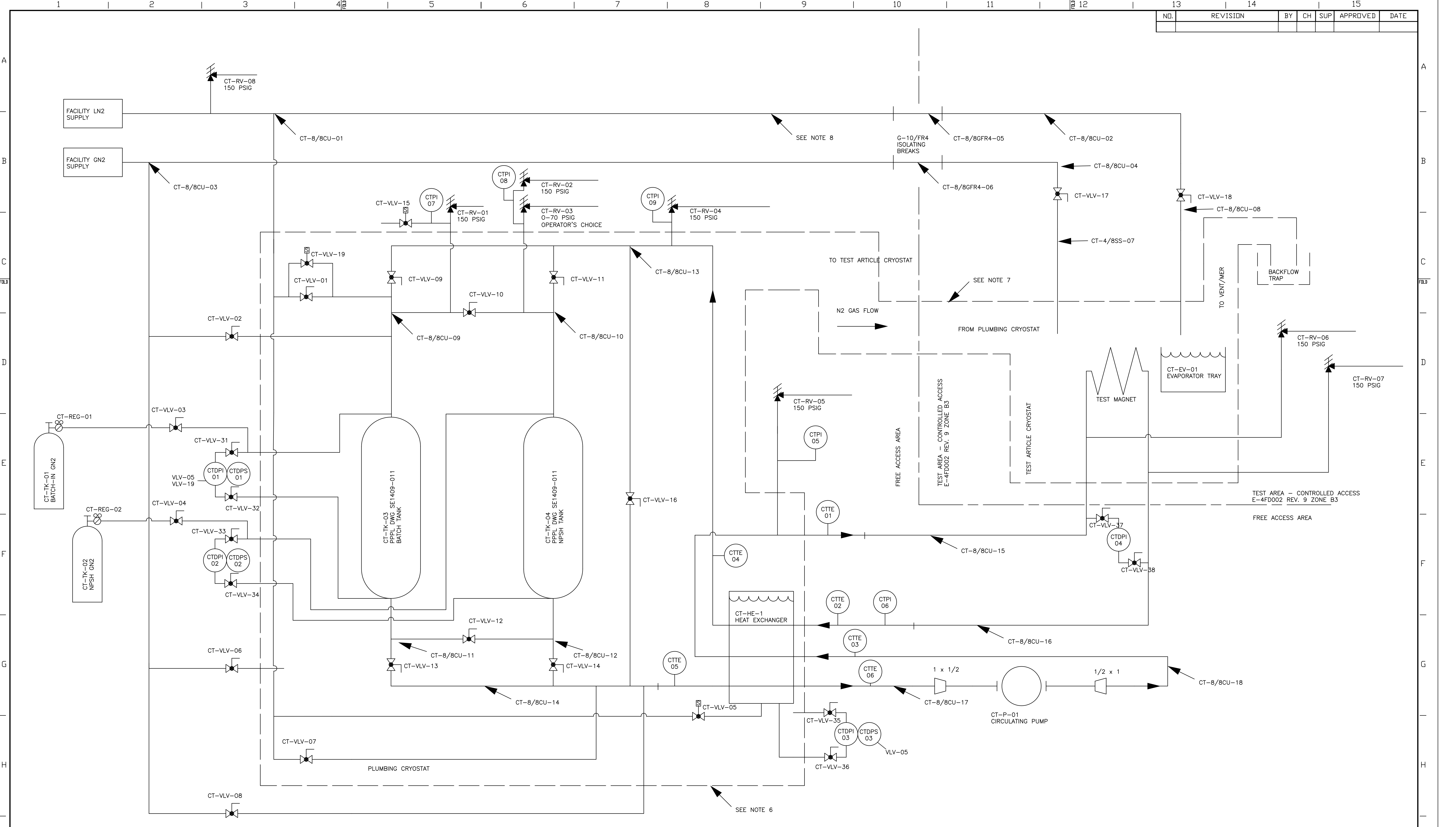


NO.	REVISION	BY	CH	SUP	APPROVED	DATE



- NOTES:
1. ALL BRAZES SHALL BE PERFORMED PER PROC EM-002.
  2. VISUAL INSPECTION CRITERIA FOR TORCH-BRAZED JOINTS PERFORMED UNDER BPS-1: ASSURE THAT BRAZING FILLER METAL HAS PENETRATED INTO THE JOINT AND THAT THERE ARE NO VOIDS OR CRACKS.
  3. CRITERIA FOR GTAW/BCuP FILLETS PERFORMED PER WPS-400: 3/64-INCH FILLETS SHALL CONFORM WITH THE VISUAL INSPECTION CRITERIA OF B31.3, CATEGORY D.
  4. SYSTEM SHALL BE HYDROSTATICALLY TESTED TO 190 PSIG.
  5. ALL MANUAL VALVES SHOWN IN A CRYOSTAT ARE LONG-BONNET TYPES WITH THEIR HANDLES PROTRUDING THROUGH THE INSULATION INTO THE AMBIENT TEMPERATURE AREA FOR PERSONNEL ACCESS.
  6. PLUMBING CRYOSTAT IS 6-INCH WALL THICKNESS MADE OF 2-INCH OR THINNER LAYERS OF POLYISOCYANURATE FOAM (DOW TRYMER 2000 OR EQUIVALENT). ALL JOINTS STAGGERED FROM ADJACENT JOINTS.
  7. DUCT FROM PLUMBING CRYOSTAT TO TEST ARTICLE CRYOSTAT MADE OF 4-INCH ID, 2-INCH WALL POLYISOCYANURATE FOAM PIPE INSULATION (DOW TRYMER 2000 OR EQUIVALENT).
  8. 1-INCH LN2 FIELD RUNS TO BE INSULATED WITH 1.63 ID X 2-INCH WALL POLYISOCYANURATE FOAM PIPE INSULATION (DOW TRYMER 2000 OR EQUIVALENT). ANNULUS BETWEEN PIPE AND INSULATION TO BE FILLED WITH EXPANDING POLYURETHANE FOAM INSULATION.
  9. DEVICES CT-VLV-31 THRU -38 ARE INSTRUMENT ISOLATION VALVES. TAP LINES TO PROCESS ARE 0.250 OD SS X 0.049 WALL OR THICKER WITH COMPRESSION FTGS FOR 200 PSIG SERVICE. TAP LINES ARE NOT ASSIGNED UNIQUE IDENTIFIERS.
  10. SS PROCESS TAP LINES MAY TRANSITION TO CU/BRASS BEFORE CT-VLV-31 THRU -38 BUT OUTSIDE OF INSUL SYSTEM.
  11. UNINSULATED GN2 LINES PENETRATING CRYOSTATS SHALL BE SS THRU CRYOSTAT WALL.
  12. RISERS FOR RELIEF VALVES MAY BE 1/2 SCH 40-NPT FORMAT.

PART NO.	DRAWING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY REQD
PARTS LIST				
COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED		CENTRAL FILES UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY NATIONAL COMPACT STELLARATOR EXPERIMENT	
AUTO CAD		DIMENSIONS ARE IN INCHES MACHINE SURFACES	COIL TEST FACILITY PIPING & INSTRUMENTATION DIAGRAM	
DO NOT VERIFY INFORMATION BY SCALING DRAWING		BREAK SHARP EDGES 005/020	DRAWING NO: SE1409-12	
NEXT ASSEMBLY		TOLERANCES NON-CUMULATIVE	DSN: G. GETTELFINGER	CHK: M. MESSINED
		DECIMAL-INCH FRACTIONS	ENGR: G. GETTELFINGER	SUPV: J. SIEGEL
		.XX +/- .000 0°-15°		
		.XXX +/- .005 15°-75°		
		ANGULAR +/- .01° 75°-120°		
		OVER 120° +/- .12°		
WEIGHT				
MODEL NAME				
WELDING ENGINEER				
		SHEET 1 OF 1		REV 0

NCSX-SE1409-12