



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.

RELEASED FOR FABRICATION/INSTALLATION
 PPPL Drafting

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)

PART NO.	DRAWING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY	RECD
5	SE186-352-6	WEDGE FORKLIFT BLOCK	ASTM A36	2	
4	SE186-352-5	WEDGE TOP	ASTM A36	1	
3	SE186-352-4	WEDGE SIDE, 20 DEGREES	ASTM A36	2	
2	SE186-352-3	WEDGE BOTTOM	ASTM A36	1	
1	SE186-352-2	WEDGE BACK, 20 DEGREES	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 NATIONAL COMPACT STELLARATOR EXPERIMENT TOOLING DESIGN AND FABRICATION FIELD PERIOD ASSEMBLY FIXTURE 20 DEGREE WEDGE FIXTURE WELDMENT
DO NOT VERIFY INFORMATION BY SCALING DRAWING	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS XX ±.005 XXX ±.005 ANGULAR ±.05	DSN: R. UPCAVALLE 2/26/2008 CHK: M. VIOLA 2/26/2008 ENGR: B. SANDS 2/26/2008 SUPV: J. SIEGEL 2/26/2008
WEIGHT 6.851 lbs	MODEL NAME SE186-352-01	DRAWING NO: SE186-352
RELEASE LEVEL: Fabrication DWG VERSION NO: 4	WELDING ENGINEER L. DUDEK 2/26/2008	SHEET 1 OF 1 REV 0

NCSX-SE186-352