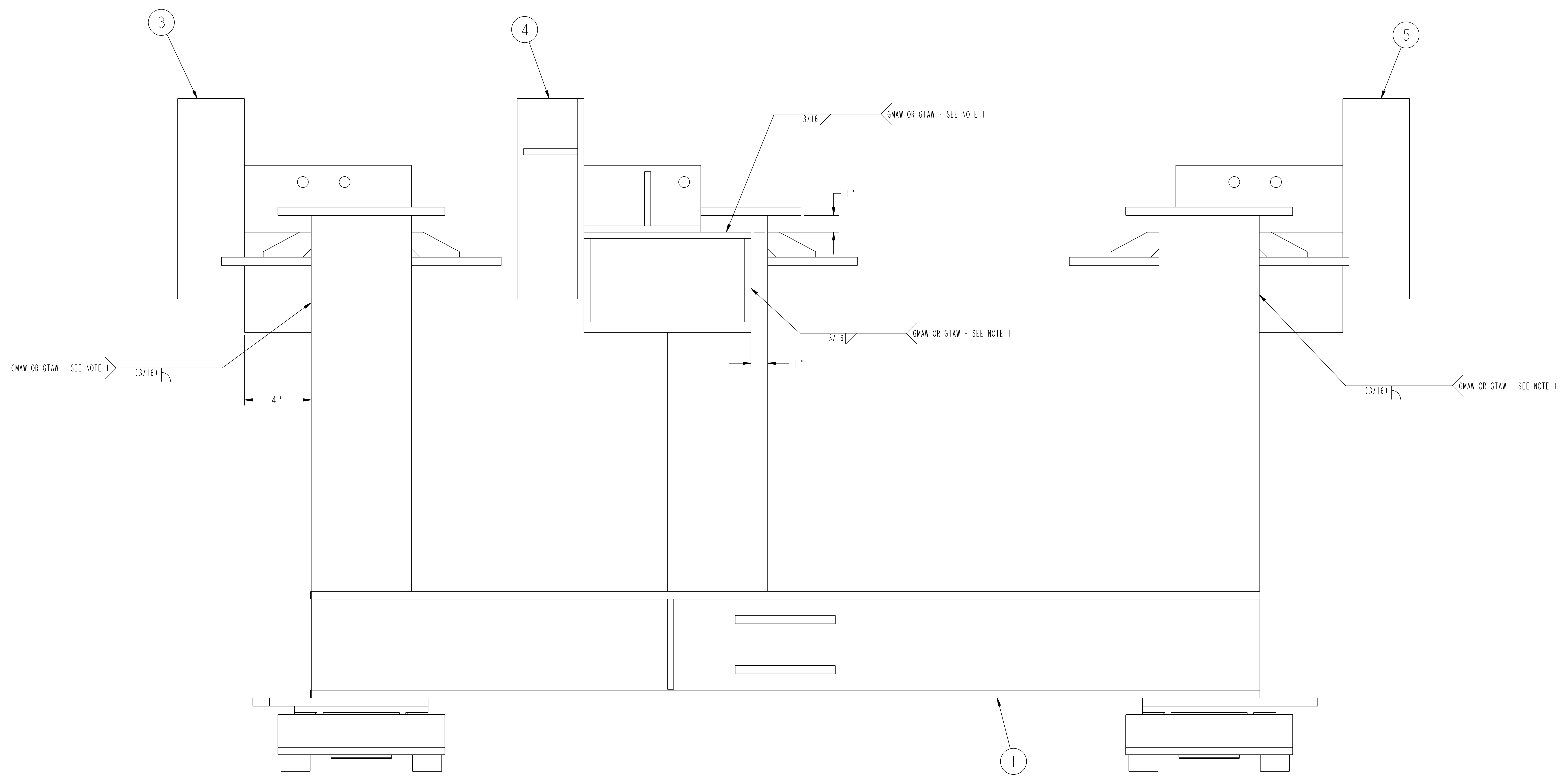
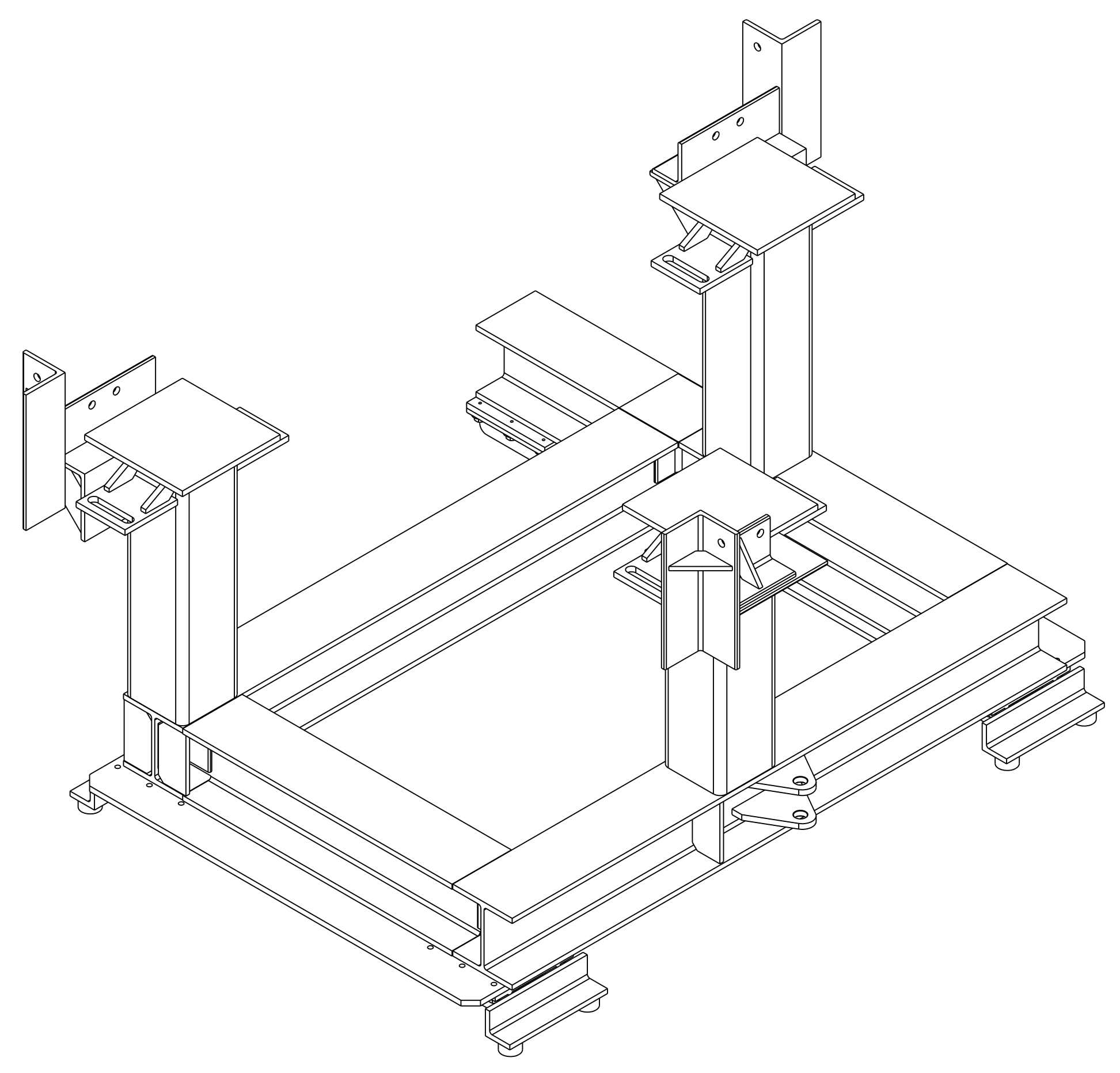


NO.	REVISION	BY	CH	SUP	APPROVED	DATE



01 ASSEMBLY  
FRONT VIEW



REFERENCE ISOMETRIC  
SCALE 0.125

NOTES

1. WELDING TO 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.

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

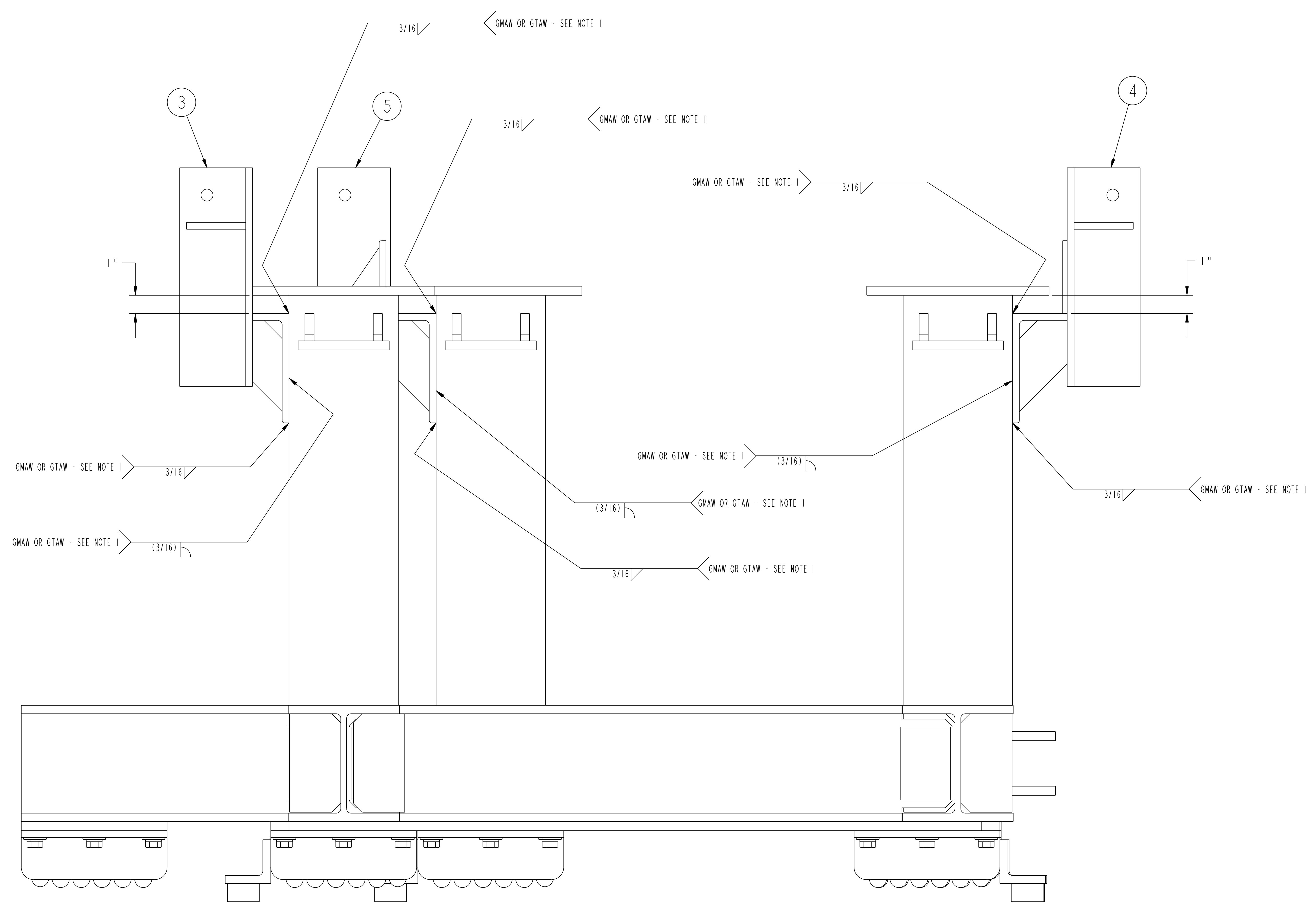
02 ASSY	01 ASSY	PART NO.	DRAWING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY	REQD
		8	SE186-335-06	POSITIONER BRACKET WELDMENT - TYPE "F"			SEE DWG
		7	SE186-335-05	POSITIONER BRACKET WELDMENT - TYPE "E"			SEE DWG
		6	SE186-335-04	POSITIONER BRACKET WELDMENT - TYPE "D"			SEE DWG
		5	SE186-335-03	POSITIONER BRACKET WELDMENT - TYPE "C"			SEE DWG
		4	SE186-335-02	POSITIONER BRACKET WELDMENT - TYPE "B"			SEE DWG
		3	SE186-335-01	POSITIONER BRACKET WELDMENT - TYPE "A"			SEE DWG
		2	SE186-330-02	MCWF LEFT SIDE SUPPORT CART WELDMENT			SEE DWG
		1	SE186-315	MCWF RIGHT SIDE SUPPORT CART ASSEMBLY			SEE DWG
				THIS DWG			LEFT SIDE CART WITH POSITIONER BRACKETS WELDMENT
							RIGHT SIDE CART WITH POSITIONER BRACKETS WELDMENT

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E		CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY	
DO NOT VERIFY INFORMATION BY SCALING DRAWING		DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	NATIONAL COMPACT STELLARATOR EXPERIMENT	
WEIGHT 1271.3 lbs		TOLERANCES NON-CUMULATIVE	FIELD PERIOD ASSEMBLY	
MODEL NAME SE186-334-01		DECIMAL-INCH FRACTIONS	TOOLING DESIGN AND FABRICATION	
WELDING ENGINEER L. DUDEK 4-18-08		.XX ±.005 .XX ±.010 ANGULAR ±.0°-15° OVER 120° ±.1°-1.2°	DSN: L. MORRIS 4-18-08	DRAWING NO: <b>SE186-334</b>
RELEASE LEVEL: Fabrication DWG VERSION NO: 0		NEXT ASSEMBLY	CHK: T. BROWN 4-18-08	ENGR: T. BROWN 4-18-08
			SUPV: J. SIEGEL 4-18-08	SHEET 1 OF 6 REV 0

NCSX-SE186-334

NCSX-ASSY-FORMAT.E

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



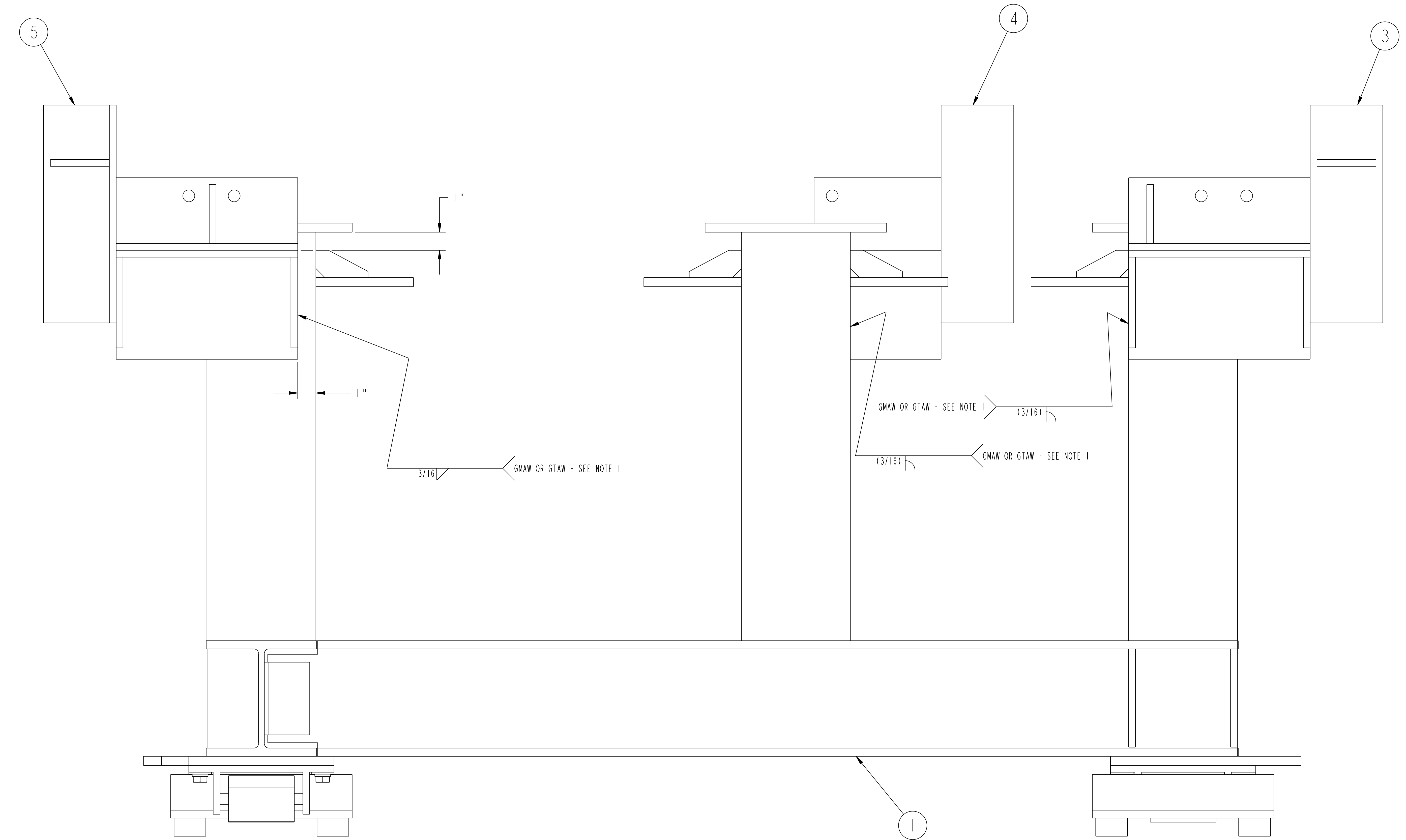
01 ASSEMBLY  
LEFT SIDE VIEW

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

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES:	PRINCETON PLASMA PHYSICS LABORATORY NATIONAL COMPACT STELLATOR EXPERIMENT			
	UNLESS OTHERWISE SPECIFIED	FIELD PERIOD ASSEMBLY TOOLING DESIGN AND FABRICATION			
DO NOT VERIFY INFORMATION BY SCALING DRAWING	DIMENSIONS ARE IN INCHES MACHINE SURFACES	R. H. AND L. H. CART WITH POSITIONER BRACKET WELDMENTS			
NEXT ASSEMBLY	BREAK SHARP EDGES .005/.020	DSN: L. MORRIS	4-18-08	DRAWING NO:	<b>SE186-334</b>
	TOLERANCES NON-CUMULATIVE	CHK: T. BROWN	4-18-08	ENGR: T. BROWN	
WEIGHT	DECIMAL-INCH FRACTIONS	SUPV: J. SIEGEL	4-18-08	SHEET 2 OF 6	REV 0.1
1271.3 lbs	.XX +/- .000 .XX +/- .030 .XX +/- .005				
MODEL NAME	ANGULAR +/- .05°				
SE186-334-01	90°-120° 120°-120° OVER 120° +/- .12°				
RELEASE LEVEL: Fabrication					
DWG VERSION NO: 0					

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



01 ASSEMBLY  
BACK VIEW

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

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

RELEASE LEVEL: Fabrication  
DWG VERSION NO: 0

WEIGHT  
1271.3 lbs

MODEL NAME  
SE186-334-01

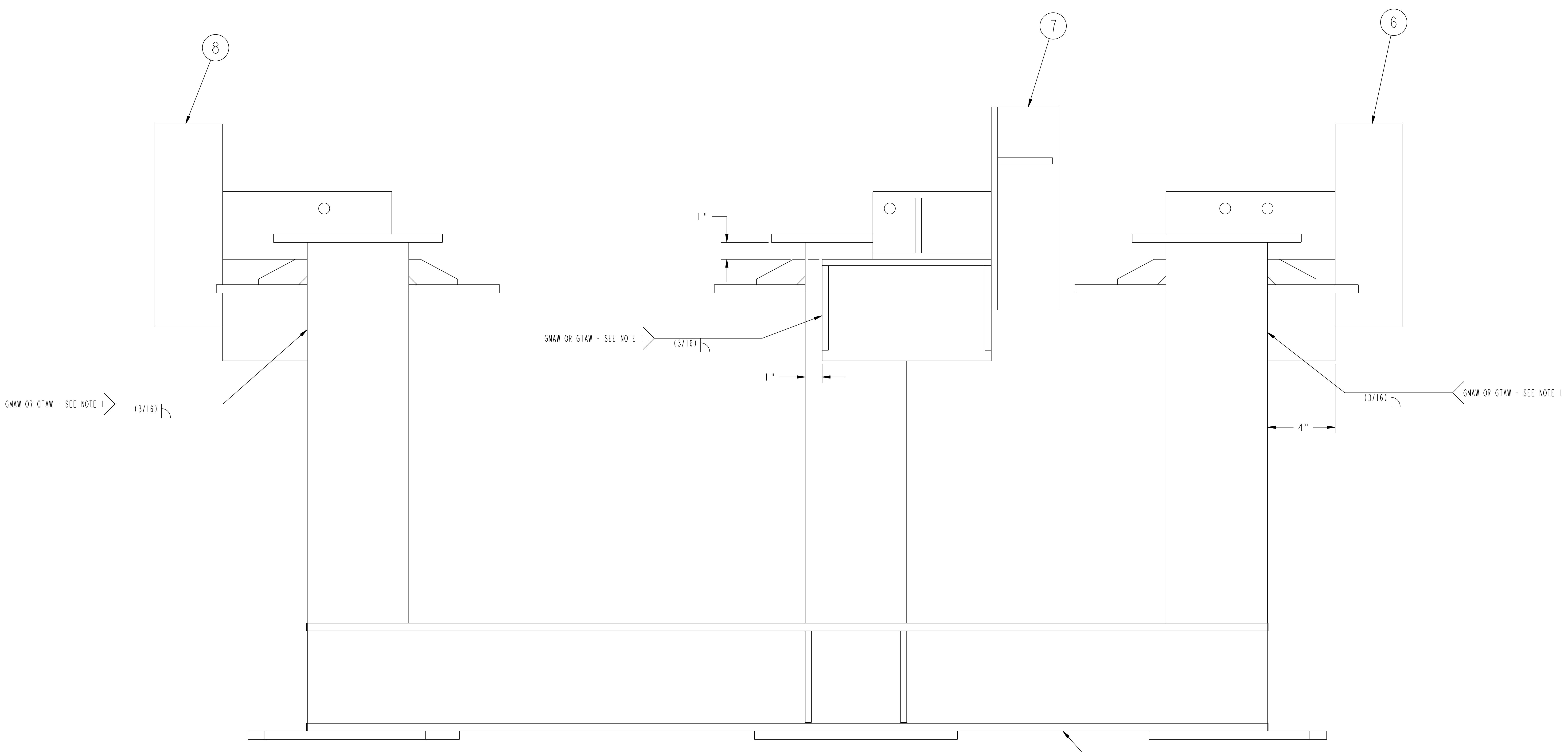
WELDING  
ENGINEER

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES:	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY			
	UNLESS OTHERWISE SPECIFIED	<b>NATIONAL COMPACT STELLATOR EXPERIMENT</b>			
DO NOT VERIFY INFORMATION BY SCALING DRAWING	DIMENSIONS ARE IN INCHES MACHINE SURFACES	FIELD PERIOD ASSEMBLY TOOLING DESIGN AND FABRICATION R. H. AND L. H. CART WITH POSITIONING BRACKET WELDMENTS			
NEXT ASSEMBLY	BREAK SHARP EDGES .005/.020	TOLERANCES NON-CUMULATIVE	DSN: L. MORRIS	4-18-08	DRAWING NO:
	DECIMAL-INCH FRACTIONS	CHK: T. BROWN	4-18-08	<b>SE186-334</b>	
	.XX +/- .005	ENGR: T. BROWN	4-18-08	SHEET 3 OF 6	
	ANGULAR +/- .05	SUPV: J. SIEGEL	4-18-08	REV 0.1	

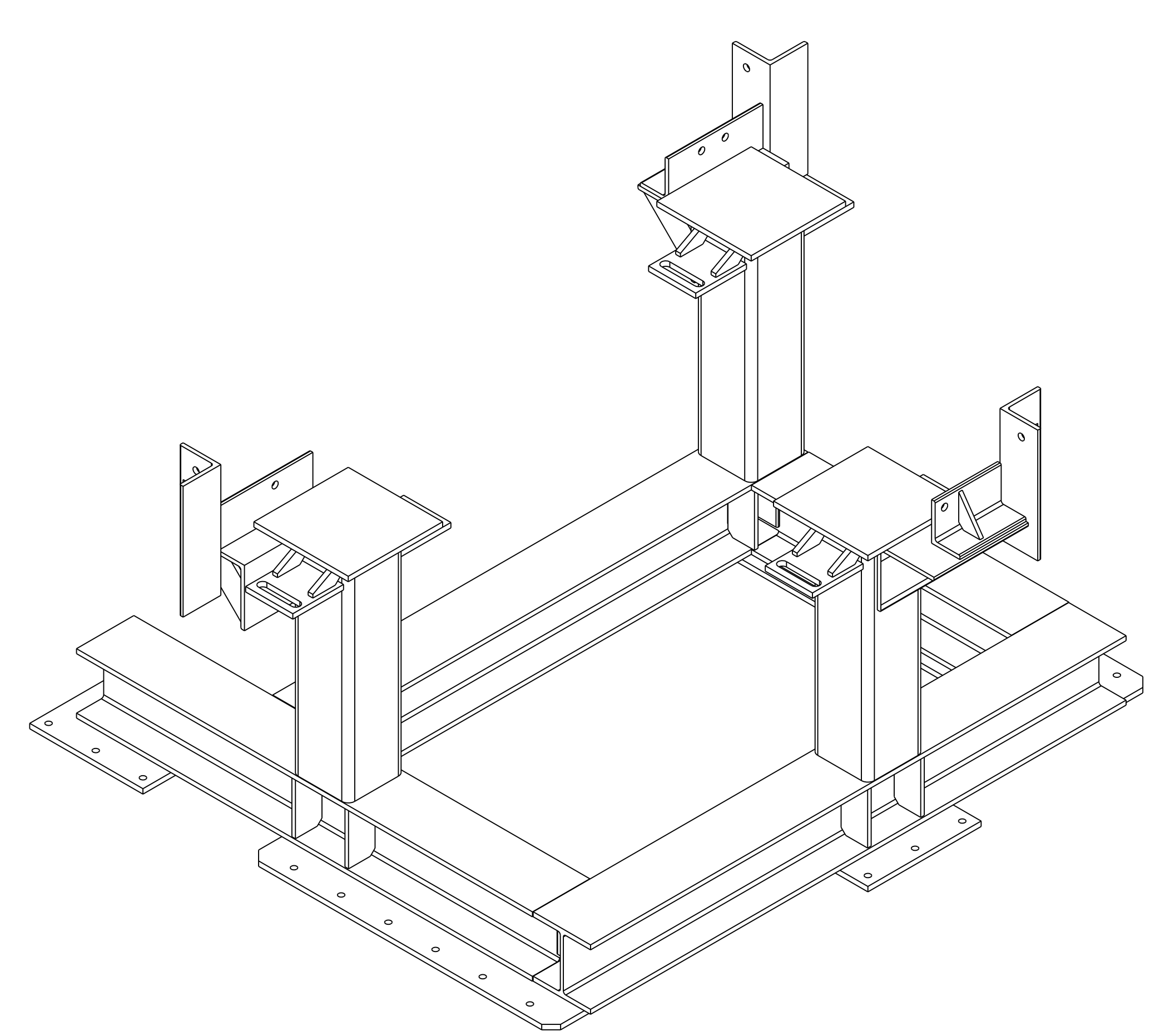
NCSX-SE186-334



NO.	REVISION	BY	CH	SUP	APPROVED	DATE



02 ASSEMBLY  
FRONT VIEW



REFERENCE ISOMETRIC  
SCALE 0.125

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

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

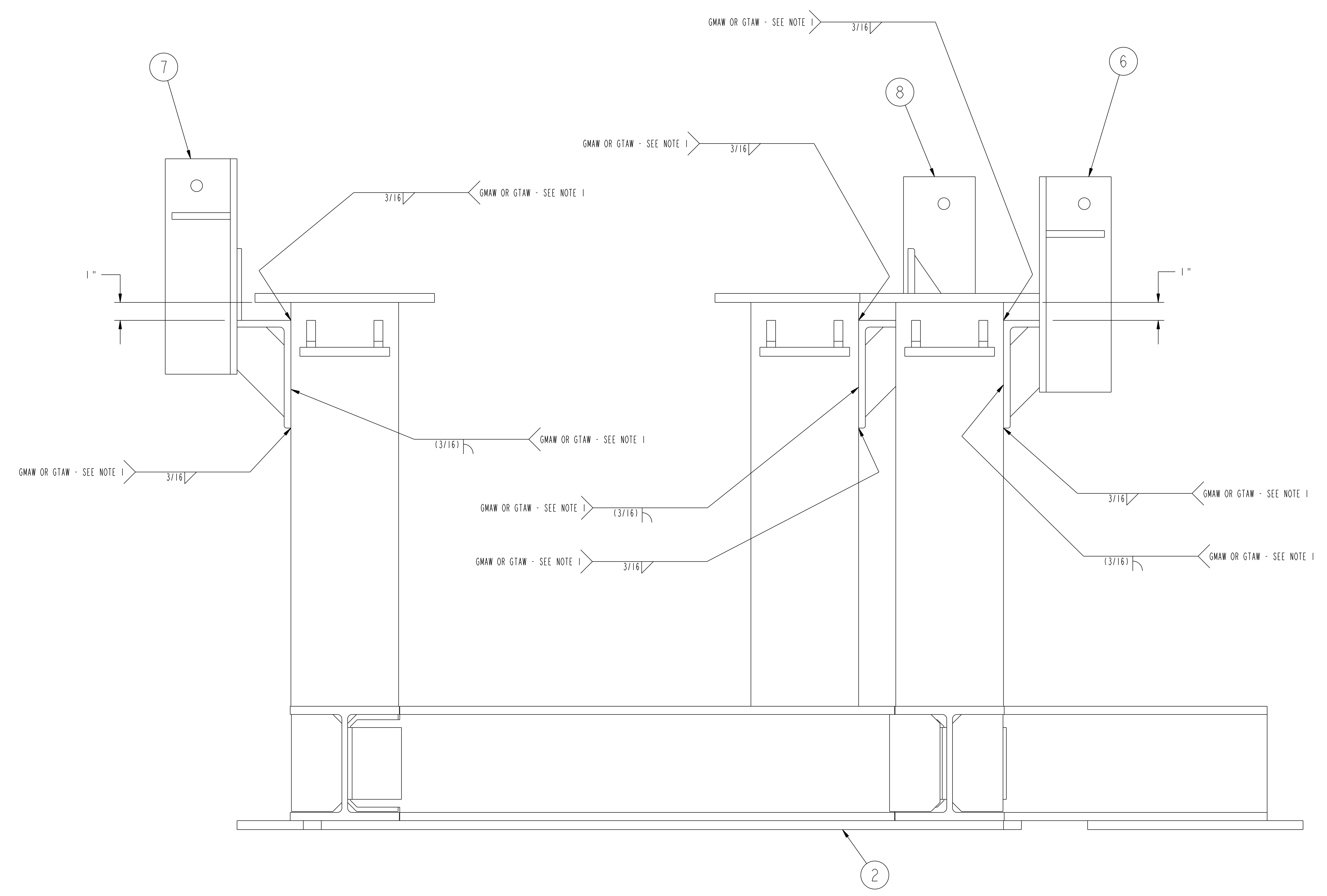
RELEASE LEVEL: Fabrication  
DWG VERSION NO: 0

WEIGHT	1271.3 lbs
MODEL NAME	SE186-334-01
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	FIELD PERIOD ASSEMBLY TOOLING DESIGN AND FABRICATION R. H. AND L. H. CART WITH POSITIONER BRACKET WELDMENTS	
NEXT ASSEMBLY	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .X ±.000 .XX ±.005 ANGULAR ±.0°-15°	DSN: L. MORRIS	4-18-08
		CHK: T. BROWN	4-18-08
		ENGR: T. BROWN	4-18-08
		SUPV: J. SIEGEL	4-18-08
		DRAWING NO:	<b>SE186-334</b>
		SHEET 4 OF 6	REV 0.1

NCSX-SE186-334

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



02 ASSEMBLY  
RIGHT SIDE VIEW

**RELEASED FOR  
FABRICATION / INSTALLATION**  
PPPL Drafting

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

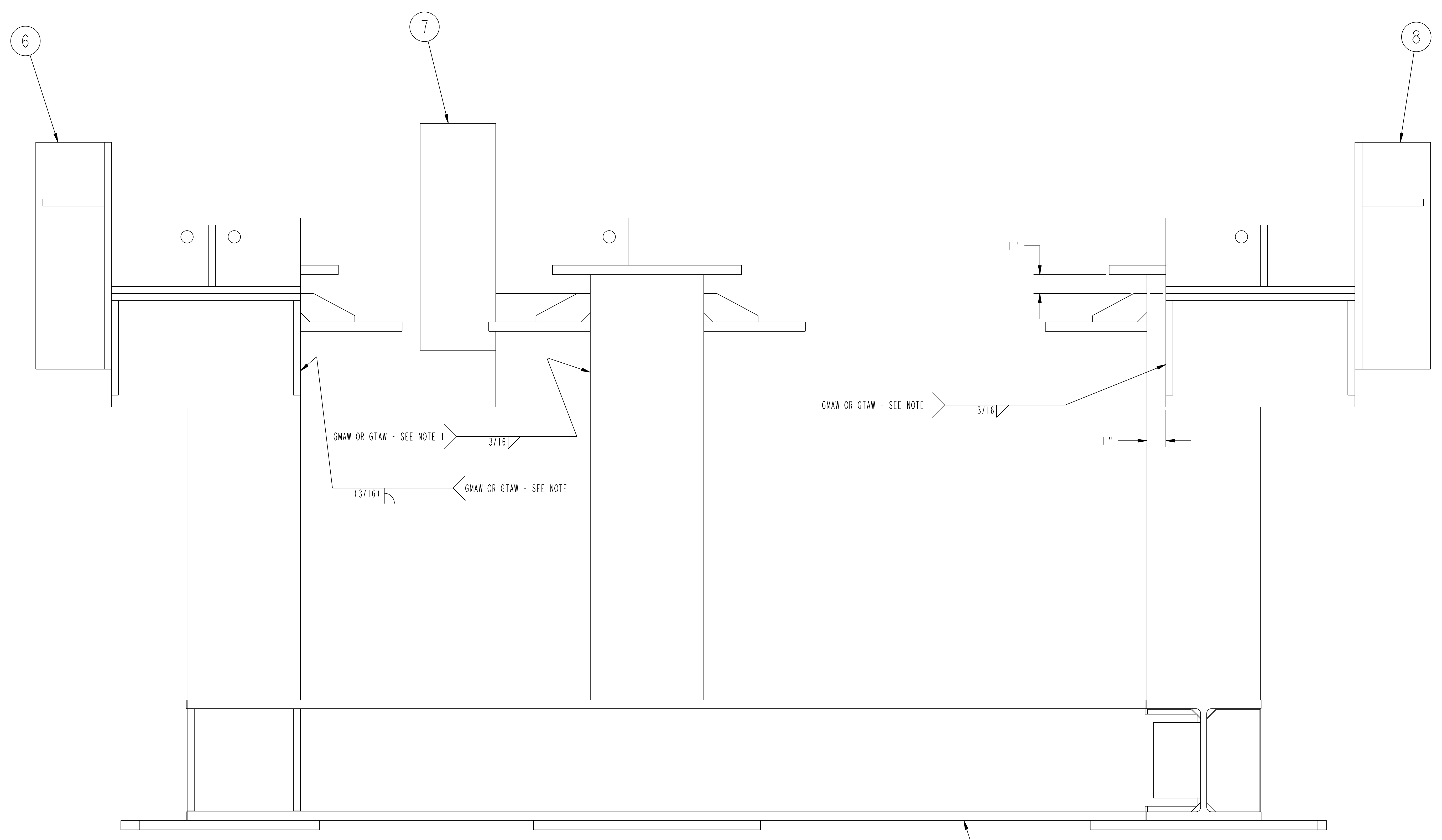
RELEASE LEVEL: Fabrication  
DWG VERSION NO: 0

WEIGHT	1423.1 lbs
MODEL NAME	SE186-334-02
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	FIELD PERIOD ASSEMBLY TOOLING AND DESIGN FABRICATION R. H. AND L. H. CART WITH POSITIONER BRACKET WELDMENTS	
NEXT ASSEMBLY	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .X ±.000 .XX ±.005 ANGULAR ±.0°-15°	DSN: L. MORRIS CHK: T. BROWN ENGR: T. BROWN SUPV: J. SIEGEL	4-18-08 4-18-08 4-18-08 4-18-08
		DRAWING NO: <b>SE186-334</b>	SHEET 5 OF 6 REV 0.1

NCSX-SE186-334

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02 ASSEMBLY  
BACK VIEW

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

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

RELEASE LEVEL: Fabrication  
DWG VERSION NO: 0

WEIGHT  
1423.1 lbs  
MODEL NAME  
SE186-334-02  
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/.02R	FIELD PERIOD ASSEMBLY TOOLING DESIGN AND FABRICATION H. AND L.H. CART WITH POSITIONAL BRACKET WELDMENT	
NEXT ASSEMBLY	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX +/- .000 .XXX +/- .005 ANGULAR +/- .05	DSN: L. MORRIS CHK: T. BROWN ENGR: T. BROWN SUPV: J. SIEGEL	DRAWING NO: 4-18-08 4-18-08 4-18-08 4-18-08 <b>SE186-334</b> SHEET 6 OF 6 REV 0.1

NCSX-SE186-334