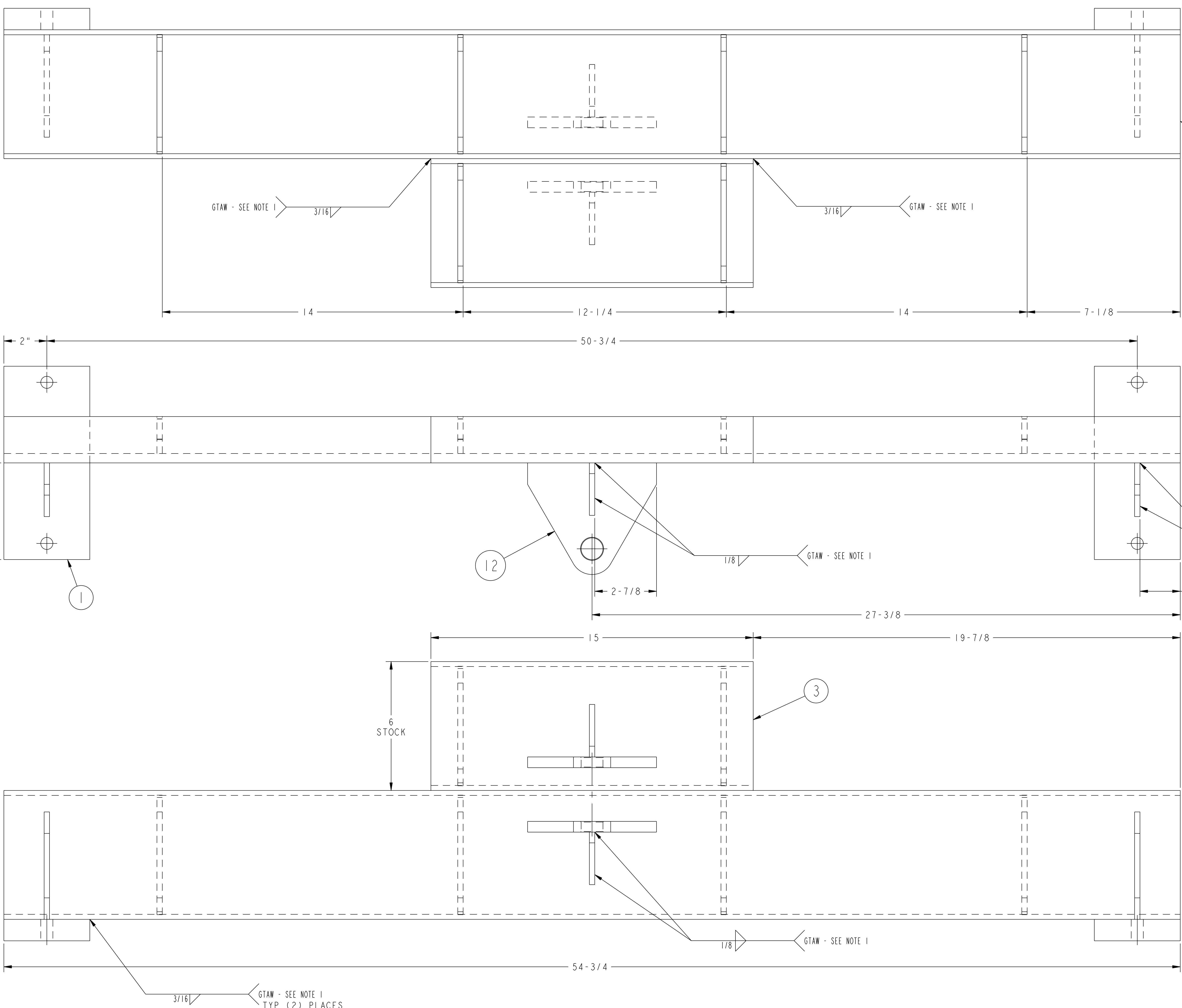
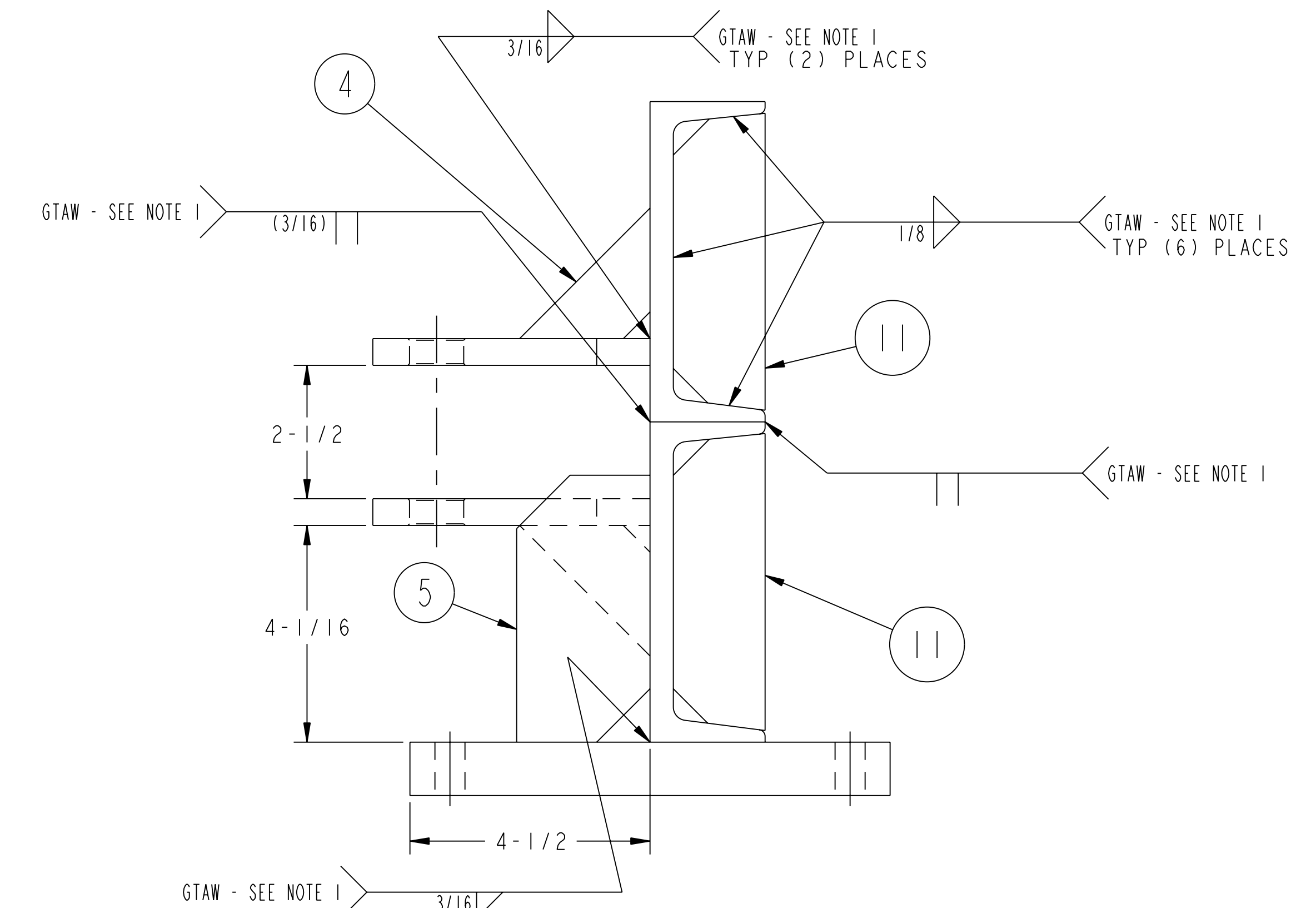


NO.	REVISION	BY	CH	SUP	APPROVED	DATE



NOTES

1. WELDING SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF AWS D1.1 OR PPPL PROCEDURE ENG-037. VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH THE ACCEPTANCE CRITERIA OF AWS D1.1 Section 6.
2. SAND BLAST AND APPLY 2 COATS "SAFETY YELLOW" PAINT.



01 ASSEMBLY - ADJUSTER BAR SUPPORT STRUCTURE WELDMENT

**RFD-18-001 permitted either GTAW or GMAW welds. See RFD-18-001 for details)**

**RELEASED FOR FABRICATION / INSTALLATION**  
PPPL Drafting:

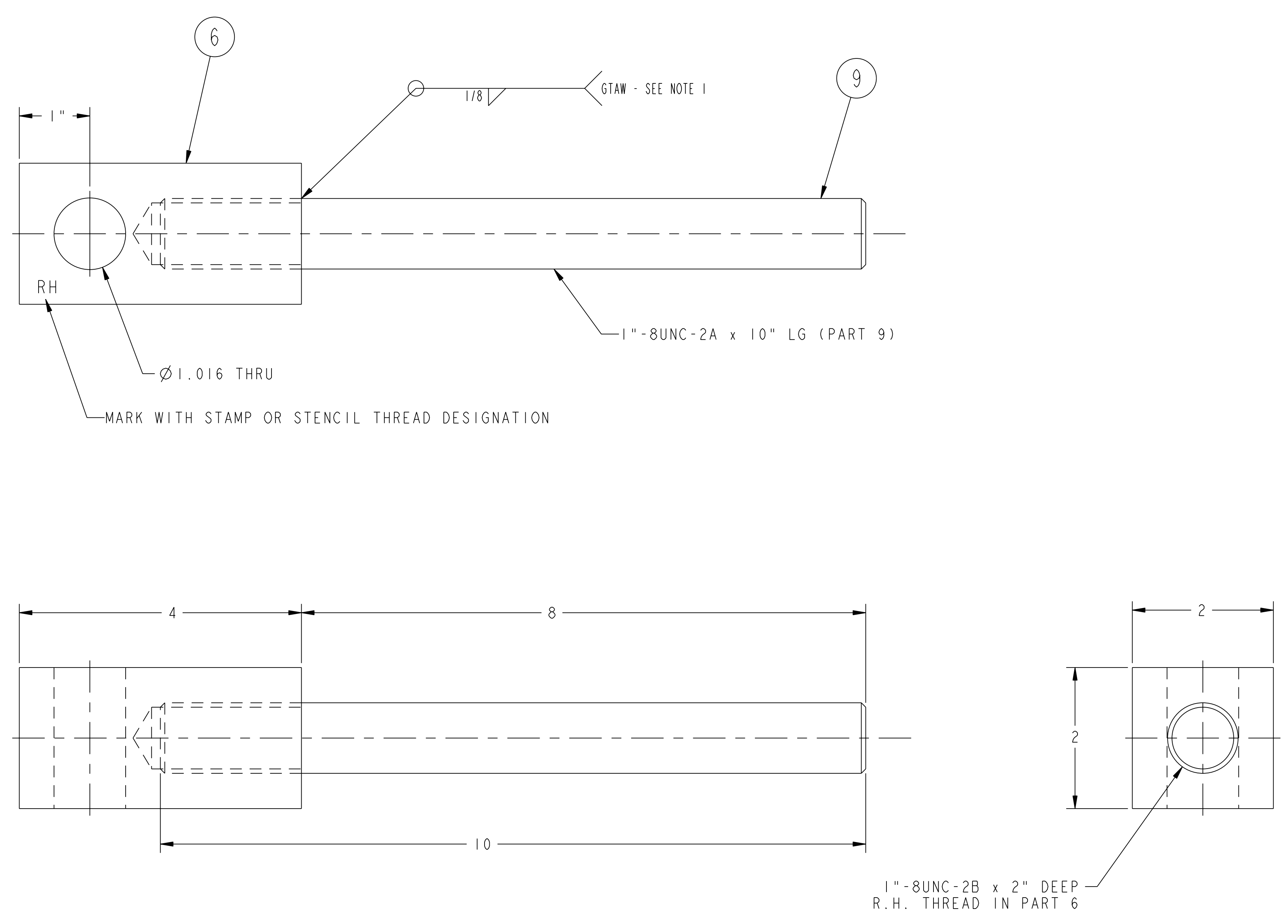
**RELEASE LEVEL: Fabrication**  
**DWG VERSION NO: 3**

QTY	PART NO.	DRAWING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY REQ'D
2	12	SE186-326-3	SUPPORT CART PULL PLATE	ASTM A36	
6	11	THIS DWG	CHANNEL STIFFENER GUSSET	ASTM A36	
1	10	THIS DWG	THREADED ROD - 1"-8UNC-2A x 10" LG L.H. THREAD	ASTM A108	
1	9	THIS DWG	THREADED ROD - 1"-8UNC-2A x 10" LG R.H. THREAD	ASTM A108	
1	8	THIS DWG	ADJUSTER BLOCK - R.H. AND L.H. THREAD	ASTM A36	1
1	7	THIS DWG	ADJUSTER BAR THREADED BLOCK - L.H. THREAD	ASTM A36	
1	6	THIS DWG	ADJUSTER BAR THREADED BLOCK - R.H. THREAD	ASTM A36	
2	5	THIS DWG	STIFFENER GUSSET	ASTM A36	
2	4	THIS DWG	GUSSET	ASTM A36	
1	3	THIS DWG	PUSHER SUPPORT CHANNEL - SHORT - 6" x 25# CHANNEL	ASTM A36	
1	2	THIS DWG	PUSHER SUPPORT CHANNEL - LONG - 6" x 25# CHANNEL	ASTM A36	
2	1	THIS DWG	FOOT PLATE	ASTM A36	
			ADJUSTER BAR WELDMENT - L.H. THREAD		1
			ADJUSTER BAR WELDMENT - R.H. THREAD		1
			ADJUSTER BAR SUPPORT STRUCTURE WELDMENT		1

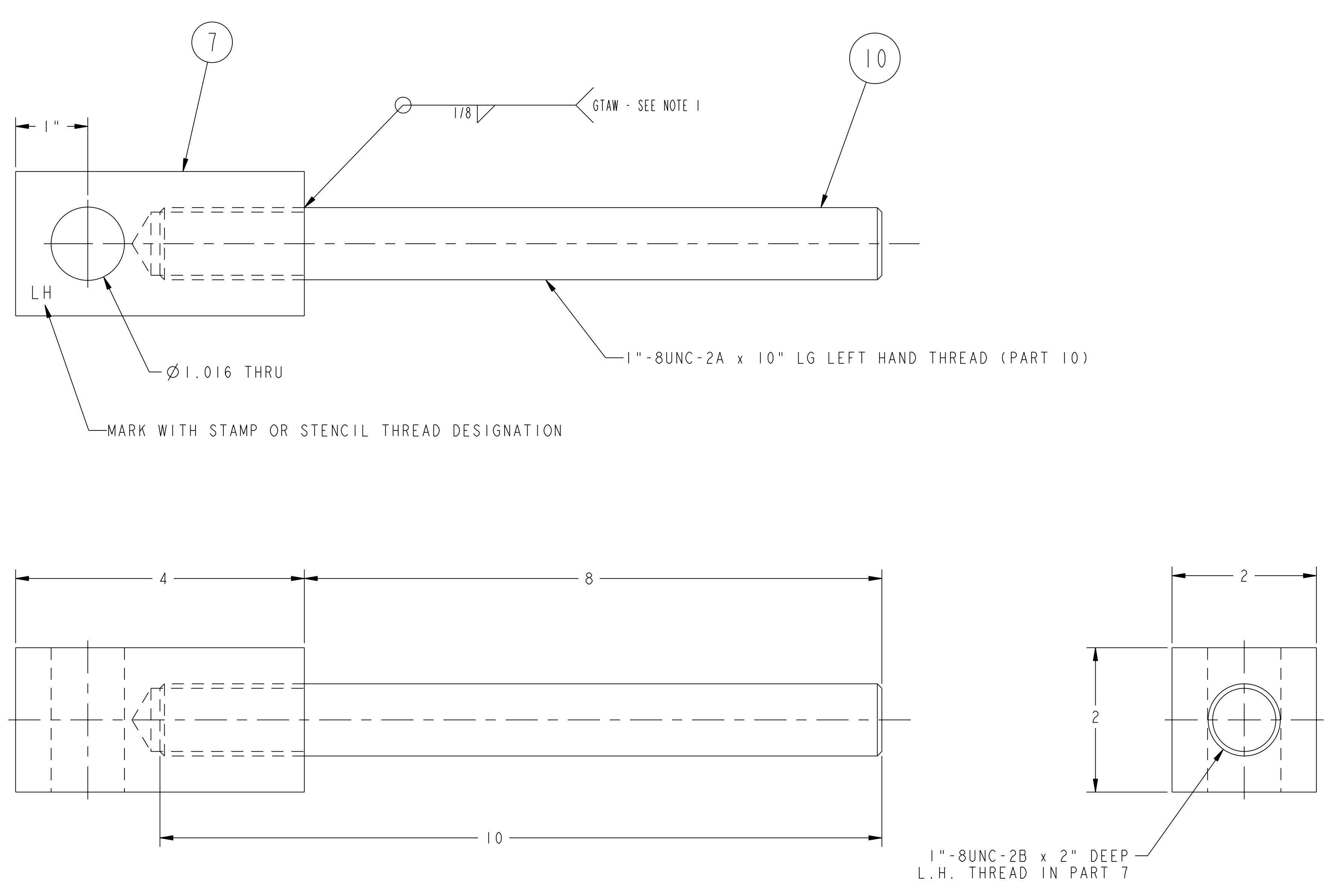
WEIGHT	MODEL NAME	WELDING ENGINEER	COMPUTER GENERATED DRAWING	CENTRAL FILES:	PRINCETON PLASMA PHYSICS LABORATORY
107.7 lbs	SE186-333-01	G. GETTELFINGER 8-2-2007	MANUAL CHANGES NOT PERMITTED	UNLESS OTHERWISE SPECIFIED	NATIONAL COMPACT STELLARATOR EXPERIMENT
			DO NOT VERIFY INFORMATION BY SCALING DRAWING	DIMENSIONS ARE IN INCHES	STELLARATOR CORE
				BREAK SHARP EDGES .005/.020	TOOLING DESIGN AND FABRICATION
				TOLERANCES NON-CUMULATIVE	ADJUSTER BAR SUPPORT STRUCTURE WELDMENTS AND DETAILS
				DECIMAL-INCH FRACTIONS	DSN: L. MORRIS 8-2-2007
				XXX .005 72"-120" .1"-1/16	CHK: M. COLE 8-2-2007
				ANGULAR .1"-15" OVER 120"-112	ENGR: T. BROWN 8-2-2007
					SUPV: J. SIEGEL 8-2-2007
					DRAWING NO: SE186-333
					SHEET 1 OF 3
					REV 0

NCSX-SE186-333

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



02 ASSEMBLY - ADJUSTER BAR WELDMENT - R.H. THREAD



03 ASSEMBLY - ADJUSTER BAR WELDMENT - L.H. THREAD

**RELEASED FOR FABRICATION / INSTALLATION**  
PPPL Drafting:

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

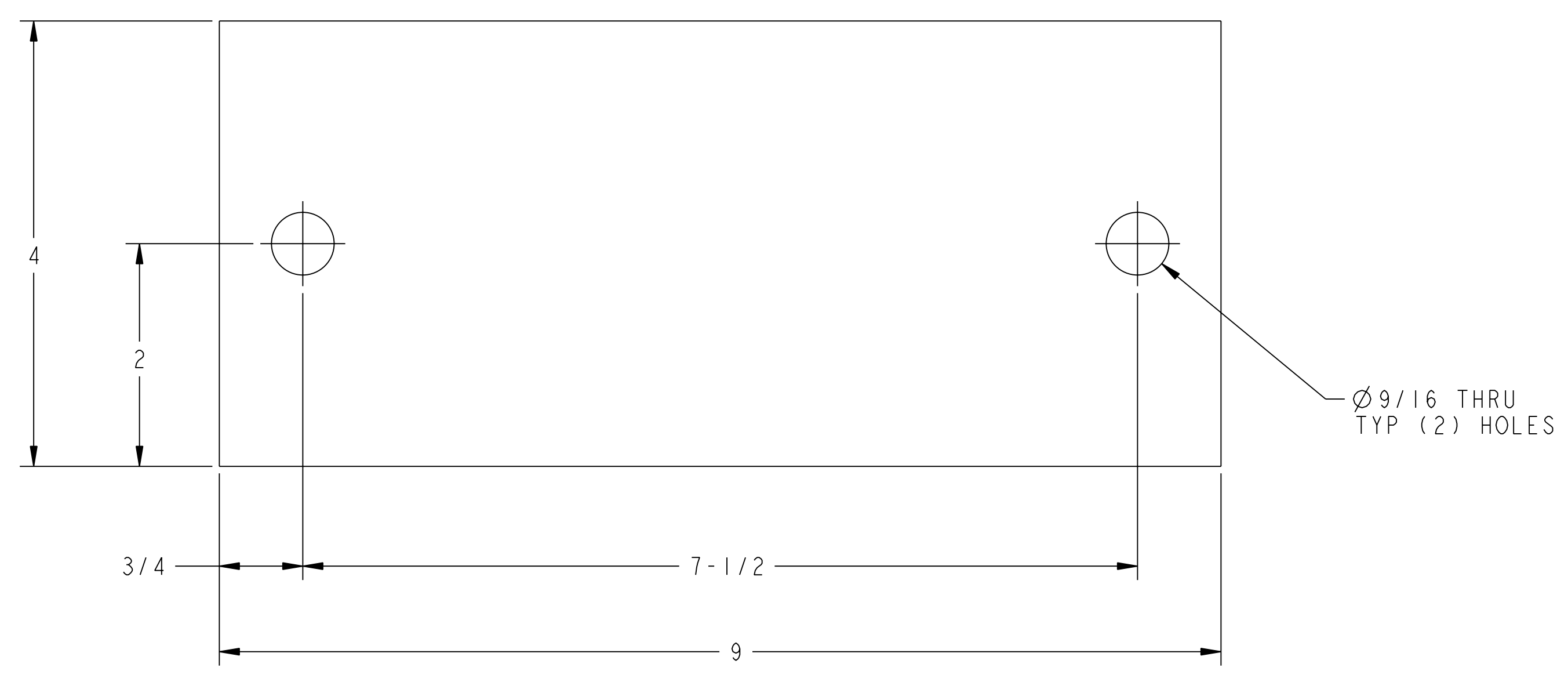
RELEASE LEVEL: Fabrication  
DWG VERSION NO: 3

WEIGHT	107.7 lbs
MODEL NAME	SE186-333-01
WELDING ENGINEER	G. GETTELFINGER 8-2-2007

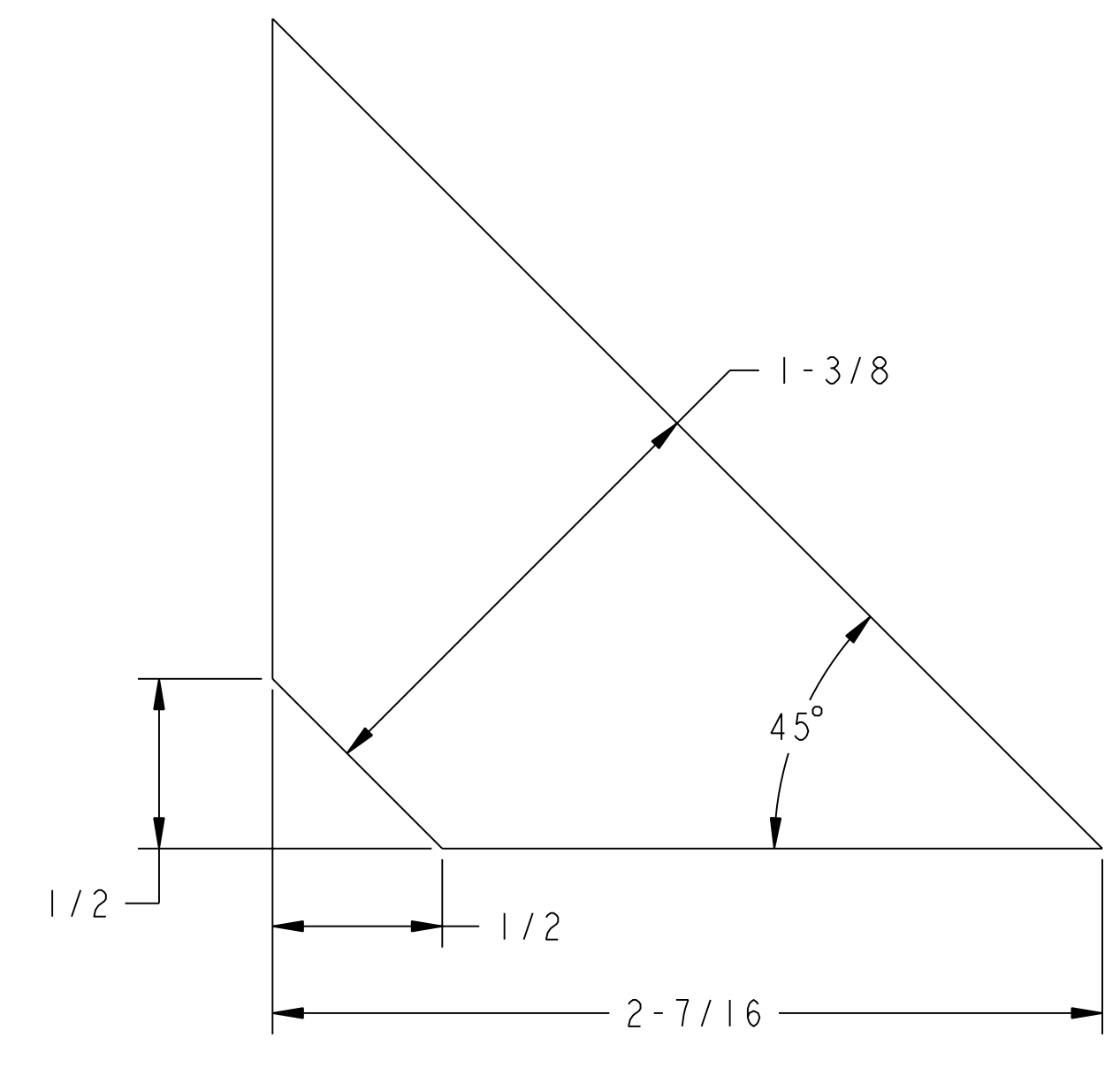
COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY <b>NATIONAL COMPACT STELLARATOR EXPERIMENT</b> STELLARATOR CORE TOOLING DESIGN AND FABRICATION ADJUSTER BAR SUPPORT STRUCTURE WELDMENTS AND DETAILS	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX ±.000 .XXX ±.005 ANGULAR ±.0°-15°	DSN: L. MORRIS CHK: M. COLE ENGR: T. BROWN SUPV: J. SIEGEL	8-2-2007 8-2-2007 8-2-2007 8-2-2007
NEXT ASSEMBLY		DRAWING NO:	<b>SE186-333</b>
		SHEET 2 OF 3	REV D. 3

NCSX-SE186-333

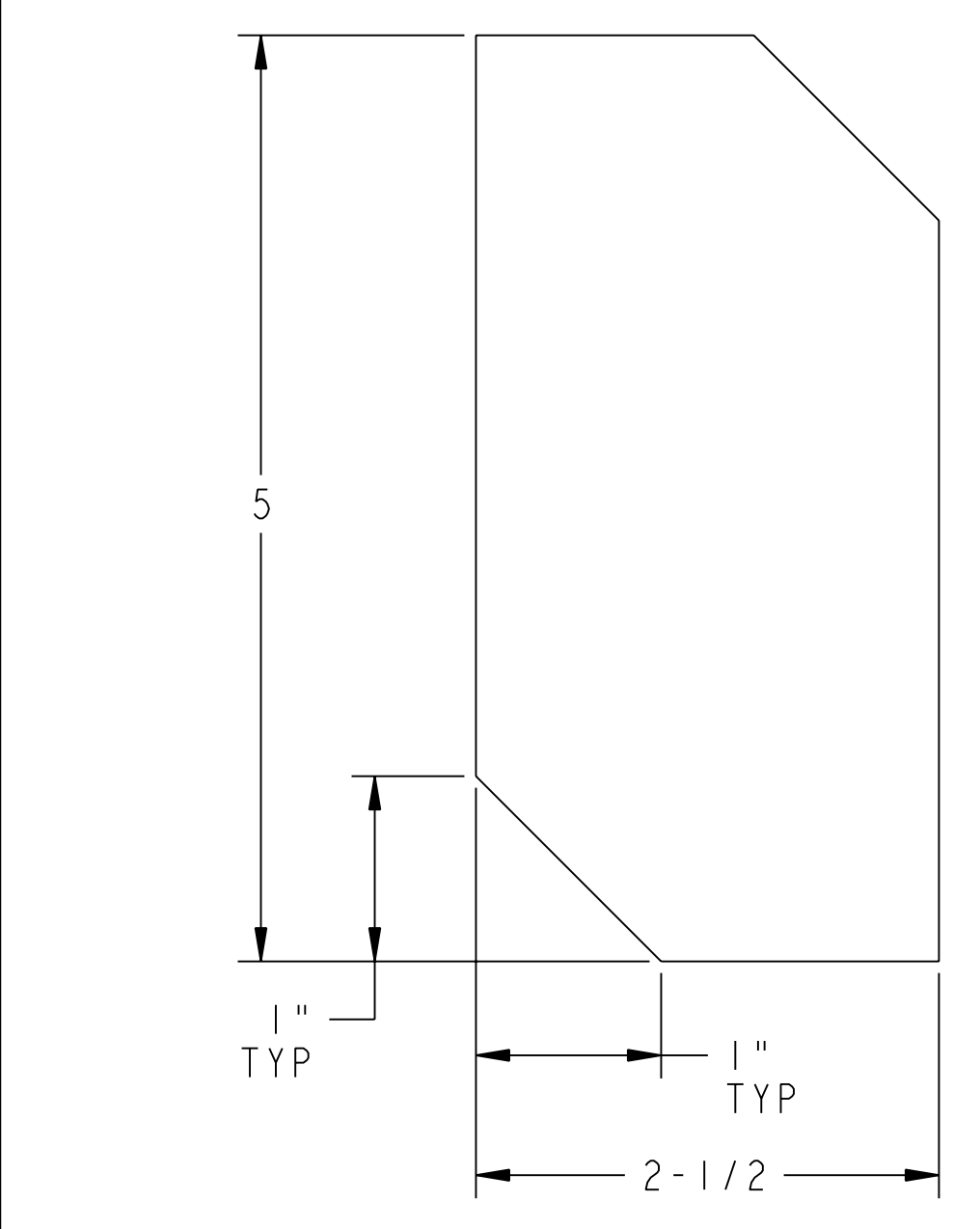
NO.	REVISION	BY	CH	SUP	APPROVED	DATE



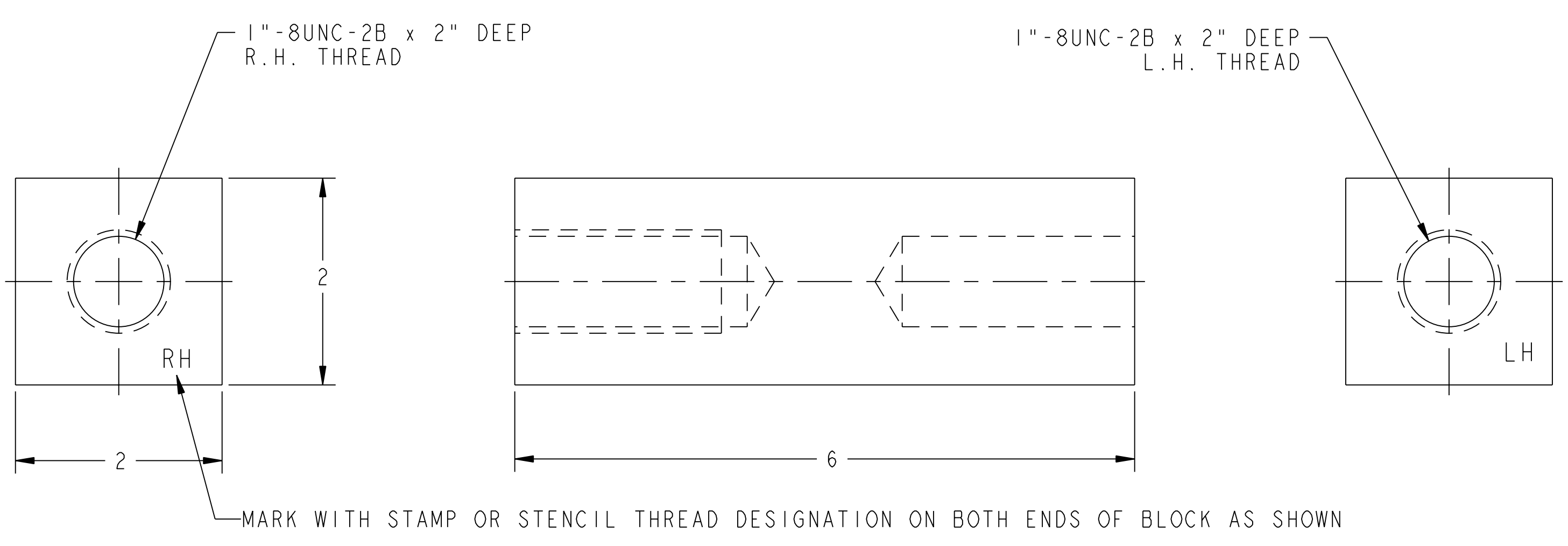
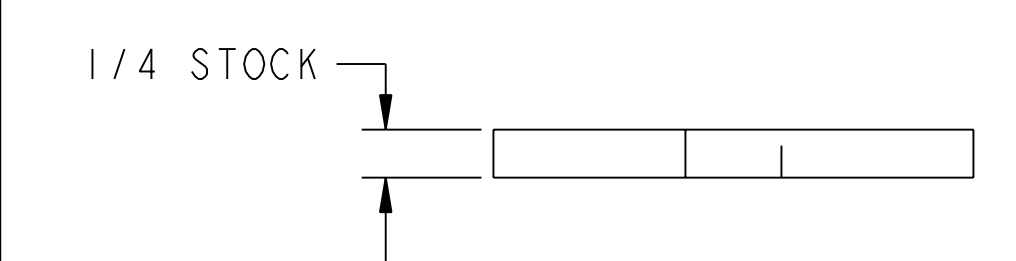
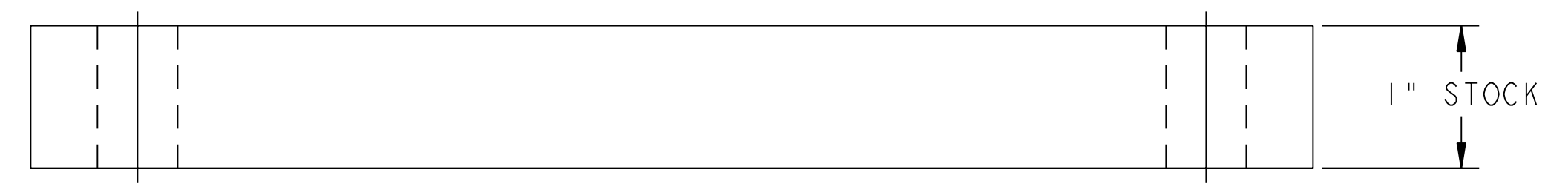
1 FOOT PLATE



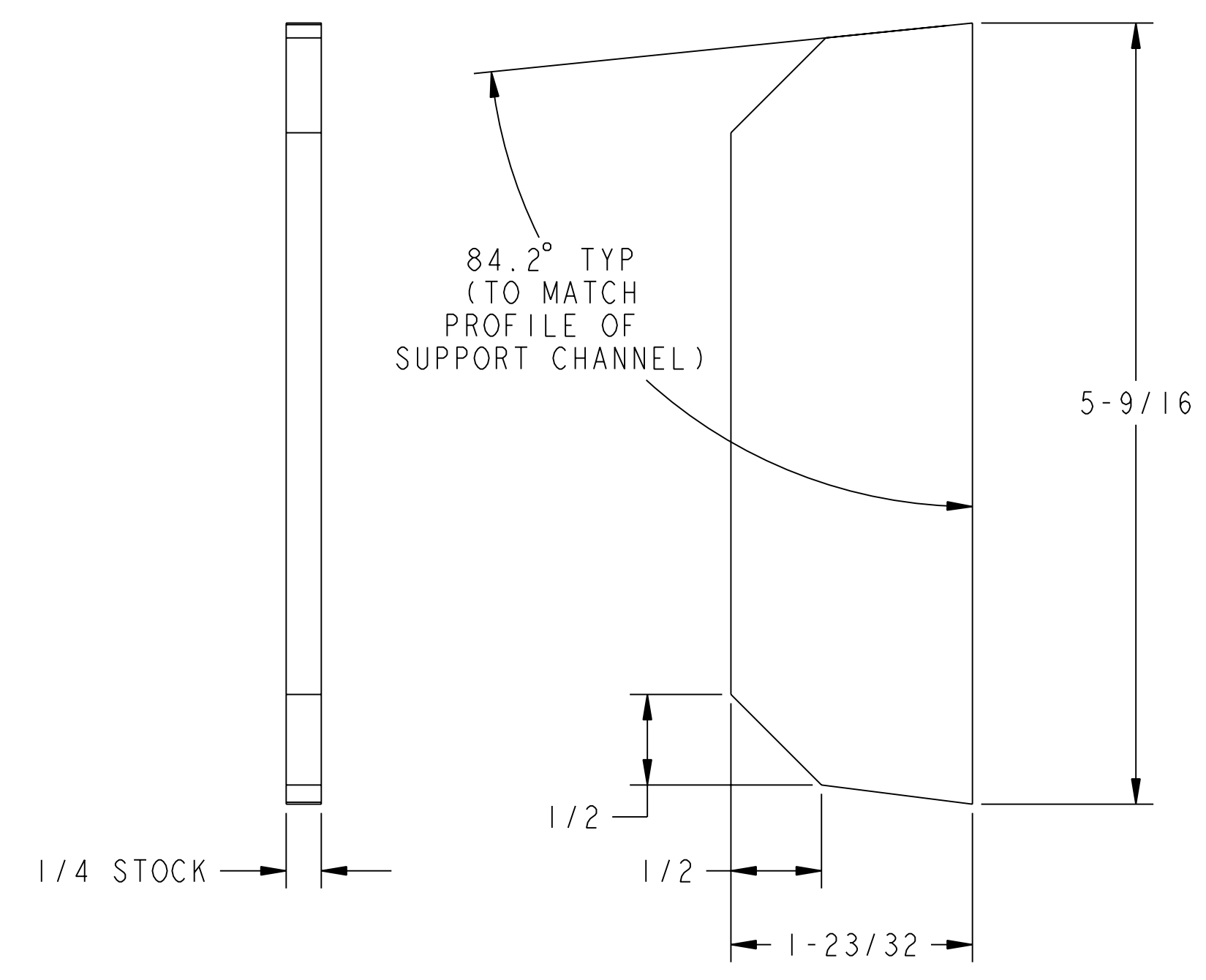
4 GUSSET



5 STIFFENER GUSSET



8 ADJUSTER BAR THREADED BLOCK - R.H. AND L.H. THREADS



11 CHANNEL STIFFENER GUSSET

**RELEASED FOR FABRICATION / INSTALLATION**  
PPPL Drafting

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

RELEASE LEVEL: Fabrication  
DWG VERSION NO: 1

WEIGHT  
6.1 lbs  
MODEL NAME  
SE186-333-03  
WELDING ENGINEER

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY <b>NATIONAL COMPACT STELLARATOR EXPERIMENT</b>	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	STELLARATOR CORE TOOLING DESIGN AND FABRICATION ADJUSTER BAR SUPPORT STRUCTURE WELDMENTS AND DETAILS	
NEXT ASSEMBLY	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX +/- .000 0°-120° +/- .010 .XXX +/- .005 120°-120° +/- .010 ANGULAR +/- 0°-15° OVER 120° +/- .125	DSN: L. MORRIS CHK: M. COLE ENGR: T. BROWN SUPV: J. SIEGEL	8-2-2007 8-2-2007 8-2-2007 8-2-2007
		DRAWING NO: <b>SE186-333</b>	SHEET 3 OF 3 REV D. 3

NCSX-SE186-333