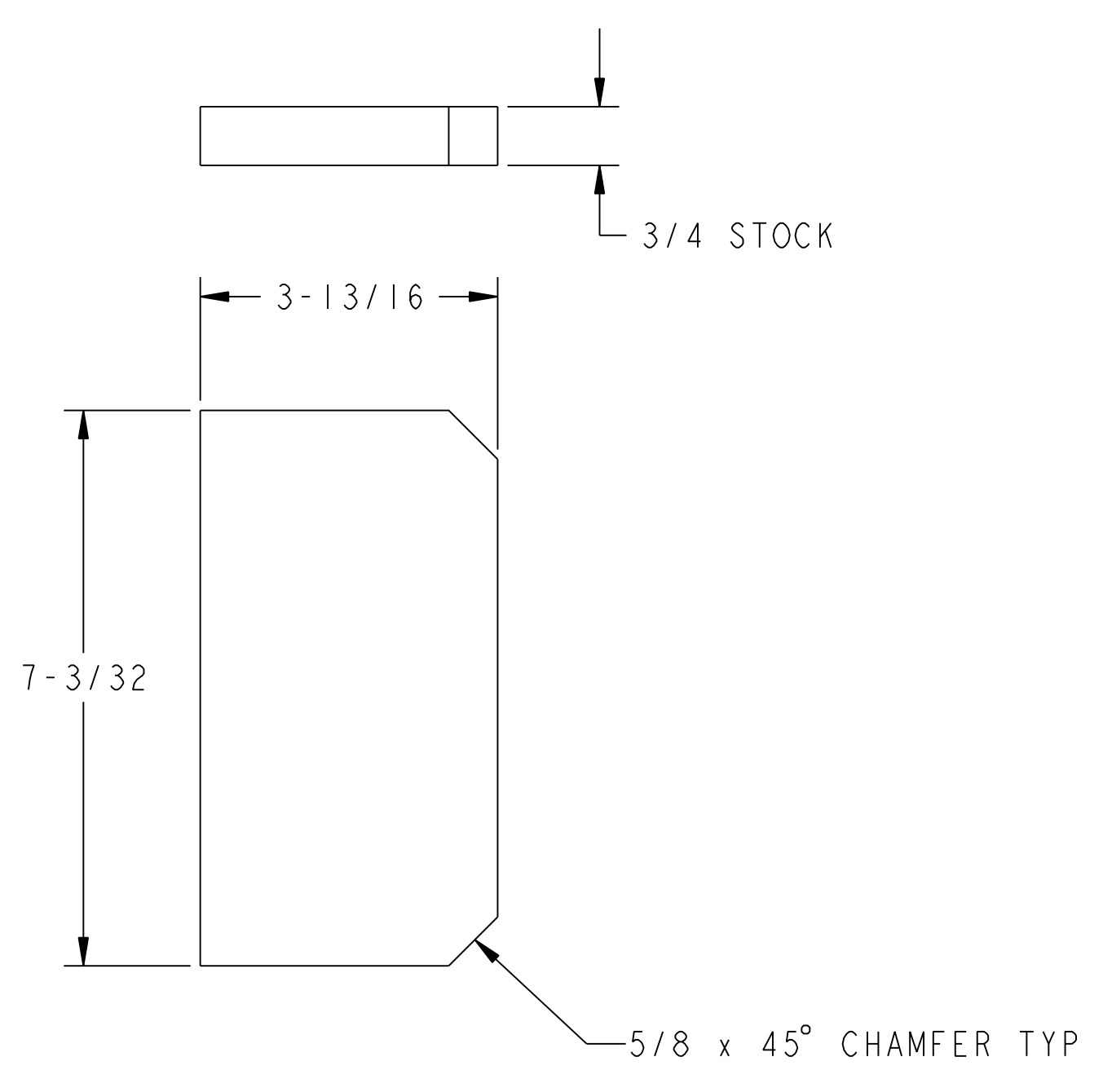
4 CONNECTING SUPPORT BEAM - LONG

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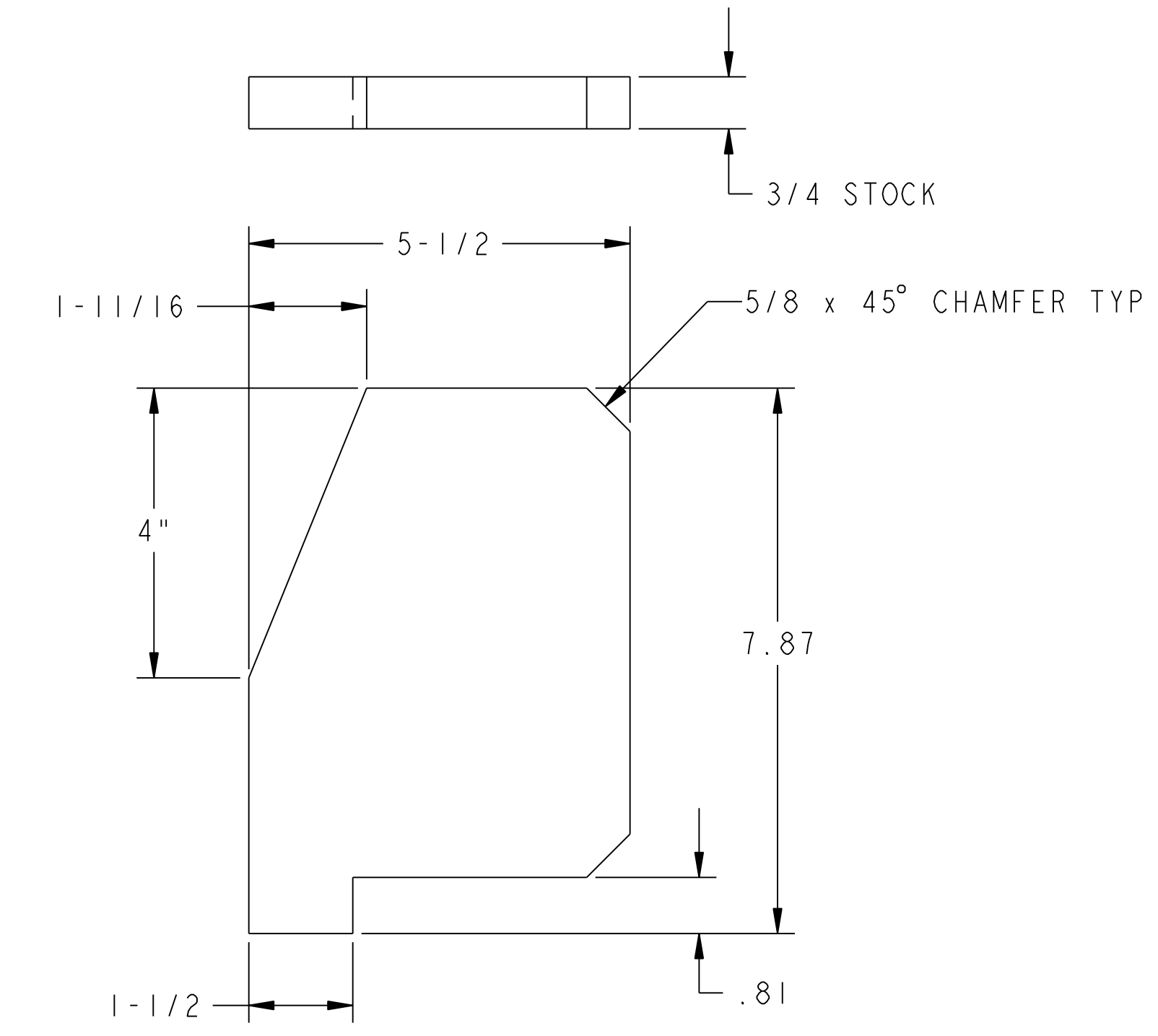
FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

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 MCWF HALF PERIOD LIFTING FIXTURE FRAME WELDMENT	
NEXT ASSEMBLY	BREAK SHARP EDGES .005/.020	DSN: L. MORRIS	11-19-07
	TOLERANCES NON-CUMULATIVE	CHK: M. COLE	11-19-07
WEIGHT 228.9 lbs	DECIMAL-INCH FRACTIONS	ENGR: T. BROWN	11-19-07
	.XX +/- .000 0°-12° +/- .010	SUPV: J. SIEGEL	11-19-07
MODEL NAME SE 185-316-2	.XXX +/- .005 12°-120° +/- .010 ANGULAR +/- .0°-15° OVER 120° +/- .12	DRAWING NO: SE185-316	
RELEASE LEVEL: Fabrication DWG VERSION NO: 6	WELDING ENGINEER	SHEET 4 OF 5 REV 1.04	

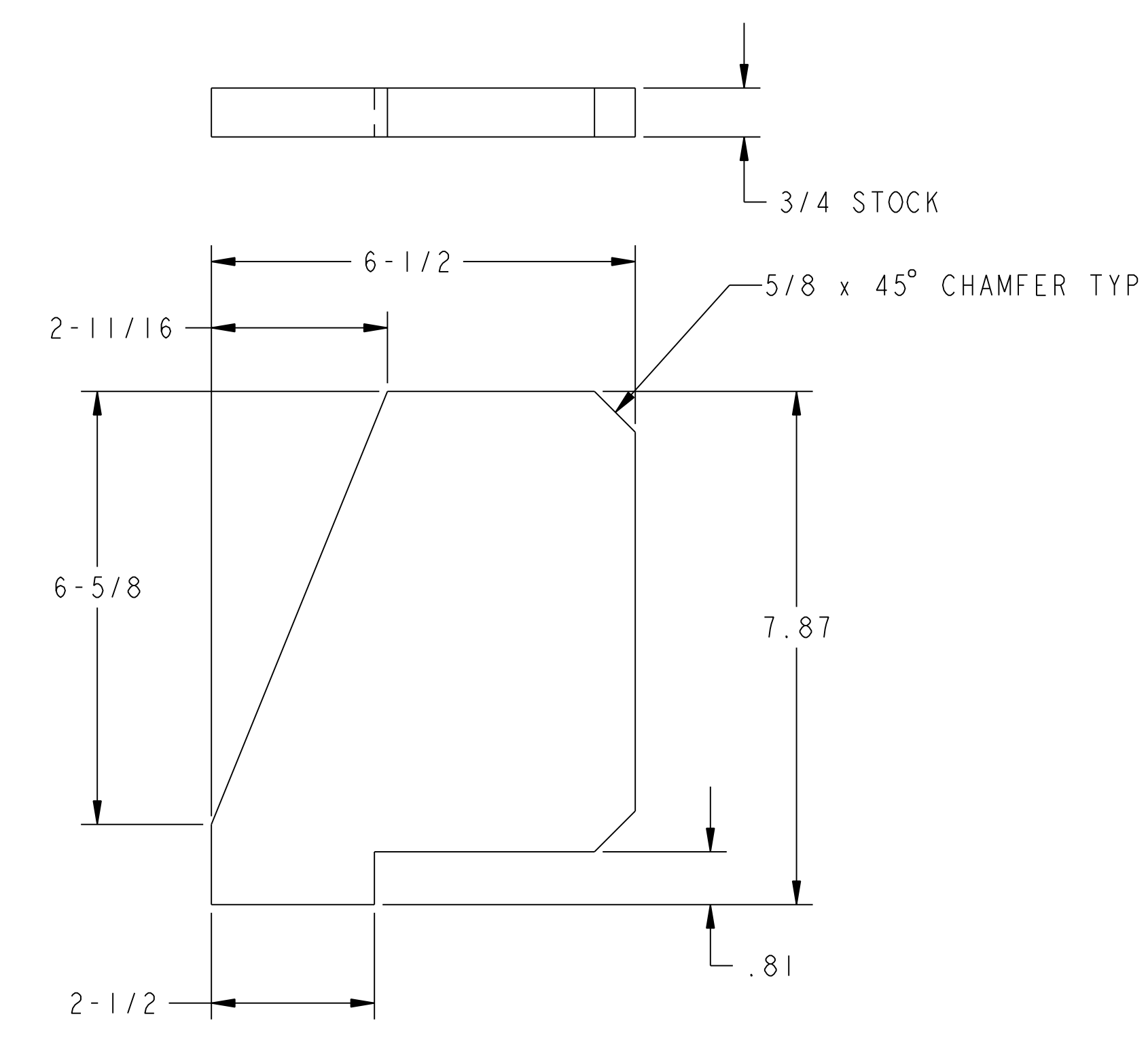
NO.	REVISION	BY	CH	SUP	APPROVED	DATE



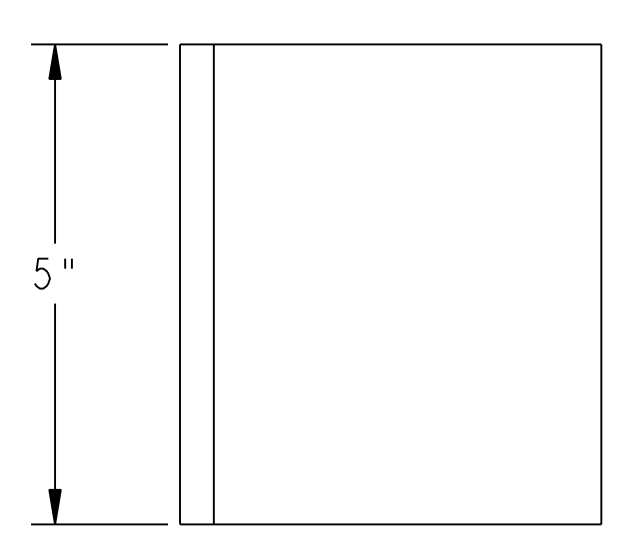
7 GUSSET - TYPE "A"



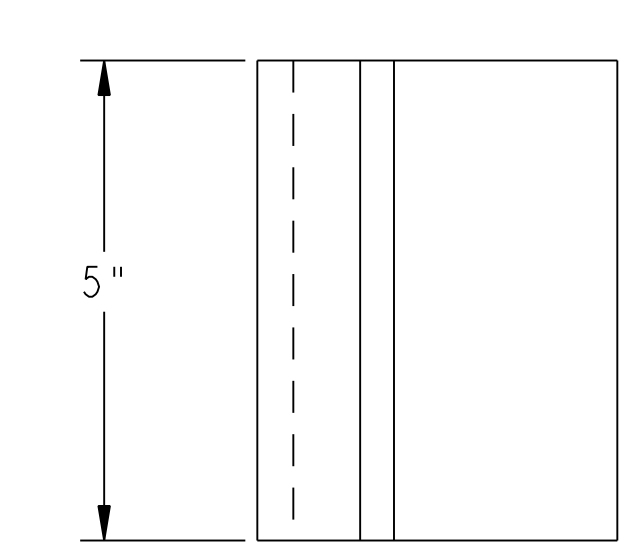
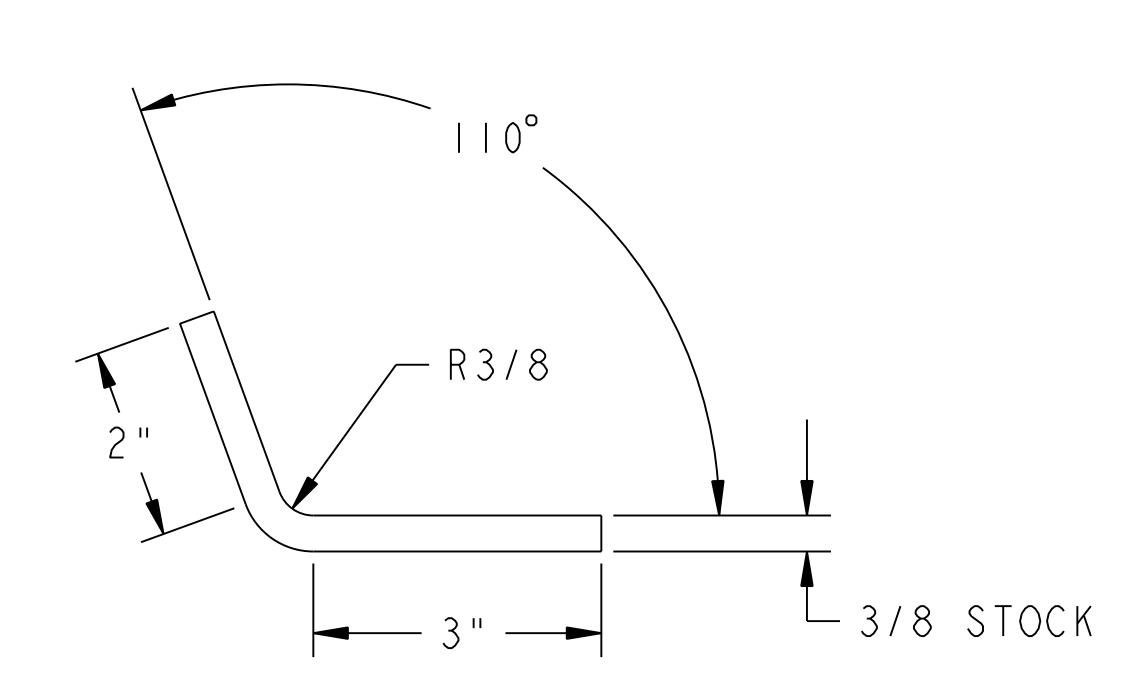
8 GUSSET - TYPE "B"



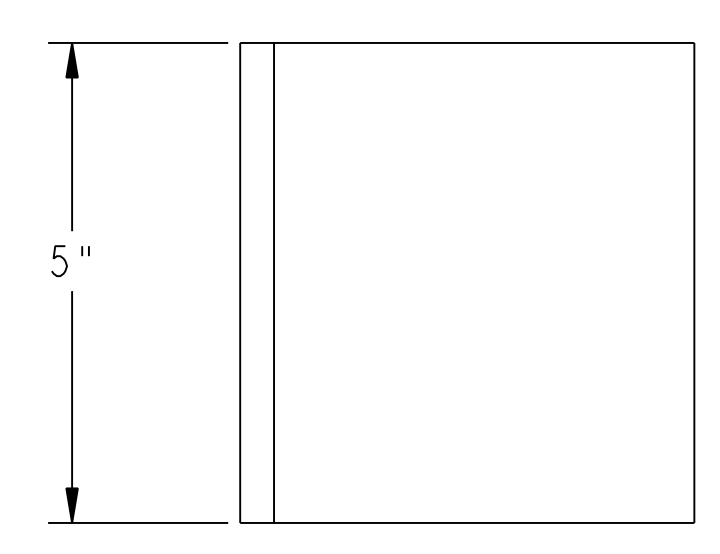
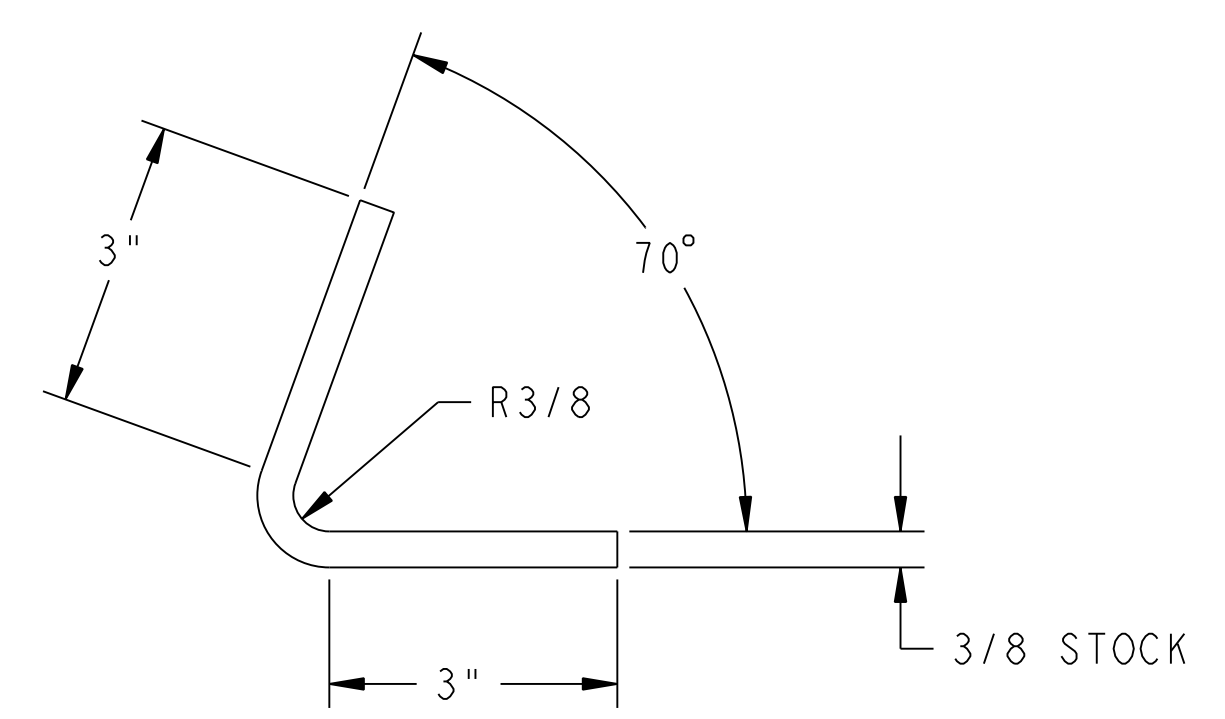
9 GUSSET - TYPE "C"



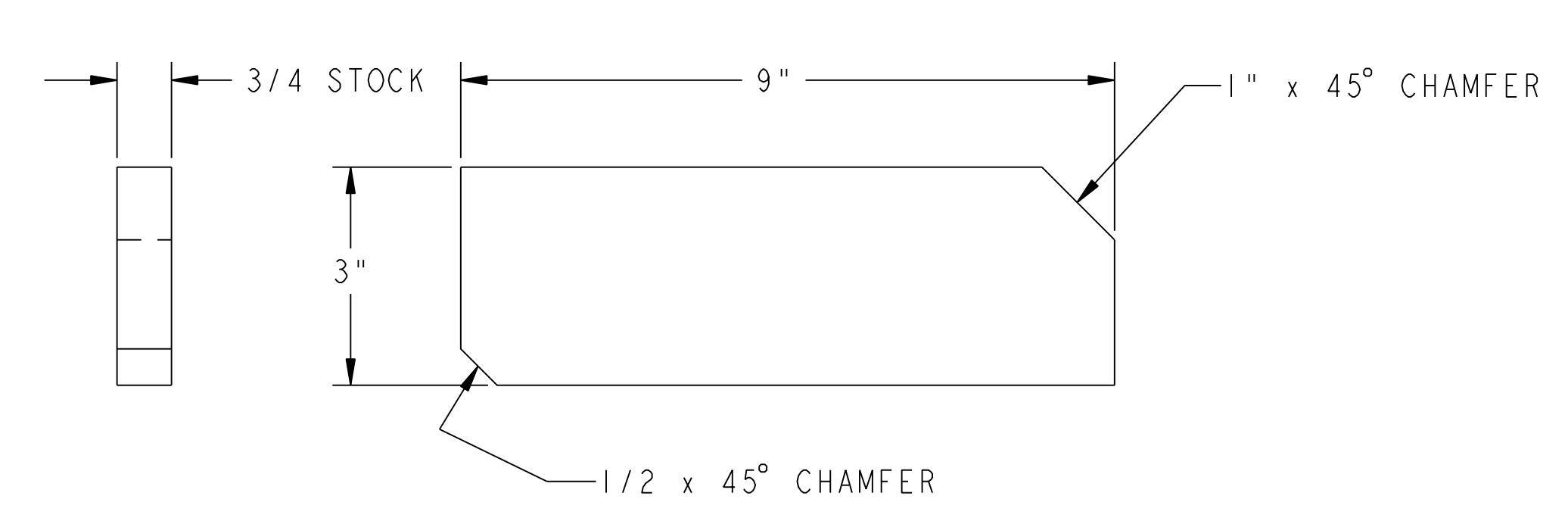
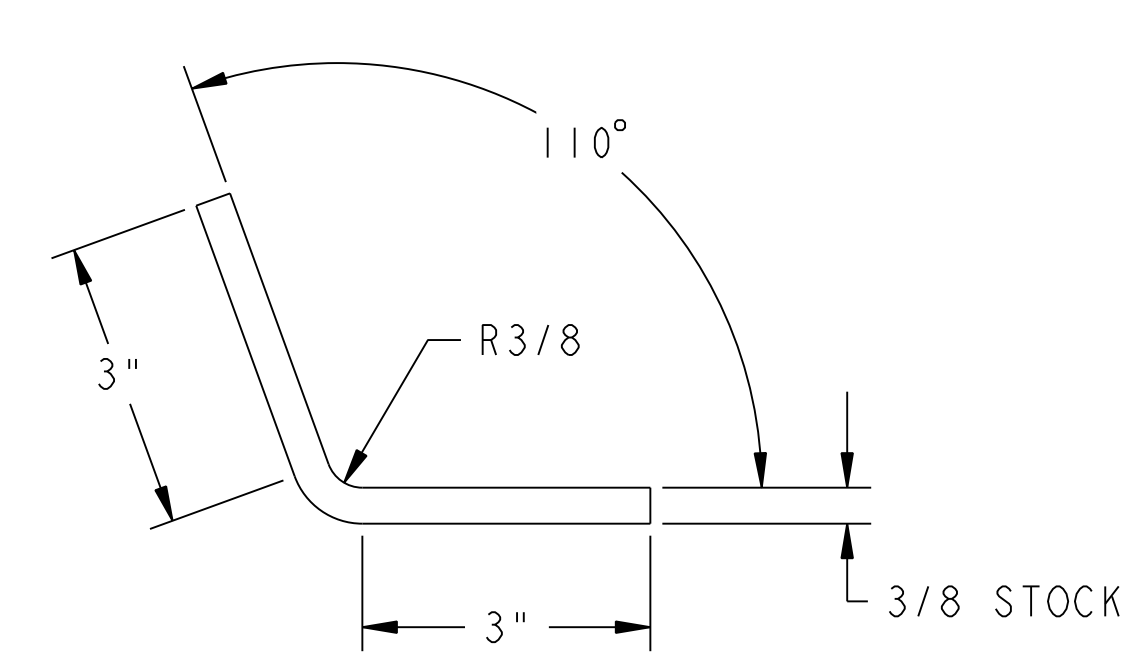
10 FORMED CLIP ANGLE - TYPE "A"



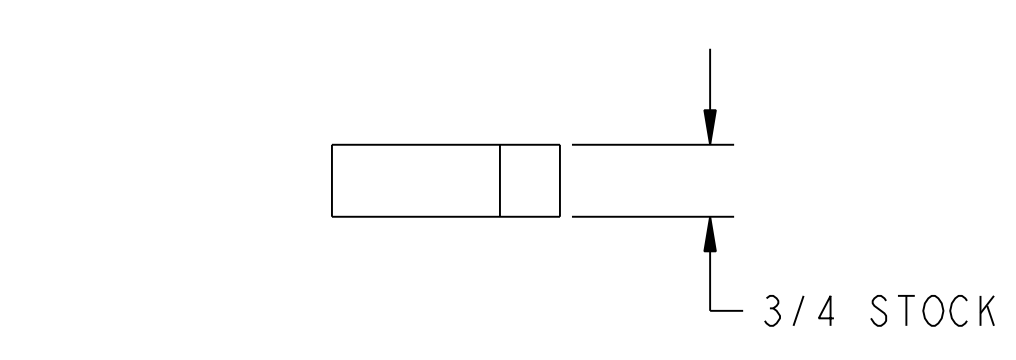
11 FORMED CLIP ANGLE - TYPE "B"



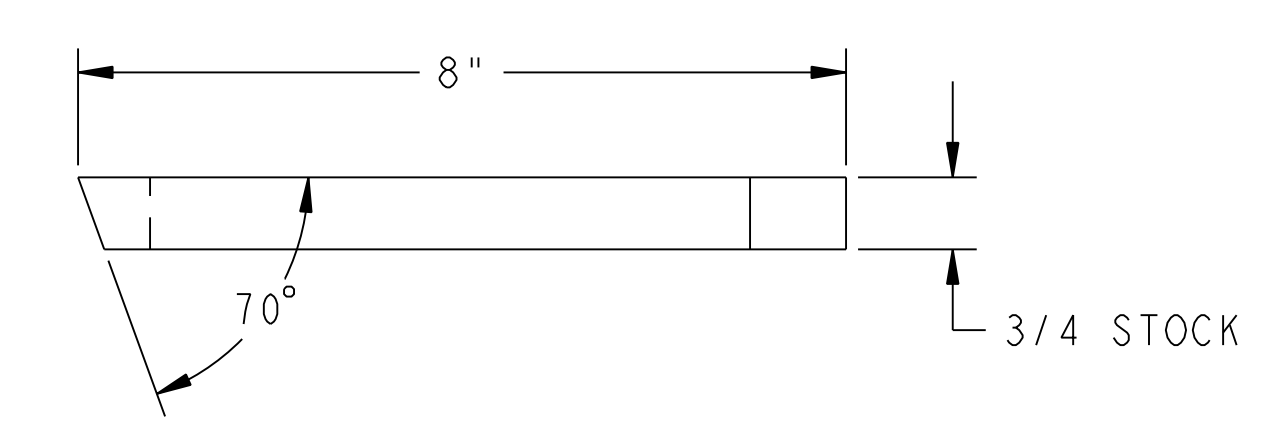
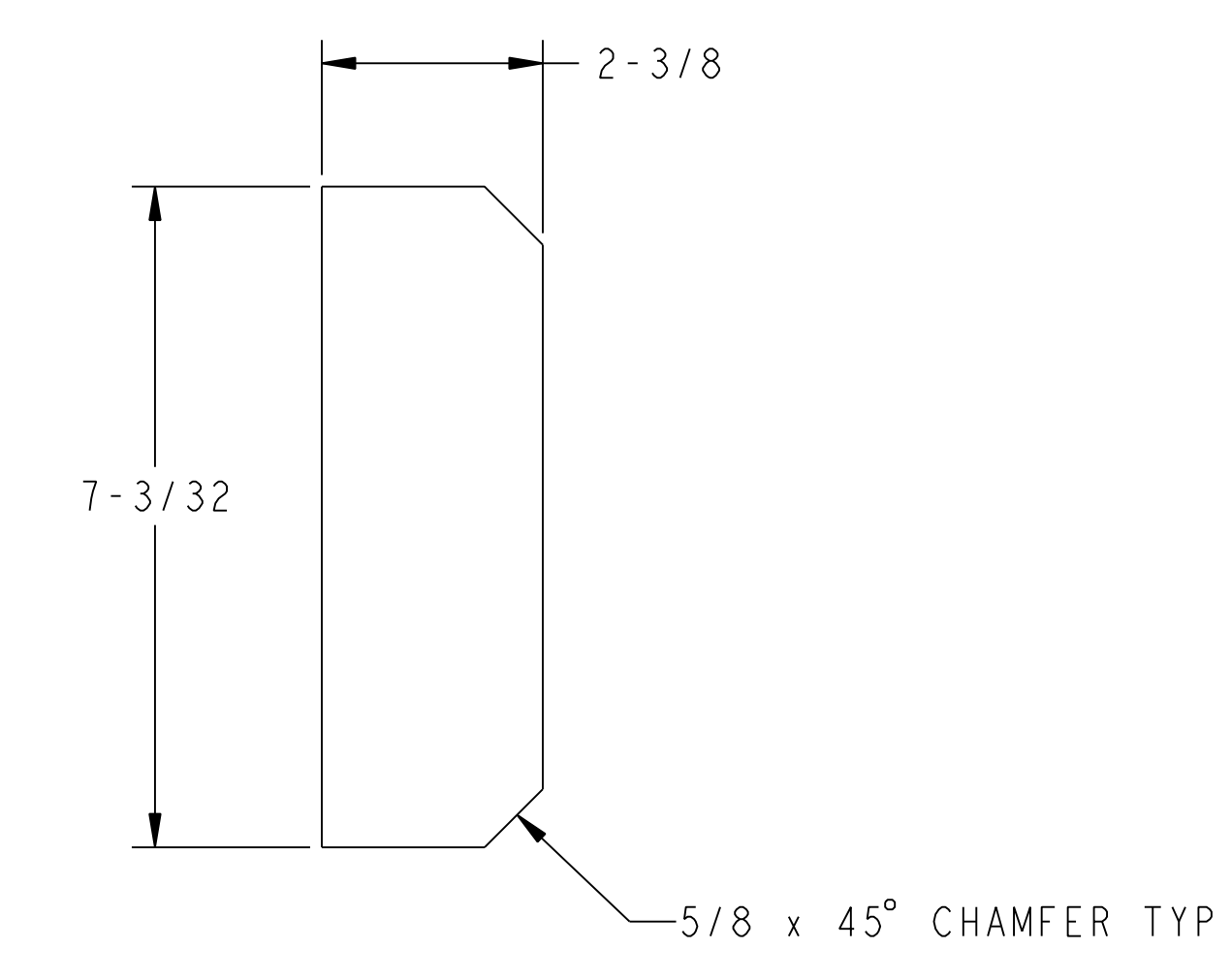
12 FORMED CLIP ANGLE - TYPE "C"



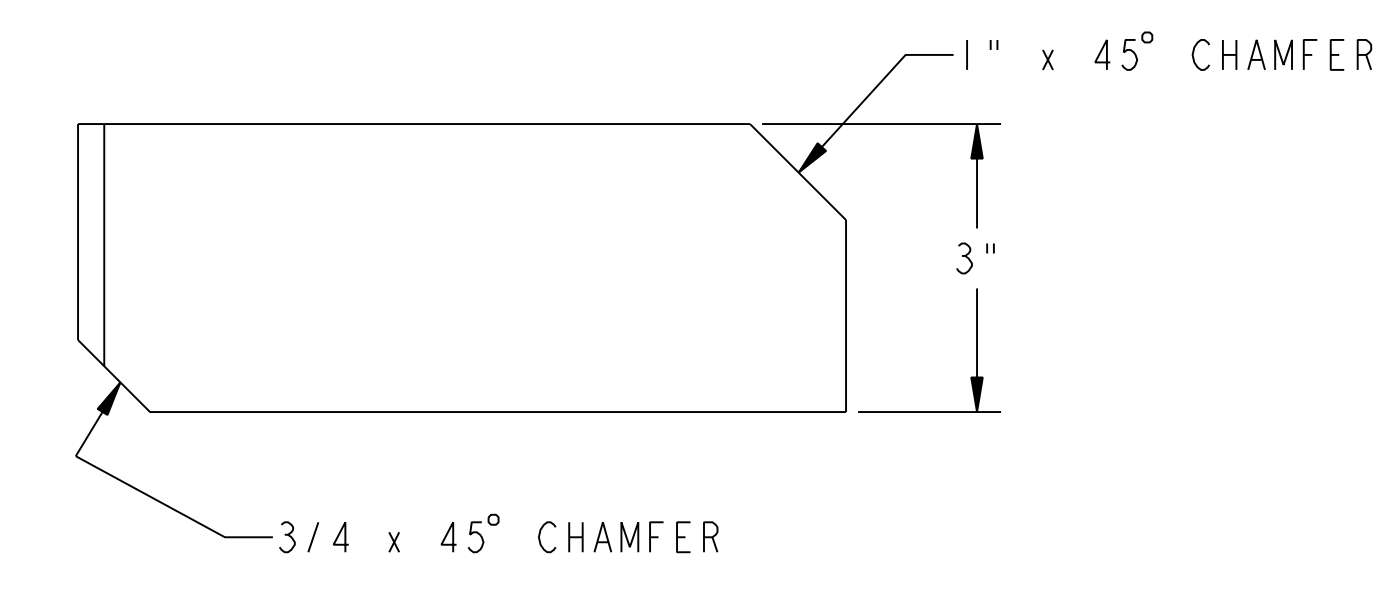
13 LIFTING BLOCK GUSSET - TYPE "A"



14 GUSSET - TYPE "D"



15 LIFTING BLOCK GUSSET - TYPE "B" - AS SHOWN



16 LIFTING BLOCK GUSSET - TYPE "C" - OPPOSITE

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FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

WEIGHT	2072.5 lbs
MODEL NAME	LM_SE185-314_JUNK
WELDING ENGINEER	

RELEASE LEVEL: FABRICATION
DWG VERSION NO: 24

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	PRINCETON PLASMA PHYSICS LABORATORY NATIONAL COMPACT STELLARATOR EXPERIMENT FIELD PERIOD ASSEMBLY FIXTURE MCWF HALF PERIOD LIFTING FIXTURE FRAME WELDMENT	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX +/- .000 0°-12° +/- .010 .XXX +/- .005 12°-120° +/- .010 ANGULAR +/- 0°-15° OVER 120° +/- .125	DSN: L. MORRIS CHK: M. COLE ENGR: T. BROWN SUPV: J. SIEGEL	11-19-07 11-19-07 11-19-07 11-19-07
NEXT ASSEMBLY		DRAWING NO: SE185-316	SHEET 5 OF 5 REV 04

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