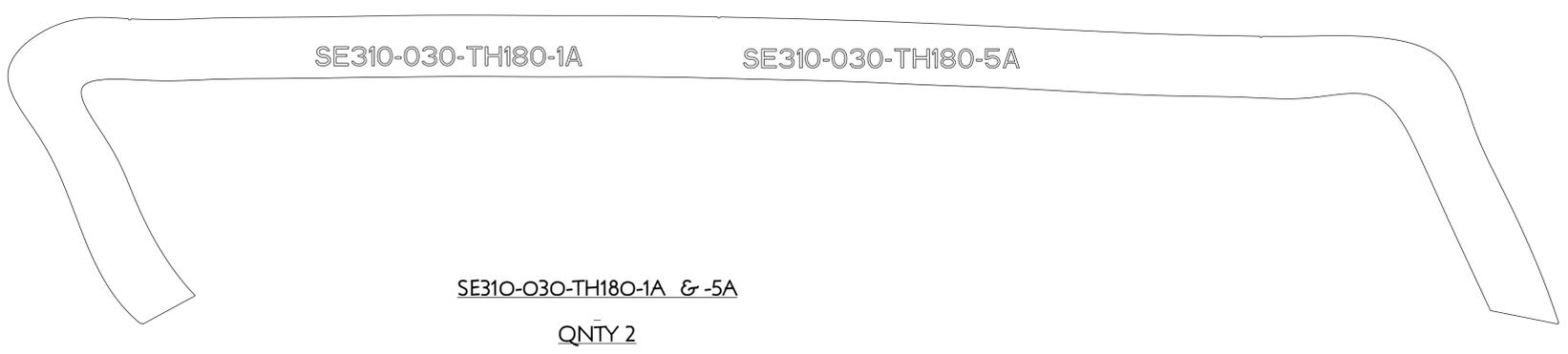
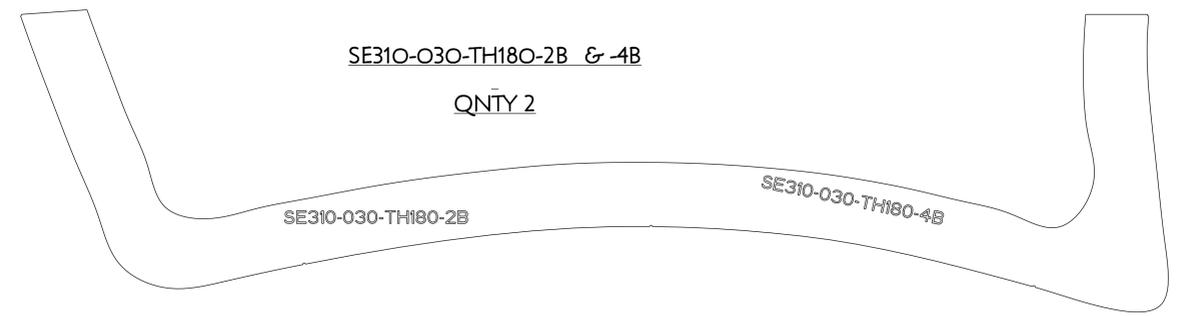
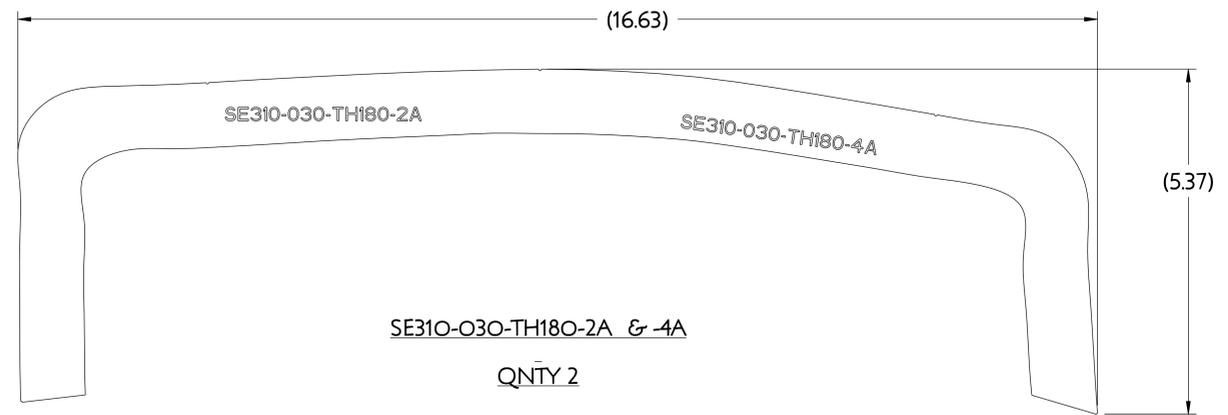
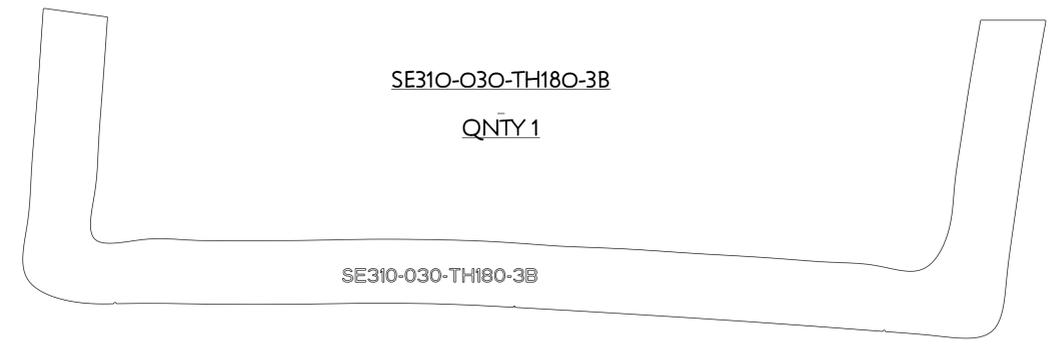
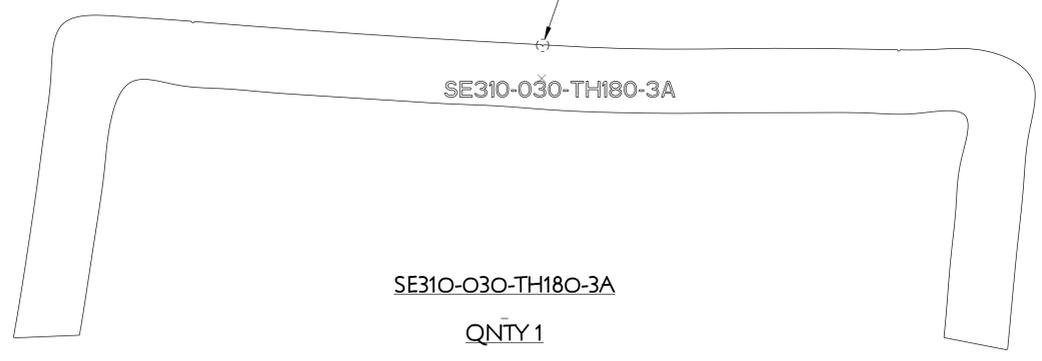


NO.	REVISION	BY	CH	SUP	APPROVED	DATE

SEE DETAIL B

DETAIL B
SCALE 6.000

NOTCH LOCATION AND
QUANTITY VARIES
BY PART



NOTES:

- DRAWING DEPICTS FLAT PATTERN OF FORMED PARTS DEFINED BY PRO/ENGINEER FILES SE310-030-B*.PRT.
- THE MATERIAL USED SHALL BE COPPER ALLOY UNS C 11000, ANNEALED OR 1/8 HARD (HOO-TEMPER) PER ASTM B370 OR ASTM B152
- MACHINED EDGES ARE TO BE DEBURRED AND SMOOTH TO PRECLUDE INJURY FROM HANDLING.
- PART NUMBERS AND ALIGNMENT ARROWS ARE TO BE PERMANENTLY MECHANICALLY ETCHED INTO THE TEMPLATE SURFACE EXACTLY AS SHOWN IN THE DRAWING. SOME TEMPLATES HAVE TWO TAG NUMBERS AND ALIGNMENT ARROWS. TAG NUMBERS AND ARROWS ARE USED TO ORIENT THE TEMPLATE DURING INSTALLATION.
- HANDLING AND PROCESSING SHALL BE CONTROLLED TO MINIMIZE WORK HARDENING.
- THE EDGES ARE TO BE PERPENDICULAR TO THE TEMPLATE SURFACE TO + OR - 5 DEGREES (+ OR - 0.004 INCH) MACHINED TEMPLATES ARE TO BE DELIVERED TO PPPL WITH THE SAME TEMPER AS THE STOCK SHEETS (RAW MATERIAL). IT IS RECOGNIZED THAT THE CUT EDGES MAY BE SLIGHTLY HARDENED FROM THE CUTTING PROCESS.
- COATING THE SURFACE TO FACILITATE MACHINING IS PERMITTED. THE TEMPLATES ARE USED TO LOCATE AND WIND MAGNETIC COILS AND ARE REMOVED AFTERWARD.
- THE LOCATOR SEMICIRCULAR HOLES AND THEIR RESPECTIVE LOCATIONS ARE TO BE POSITIONED TO + OR - 0.005 INCH AND VERIFIED BY INSPECTION. THE GENERAL TEMPLATE DIMENSIONS ARE TO BE WITHIN + OR - 0.020 INCH OF THE IDEAL GEOMETRY (DXF MODEL). THE PPPL PROVIDED E-SIZE DRAWINGS WITH FULL SCALE TEMPLATES ARE TO BE USED BY THE VENDOR AS A "GO- NO GO" GAUGE.

TYP NOTCH
.020 R

DETAIL A
SCALE 6.000

SEE DETAIL A

SCALE 1.000

RELEASE LEVEL:
DWG VERSION NO:

WEIGHT	0.0 lbs
MODEL NAME	SE310-030-TH180-1A
WELDING ENGINEER	

PART NO.	DRAWING NO	NOMENCLATURE OR DESCRIPTION	SEE NOTES	MATERIAL	QTY RECD
PARTS LIST					
COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY NATIONAL COMPACT STELLARATOR EXPERIMENT			
DO NOT VERIFY INFORMATION BY SCALING DRAWING	DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	DIAGNOSTICS MAGNETIC DIAGNOSTICS MAGNETIC LOOPS SERIES THO-180			
PRO E	TOLERANCES NON-CUMULATIVE	DSN: J. RUSHINSKI	1/12/06	DRAWING NO:	
NEXT ASSEMBLY	DECIMAL-INCH FRACTIONS	CHK: T. BROWN	1/12/06	SE310-030-TH180	
	.XX +/- .030	ENGR: G. LABIK	1/12/06	SHEET 1 OF 1	
	.XXX +/- .005	SUPV: J. SIEGEL	1/12/06	REV 0	
	ANGULAR +/- 0°15'			NCSX-PART-FORMAT.E	

NCSX-SE310-030-TH180