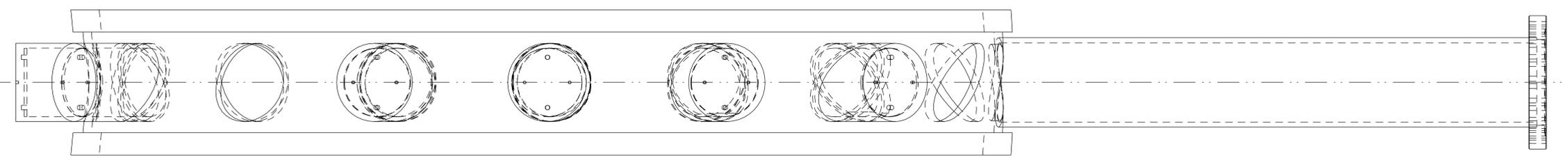
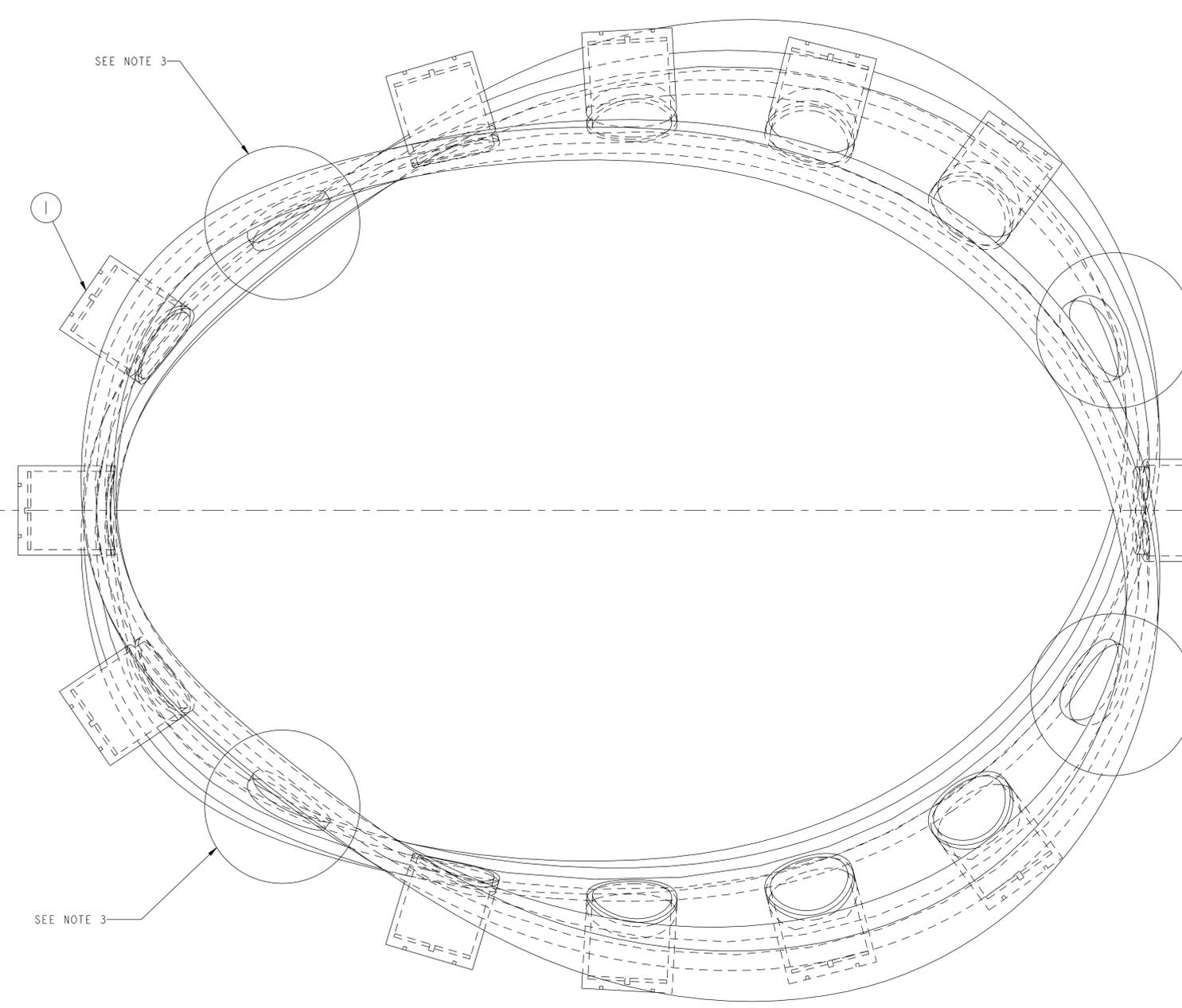


NO.	REVISION	BY	CH	SUP	APPROVED	DATE
1	REVISED PER ECN-5090	LM	TB	JS	T. BROWN	3-9-2006



A

A  
(SHEET 2)



**NOTES**

1. WELDING SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF ASME B31.3. WELDING PERFORMED ONSITE SHALL ALSO MEET THE REQUIREMENTS OF PPPL PROCEDURE ENG-037. VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH THE ACCEPTANCE CRITERIA OF ASME B31.3 CATEGORY D.
2. OPEN END OF SXR MOUNTING CUPS, PARTS 1, TO BE CUT OFF TO WITHIN APPROXIMATELY 3/16" OF INNER PROFILE OF VACUUM VESSEL SPACER, PART 2.
3. SXR MOUNTING CUP AT THIS LOCATION IS TO BE INSTALLED AT NCSX FINAL ASSEMBLY AT PPPL. THE FOUR UNATTACHED MOUNTING CUPS ARE TO BE SUPPLIED BY THE VENDOR. VENDOR IS TO MATCH MARK THESE TO CORRESPONDING THRU HOLES IN V.V. SPACER.
4. LEAK TEST TO BE PERFORMED AT VENDOR SITE IN ACCORDANCE WITH SPECIFICATION NCSX-CSPEC-121-02 WITH TEMPORARY COVERS COVERING THE FOUR HOLES WITH THE UNATTACHED MOUNTING CUPS OR THESE CUP HOLES CAN BE MACHINED AFTER LEAK TEST. ANY TEMPORARY COVERS ARE TO BE REMOVED.
5. INTERNAL 1/4-20 MOUNTING HOLES IN CUP CAP ARE TO BE LOCATED NORMAL TO SECTION A-A SHOWN ON SHEET 2.

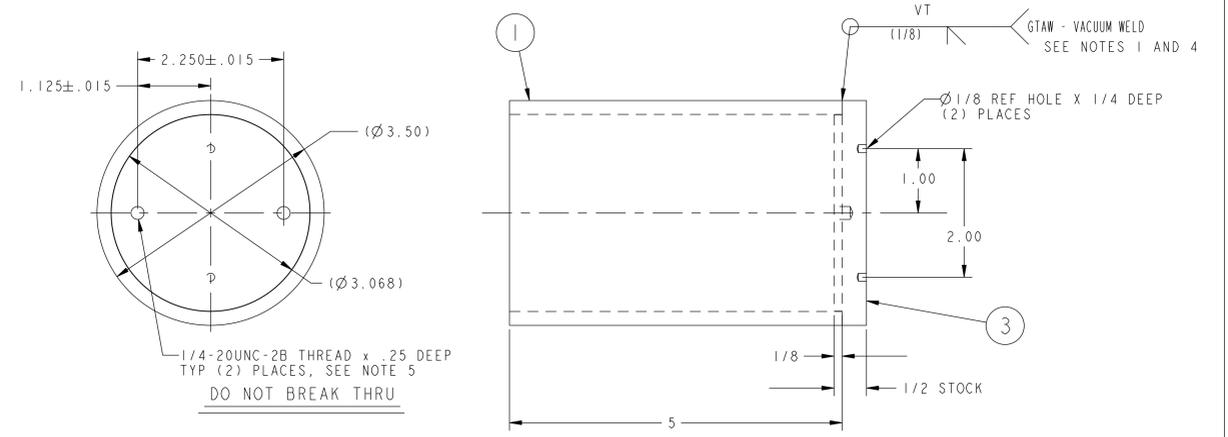
**RELEASED FOR FABRICATION / INSTALLATION**  
PPPL Drafting:

REV	PART NO.	DESCRIPTION	MATERIAL	SPECIFICATION	QTY REQD	
15	3	THIS DWG	SXR MOUNTING CUP CAP	INCONEL UNS N06625	ASTM B443	15
1	2	SE340-002	V.V. SPACER PREPARATION DETAIL	SEE DWG	---	1
15	1	THIS DWG	SXR MOUNTING CUP, PIPE 3.0 SCH 40 EAGLE ALLOY CORP 117 WEST PARK COURT TALBOTT, TN 37877 OR EQUIVALENT	INCONEL UNS N06625	ASTM B705	AR
X	---	THIS DWG	SXR ARRAY MOUNTING CUP WELDMENT	---	---	1

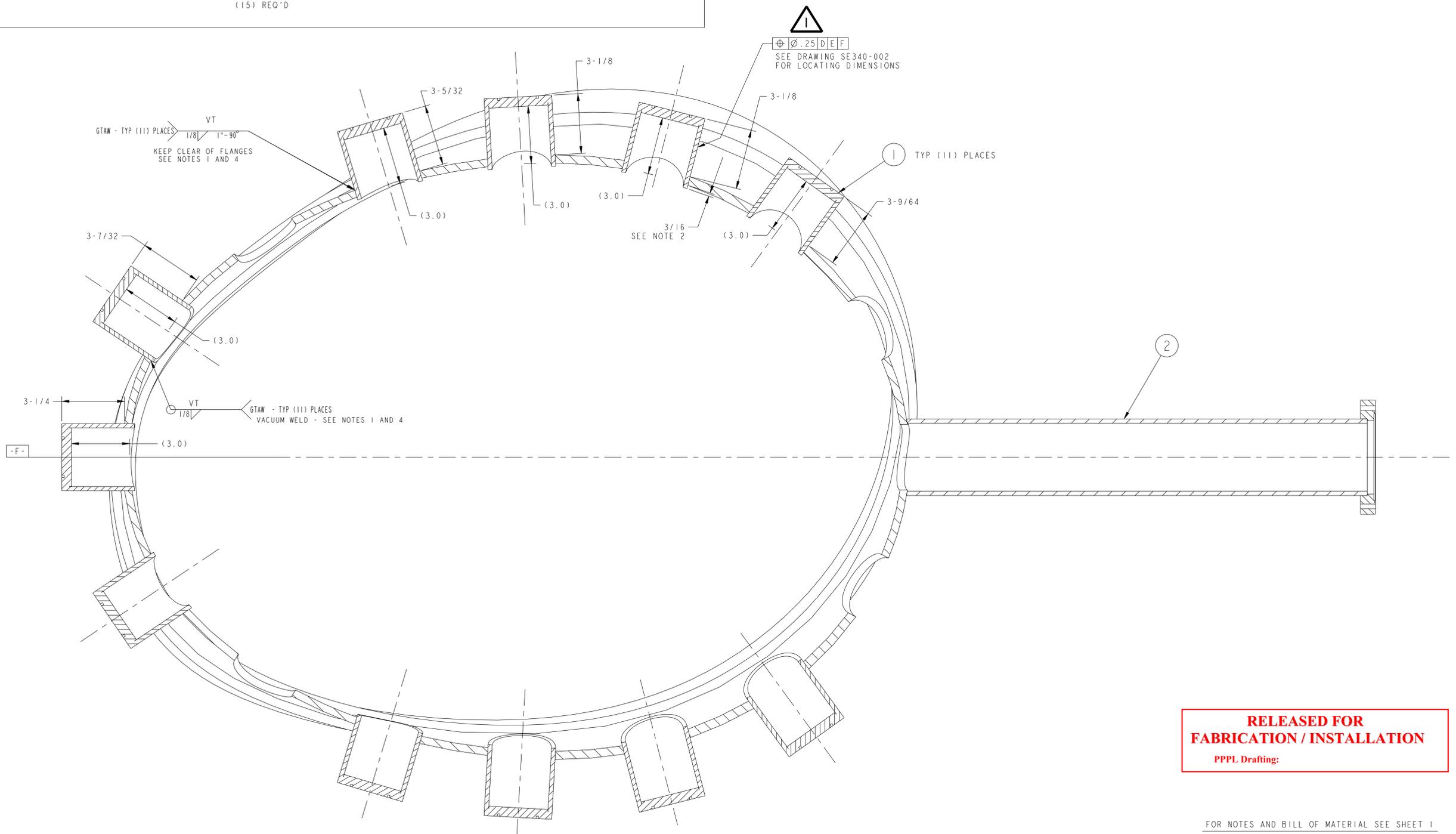
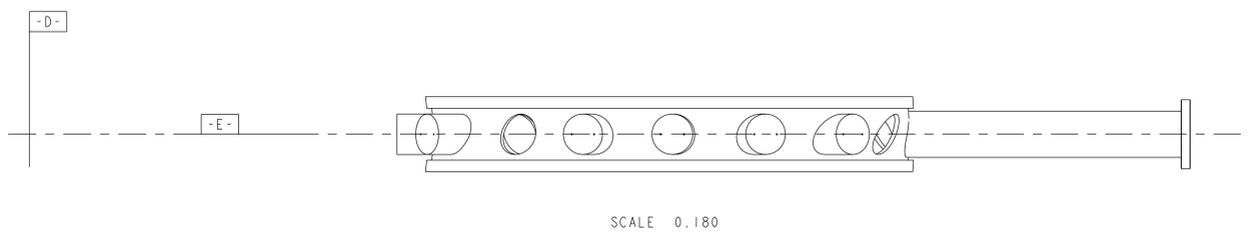
COMPUTER GENERATED DRAWING CHANGES NOT PERMITTED		CENTRAL FILES: UNLESS OTHERWISE SPECIFIED		PRINCETON PLASMA PHYSICS LABORATORY	
DO NOT VERIFY INFORMATION BY SCALING DRAWING		DIMENSIONS ARE IN INCHES MACHINE SURFACES UNLESS OTHERWISE SPECIFIED		NATIONAL COMPACT STELLARATOR EXPERIMENT	
WEIGHT: 15472.2 lbs		TOLERANCES NON-CUMULATIVE		MHD DIAGNOSTICS	
MODEL NAME: SE340-001		DECIMAL-INCH FRACTIONS		SOFT X-RAY DIAGNOSTIC	
WELDING ENGINEER: R. KEILBACH 2-24-06		NEXT ASSEMBLY		SXR ARRAY MOUNTING CUP WELDMENT	
RELEASE LEVEL: WIP		TOLERANCES: .005, .010, .015, .020, .030, .040, .050, .060, .070, .080, .090, .100, .125, .150, .175, .200, .250, .300, .375, .450, .500, .625, .750, .875, 1.000, 1.250, 1.500, 1.750, 2.000, 2.500, 3.000, 3.750, 4.500, 5.000, 6.250, 7.500, 8.750, 10.000		DRAWING NO: SE340-001	
DWG VERSION NO: 0		WELDING ENGINEER: R. KEILBACH 2-24-06		SHEET 1 OF 2	

NCSX-SE340-001

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



SXR MOUNTING CUP WELDMENT  
(15) REQ'D



SECTION A-A

DIMENSIONS SHOWN ARE SYMMETRICAL ABOUT HORIZONTAL CENTERLINE

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

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

COMPUTER GENERATED DRAWING CHANGES NOT PERMITTED Pro E DO NOT VERIFY INFORMATION BY SCALING DRAWING	CENTRAL FILES:	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY		
	UNLESS OTHERWISE SPECIFIED	NATIONAL COMPACT STELLARATOR EXPERIMENT		
WEIGHT +5472.2 lbs	DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	MHD DIAGNOSTICS SOFT X-RAY DIAGNOSTIC SXR ARRAY MOUNTING CUP WELDMENT		
MODEL NAME SE340-001	TOLERANCES NON-CUMULATIVE	DSN: L. MORRIS	2/24/06	DRAWING NO:
WELDING ENGINEER	DECIMAL-INCH FRACTIONS	CHK: M. COLE	2/24/06	<b>SE340-001</b>
RELEASE LEVEL: WIP DWG VERSION NO: 0	.XX ±.000 .XXX ±.005 ANGULAR ±.0°-15°	ENGR: T. BROWN	2/24/06	SHEET 2 OF 2
	OVER 120° ±.1°-172°	SUPV: J. SIEGEL	2/24/06	REV 1

NCSX-SE340-001