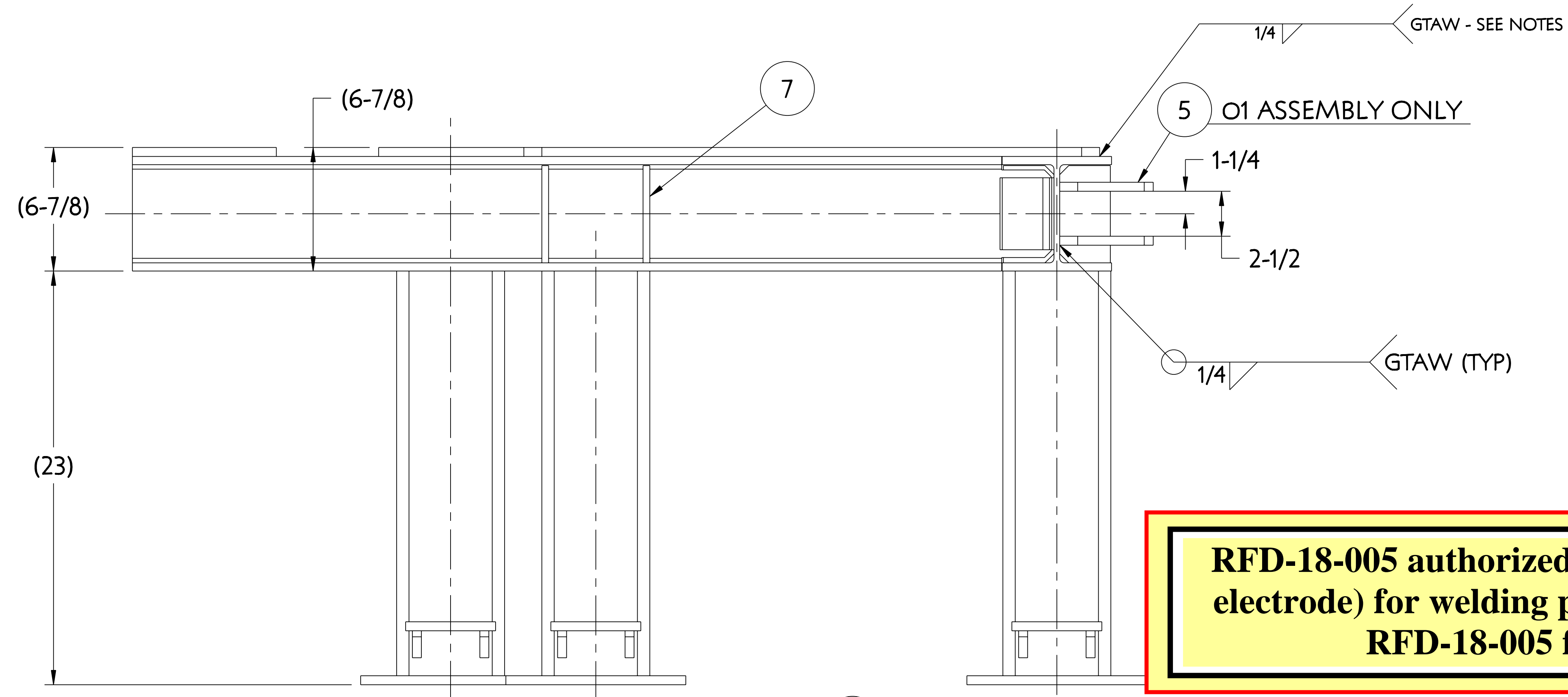
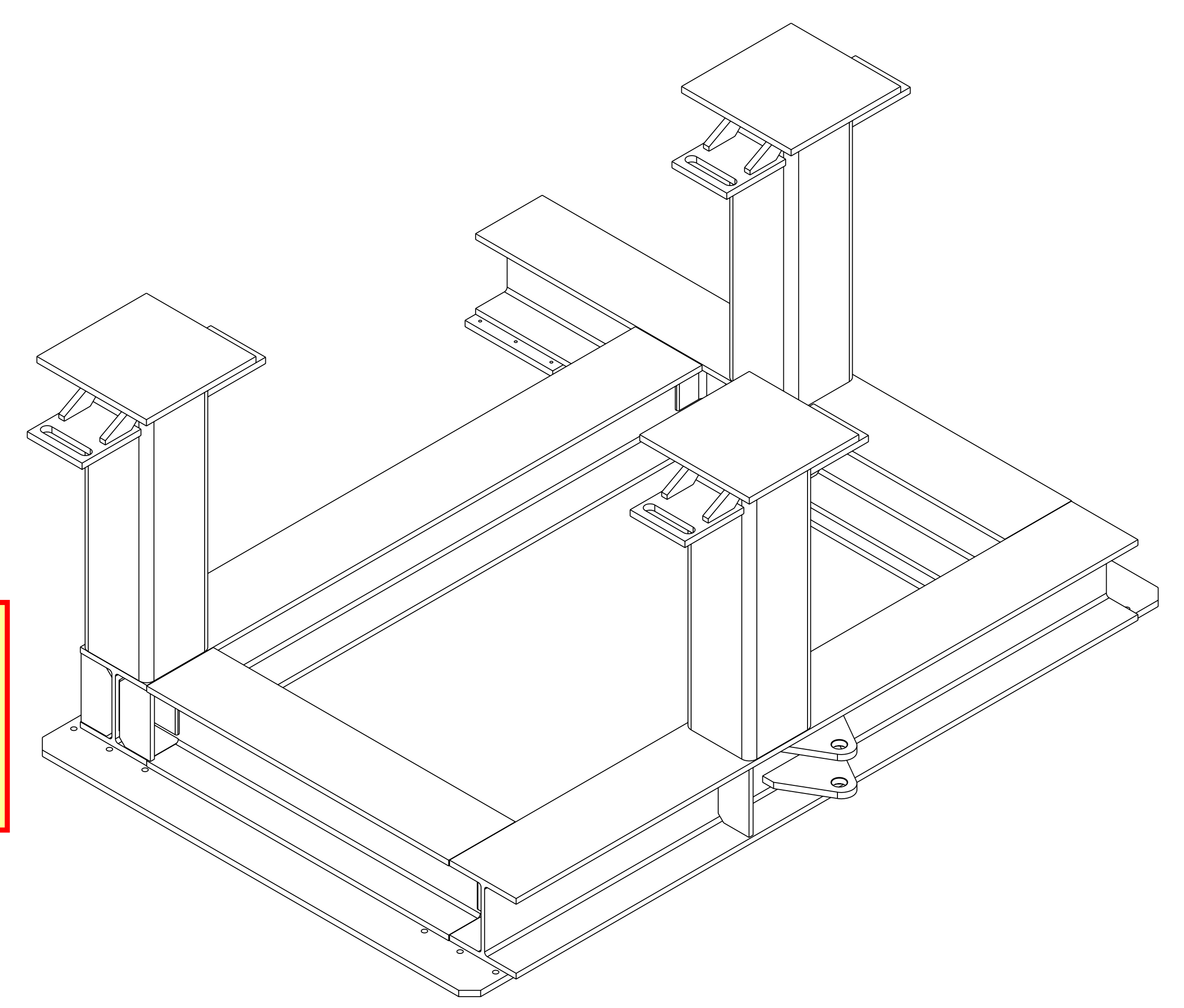


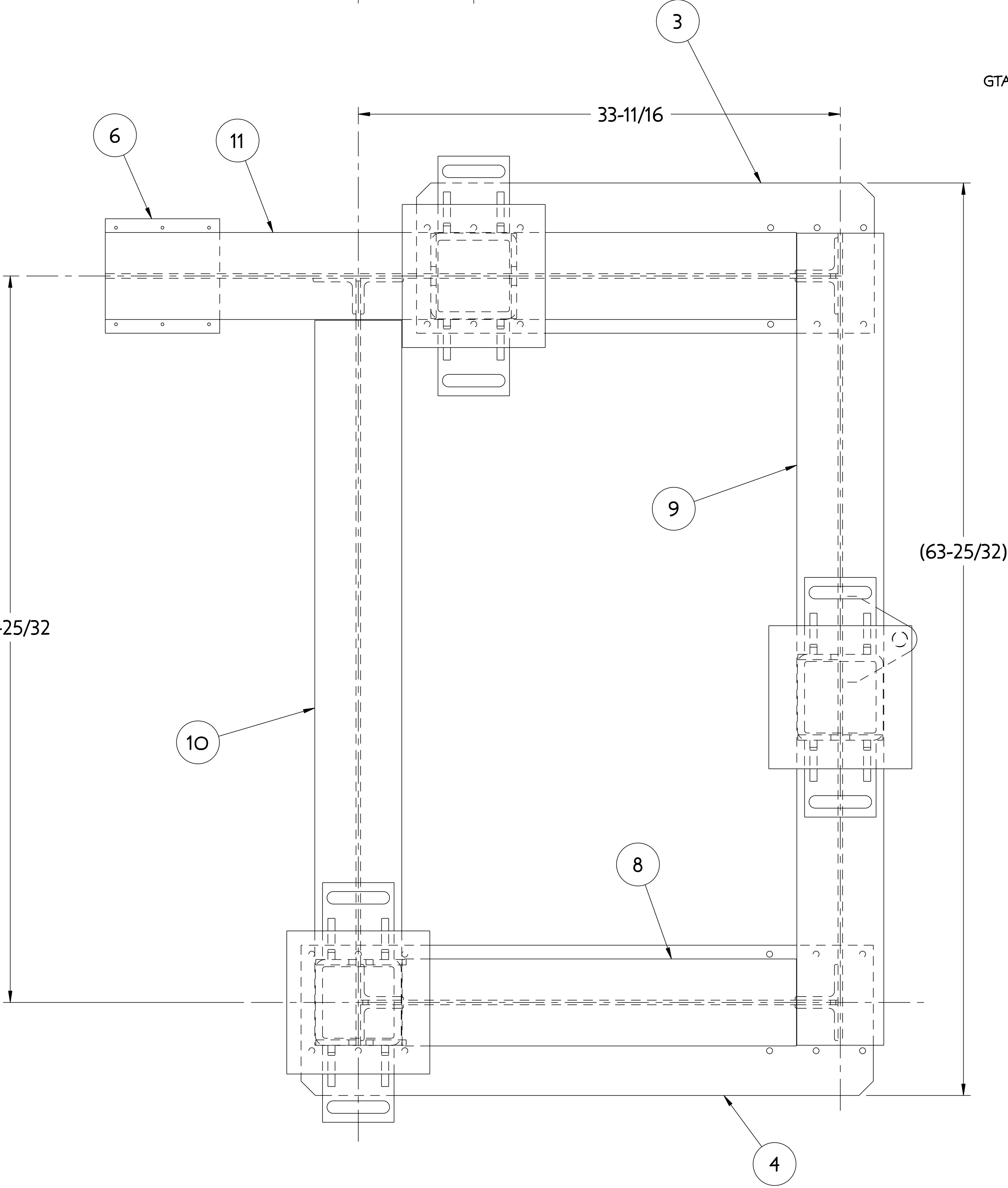
NO.	REVISION	BY	CH	SUP	APPROVED	DATE



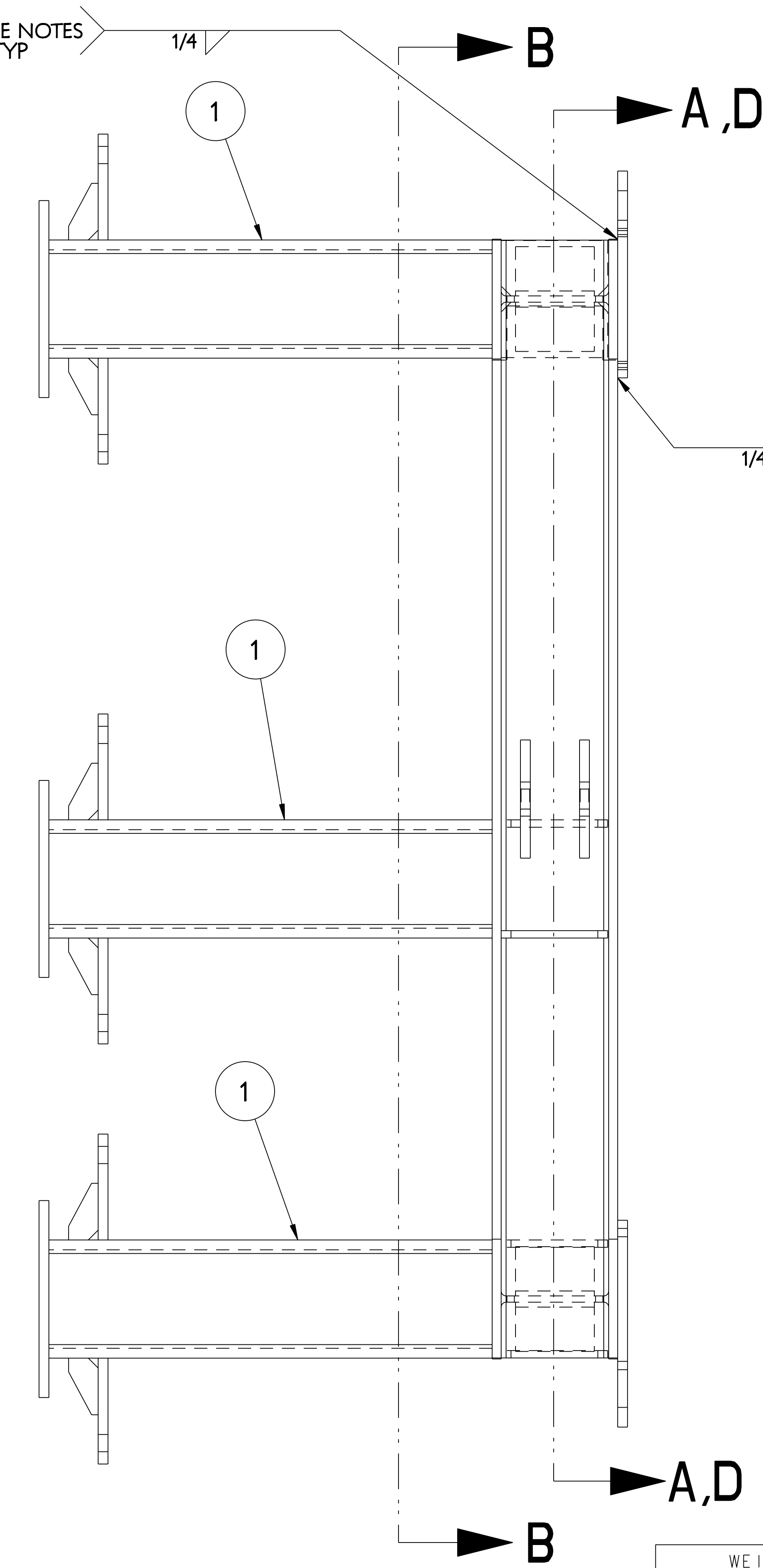
**RFD-18-005 authorized use of SMAW (stick electrode) for welding part 5 to part 9. (See RFD-18-005 for details)**



O1 ASSEMBLY  
REFERENCE ISOMETRIC



O1 ASSEMBLY - RIGHT SIDE SUPPORT CART WELDMENT - AS SHOWN  
O2 ASSEMBLY - LEFT SIDE SUPPORT CART WELDMENT - OPPOSITE (SEE SHEET 3)



**RFD-18-004 replaced either "GMAW or GTAW" welds with either "GMAW or FCAW" welds wherever appearing on this drawing. See RFD-18-004 for details)**

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**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.  
SAND BLAST AND APPLY 2 COATS "SAFETY YELLOW" PAINT

QTY	PART NO.	DRAWING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY REQD
2	14	SE186-326-8	MCWF SUPPORT CART ANTI-TIP PLATE - TYPE "E"	SEE DWG	
1	13	SE186-326-7	MCWF SUPPORT CART ANTI-TIP PLATE - TYPE "D"	SEE DWG	
1	12	SE186-326-6	MCWF SUPPORT CART ANTI-TIP PLATE - TYPE "C"	SEE DWG	
1	11	SE186-341-4	FRAMING BEAM - TYPE # 4	SEE DWG	
1	10	SE186-341-3	FRAMING BEAM - TYPE # 3	SEE DWG	
1	9	SE186-341-2	FRAMING BEAM - TYPE # 2	SEE DWG	
1	8	SE186-341-1	FRAMING BEAM - TYPE # 1	SEE DWG	
12	11	7	SE186-331-6	SUPPORT GUSSET	SEE DWG
1	6	SE186-326-5	HILMAN ROLLER MOUNTING PLATE	SEE DWG	
2	5	SE186-326-4	PULL PLATE	SEE DWG	
1	4	SE186-326-3	MCWF SUPPORT CART ANTI-TIP PLATE - TYPE "B"	SEE DWG	
1	3	SE186-326-2	MCWF SUPPORT CART ANTI-TIP PLATE - TYPE "A"	SEE DWG	
8	8	2	SE186-326-1	CLIP ANGLE	SEE DWG
3	3	1	SE186-325	MCWF SUPPORT CART SUPPORT POST WELDMENT	SEE DWG
			THIS DWG	MCWF LEFT SIDE SUPPORT CART WELDMENT	1
			THIS DWG	MCWF RIGHT SIDE SUPPORT CART WELDMENT	1

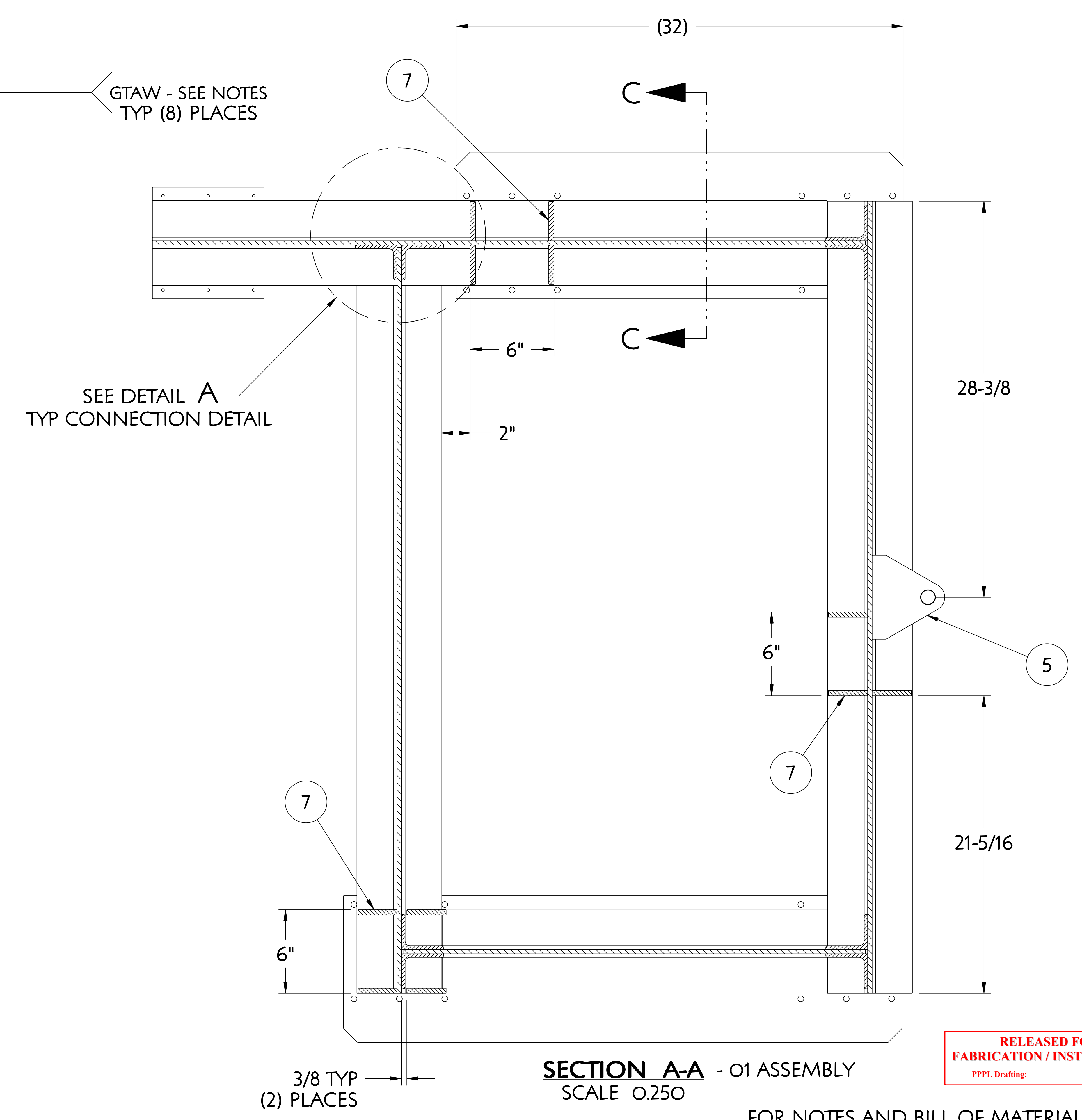
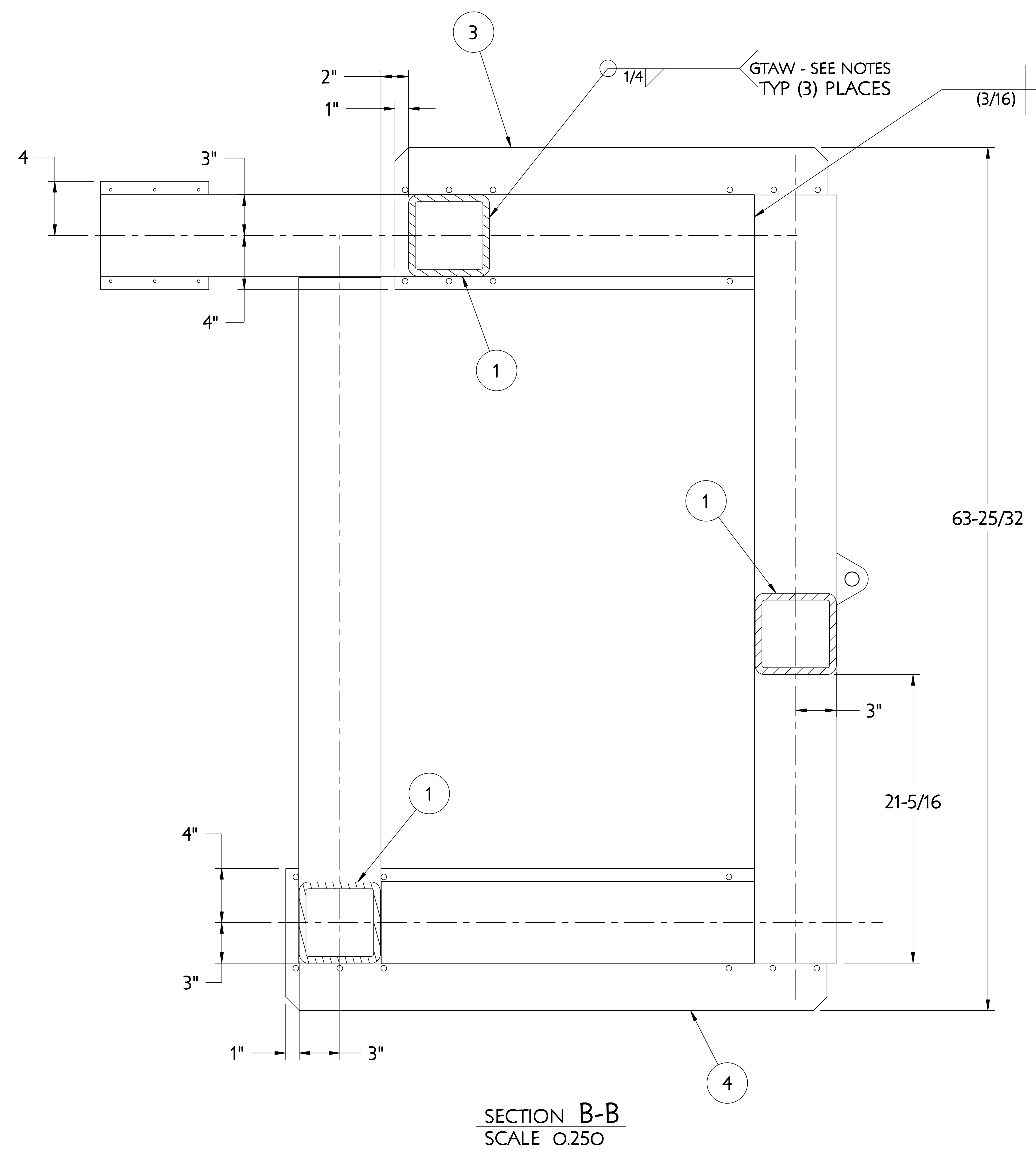
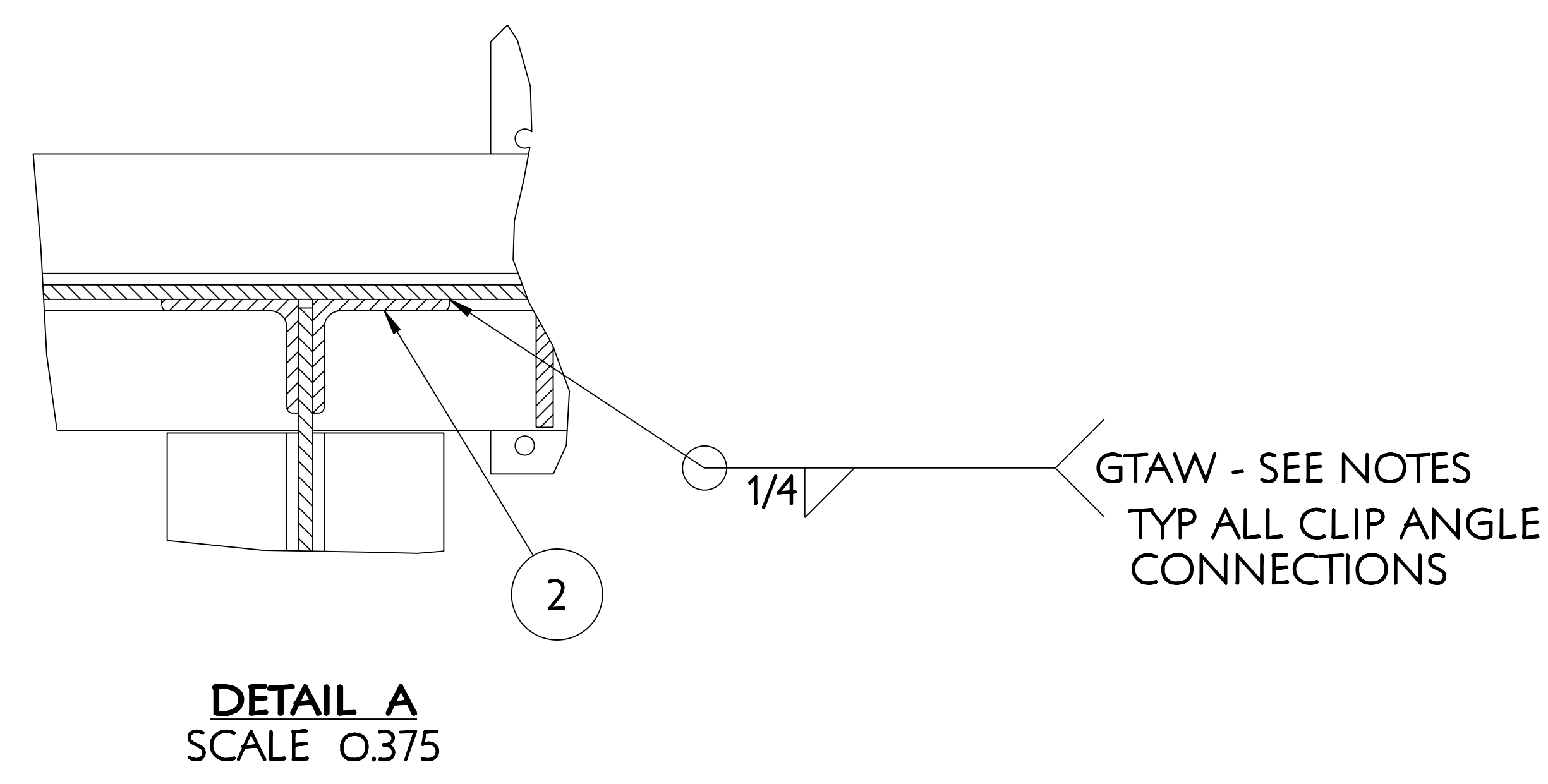
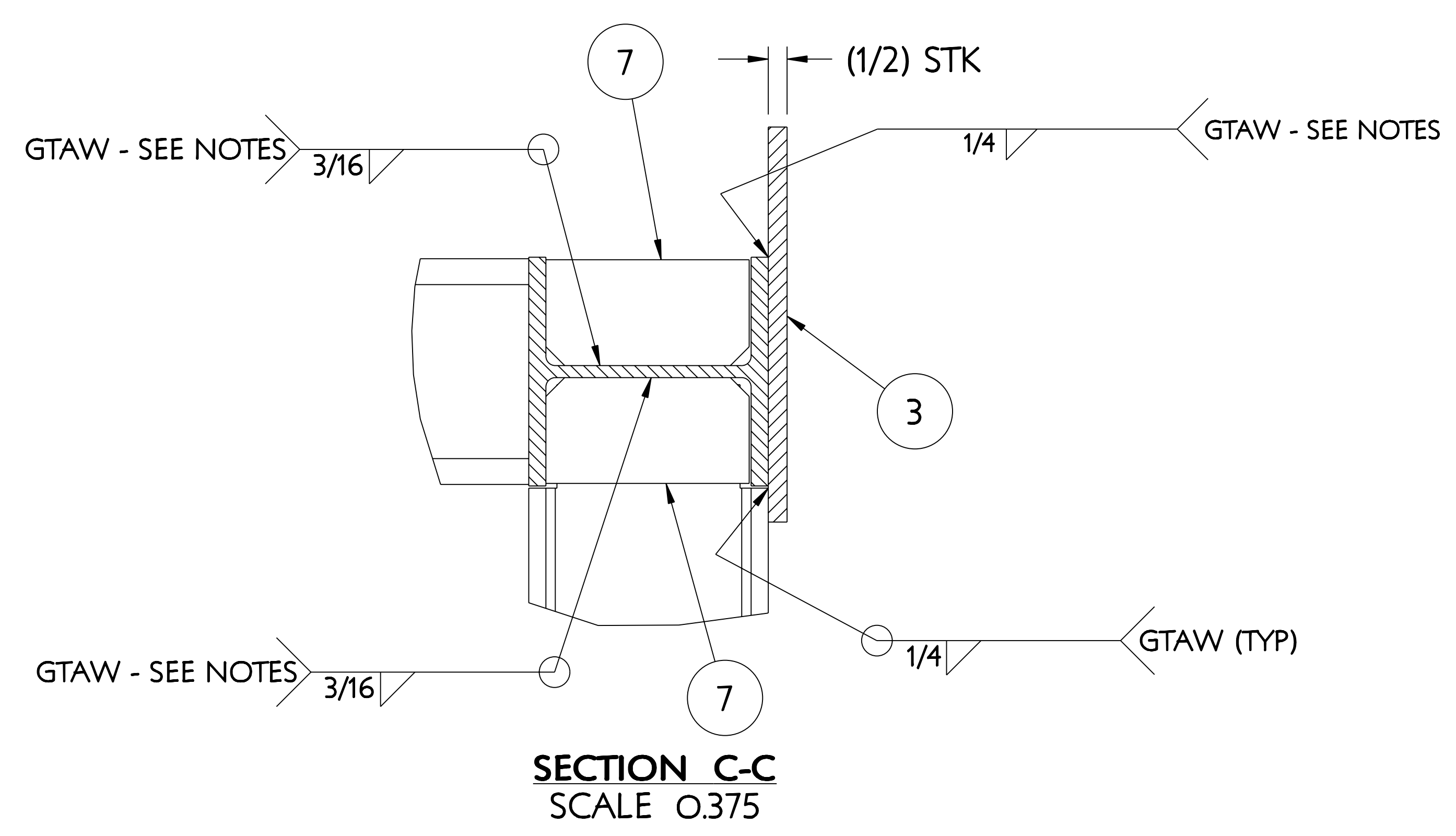
COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY	
Pro E	DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	NATIONAL COMPACT STELLARATOR EXPERIMENT	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	SCALE 0:250	STELLARATOR CORE TOOLING DESIGN & FABRICATION MCWF SUPPORT CART WELDMENTS	
WEIGHT 1160.8 lbs	TOLERANCES NON-CUMULATIVE	DSN: J. RUSHINSKI 8-2-2007	DRAWING NO:
MODEL NAME SE186-330-01	DECIMAL-INCH FRACTIONS	CHK: M. COLE 8-2-2007	SE186-330
WELDING ENGINEER G. GETTELFINGER 8-2-2007	ENGR: T. BROWN 8-2-2007	ENGR: T. BROWN 8-2-2007	
	ANGLAR: J. SIEGEL 8-2-2007	SUPV: J. SIEGEL 8-2-2007	SHEET 1 OF 3
			REV 0

RELEASE LEVEL: Fabrication  
DWG VERSION NO: 26

NCSX-SE186-330

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FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

RELEASE LEVEL: Fabrication  
DWG VERSION NO: 26

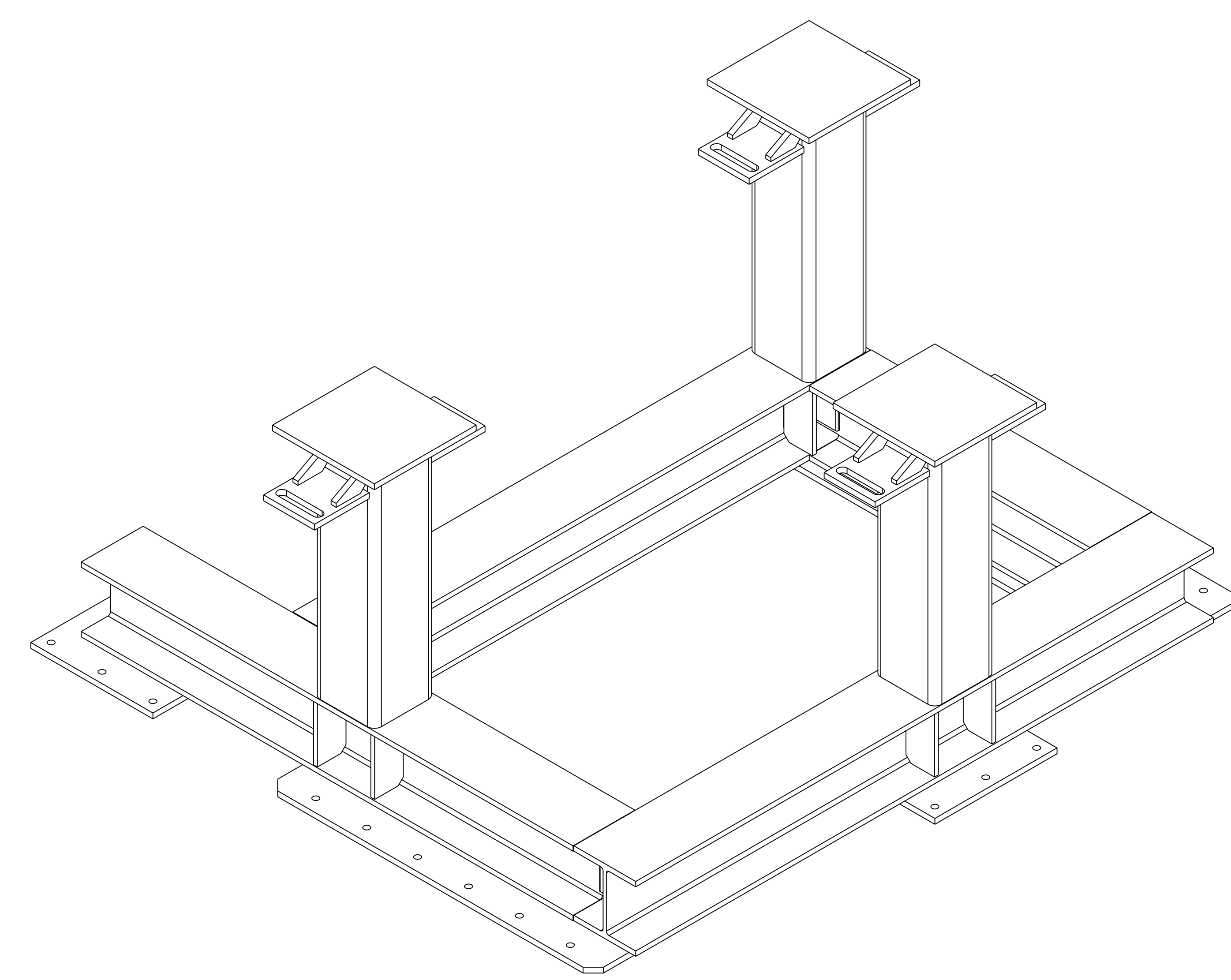
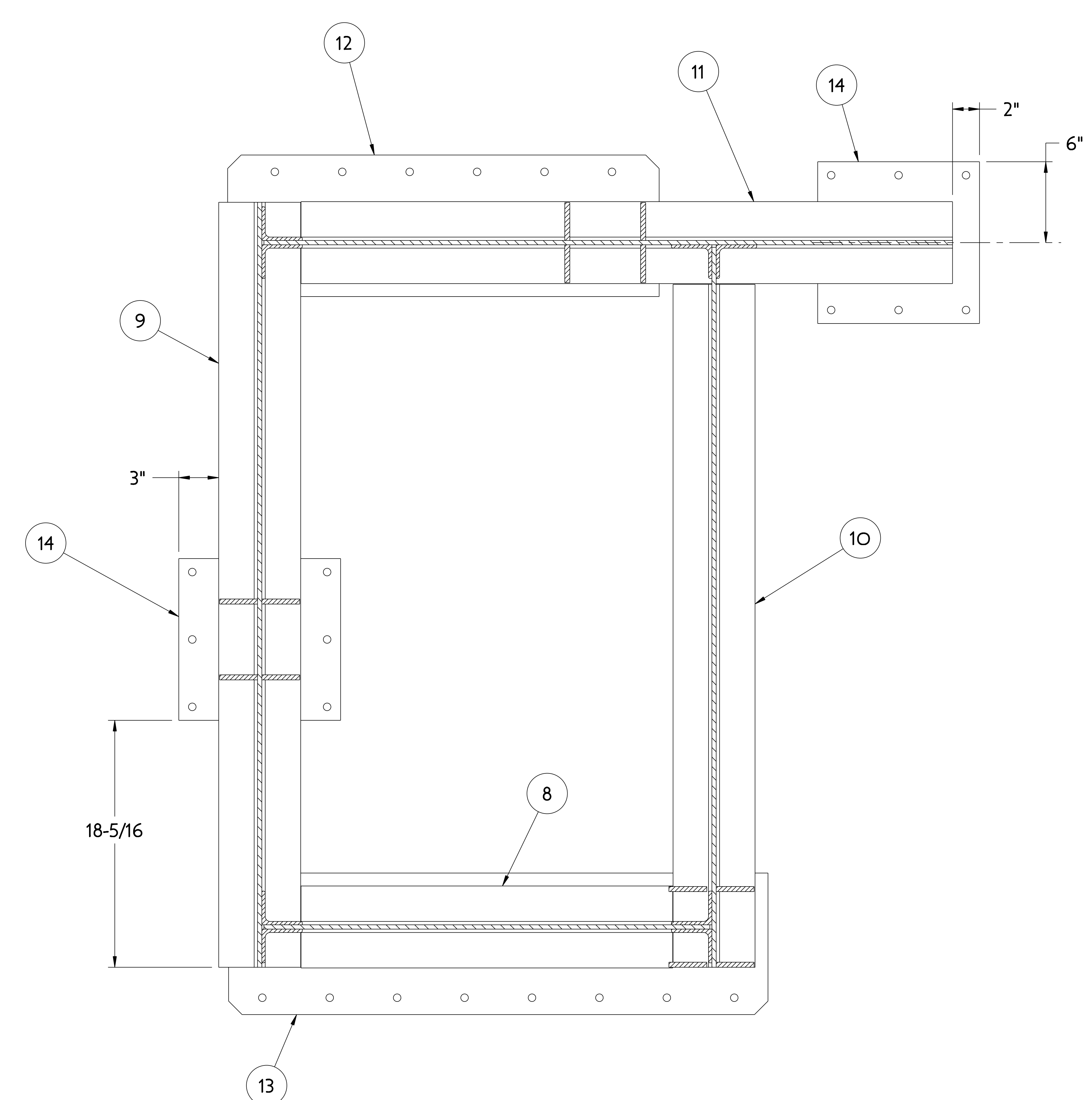
WEIGHT	1160.8 lbs
MODEL NAME	SE186-330-01
WELDING ENGINEER	

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 STELLARATOR CORE TOOLING DESIGN & FABRICATION MCWF SUPPORT CART WELDMENTS
DO NOT VERIFY INFORMATION BY SCALING DRAWING	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX +/- .005 .XXX +/- .005 ANGULAR +/- .05	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: <b>SE186-330</b> SHEET 2 OF 3

NCSX-SE186-330



NO.	REVISION	BY	CH	SUP	APPROVED	DATE



O2 ASSEMBLY  
REFERENCE ISOMETRIC

**RELEASED FOR  
FABRICATION / INSTALLATION**  
 PPPL Drafting

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

**RELEASE LEVEL: Fabrication**  
**DWG VERSION NO: 26**

WEIGHT	1160.8 lbs
MODEL NAME	SE186-330-01
WELDING ENGINEER	

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY NATIONAL COMPACT STELLARATOR EXPERIMENT	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	STELLARATOR CORE TOOLING DESIGN & FABRICATION MCWF SUPPORT CART WELDMENTS	
TOLERANCES NON-CUMULATIVE	DECIMAL-INCH FRACTIONS	DSN: L. MORRIS	8-2-2007 DRAWING NO:
NEXT ASSEMBLY	.X +/- .100 0°-120° +/- .125 .XX +/- .030 120°-120° +/- .125 .XXX +/- .005 120°-120° +/- .125 ANGULAR +/- .0°-15° OVER 120° +/- .125	CHK: M. COLE	8-2-2007
		ENGR: T. BROWN	8-2-2007
		SUPV: J. SIEGEL	8-2-2007
			SHEET 3 OF 3
			REV D, I

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