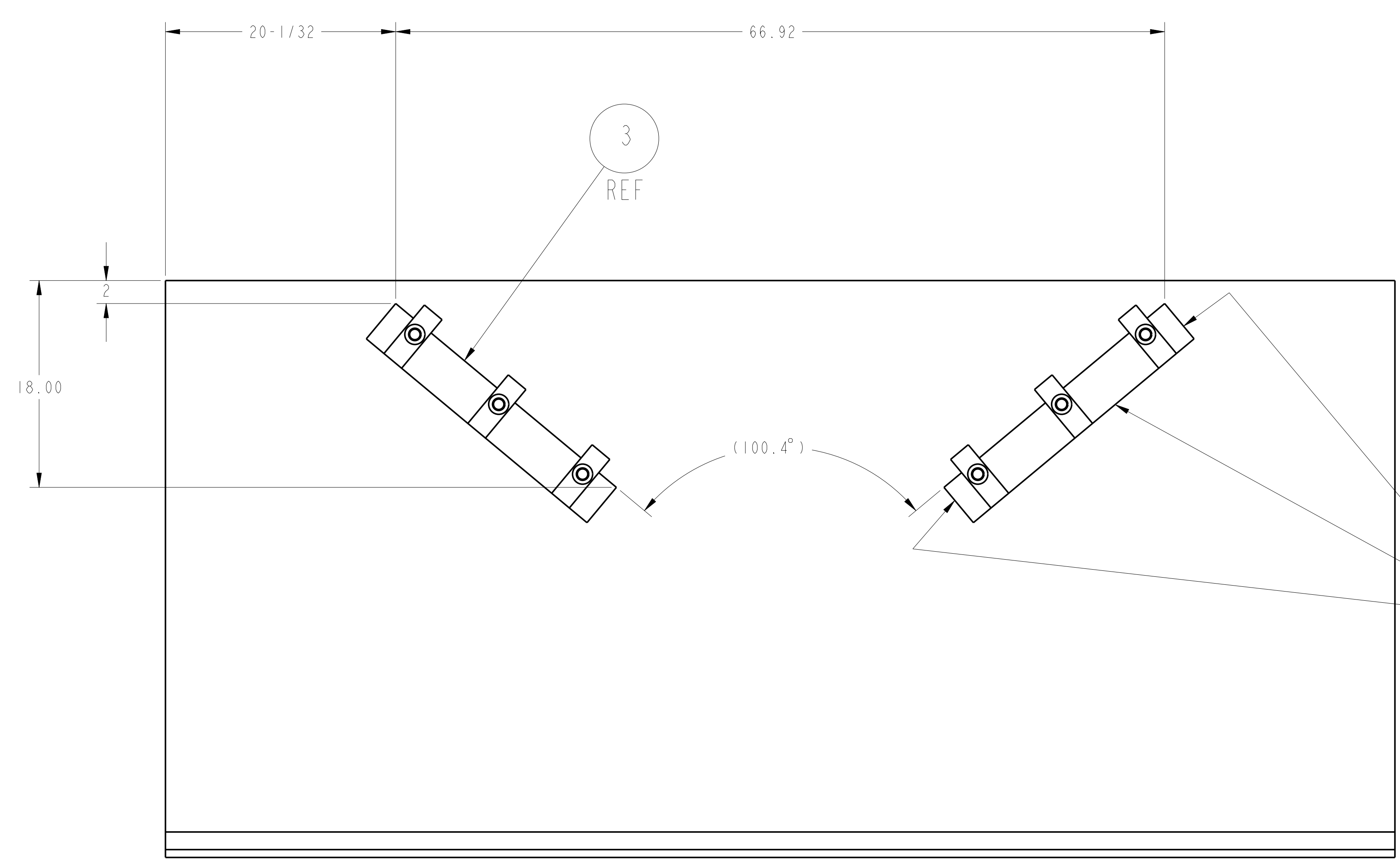


DETAIL A
SCALE 1.000

SEE DETAIL A



3/8 4-9 1/2 GMAW OR GTAW - SEE NOTE 1
TYP (2) PLACES
FIELD LOCATE
TACK & WELD IN PLACE

RELEASED FOR FABRICATION/INSTALLATION
PPPL Drafting

NOTES

1. WELDING SHALL BE PERFORMED IN ACCORDANCE WITH PPPL PROCEDURE ENG-037. VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH THE ACCEPTANCE CRITERIA OF AWS D1.1 Section 6.

PART NO.	DRAWING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY	RECD
6	NS150170	5/8-11 UNC -2A HEX BOLT, 2 1/2 LG	SAE J429 GRADE 8	6	
5	NS151376	5/8 SPLIT LOCK WASHER (GRADE 8 COMPATIBLE)	C' STL-ZN PLT	6	
4	NS151375	5/8 FLAT WASHER (GRADE 8 COMPATIBLE)	ASTM F436	6	
3	SE186-354-2	CLAMP STOP	ASTM A36	2	
2	SE186-354-1	CLAMP BLOCK	ASTM A36	6	
1	SE186-352-01	20 DEGREE WEDGE FIXTURE WELDMENT	ASTM A36	1	

PARTS LIST

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, TX NATIONAL COMPACT STELLARATOR EXPERIMENT TOOLING DESIGN AND FABRICATION FIELD PERIOD ASSEMBLY FIXTURE 20 DEGREE WEDGE FIXTURE ASSEMBLY
DO NOT VERIFY INFORMATION BY SCALING DRAWING	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS: X .XX ±.005 X.XX ±.005 X.XXX ±.005 OVER 120° ±.125	DSN: R. UPCAVALA 2/26/2008 CHK: M. VIOLA 2/26/2008 ENGR: B. SANDS 2/26/2008 SUPV: J. SIEGEL 2/26/2008
WEIGHT 6851 lbs	MODEL NAME SE186-350	DRAWING NO: SE186-350
RELEASE LEVEL: Fabrication DWG VERSION NO: 4	WELDING ENGINEER L. DUDER 2/26/2008	SHEET 1 OF 1 REV 0.6

NCSX-SE186-350