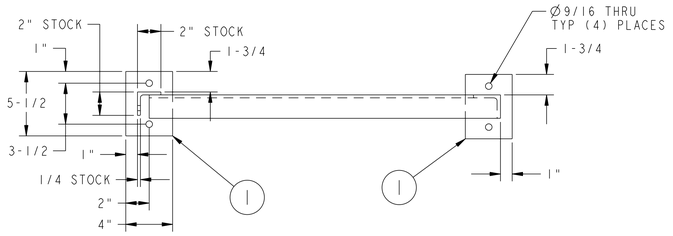
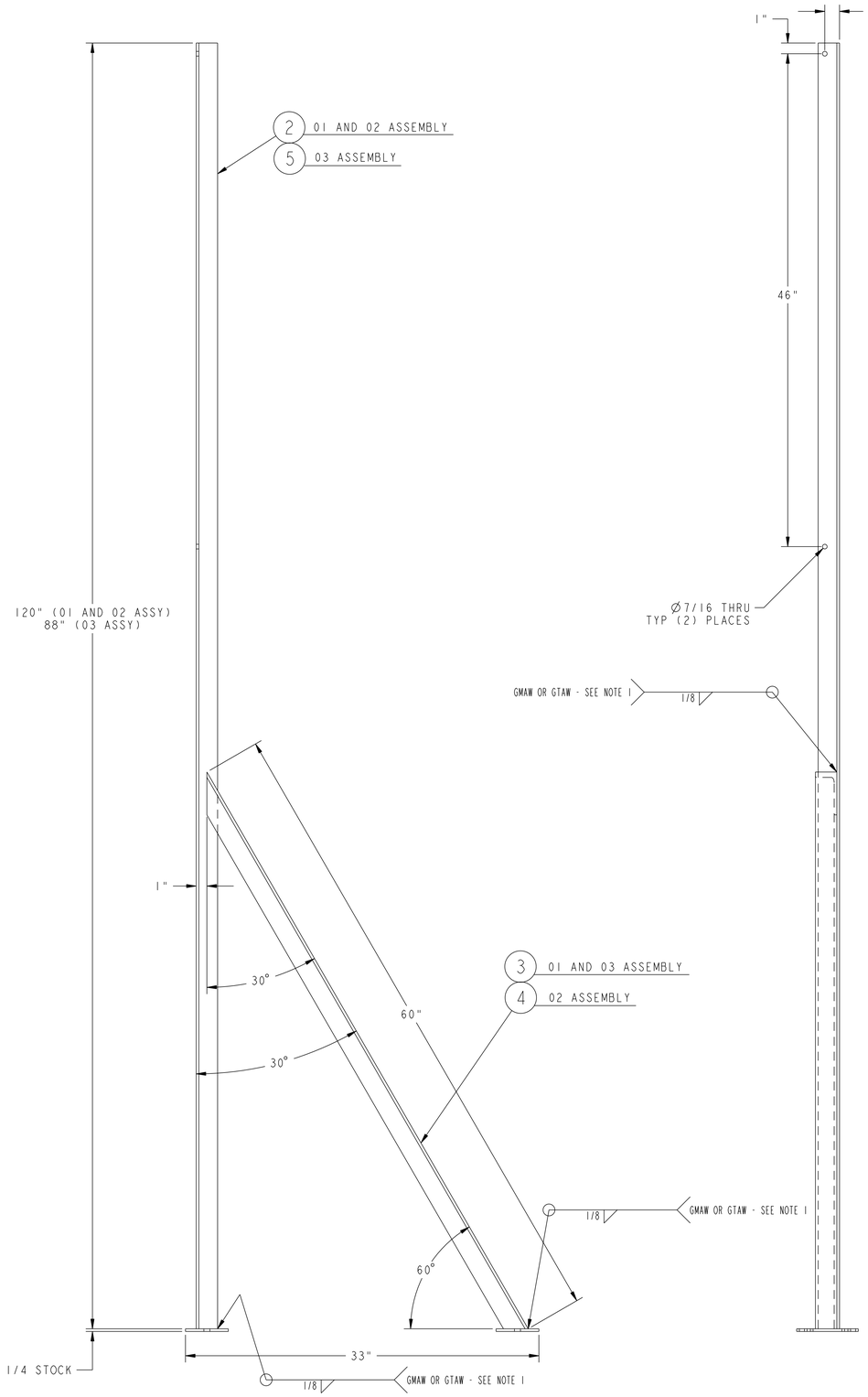
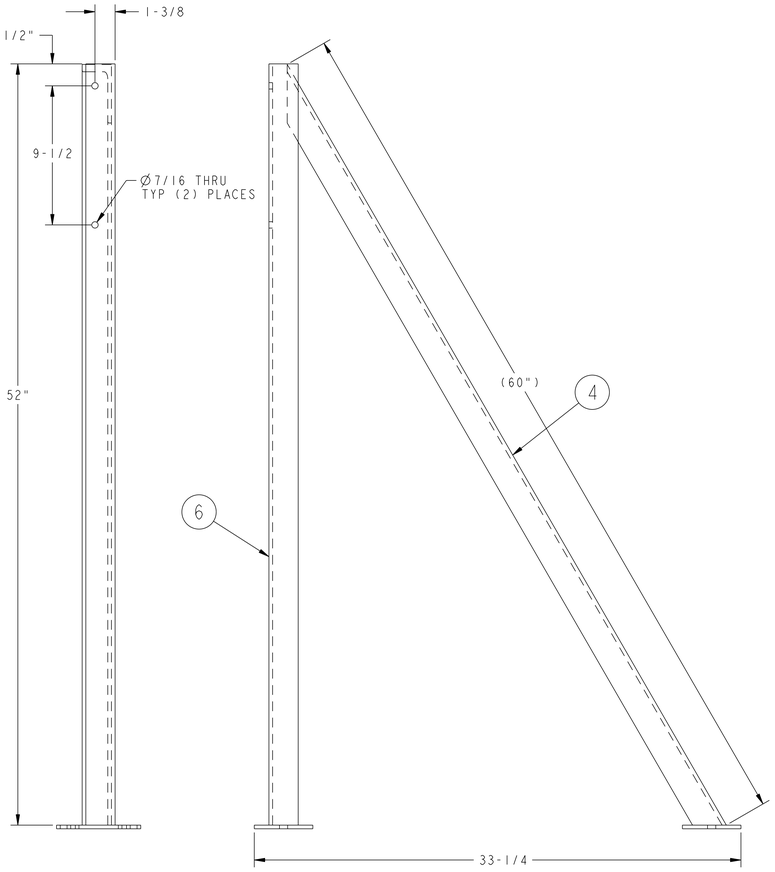
NO.	REVISION	BY	CH	SUP	APPROVED	DATE





01 AND 03 ASSEMBLY - AS SHOWN

02 ASSEMBLY - OPPOSITE



04 ASSEMBLY

FOR ALL DIMENSIONS NOT SHOWN AND WELD INFORMATION REFER TO 02 ASSEMBLY

NOTE ORIENTATION OF PARTS

NOTES

1. WELDING SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF PPPL PROCEDURE ENG-037. VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH THE ACCEPTANCE CRITERIA OF AWS D1.1 Section 6.
2. ALL MACHINING TO BE PERFORMED AFTER WELDING IS COMPLETE.

RELEASED FOR FABRICATION / INSTALLATION
PPPL Drafting: Jerry Siegel 2007.12.14 08:32:17 -05'00'

04 ASSY	03 ASSY	02 ASSY	01 ASSY	PART NO.	DRAWING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY REQD
1				6	THIS DWG	UPRIGHT SUPPORT ANGLE - 52"	ASTM A36	
	1			5	THIS DWG	UPRIGHT SUPPORT ANGLE - 88"	ASTM A36	
1		1		4	THIS DWG	OUTRIGGER - 2"x2"x1/4" STRUCT ANGLE - OPPOSITE	ASTM A36	
	1		1	3	THIS DWG	OUTRIGGER - 2"x2"x1/4" STRUCT ANGLE - AS SHOWN	ASTM A36	
		1	1	2	THIS DWG	UPRIGHT SUPPORT ANGLE - 120"	ASTM A36	
2	2	2	2	1	THIS DWG	BASE PLATE	ASTM A36	
X				—	THIS DWG	UPRIGHT SUPPORT WELDMENT (OPPOSITE) - 52"	—	1
	X			—	THIS DWG	UPRIGHT SUPPORT WELDMENT (AS SHOWN) - 88"	—	1
		X		—	THIS DWG	UPRIGHT SUPPORT WELDMENT (OPPOSITE) - 120"	—	1
			X	—	THIS DWG	UPRIGHT SUPPORT WELDMENT (AS SHOWN) - 120"	—	1

PARTS LIST

NCSX-SE185-321

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY NATIONAL COMPACT STELLARATOR EXPERIMENT
Pro E	DIMENSIONS ARE IN INCHES MACHINE SURFACES 125	FIELD PERIOD ASSEMBLY FIELD PERIOD ASSEMBLY FIXTURE UPRIGHT SUPPORT WELDMENTS - 52", 88" AND 120"
DO NOT VERIFY INFORMATION BY SCALING DRAWING	BREAK SHARP EDGES .005/.020	
	TOLERANCES NON-CUMULATIVE	DSN: L. MORRIS 11-19-07 — DRAWING NO:
NEXT ASSEMBLY	DECIMAL-INCH FRACTIONS	CHK: M. COLE 11-19-07 — SE185-321
	.X +/-.100 0°-12° +/-1/16	ENGR: T. BROWN 11-19-07
	.XX +/-.030 12°-72° +/-1/8	
	.XXX +/-.005 72°-120° +/-1/4	SUPV: J. SIEGEL 11-19-07 — SHEET 1 OF 1 — REV 0
	ANGULAR +/-0°-15' OVER 120° +/-1/2	

WEIGHT	RELEASE LEVEL: Fabrication
52.3 lbs	DWG VERSION NO: 4
MODEL NAME SE185-321-01	
WELDING ENGINEER L. DUDEK 11-14-07	

NCSX_ASSY_FORMAT_E