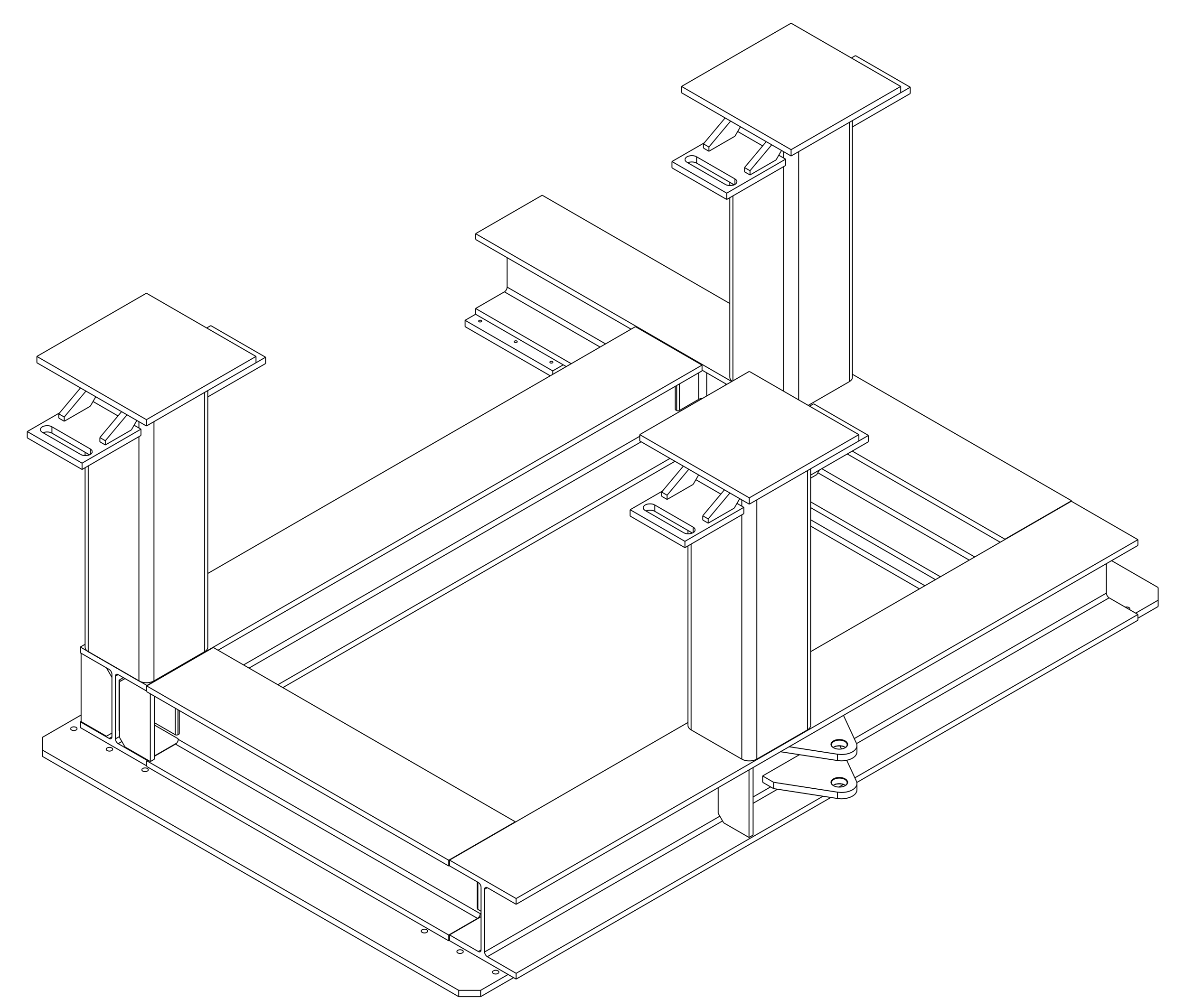
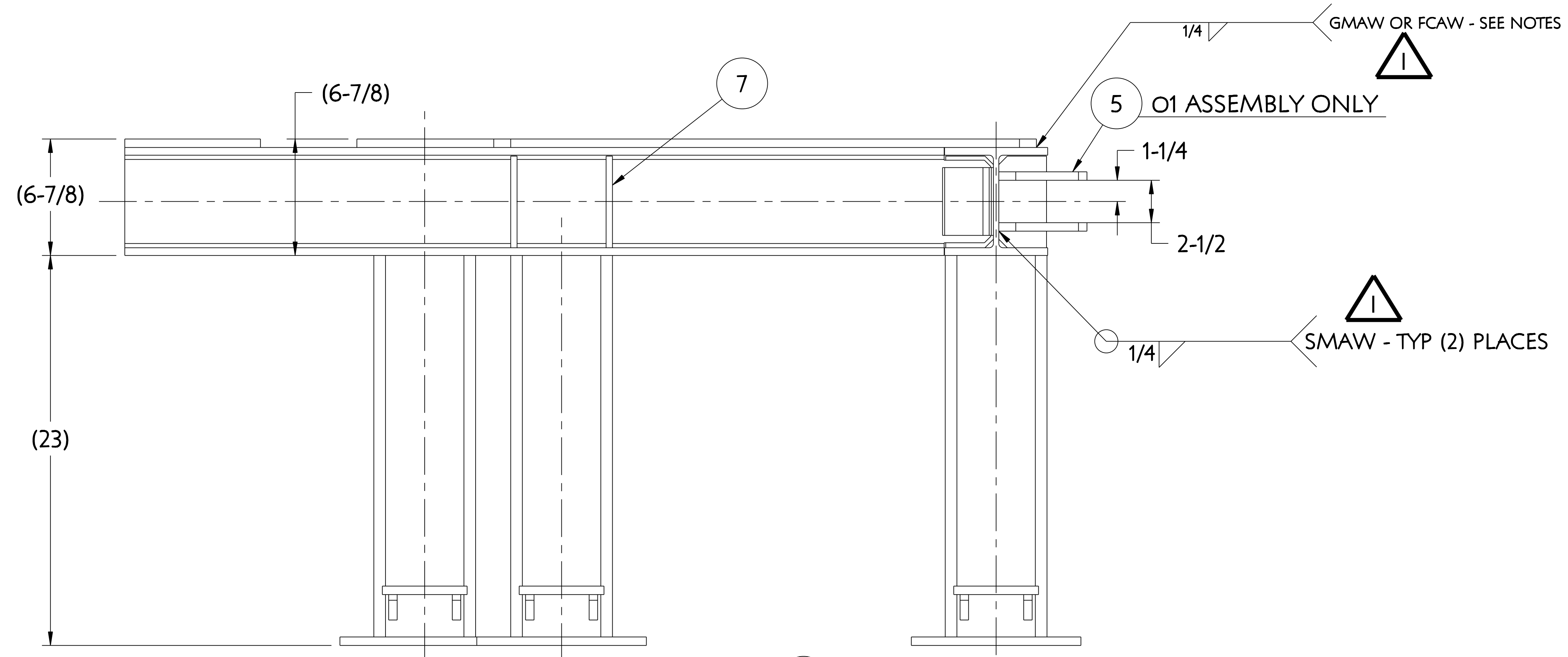
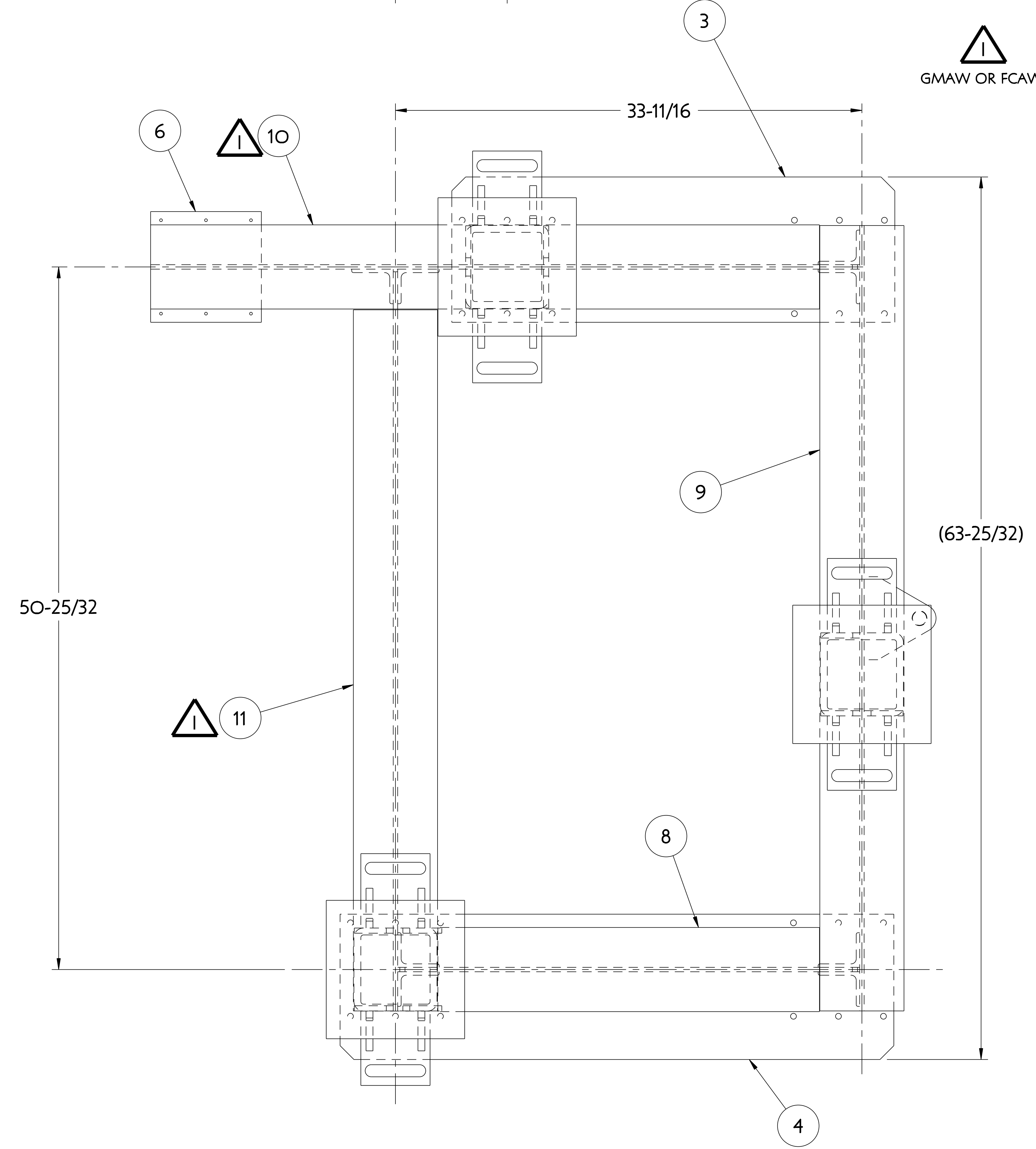


| NO. | REVISION             | BY | CH | SUP | APPROVED | DATE   |
|-----|----------------------|----|----|-----|----------|--------|
| 1   | REVISED PER ECN-5355 | LM | TB | JS  | T. BROWN | 5-8-08 |

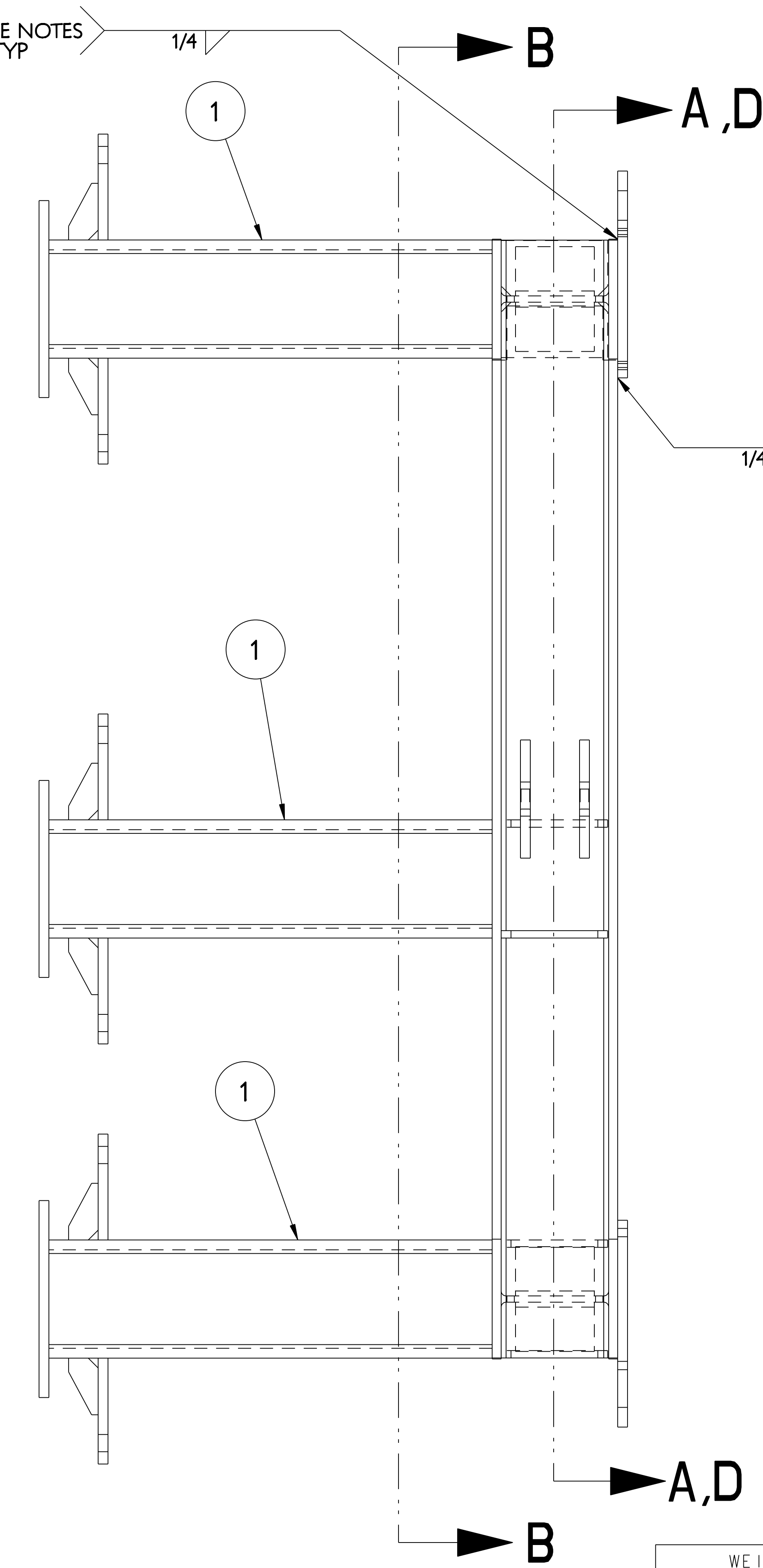


O1 ASSEMBLY  
REFERENCE ISOMETRIC



O1 ASSEMBLY - RIGHT SIDE SUPPORT CART WELDMENT - AS SHOWN

O2 ASSEMBLY - LEFT SIDE SUPPORT CART WELDMENT - OPPOSITE (SEE SHEET 3)



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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

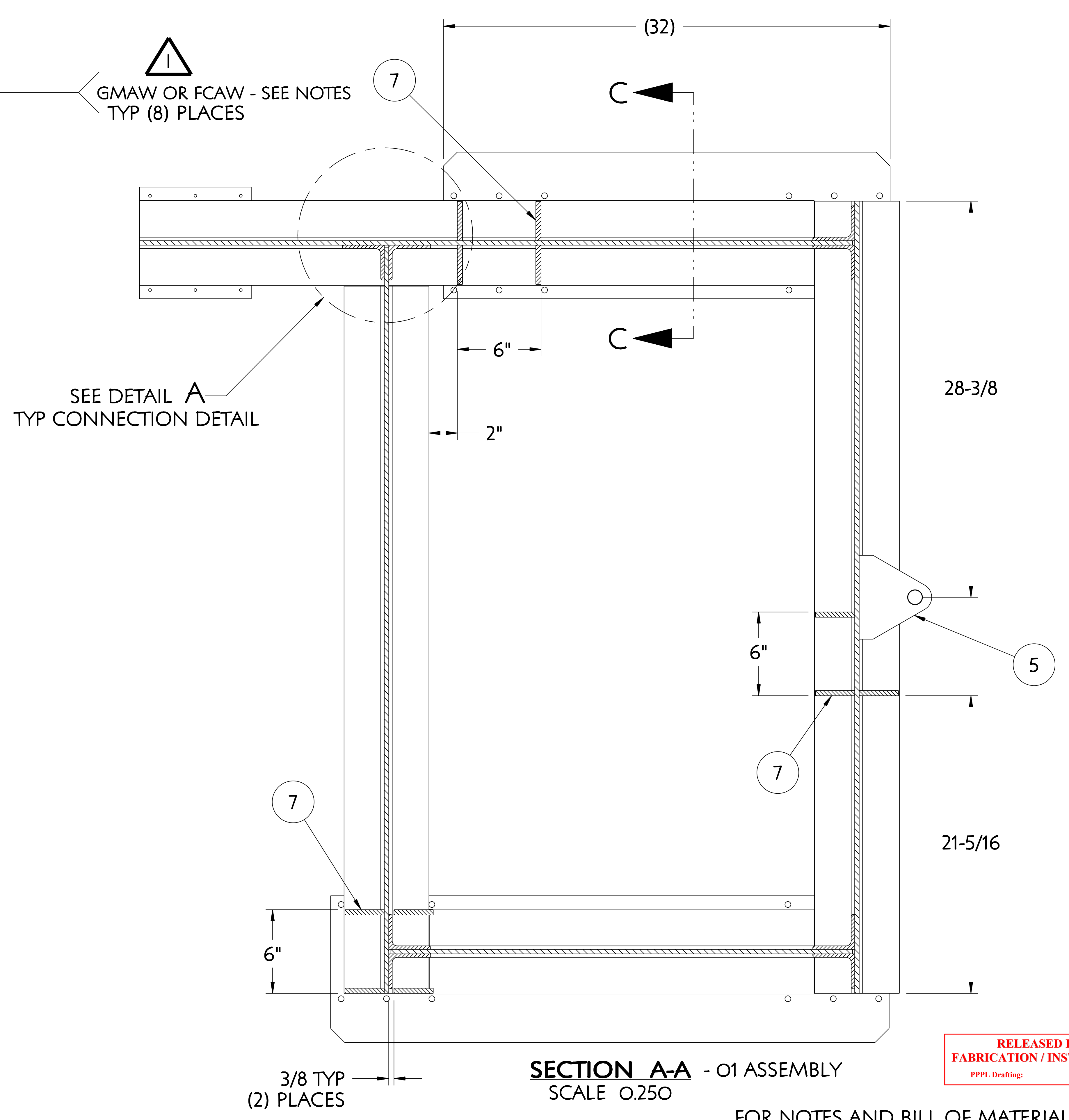
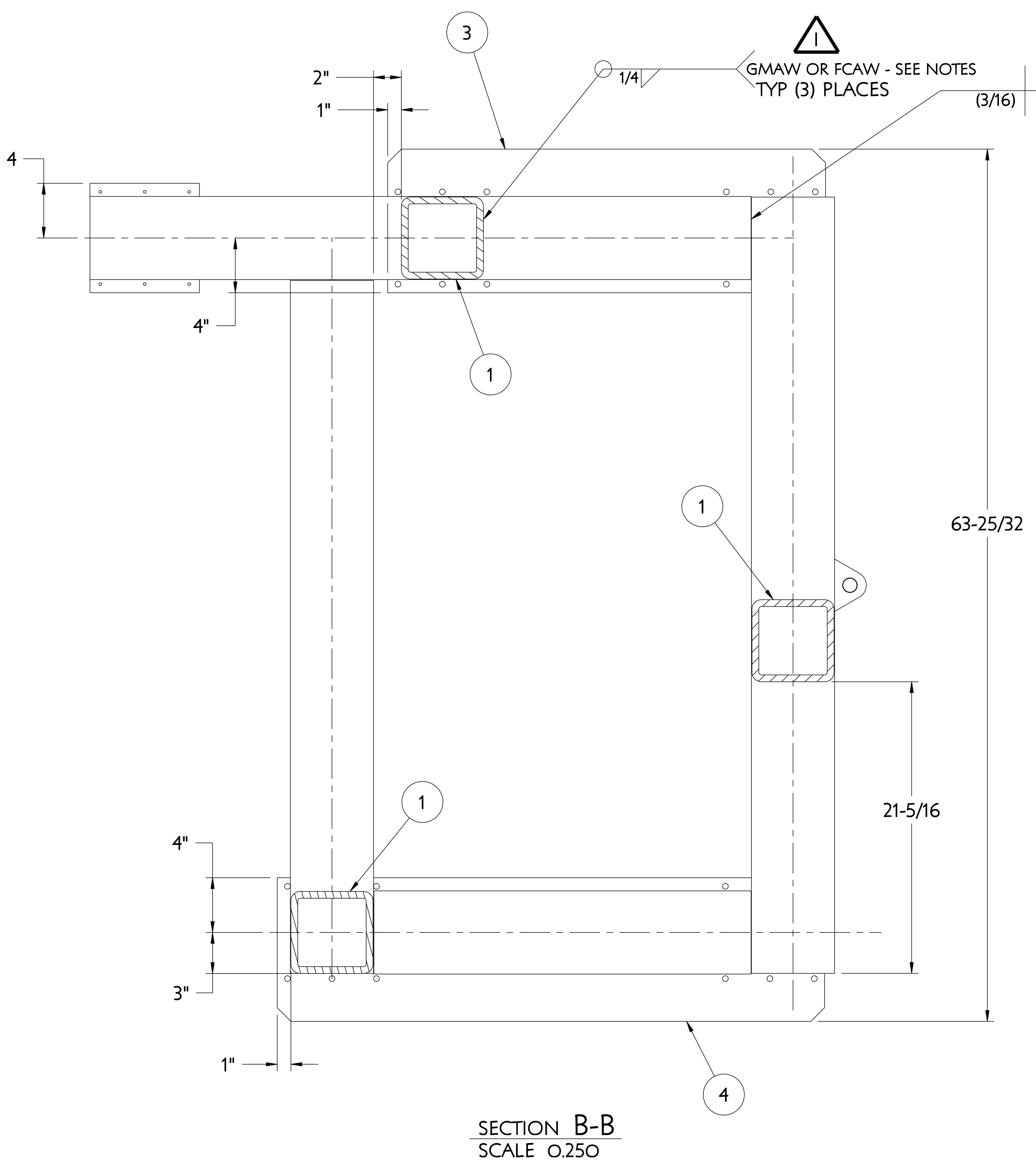
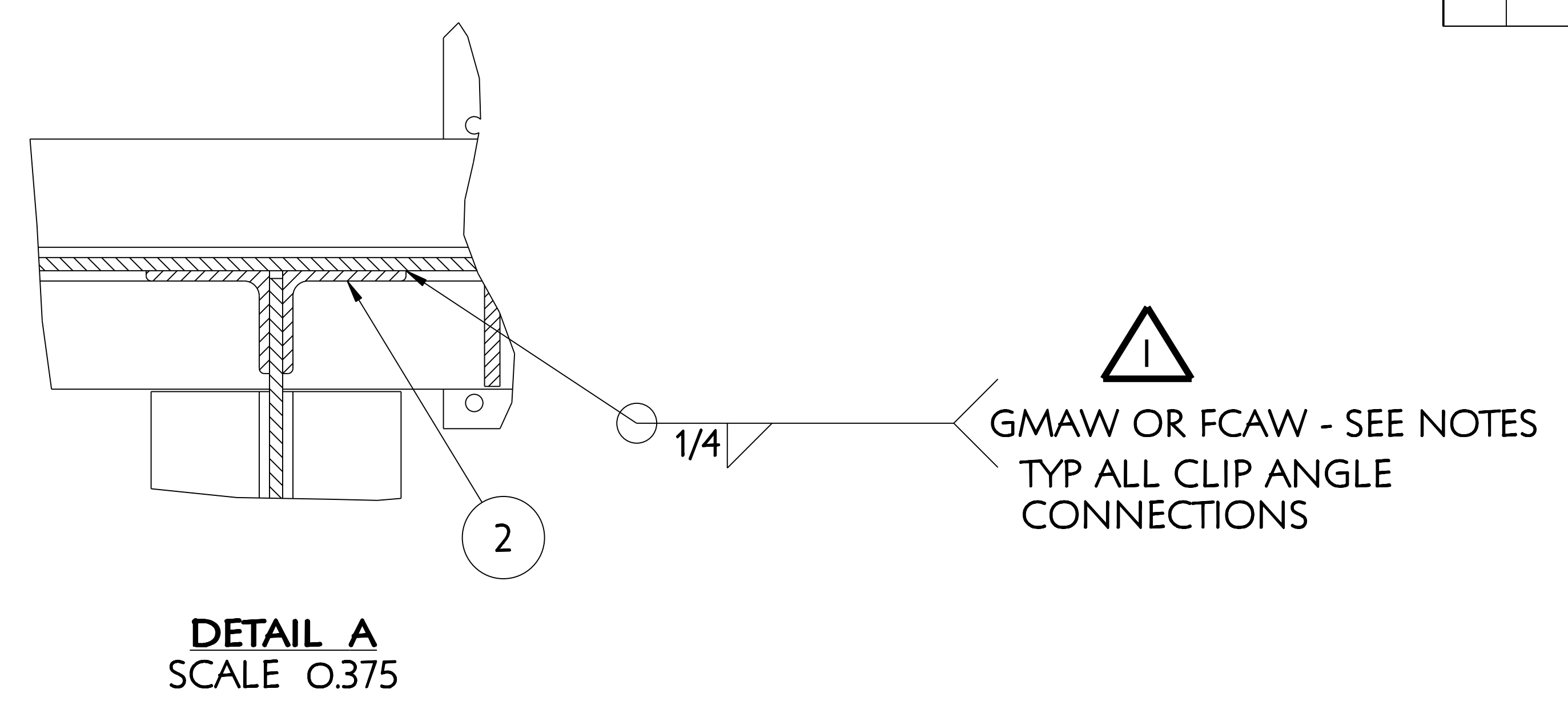
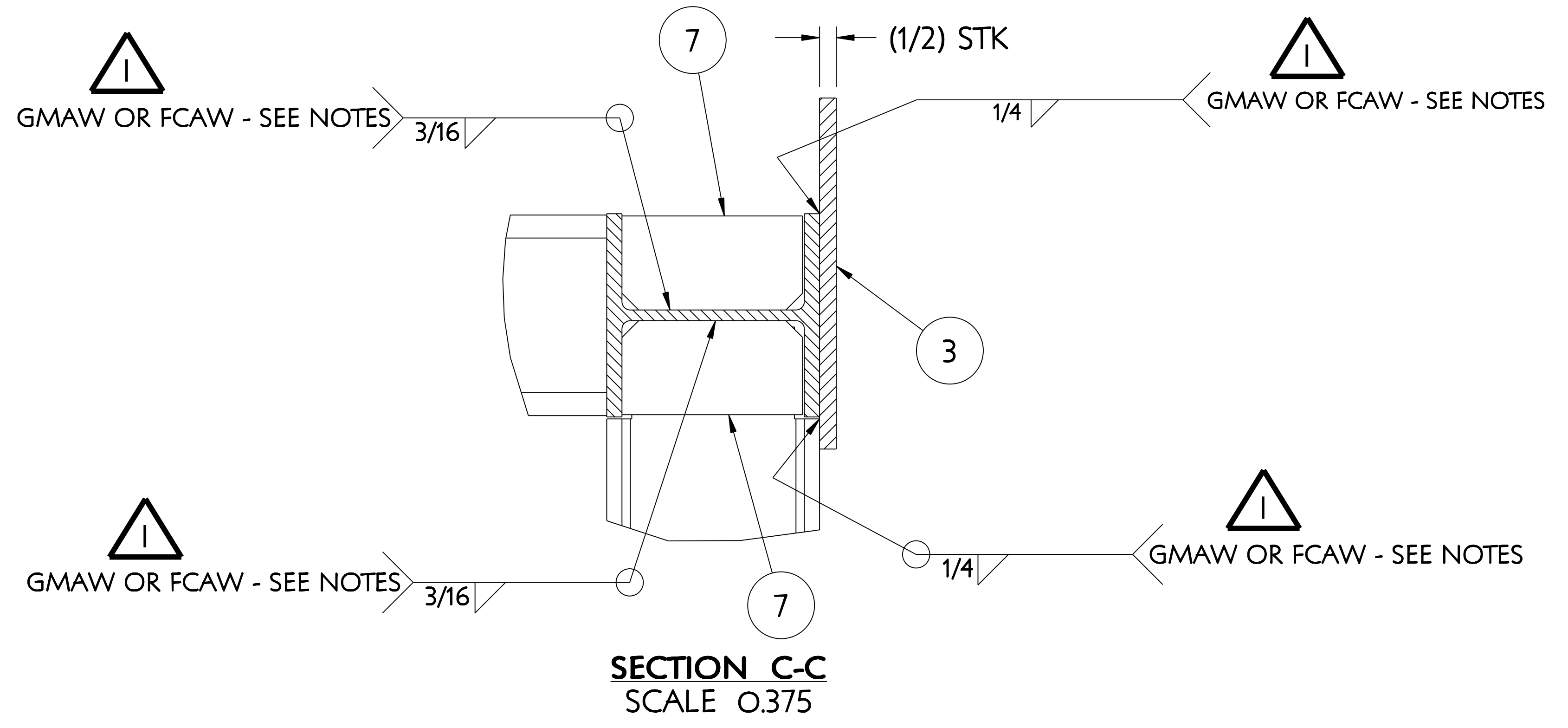
| QTY | PART NO. | DRAWING NO. | NOMENCLATURE OR DESCRIPTION                 | MATERIAL                                | QTY RECD |
|-----|----------|-------------|---------------------------------------------|-----------------------------------------|----------|
| 2   | 14       | SE186-326-8 | MCWF 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<br>MANUAL CHANGES NOT PERMITTED | CENTRAL FILES:<br>UNLESS OTHERWISE SPECIFIED                                | PRINCETON PLASMA PHYSICS LABORATORY<br>PRINCETON UNIVERSITY |                                               |
| Pro E                                                      | DIMENSIONS ARE IN INCHES<br>MACHINE SURFACES<br>BREAK SHARP EDGES .005/.020 | NATIONAL COMPACT STELLARATOR EXPERIMENT                     |                                               |
| DO NOT VERIFY INFORMATION BY SCALING DRAWING               | SCALE 0:250                                                                 | TOLERANCES NON-CUMULATIVE                                   | STELLARATOR CORE TOOLING DESIGN & FABRICATION |
| WEIGHT<br>1160.8 lbs                                       | MODEL NAME<br>SE186-330-01                                                  | DECIMAL-INCH FRACTIONS                                      | MCWF SUPPORT CART WELDMENTS                   |
| RELEASE LEVEL: Fabrication                                 | DWG VERSION NO: 0                                                           | 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                                     | 8-2-2007                                      |
|                                                            |                                                                             | SUPV: J. SIEGEL 8-2-2007                                    | 8-2-2007                                      |

NCSX-SE186-330

NCSX-ASSY-FORMAT.E

| NO. | REVISION | BY | CH | SUP | APPROVED | DATE |
|-----|----------|----|----|-----|----------|------|
|     |          |    |    |     |          |      |



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PPPL Drafting

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

**RELEASE LEVEL: Fabrication**  
**DWG VERSION NO: 0**

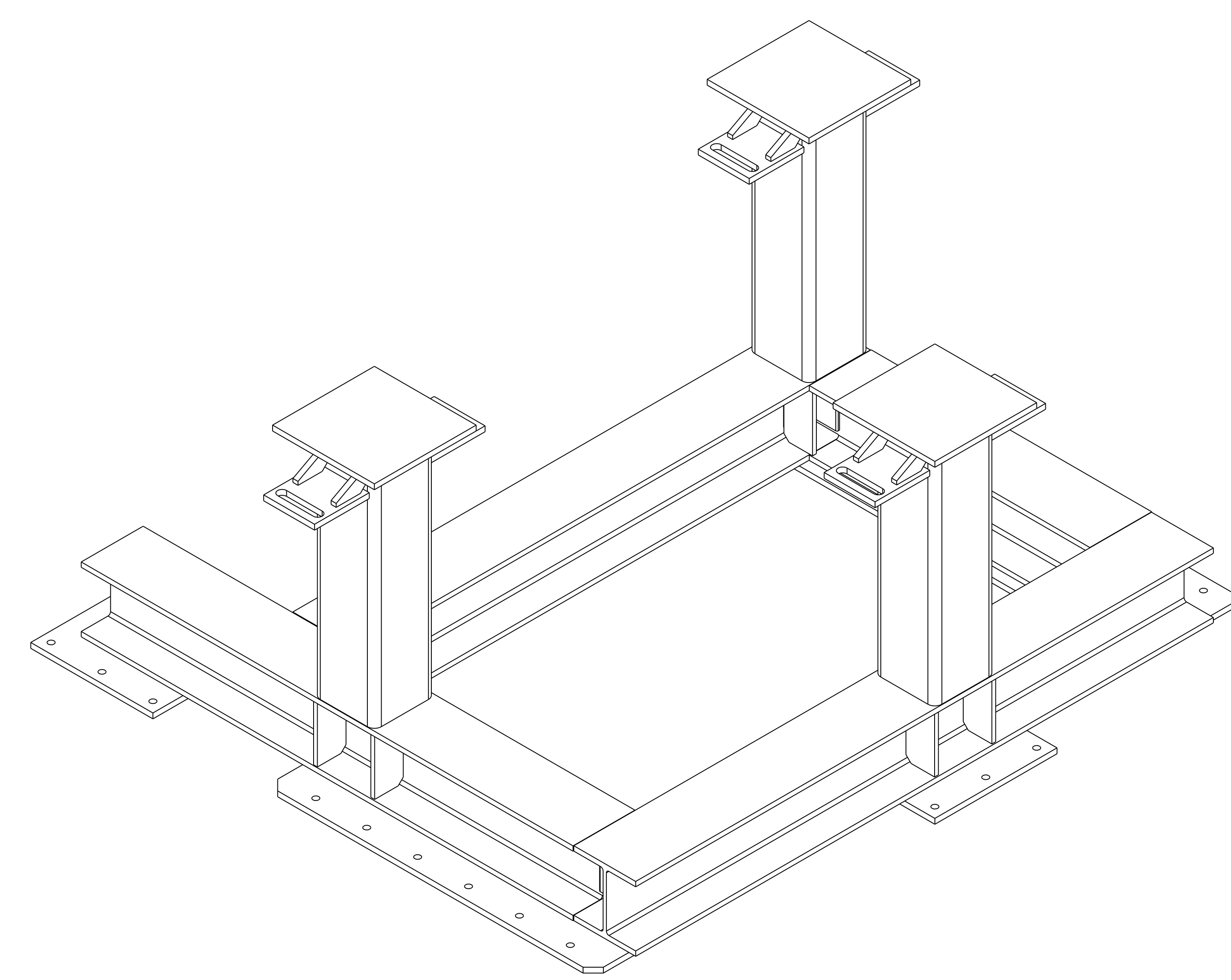
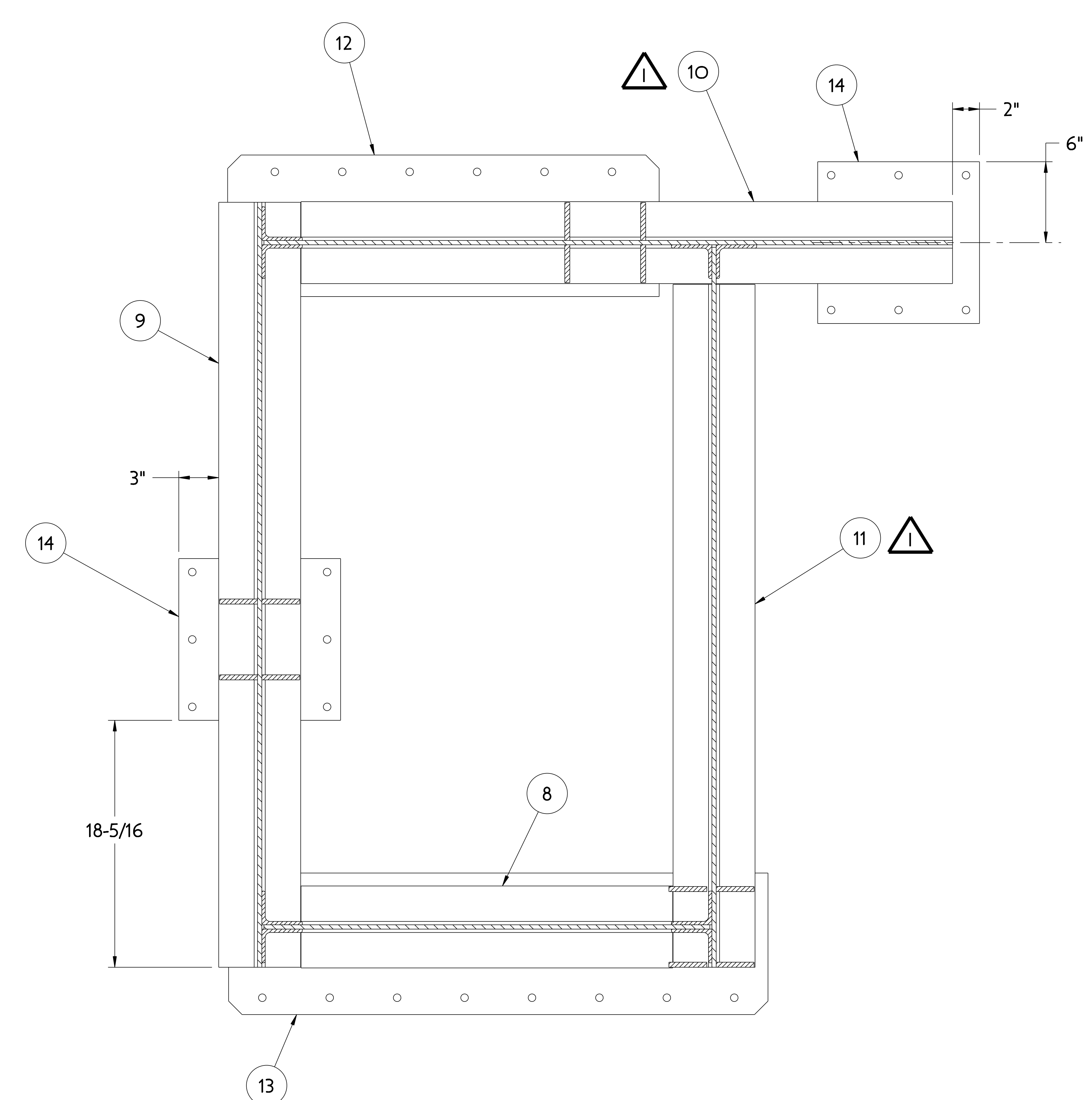
|                  |              |
|------------------|--------------|
| WEIGHT           | 1160.8 lbs   |
| MODEL NAME       | SE186-330-01 |
| WELDING ENGINEER |              |

|                                                                     |                                                                                                                             |                                                                                                                                                                   |
|---------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| COMPUTER GENERATED DRAWING<br>MANUAL CHANGES NOT PERMITTED<br>Pro E | CENTRAL FILES:<br>UNLESS OTHERWISE SPECIFIED<br>DIMENSIONS ARE IN INCHES<br>MACHINE SURFACES<br>BREAK SHARP EDGES .005/.020 | PRINCETON PLASMA PHYSICS LABORATORY<br>NATIONAL COMPACT STELLARATOR EXPERIMENT<br>STELLARATOR CORE<br>TOOLING DESIGN & FABRICATION<br>MCWF SUPPORT CART WELDMENTS |
| DO NOT VERIFY INFORMATION BY SCALING DRAWING                        | TOLERANCES NON-CUMULATIVE<br>DECIMAL-INCH FRACTIONS<br>.XX +/- .005<br>.XXX +/- .005<br>ANGULAR +/- 0°15'                   | DSN: J. RUSHINSKI 8-2-2007<br>CHK: M. COLE 8-2-2007<br>ENGR: T. BROWN 8-2-2007<br>SUPV: J. SIEGEL 8-2-2007                                                        |
| NEXT ASSEMBLY                                                       |                                                                                                                             | DRAWING NO:<br><b>SE186-330</b>                                                                                                                                   |
|                                                                     |                                                                                                                             | SHEET 2 OF 3 REV 1.0                                                                                                                                              |

NCSX-SE186-330



|     |          |    |    |     |          |      |
|-----|----------|----|----|-----|----------|------|
| NO. | REVISION | BY | CH | SUP | APPROVED | DATE |
|     |          |    |    |     |          |      |



O2 ASSEMBLY  
REFERENCE ISOMETRIC

SECTION D-D - O2 ASSEMBLY  
REFER TO O1 ASSEMBLY FOR ADDITIONAL  
DIMENSIONS AND WELDS NOT SHOWN HERE

RELEASED FOR  
FABRICATION / INSTALLATION  
PPPL Drafting

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

RELEASE LEVEL: Fabrication  
DWG VERSION NO: 0

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

|                                                                     |                                                                                                                                                                                                     |                                                                                 |                         |
|---------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------|-------------------------|
| COMPUTER GENERATED DRAWING<br>MANUAL CHANGES NOT PERMITTED<br>Pro E | CENTRAL FILES:<br>UNLESS OTHERWISE SPECIFIED                                                                                                                                                        | PRINCETON PLASMA PHYSICS LABORATORY<br>NATIONAL COMPACT STELLARATOR EXPERIMENT  |                         |
| DO NOT VERIFY INFORMATION BY SCALING DRAWING                        | DIMENSIONS ARE IN INCHES<br>MACHINE SURFACES<br>BREAK SHARP EDGES .005/.020                                                                                                                         | STELLARATOR CORE<br>TOOLING DESIGN & FABRICATION<br>MCWF SUPPORT CART WELDMENTS |                         |
| NEXT ASSEMBLY                                                       | TOLERANCES NON-CUMULATIVE<br>DECIMAL-INCH FRACTIONS<br>.X +/- .000 0°-120° +/- .010<br>.XX +/- .005 120°-120° +/- .010<br>.XXX +/- .005 120°-120° +/- .010<br>ANGULAR +/- .0°-15° OVER 120° +/- .1° | DSN: L. MORRIS 8-2-2007                                                         | DRAWING NO: SE186-330   |
|                                                                     |                                                                                                                                                                                                     | CHK: M. COLE 8-2-2007                                                           | ENGR: T. BROWN 8-2-2007 |
|                                                                     |                                                                                                                                                                                                     | SUPV: J. SIEGEL 8-2-2007                                                        | SHEET 3 OF 3 REV 1.0    |

NCSX-SE186-330