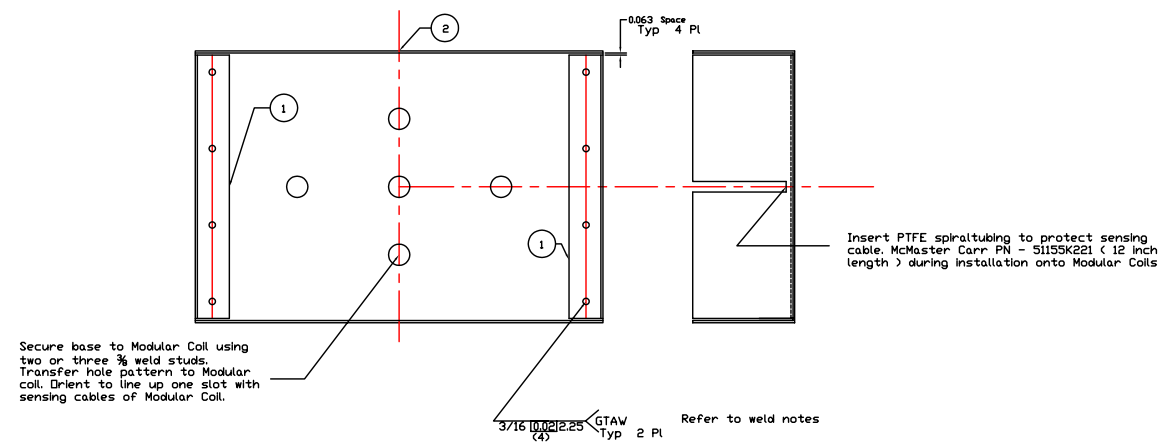
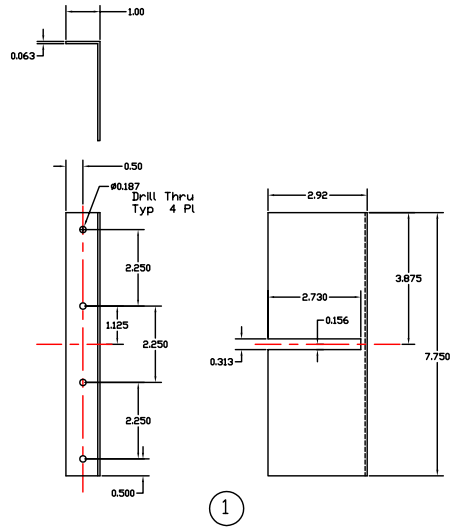
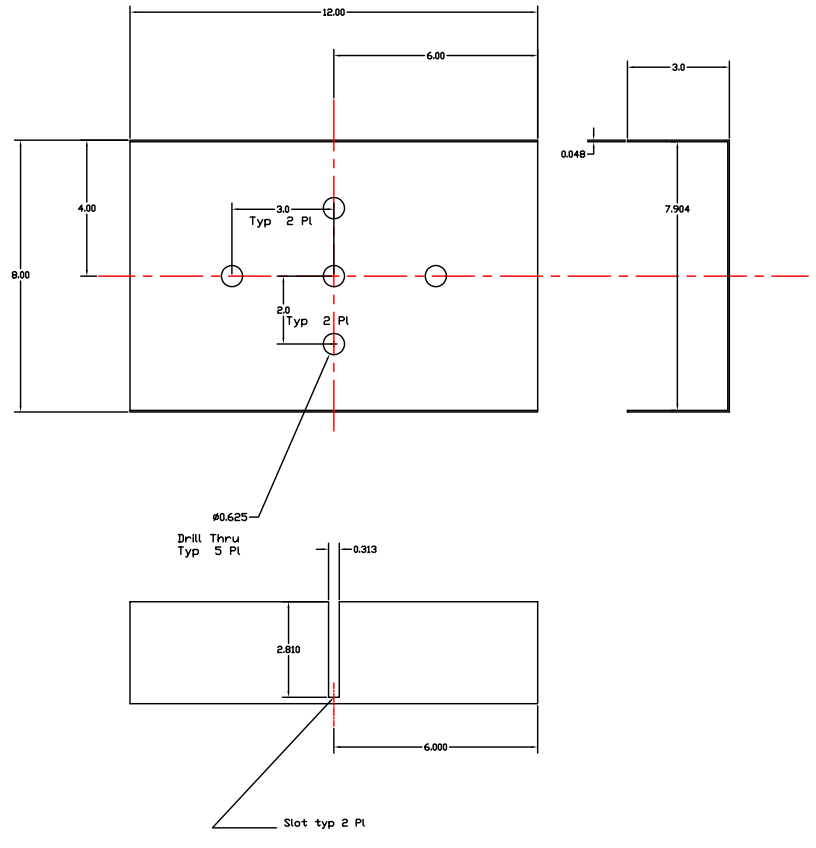
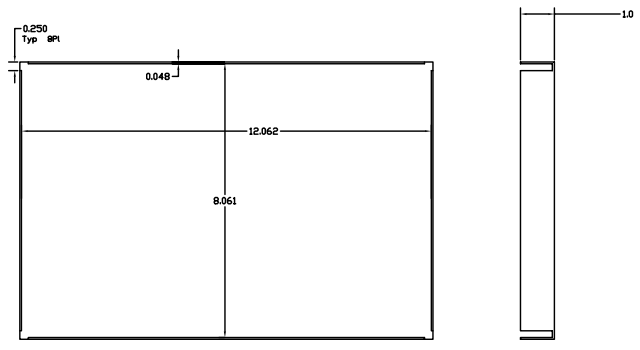
NO.	REVISION	BY	CH	SUP	APPROVED	DATE
1	MODIFY PER ECN # 5240	GL	SR	JS	G LABIK	30 MAR 07









Weld Notes:

Welding shall be performed in accordance with the requirements of PPPL Procedure ENG 037.

Visual inspection shall be performed in accordance with the acceptance criteria of AWS D1.6

Use inconel wire (ERNiCr-3 or ERNiCrMo-3) per PPPL Weld Procedure PPPL WPS # 107,to limit magnetic permeability

General Notes:

1. Use oversize washers to accommodate axial build of fillet weld at weld studs then standard ⅜ washer under hold down nut
2. Attach cover to base, PN 3 to PN 1 and or PN 2 using 0.005 inch 316 SS shim stock and spot weld

RELEASED FOR FABRICATION / INSTALLATION

PPPL Drafting: Jerry Siegel 2007.04.03 05:18:25 -05'00'

03	02	01	PART NO.	NOMENCLATURE OR DESCRIPTION	DRAWING NO.	MATERIAL
		18	3	Cover_ Plate 0.048 thick stock	This Drawing	316 SS
		18	2	Base_Plate_0.048 thick stock	This Drawing	316 SS
		36	1	Base_SideAngle Plate_0.048 thick stock	This Drawing	316 SS
		18		ASSEMBLY/WELDMENT	This Drawing	

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED

AutoCAD2000

DO NOT VERIFY INFORMATION BY SCALING DRAWING

SCALE: 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
MAGNETIC DIAGNOSTICS
CO WOUND LOOPS _ MODULAR COIL
SENSING CABLE PROTECTIVE BOX

DW: FOM | DATE: 17 JAN 07 | CADD FILE:
ENG: G LABIK | APPROVED: G LABIK
DWN: G LABIK | CHK: MC | SUPV: JS
CHK: M Cole | se 310-032
SHEET 1 OF 1 | REV 1

WELDING ENGINEER
APPVD: _____ DATE _____
APPVD: G Gettelfinger DATE _____