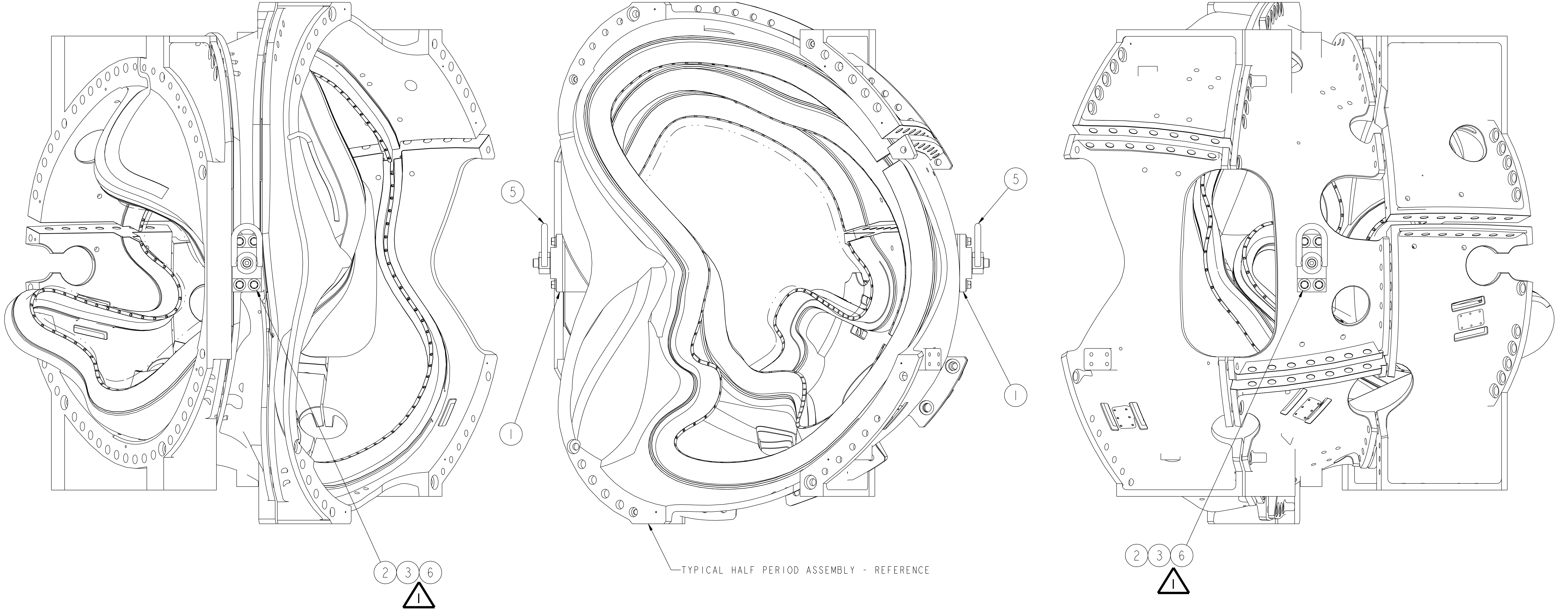


NO.	REVISION	BY	CH	SUP	APPROVED	DATE
1	REVISED PER ECN-5371	LM	TB	JS	T. BROWN	6-18-08



NOTES

- LIFTING BLOCK HARDWARE IS TO BE TORQUED TO A VALUE OF 425-440 FT-LBS TO ENSURE A PRE-LOAD OF 39,400 LBS. ON THE LIFTING BLOCK, PART 1.
- LUBRICATE THREADS OF PART 2, HEX HEAD CAP SCREW, WITH PART 6, MOLYKOTE Z MOLY POWDER.

A/R	PART NO.	DRAWING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY RECD
6	COMM		MOLYKOTE Z MOLY POWDER		
5	COMM		SWIVEL HOIST RING - 20,000# WORKING LOAD 1 3/8 - 6 THREAD McMASTER-CARR #2994782 OR EQUIV.	FORGED ST'L	
4	COMM		1" SPLIT LOCK WASHER (GRADE 8 COMPATIBLE)	CSL - 2N PLI	
3	COMM		1" NOM FLAT WASHER (GRADE 8 COMPATIBLE)	ASTM F436	
2	COMM		1"-8UNC-2A x 4" LG HEX HD CAP SCREW	SAE J429 GRADE 8	
1	SC186-201		HALF PERIOD LIFTING BLOCK - TYPE "B" BOSS	SEE DWG	
			THIS DWG		
			ROTATION FIXTURE ASSEMBLY		

PARTS LIST

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES MACHINE SURFACES UNLESS NOTED BREAK SHARP EDGES .005/.020	PRINCETON PLASMA PHYSICS LABORATORY NATIONAL COMPACT STELLARATOR EXPERIMENT TOOLING DESIGN AND FABRICATION STATION 2	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX +/- .000 .XXX +/- .005 ANGULAR +/- .05	DSN: L. MORRIS 1-24-08 CHK: M. VIOLA 1-24-08 ENGR: T. BROWN 1-24-08 SUPV: J. SIEGEL 1-24-08	DRAWING NO: SE186-200 SHEET 1 OF 1

RELEASED FOR FABRICATION / INSTALLATION
PPPL Drafting:

RELEASE LEVEL: Fabrication
DWG VERSION NO: 6

WEIGHT	21,000 LBS
MODEL NAME	SE186-200
WELDING ENGINEER	

NCSX-SE186-200

NCSX-ASSY-FORMAT.E