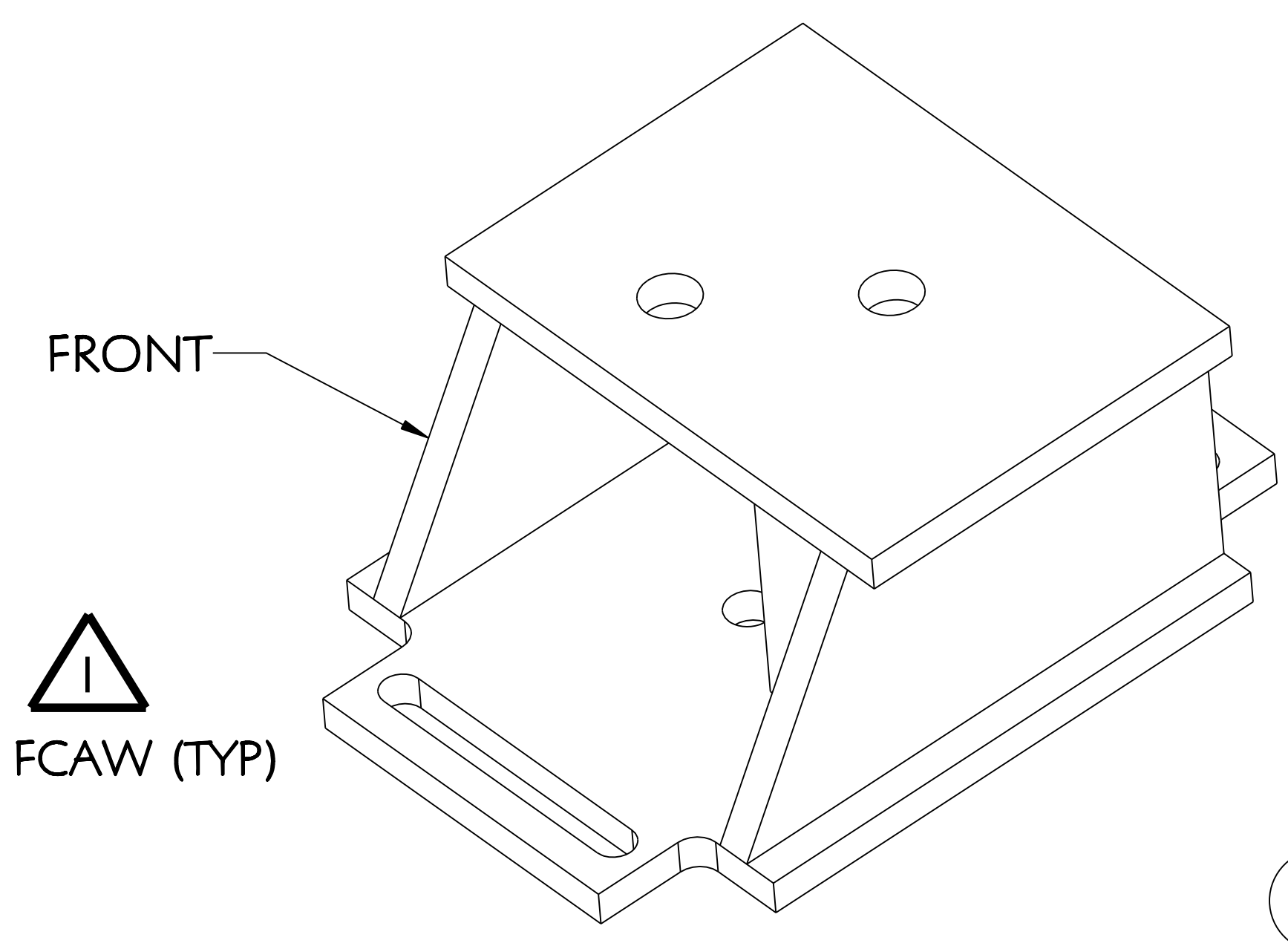
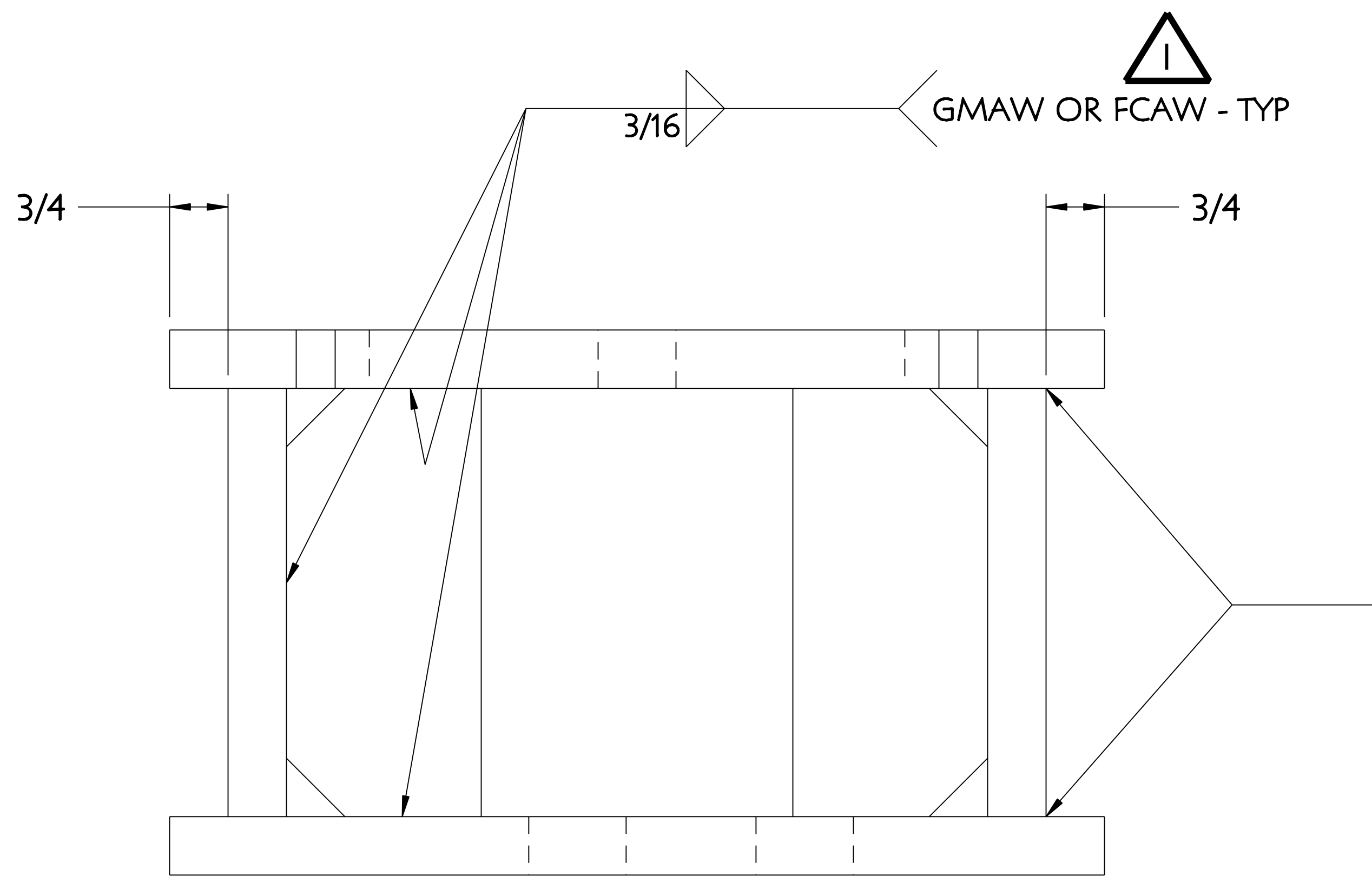
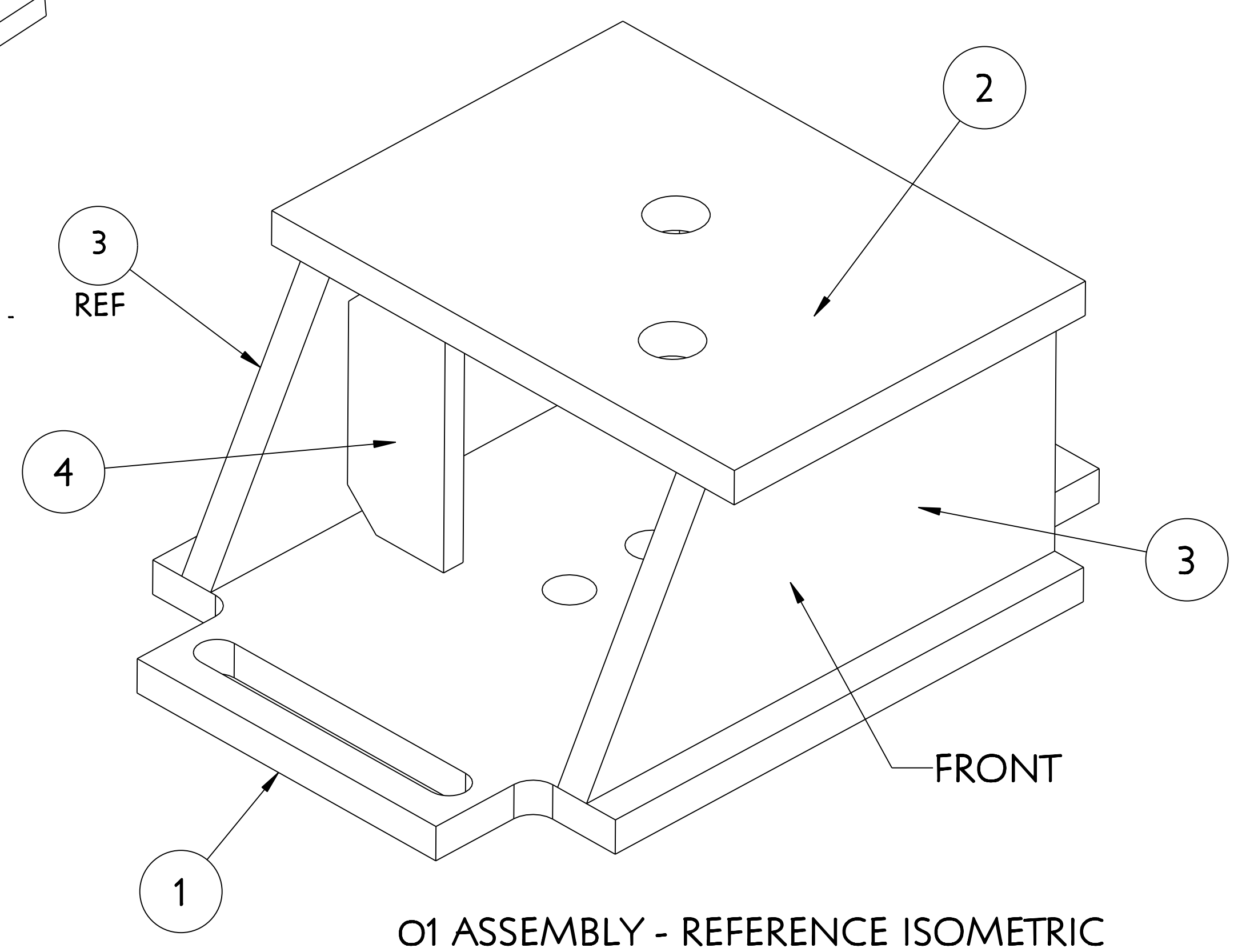


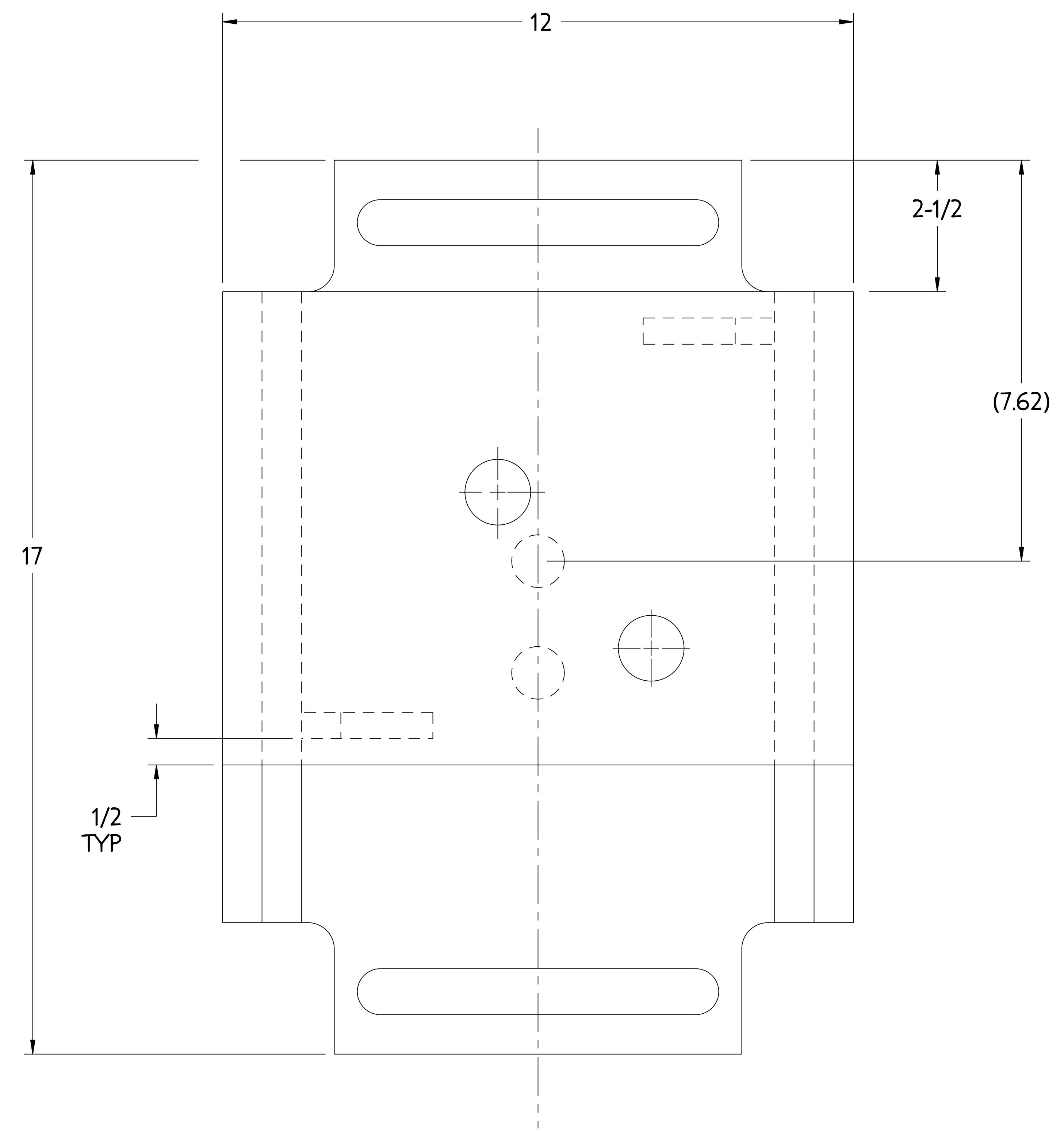
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1	REVISED PER ECN-5371	LM	TB	JS	T. BROWN	6-18-08



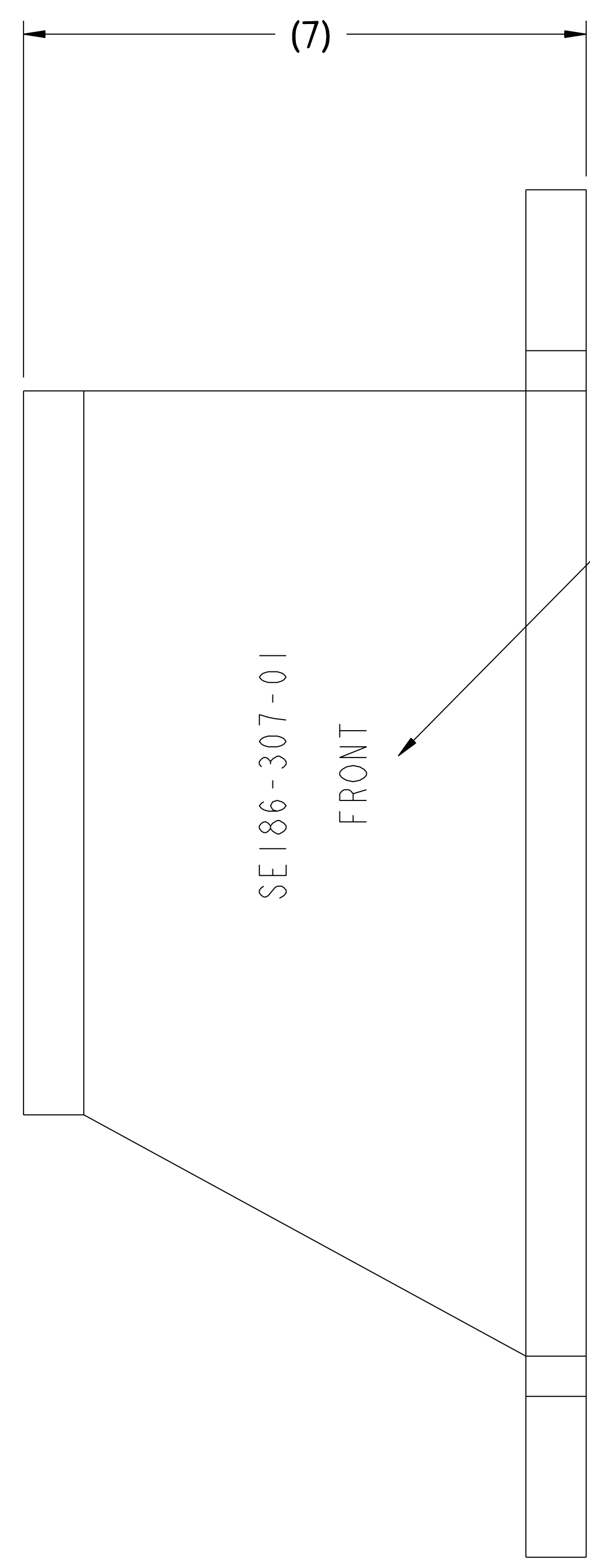
O2 ASSEMBLY - REFERENCE ISOMETRIC



O1 ASSEMBLY - REFERENCE ISOMETRIC



O1 ASSEMBLY - AS SHOWN- (1) REQ'D
O2 ASSEMBLY - OPPOSITE - (1) REQ'D



IDENTIFIER FOR O1 ASSEMBLY AS SHOWN.
IDENTIFIER FOR O2 ASSEMBLY TO BE ON OPPOSITE SIDE.
SEE NOTES.

NOTE

- WELDING SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF AWS D1.1 OR PPPL PROCEDURE NO. ENG-37.
- VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH THE ACCEPTANCE CRITERIA OF AWS D1.1 Section 6.
- NOTE ORIENTATION OF ALL PARTS PRIOR TO WELDING.
- BRACKET ASSEMBLY IS TO BE STAMPED OR PERMANENTLY MARKED WITH IDENTIFIER AS INDICATED.
- SAND BLAST AND APPLY 2 COATS "SAFETY YELLOW" PAINT.

RELEASED FOR FABRICATION / INSTALLATION
PPPL Drafting

PART NO.	DRAWING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY REQD
4	SE186-307-4	GUSSET SEGMENT "C" MCWF BRACKET	ASTM A36	2
3	SE186-307-3	SIDE PLATE MCWF SEGMENT "C" SUPPORT BRACKET TYPE #1	CARBON STEEL	2
2	SE186-307-2	TOP PLATE MCWF SEGMENT "C" SUPPORT BRACKET TYPE #1	CARBON STEEL	1
1	SE186-307-1	BOTTOM PLATE MCWF SEGMENT "C" SUPPORT BRACKET TYPE #1	CARBON STEEL	1

PARTS LIST

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY	
Pro E	DIMENSIONS ARE IN INCHES MACHINE SURFACES	NATIONAL COMPACT STELLARATOR EXPERIMENT	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	BREAK SHARP EDGES .005/.020	STELLARATOR CORE TOOLING DESIGN & FABRICATION MCWF SEGMENT "C" SUPPORT BRACKET TYPE #1 WELDMENTS	
SCALE 0.750	TOLERANCES NON-CUMULATIVE	DSN: J. RUSHINSKI	8-2-2007 DRAWING NO:
NEXT ASSEMBLY	DECIMAL-INCH FRACTIONS	CHK: M. COLE	8-2-2007
WELDING ENGINEER: G. GETTELFINGER 8-2-2007	ANGULAR: ±.15° OVER 120° ±.12°	ENGR: T. BROWN	8-2-2007
		SUPV: J. SIEGEL	8-2-2007

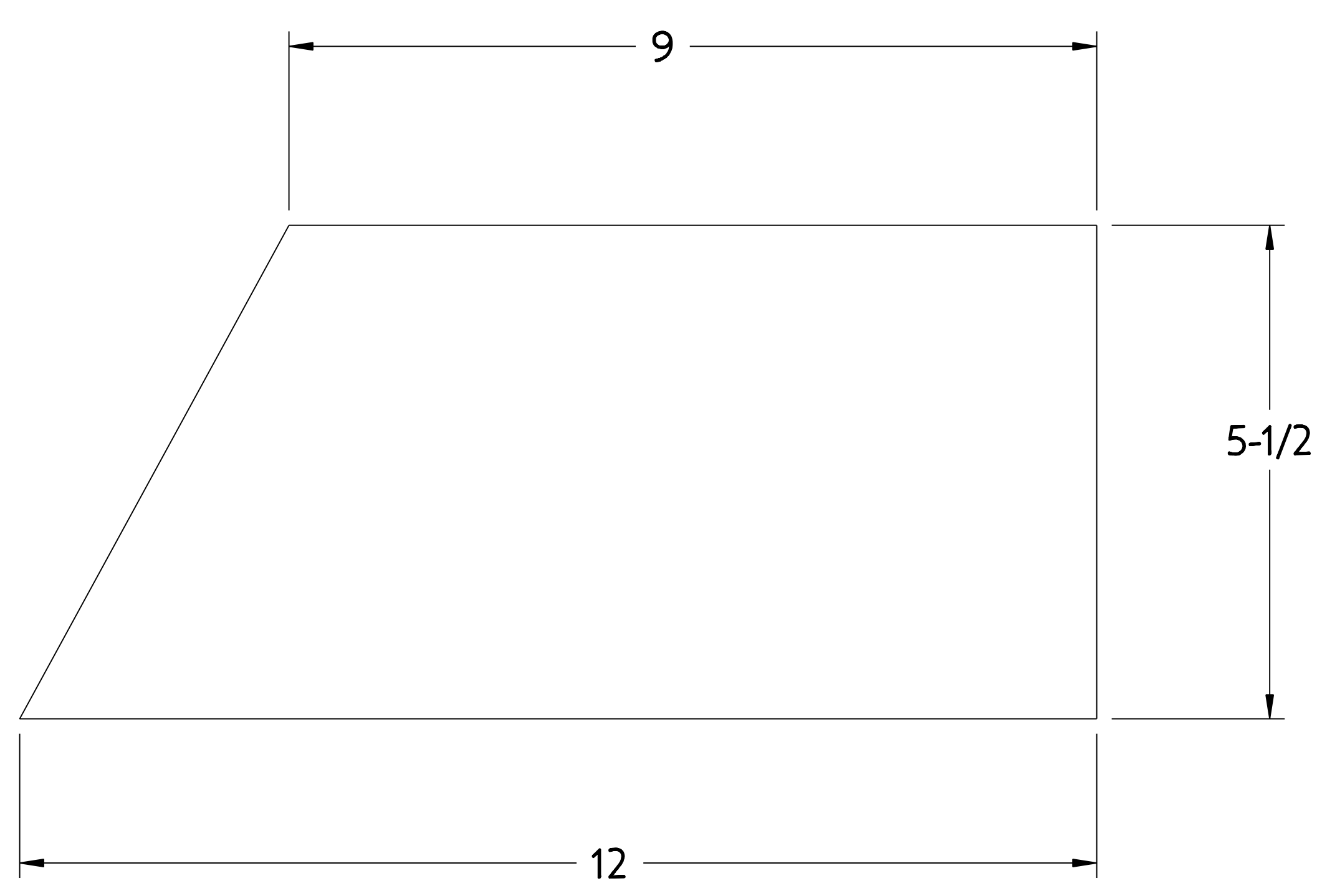
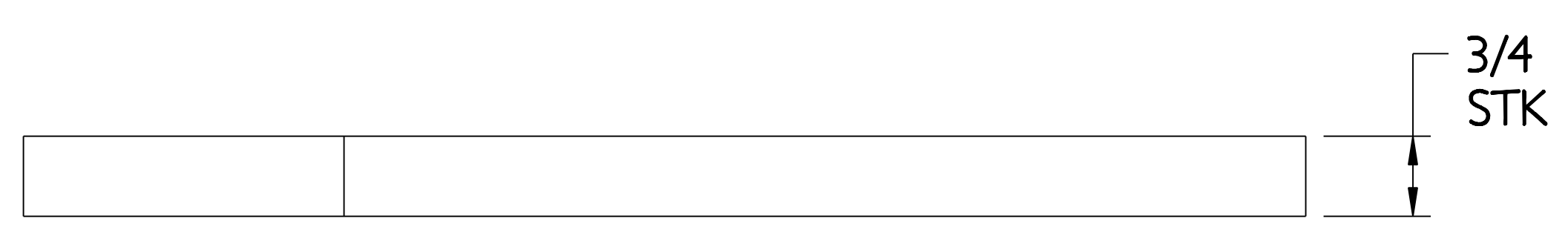
SE186-307

SHEET 1 OF 2 REV 1

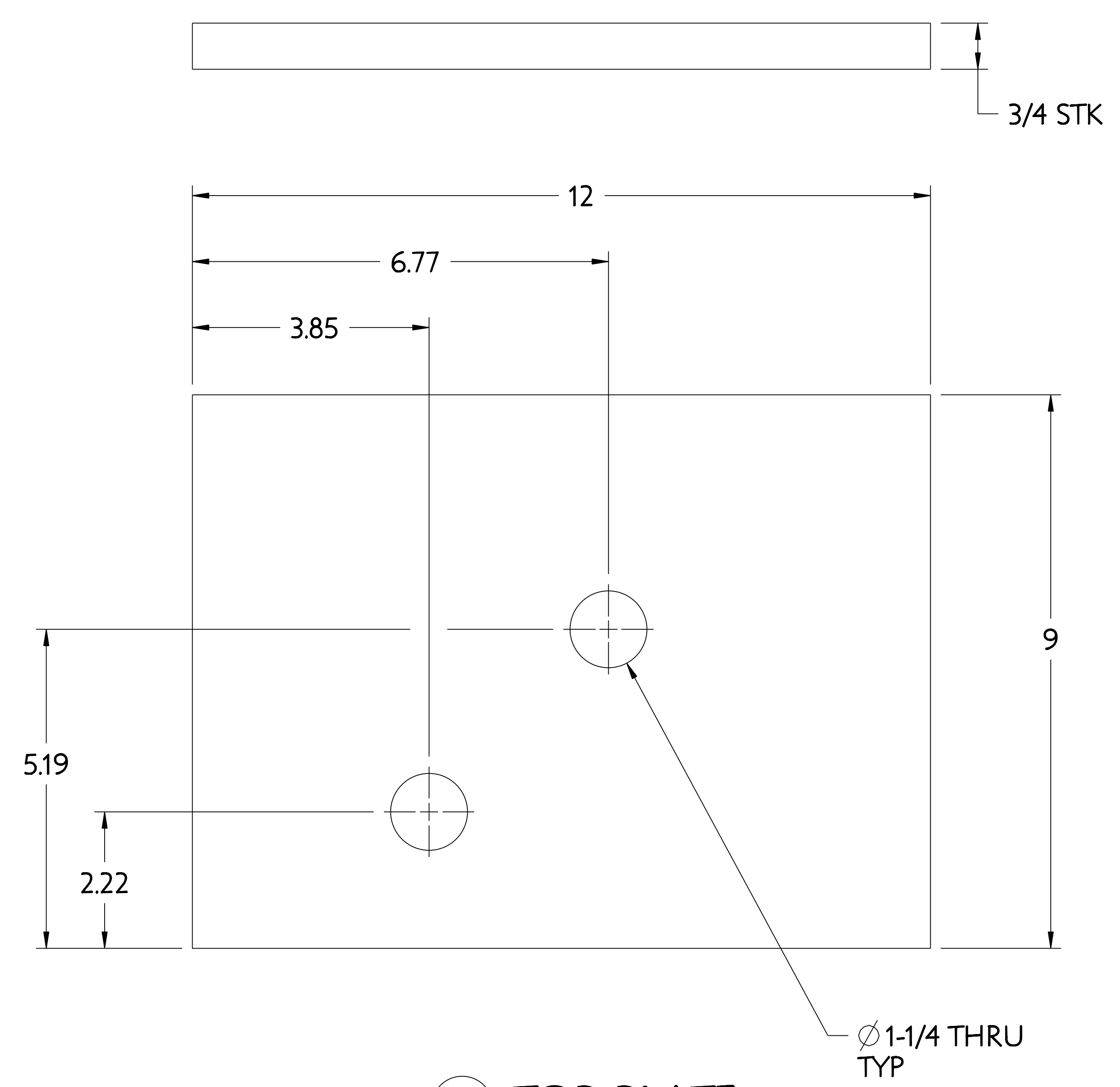
RELEASE LEVEL: FABRICATION
DWG VERSION NO: 6

NCSX-SE186-307

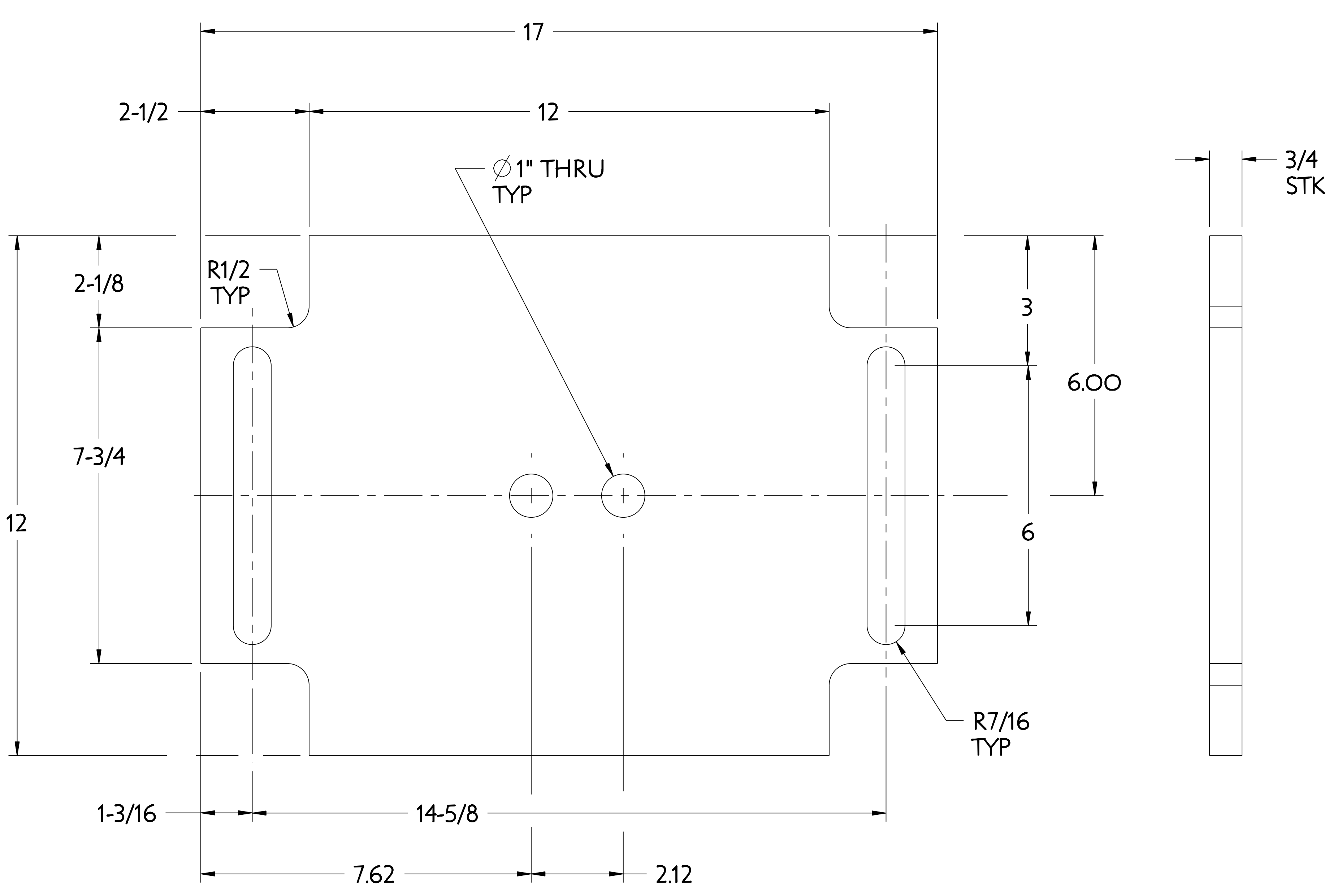
NO.	REVISION	BY	CH	SUP	APPROVED	DATE



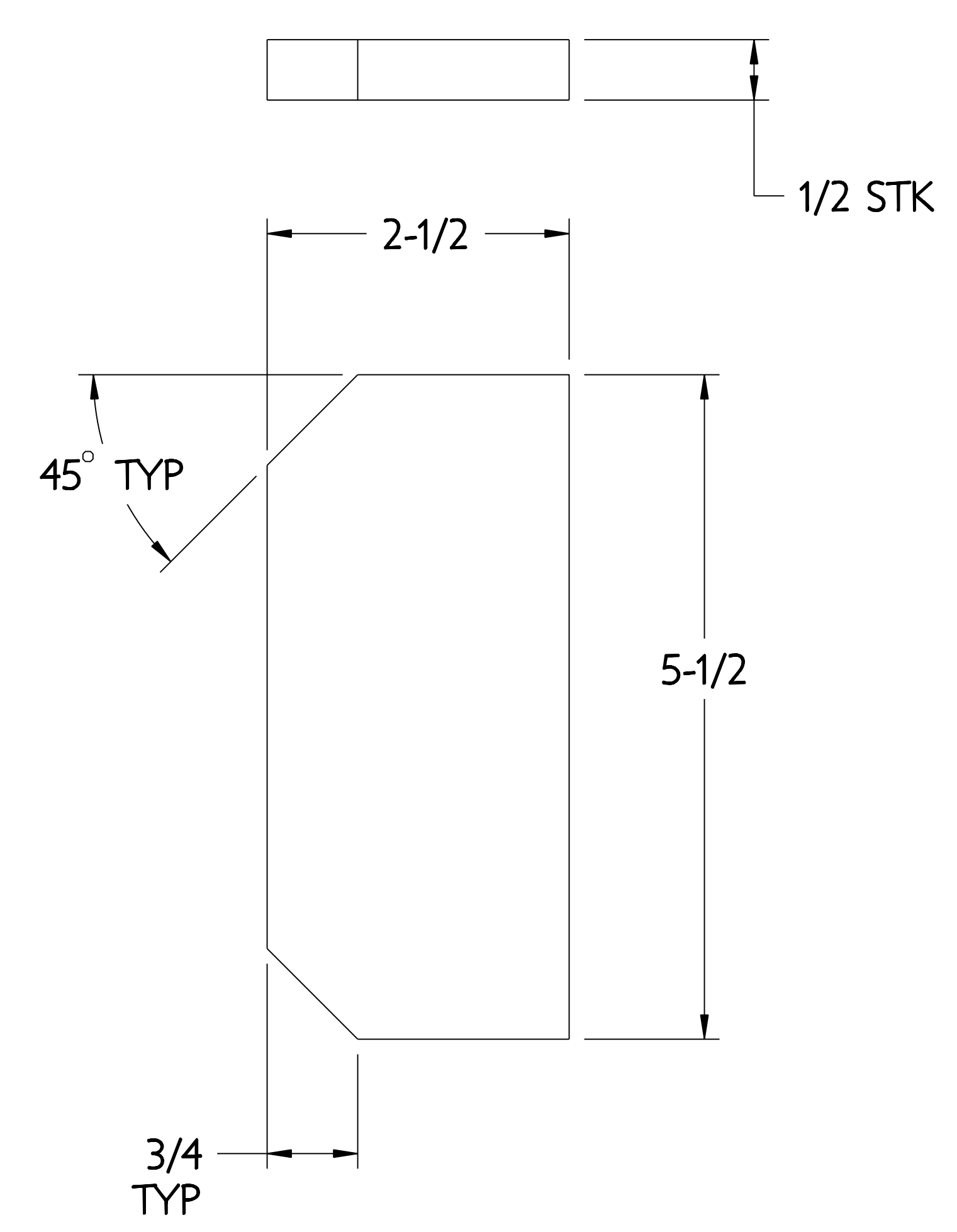
3 SIDE PLATE



2 TOP PLATE



1 BOTTOM PLATE



4 GUSSET

RELEASED FOR FABRICATION / INSTALLATION
PPPL Drafting

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

WEIGHT	88.8 lbs
MODEL NAME	SE186-307-01
WELDING ENGINEER	

RELEASE LEVEL: FABRICATION
DWG VERSION NO: 6

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 PRINCETON UNIVERSITY NATIONAL COMPACT STELLARATOR EXPERIMENT STELLARATOR CORE TOOLING DESIGN & FABRICATION MCWF SEGMENT "C" SUPPORT BRACKET TYPE #1 WELDMENTS
DO NOT VERIFY INFORMATION BY SCALING DRAWING	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX ±.005 .XXX ±.005 ANGULAR ±.0°-15° OVER 120° ±.1°-1.2°	DSN: J. RUSHINSKI 8-2-2007 CHK: M. COLE 8-2-2007 ENGR: T. BROWN 8-2-2007 SUPV: J. SIEGEL 8-2-2007
NEXT ASSEMBLY		DRAWING NO: SE186-307 SHEET 2 OF 2 REV 1.04

NCSX-SE186-307