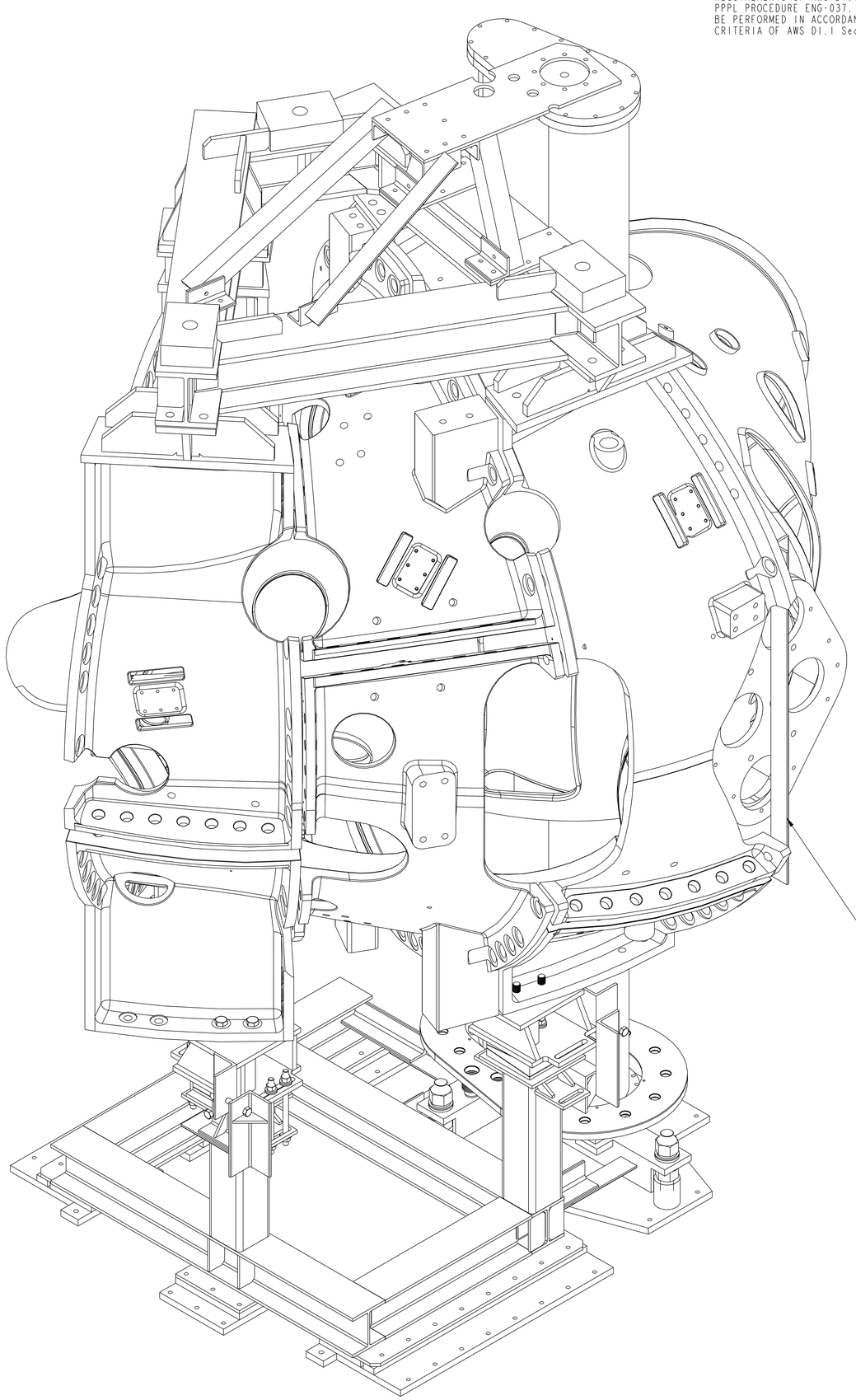
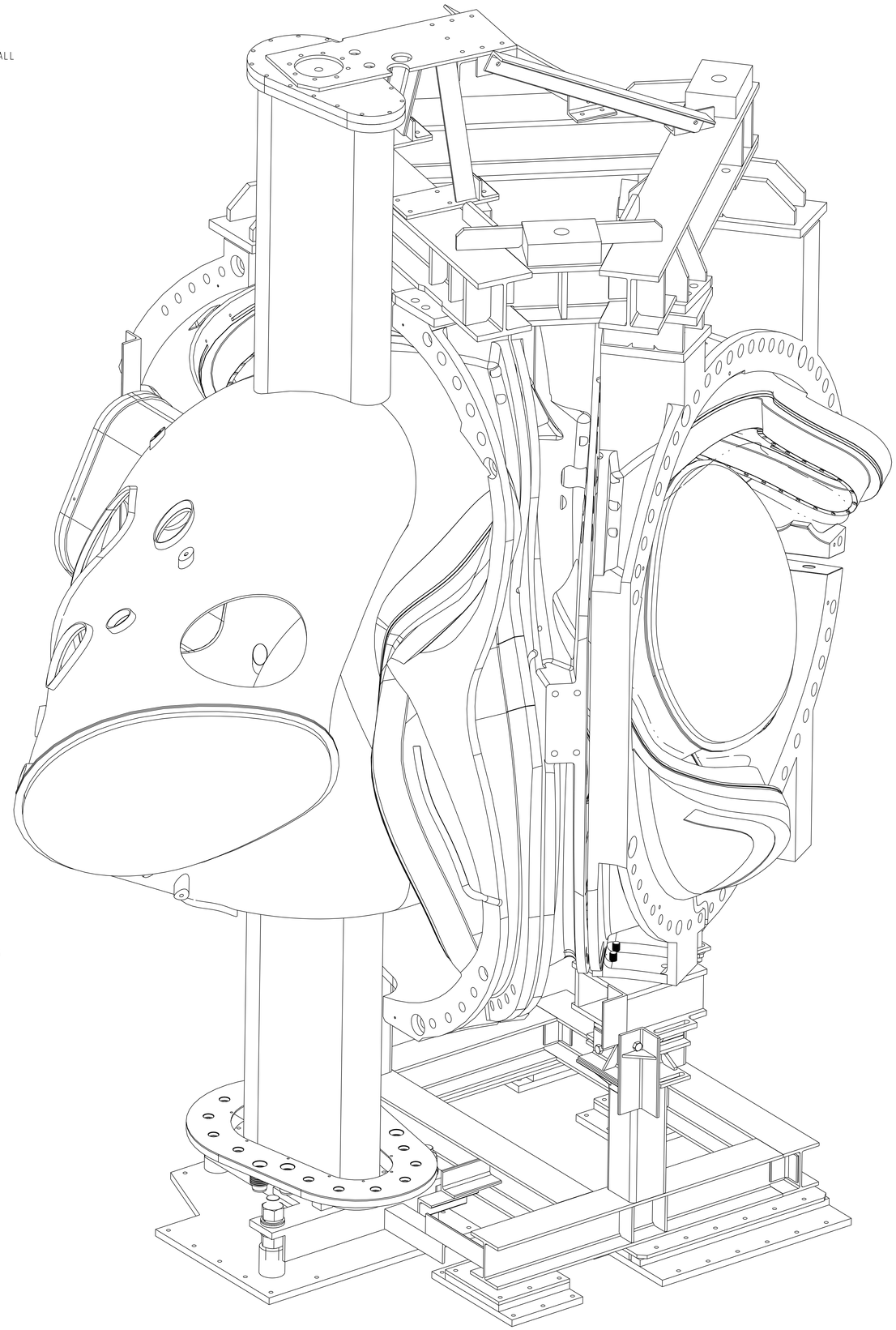
NO.	REVISION	BY	CH	SUP	APPROVED	DATE

NOTES:

1. WELDING SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF AWS D1.1 (STATIC LOAD) AND/OR PPPL PROCEDURE ENG-037. VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH THE ACCEPTANCE CRITERIA OF AWS D1.1 Section 6.



3 x 3 x 3/8 x 54" LG
STRUCTURAL ANGLE
MATCH DRILL TO SUIT



RELEASED FOR FABRICATION / INSTALLATION

PPPL Drafting: jerome siegel

Digitally signed by jerome siegel
DN: cn=jerome siegel, o, ou, email=jsiegel@pppl.gov, c=US
Date: 2008.09.18 14:47:22 -04'00'

RELEASE LEVEL: Fabrication
DWG VERSION NO: 0

WEIGHT
44085.3 lbs

MODEL NAME
SE186-425

WELDING ENGINEER: M. DENAULT 9-17-08

COMPUTER GENERATED DRAWING
MANUAL CHANGES NOT PERMITTED

Pro E

DO NOT VERIFY INFORMATION BY SCALING DRAWING

NEXT ASSEMBLY

CENTRAL FILES:
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
MACHINE SURFACES
BREAK SHARP EDGES .005/.020
TOLERANCES NON-CUMULATIVE

DECIMAL-INCH	FRACTIONS
.X +/-.100	0°-12° +/-1/16
.XX +/-.030	12°-72° +/-1/8
.XXX +/-.005	72°-120° +/-1/4
ANGULAR +/-0°15'	OVER 120° +/-1/2

PRINCETON PLASMA PHYSICS LABORATORY
PRINCETON UNIVERSITY
NATIONAL COMPACT STELLARATOR EXPERIMENT

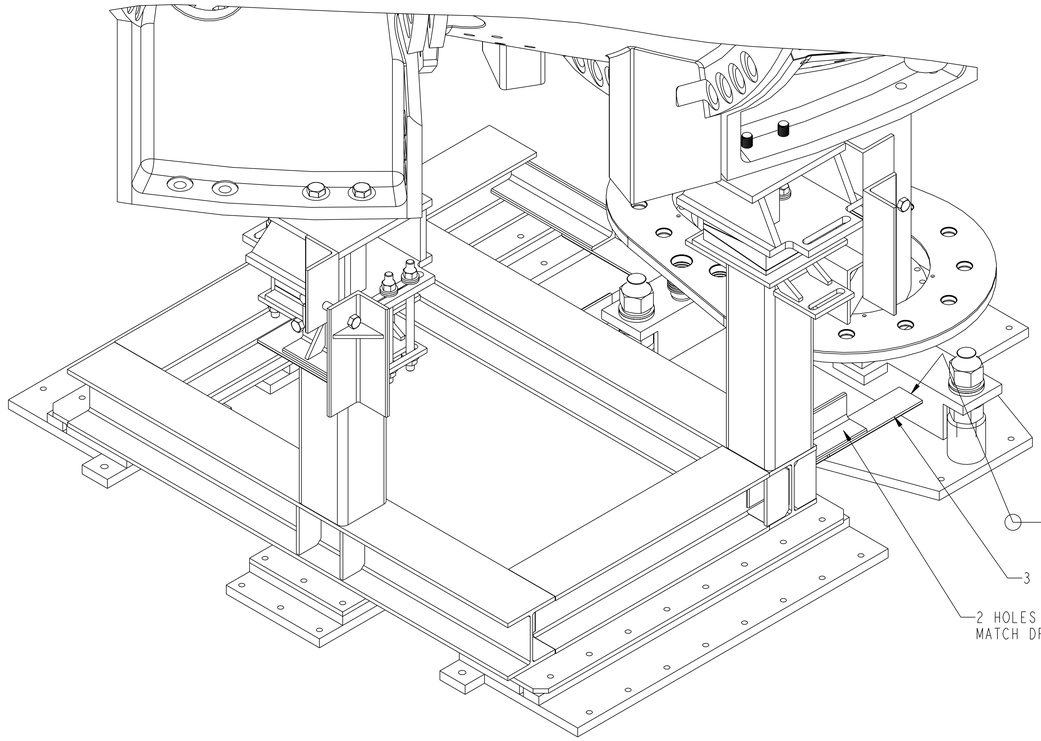
FIELD PERIOD ASSEMBLY
VV TO MC SUPPORT BRACKETING
SUPPORT BRACKETING ARRANGEMENT AND WELDMENT

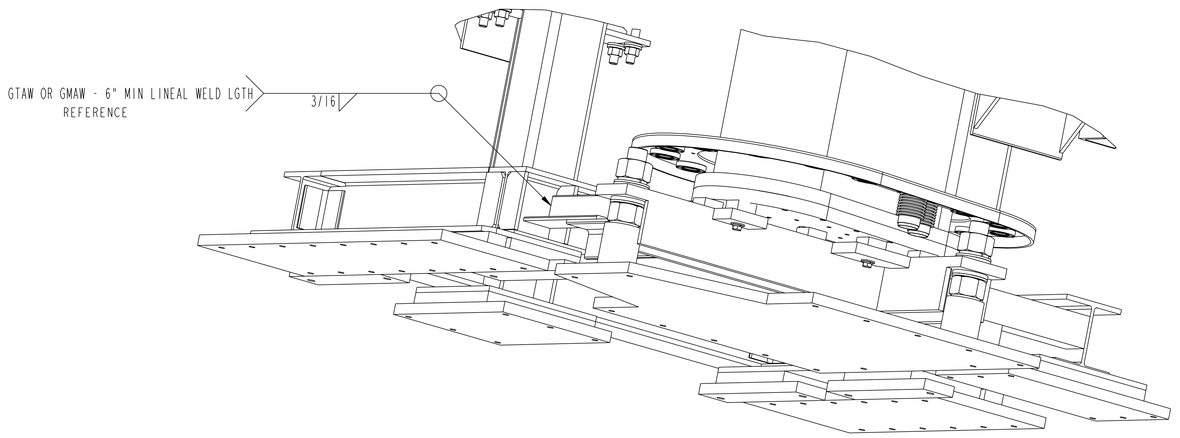
DSN: L. MORRIS	9-17-08	DRAWING NO:
CHK: M. VIOLA	9-17-08	SE186-425
ENGR: M. VIOLA	9-17-08	
SUPV: J. SIEGEL	9-17-08	SHEET 1 OF 5 REV 0

NCSX-SE186-425

NCSX_ASSY_FORMAT_E

NO.	REVISION	BY	CH	SUP	APPROVED	DATE





PARTIAL BOTTOM VIEWS

RELEASED FOR FABRICATION / INSTALLATION

PPPL Drafting: jerome siegel

Digitally signed by jerome siegel
DN: cn=jerome siegel, o, ou, email=jsiegel@pppl.gov, c=US
Date: 2008.09.18 14:48:04 -04'00'

RELEASE LEVEL: Fabrication
DWG VERSION NO: 0

WEIGHT
44085.3 lbs

MODEL NAME
SE186-425

WELDING ENGINEER

COMPUTER GENERATED DRAWING
MANUAL CHANGES NOT PERMITTED

Pro E

DO NOT VERIFY INFORMATION BY SCALING DRAWING

NEXT ASSEMBLY

CENTRAL FILES:
UNLESS OTHERWISE SPECIFIED

DIMENSIONS ARE IN INCHES
MACHINE SURFACES

BREAK SHARP EDGES .005/.020

TOLERANCES NON-CUMULATIVE

DECIMAL-INCH	FRACTIONS
.X +/-.100	0°-12° +/-1/16
.XX +/-.030	12°-72° +/-1/8
.XXX +/-.005	72°-120° +/-1/4
ANGULAR+/-0°-15'	OVER 120°+/-1/2

PRINCETON PLASMA PHYSICS LABORATORY
PRINCETON UNIVERSITY
NATIONAL COMPACT STELLARATOR EXPERIMENT

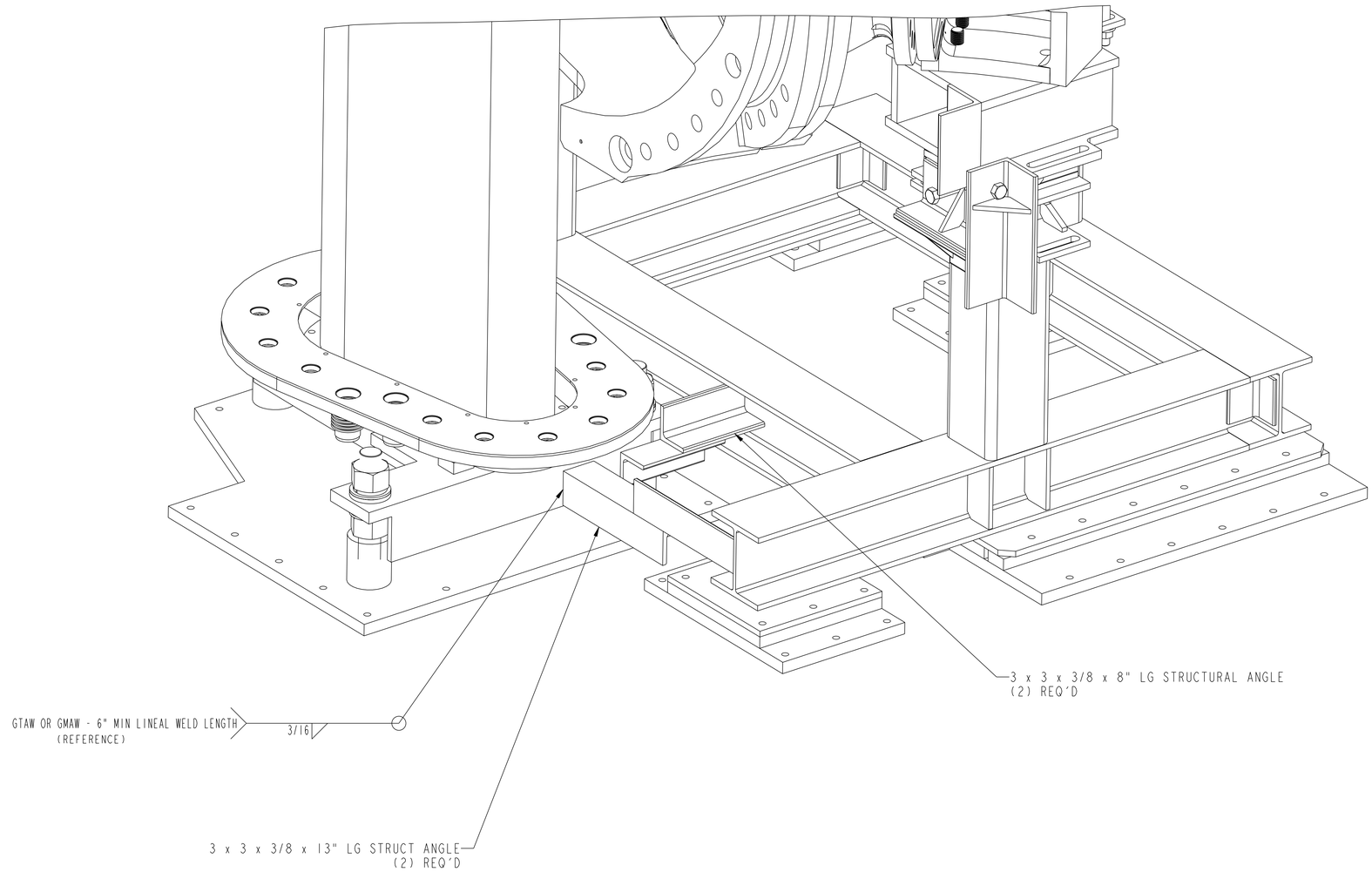
FIELD PERIOD ASSEMBLY
VV TO MC SUPPORT BRACKETING
SUPPORT BRACKETING ARRANGEMENT AND WELDMENT

DSN: L. MORRIS	9-17-08	DRAWING NO:
CHK: M. VIOLA	9-17-08	SE186-425
ENGR: M.VIOLA	9-17-08	
SUPV: J. SIEGEL	9-17-08	SHEET 2 OF 5 REV 0.1

NCSX_ASSY_FORMAT_E

NCSX-SE186-425

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



RELEASED FOR FABRICATION / INSTALLATION

PPPL Drafting: jerome siegel

Digitally signed by jerome siegel
DN: cn=jerome siegel, o, ou, email=jsiegel@pppl.gov, c=US
Date: 2008.09.18 14:48:31 -04'00'

NCSX-SE186-425

RELEASE LEVEL: Fabrication
DWG VERSION NO: 0

WEIGHT
44085.3 lbs

MODEL NAME
SE186-425

WELDING ENGINEER

COMPUTER GENERATED DRAWING
MANUAL CHANGES NOT PERMITTED

Pro E

DO NOT VERIFY INFORMATION BY SCALING DRAWING

NEXT ASSEMBLY

CENTRAL FILES:
UNLESS OTHERWISE SPECIFIED

DIMENSIONS ARE IN INCHES
MACHINE SURFACES

BREAK SHARP EDGES .005/.020

TOLERANCES NON-CUMULATIVE

DECIMAL-INCH	FRACTIONS
.X +/-.100	0°-12° +/-1/16
.XX +/-.030	12°-72° +/-1/8
.XXX +/-.005	72°-120° +/-1/4
ANGULAR +/-0°-15'	OVER 120° +/-1/2

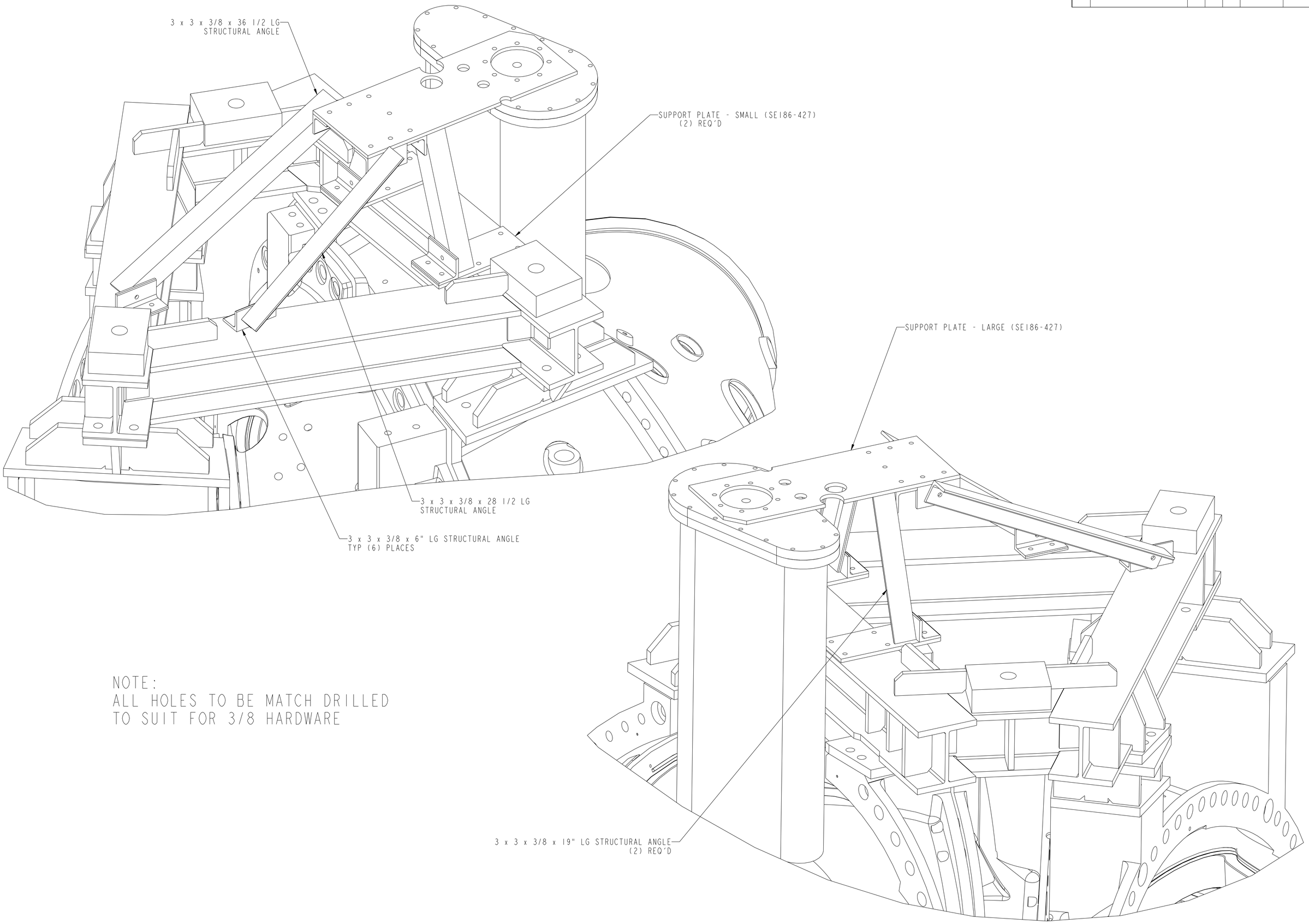
PRINCETON PLASMA PHYSICS LABORATORY
PRINCETON UNIVERSITY
NATIONAL COMPACT STELLARATOR EXPERIMENT

FIELD PERIOD ASSEMBLY
VV TO MC SUPPORT BRACKETING
SUPPORT BRACKETING ARRANGEMENT AND WELDMENT

DSN: L. MORRIS	9-17-08	DRAWING NO:
CHK: M. VIOLA	9-17-08	SE186-425
ENGR: M. VIOLA	9-17-08	
SUPV: J. SIEGEL	9-17-08	SHEET 3 OF 5 REV 0.1

NCSX_ASSY_FORMAT_E

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



NOTE:
ALL HOLES TO BE MATCH DRILLED
TO SUIT FOR 3/8 HARDWARE

RELEASED FOR FABRICATION / INSTALLATION

PPPL Drafting: jerome siegel

Digitally signed by jerome siegel
DN: cn=jerome siegel, o, ou, email=jsiegel@pppl.gov, c=US
Date: 2008.09.18 14:48:58 -04'00'

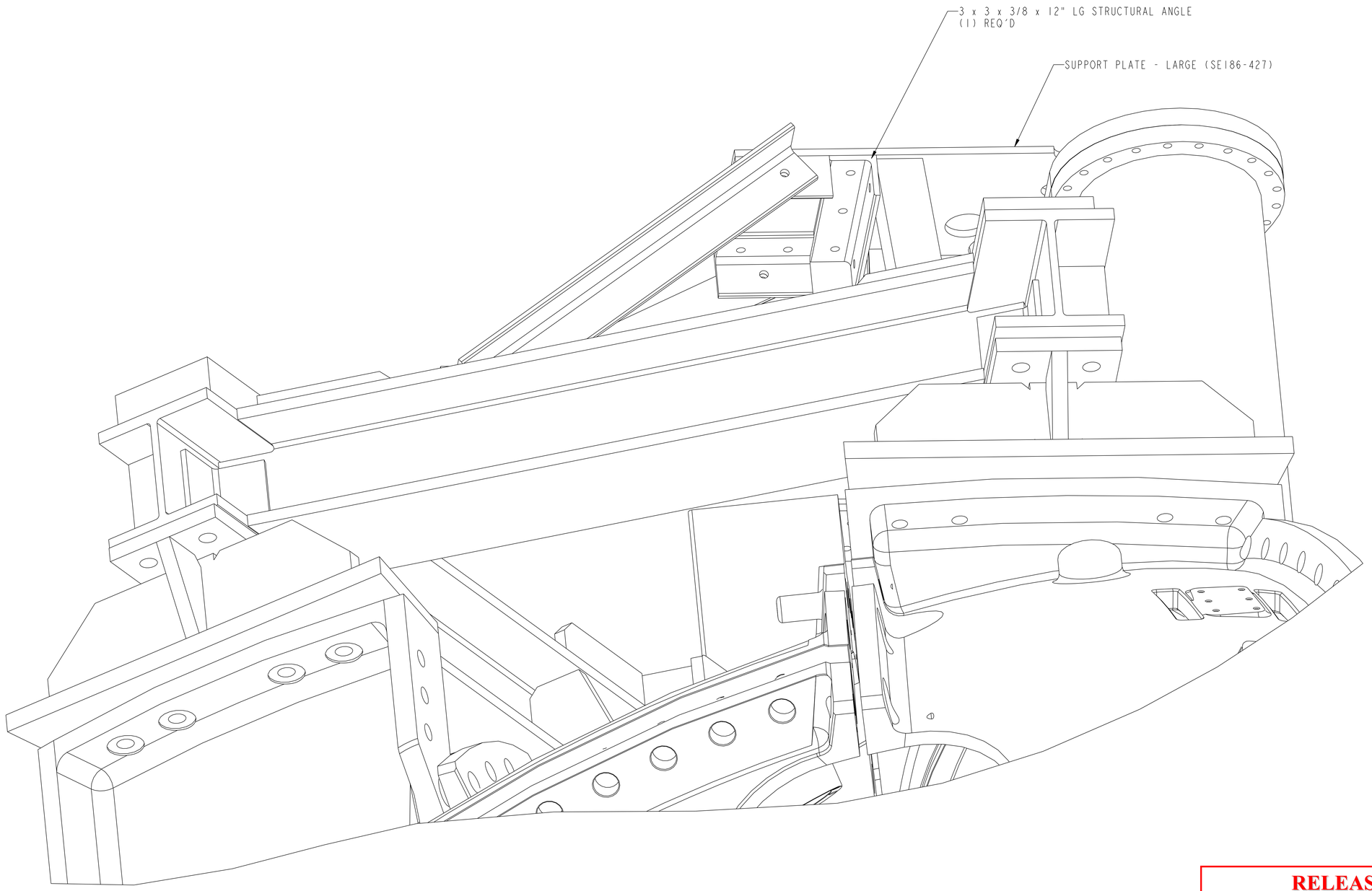
COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED	CENTRAL FILES:	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY				
	UNLESS OTHERWISE SPECIFIED	NATIONAL COMPACT STELLARATOR EXPERIMENT				
Pro E	DIMENSIONS ARE IN INCHES MACHINE SURFACES 63	FIELD PERIOD ASSEMBLY VV TO MC SUPPORT BRACKETING SUPPORT BRACKETING ARRANGEMENT AND WELDMENT				
DO NOT VERIFY INFORMATION BY SCALING DRAWING	BREAK SHARP EDGES .005/.020					
	TOLERANCES NON-CUMULATIVE	DSN: L. MORRIS	9-17-08	DRAWING NO:		
NEXT ASSEMBLY	DECIMAL-INCH / FRACTIONS	CHK: M. VIOLA	9-17-08	SE186-425		
	.X +/-.100 / 0°-12° +/-1/16	ENGR: M. VIOLA	9-17-08			
	.XX +/-.030 / 12°-72° +/-1/8					
	.XXX +/-.005 / 72°-120° +/-1/4	SUPV: J. SIEGEL	9-17-08	SHEET 4 OF 5	REV	0.1
	ANGULAR +/-0°-15' / OVER 120° +/-1/2					

WEIGHT	RELEASE LEVEL: Fabrication
44085.3 lbs	DWG VERSION NO: 0
MODEL NAME SE186-425	
WELDING ENGINEER	

NCSX_ASSY_FORMAT_E

NCSX-SE186-425

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



RELEASED FOR FABRICATION / INSTALLATION

PPPL Drafting: jerome siegel

Digitally signed by jerome siegel
DN: cn=jerome siegel, o, ou, email=jsiegel@pppl.gov, c=US
Date: 2008.09.18 14:49:24 -04'00'

RELEASE LEVEL: Fabrication
DWG VERSION NO: 0

WEIGHT
44085.3 lbs

MODEL NAME
SE186-425

WELDING ENGINEER

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED

Pro E

DO NOT VERIFY INFORMATION BY SCALING DRAWING

NEXT ASSEMBLY

CENTRAL FILES:

UNLESS OTHERWISE SPECIFIED

DIMENSIONS ARE IN INCHES
MACHINE SURFACES 125

BREAK SHARP EDGES .005/.020

TOLERANCES NON-CUMULATIVE

DECIMAL-INCH	FRACTIONS
.X +/-.100	0°-12° +/-1/16
.XX +/-.030	12°-72° +/-1/8
.XXX +/-.005	72°-120° +/-1/4
ANGULAR +/-0°-15'	OVER 120° +/-1/2

PRINCETON PLASMA PHYSICS LABORATORY
PRINCETON UNIVERSITY
NATIONAL COMPACT STELLARATOR EXPERIMENT

FIELD PERIOD ASSEMBLY
VV TO MC SUPPORT BRACKETING
SUPPORT BRACKETING ARRANGEMENT AND WELDMENT

DSN: L. MORRIS	9-17-08	DRAWING NO:
CHK: M. VIOLA	9-17-08	SE186-425
ENGR: M. VIOLA	9-17-08	
SUPV: J. SIEGEL	9-17-08	SHEET 5 OF 5 REV 0.1

NCSX-SE186-425

NCSX_ASSY_FORMAT_E