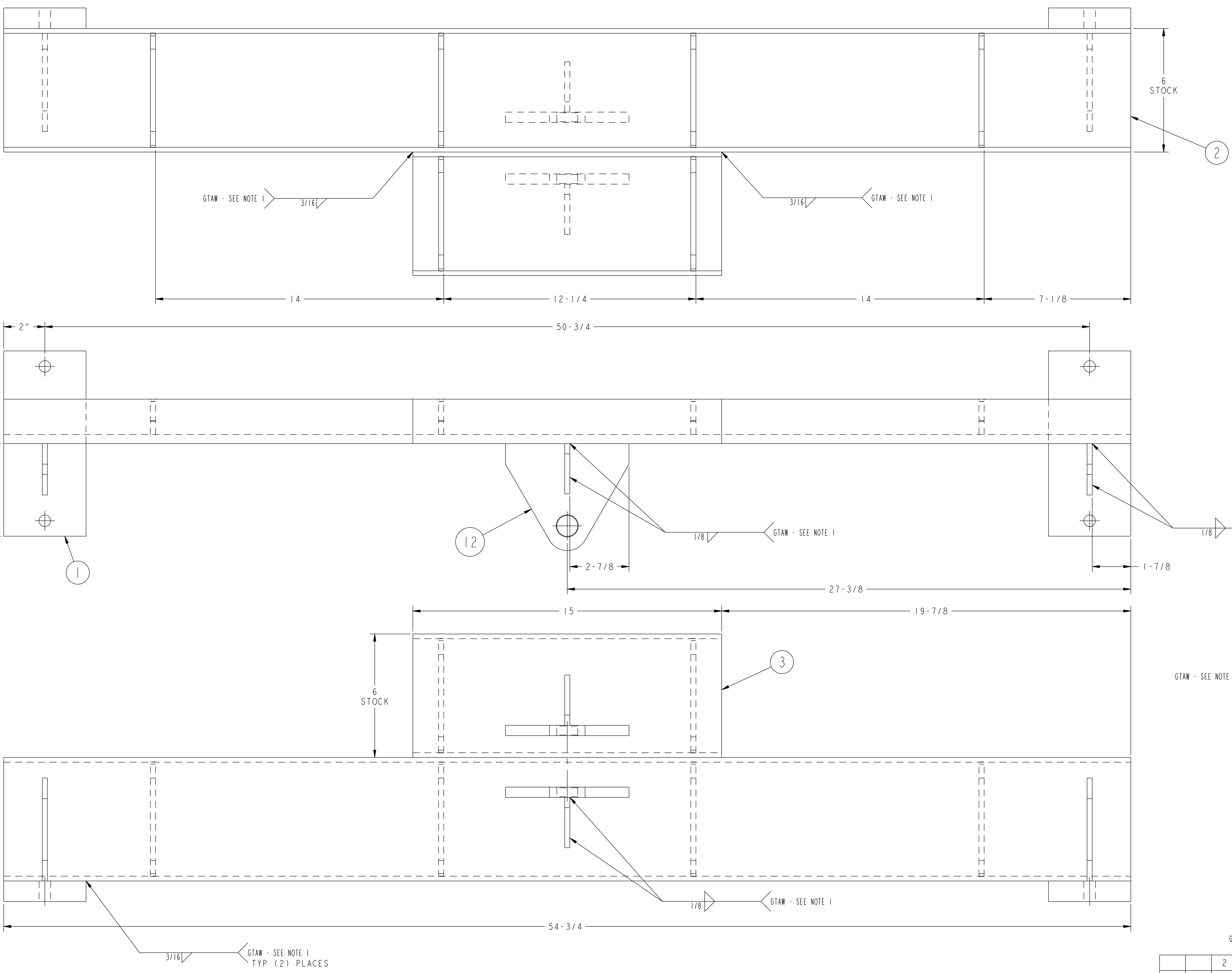
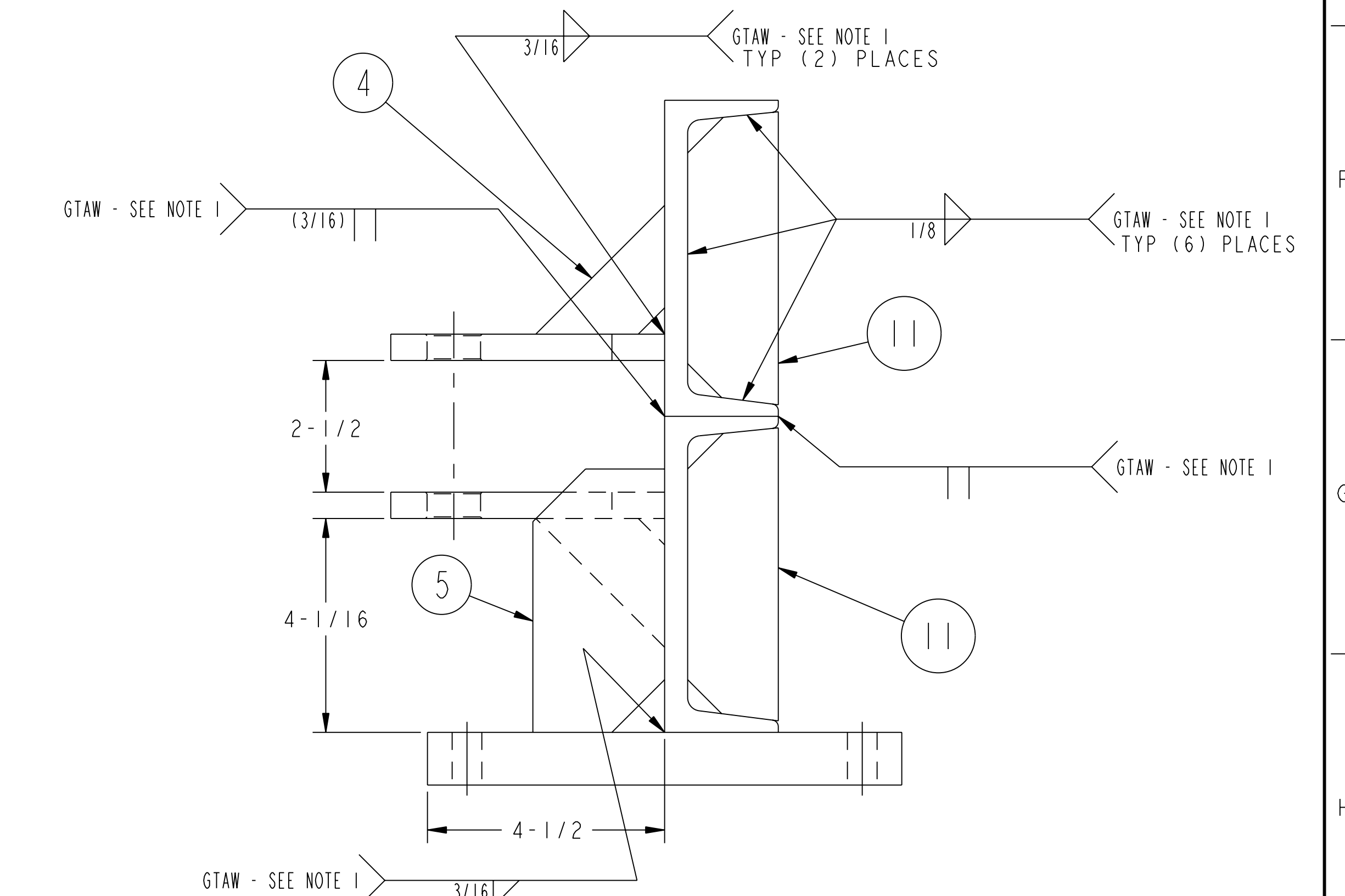


NO.	REVISION	BY	CH	SUP	APPROVED	DATE
1	REVISED PER ECN-5326	LM	TB	JS	T. BROWN	1-29-08



- 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-18-004 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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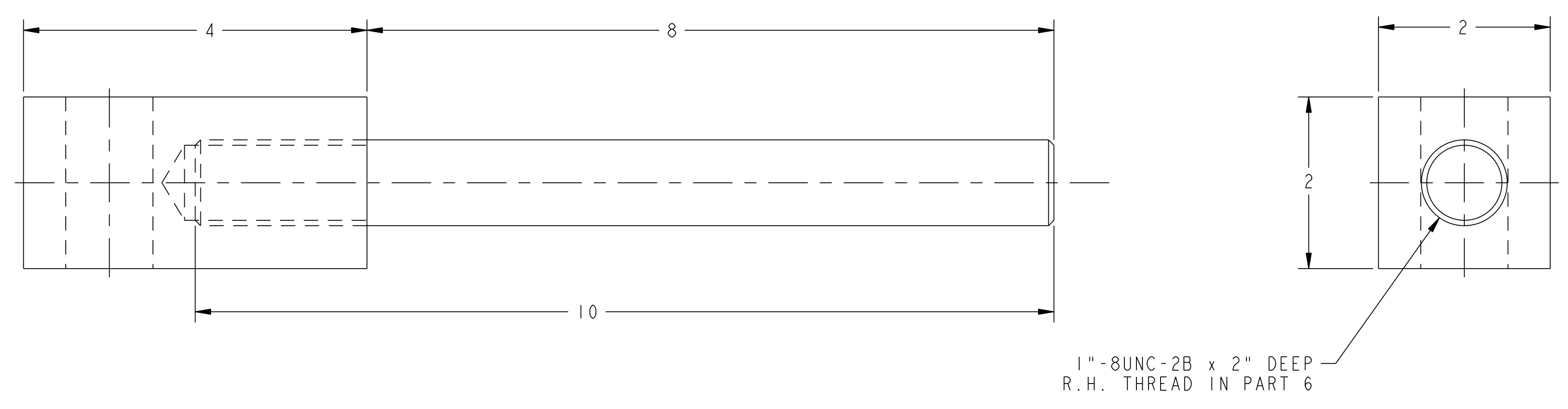
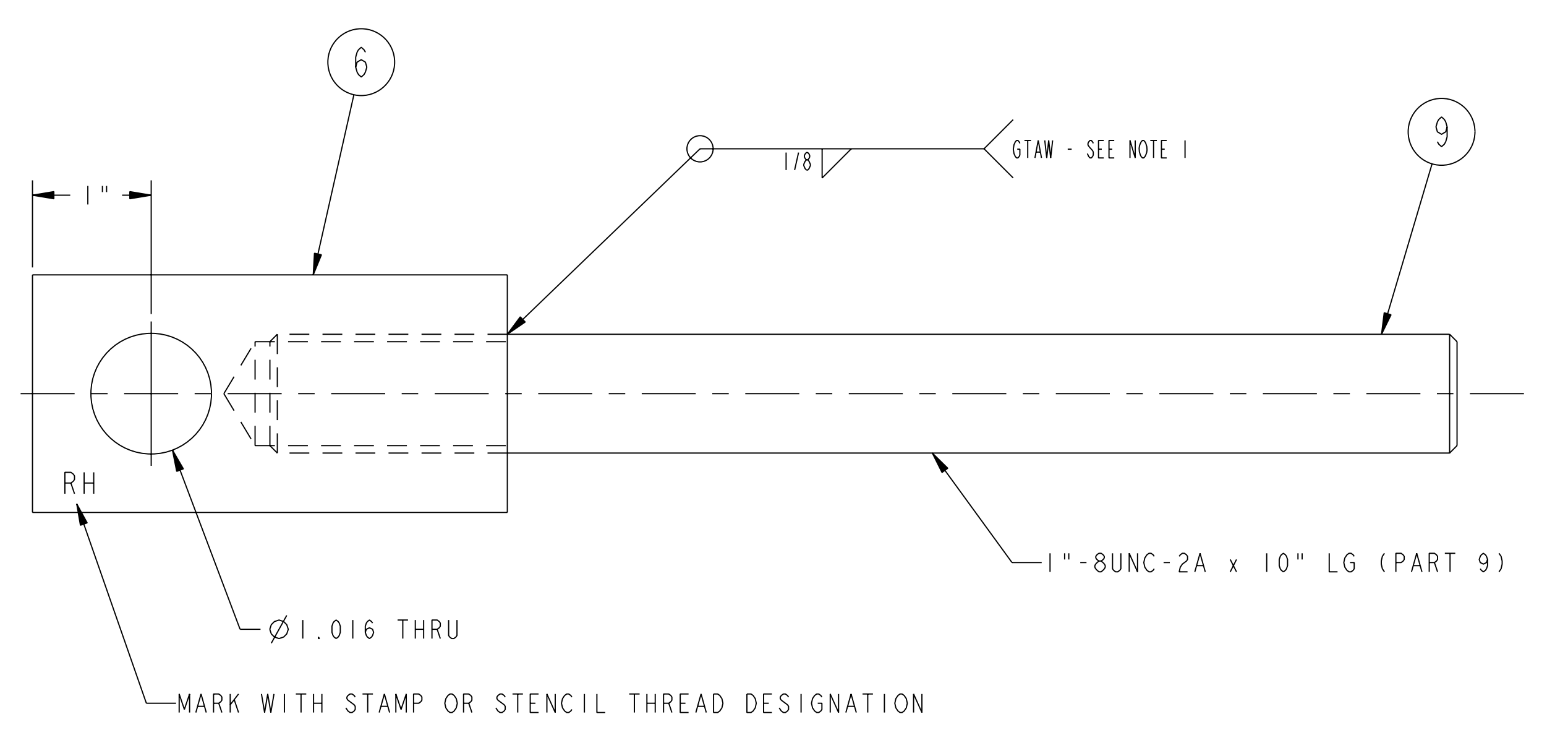
QTY	PART NO.	DRAWING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY REQ'D
	2	12	SE186-326-3	SUPPORT CART PULL PLATE	ASTM A36
	6	11	THIS DWG	CHANNEL STIFFENER GUSSET	ASTM A36
1		10	THIS DWG	THREADED ROD - 1"-8UNC-2A x 10" LG L.H. THREAD	ASTM A108
1		9	THIS DWG	THREADED ROD - 1"-8UNC-2A x 10" LG R.H. THREAD	ASTM A108
		8	THIS DWG	ADJUSTER BLOCK - R.H. AND L.H. THREAD	ASTM A36
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 13# CHANNEL	ASTM A36
	1	2	THIS DWG	PUSHER SUPPORT CHANNEL - LONG - 6" x 13# CHANNEL	ASTM A36
	2	1	THIS DWG	FOOT PLATE	ASTM A36
			THIS DWG	ADJUSTER BAR WELDMENT - L.H. THREAD	
			THIS DWG	ADJUSTER BAR WELDMENT - R.H. THREAD	
			THIS DWG	ADJUSTER BAR SUPPORT STRUCTURE WELDMENT	



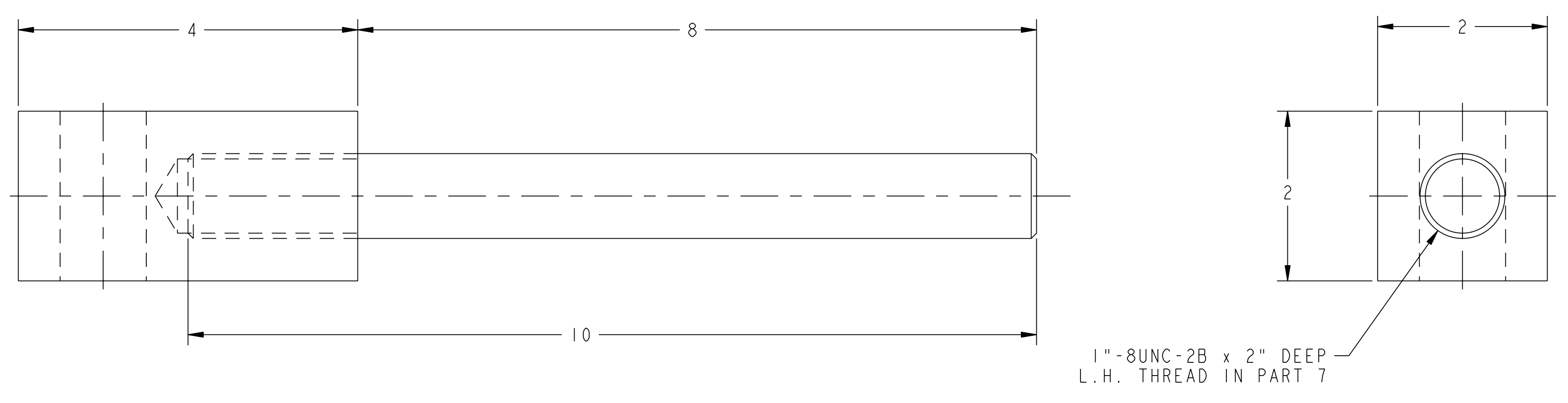
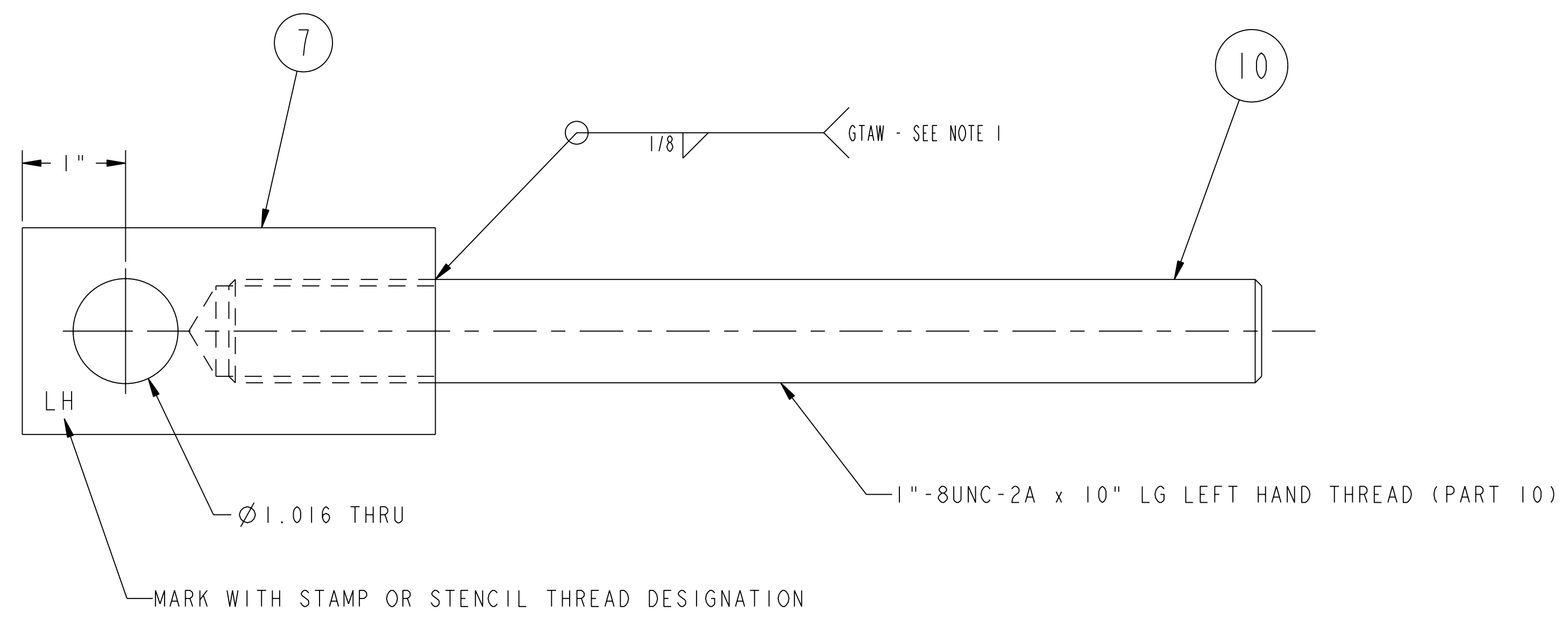
WEIGHT 107.7 lbs	MODEL NAME SE186-333-01	WELDING ENGINEER G. GETTELFINGER 8-2-2007	COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY STELLARATOR CORE TOOLING DESIGN AND FABRICATION ADJUSTER BAR SUPPORT STRUCTURE WELDMENTS AND DETAILS
RELEASE LEVEL: Fabrication DWG VERSION NO: 3	NEXT ASSEMBLY	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX +/- .030 .XXX +/- .005 ANGULAR +/- .015	DO NOT VERIFY INFORMATION BY SCALING DRAWING	DRAWN: L. MORRIS 8-2-2007 CHK: M. COLE 8-2-2007 ENGR: T. BROWN 8-2-2007 SUPV: J. SIEGEL 8-2-2007	DRAWING NO: SE186-333 SHEET 1 OF 3 REV I

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

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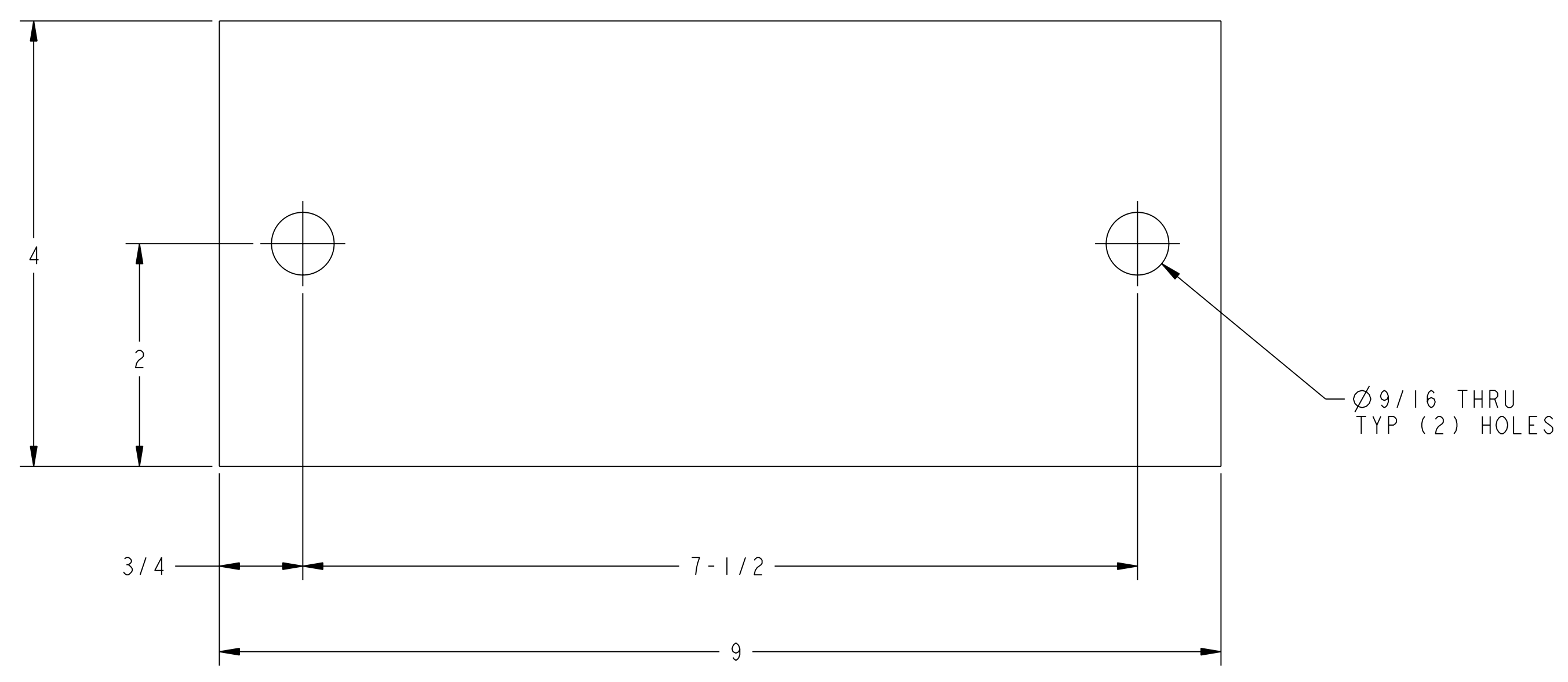
FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

RELEASE LEVEL: Fabrication
DWG VERSION NO: 3

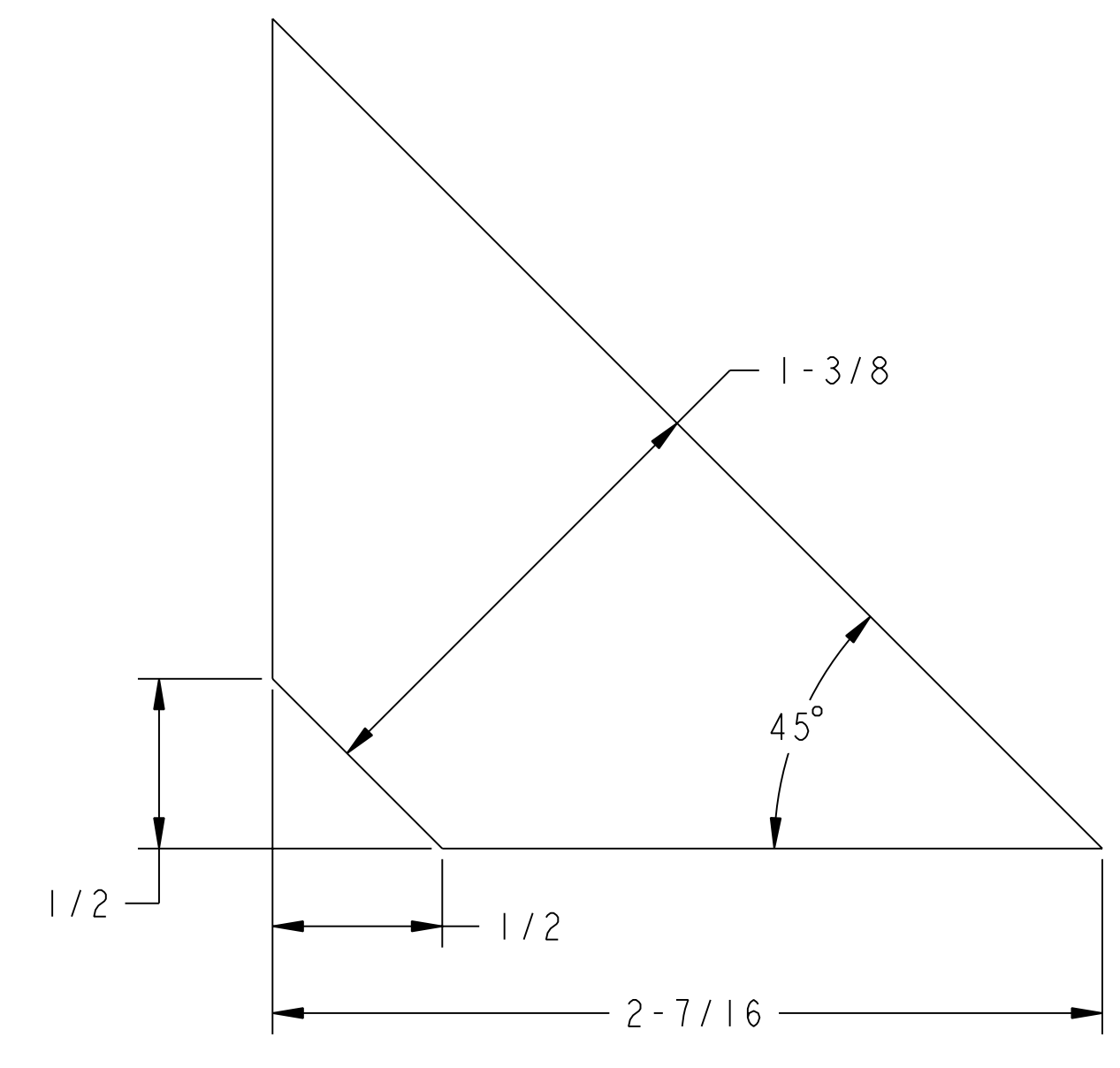
COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES:	PRINCETON PLASMA PHYSICS LABORATORY NATIONAL COMPACT STELLARATOR EXPERIMENT	
	UNLESS OTHERWISE SPECIFIED	STELLARATOR CORE TOOLING DESIGN AND FABRICATION ADJUSTER BAR SUPPORT STRUCTURE WELDMENTS AND DETAILS	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	DIMENSIONS ARE IN INCHES MACHINE SURFACES UNLESS OTHERWISE SPECIFIED	DSN: L. MORRIS	8-2-2007
NEXT ASSEMBLY	TOLERANCES NON-CUMULATIVE	CHK: M. COLE	8-2-2007
	DECIMAL - INCH FRACTIONS	ENGR: T. BROWN	8-2-2007
WEIGHT 107.7 lbs	ANGULAR ± 0°-15' OVER 120° ± 1/2	SUPV: J. SIEGEL	8-2-2007
MODEL NAME SE186-333-01	WELDING ENGINEER G. GETTELFINGER 8-2-2007	DRAWING NO: SE186-333	SHEET 2 OF 3
			REV 1.0

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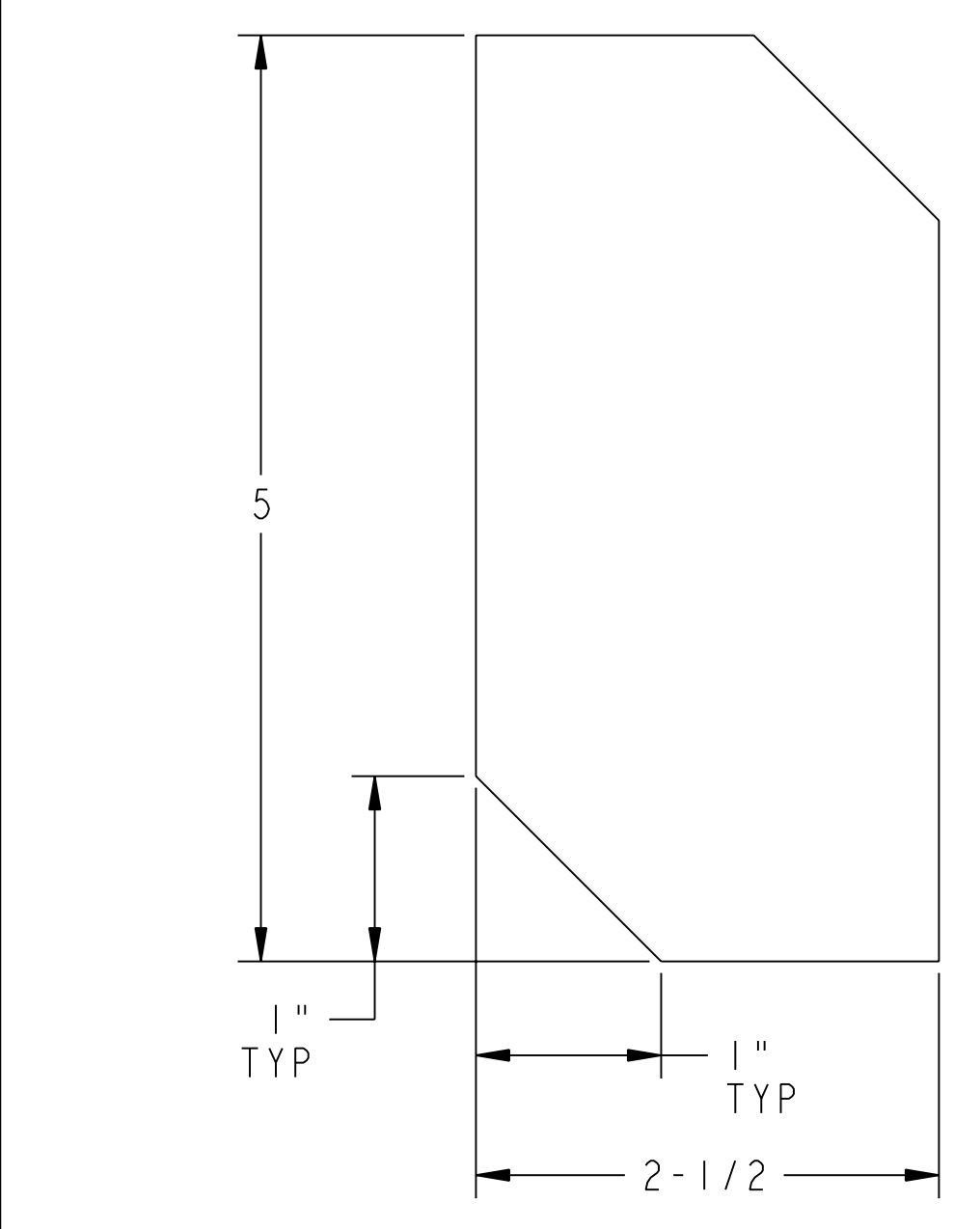
NO.	REVISION	BY	CH	SUP	APPROVED	DATE



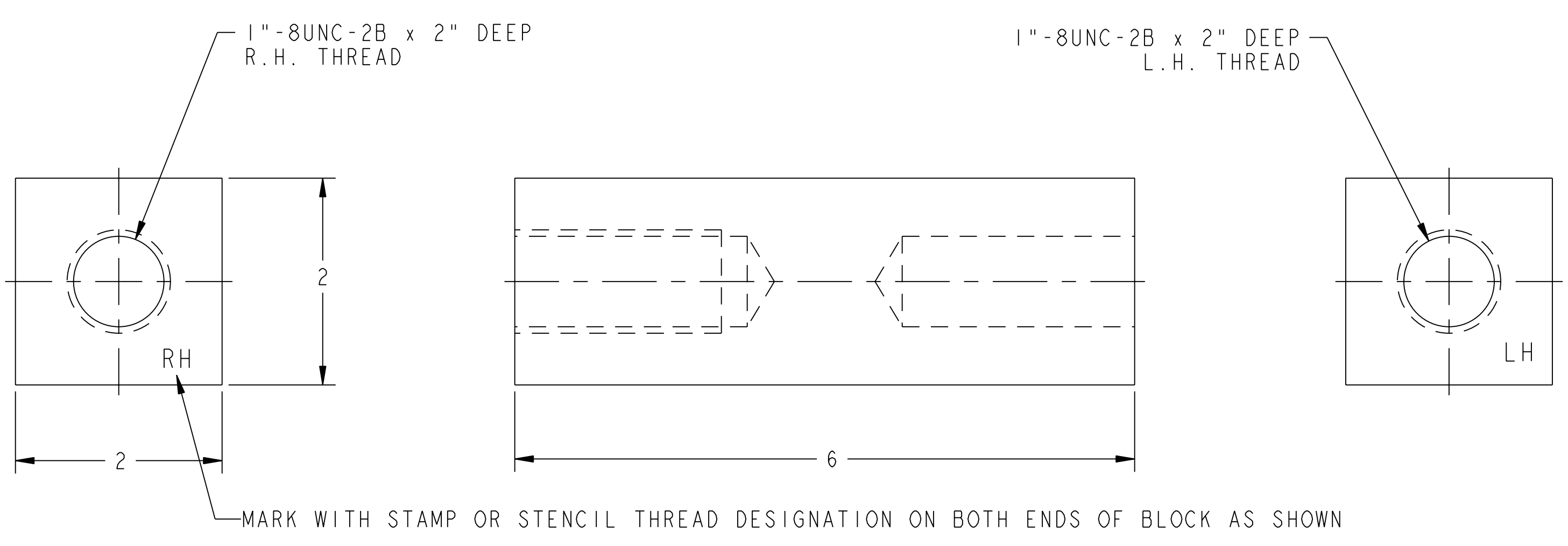
1 FOOT PLATE



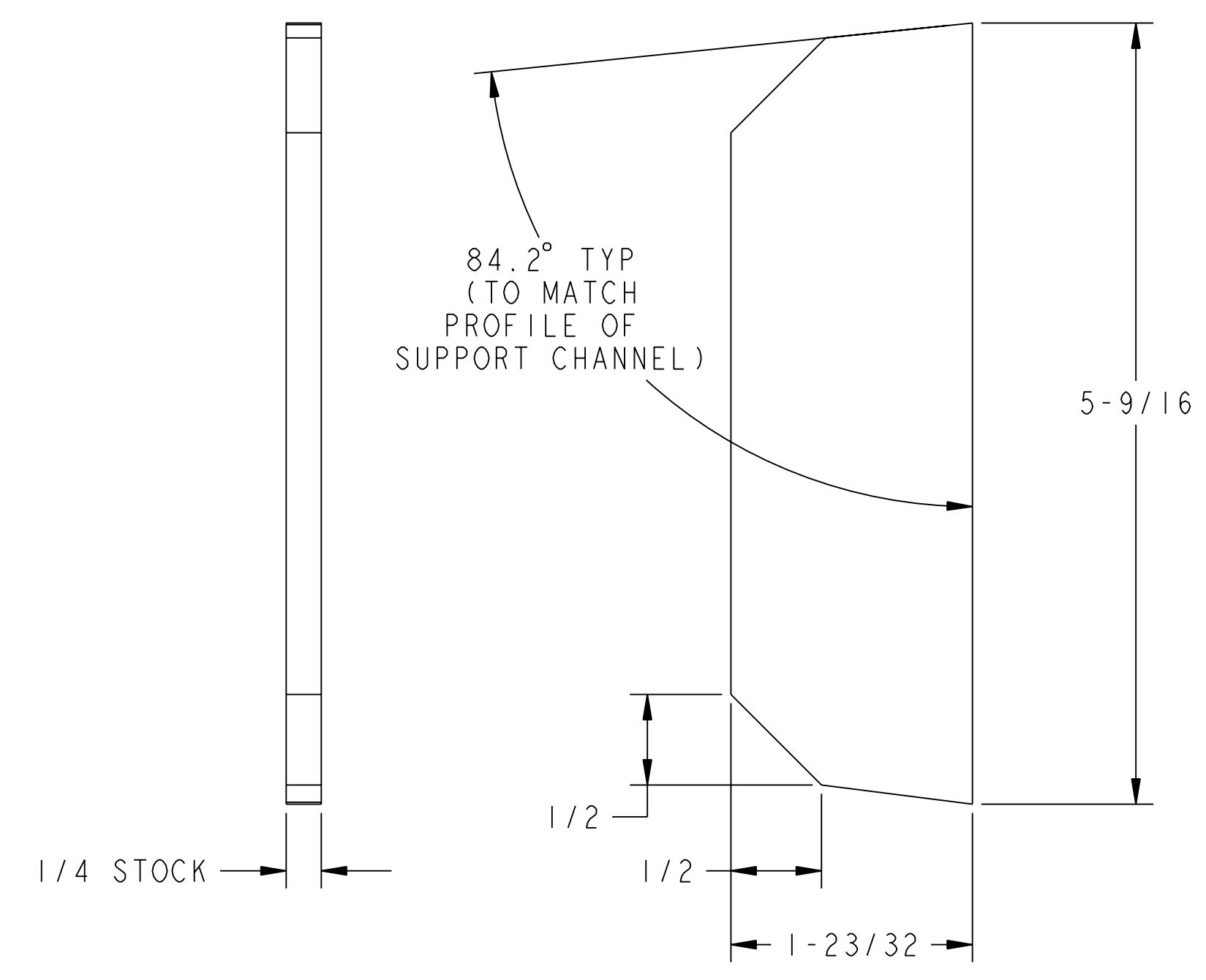
4 GUSSET



5 STIFFENER GUSSET



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



11 CHANNEL STIFFENER GUSSET

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PPPL Drafting

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

RELEASE LEVEL: Fabrication
DWG VERSION NO: 1

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES:	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY	
	UNLESS OTHERWISE SPECIFIED	NATIONAL COMPACT STELLARATOR EXPERIMENT	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	DIMENSIONS ARE IN INCHES MACHINE SURFACES	STELLARATOR CORE TOOLING DESIGN AND FABRICATION	
NEXT ASSEMBLY	BREAK SHARP EDGES .005/.020	ADJUSTER BAR SUPPORT STRUCTURE WELDMENTS AND DETAILS	
	TOLERANCES NON-CUMULATIVE	DSN: L. MORRIS	8-2-2007
WEIGHT 6.1 lbs	DECIMAL-INCH FRACTIONS	CHK: M. COLE	8-2-2007
	.XX +/- .000 0°-12° +/- .010	ENGR: T. BROWN	8-2-2007
MODEL NAME SE186-333-03	.XXX +/- .005 12°-120° +/- .100	SUPV: J. SIEGEL	8-2-2007
WELDING ENGINEER	ANGULAR +/- .0°-15° OVER 120° +/- .100	DRAWING NO:	SE186-333
		SHEET 3 OF 3	REV 1.0

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