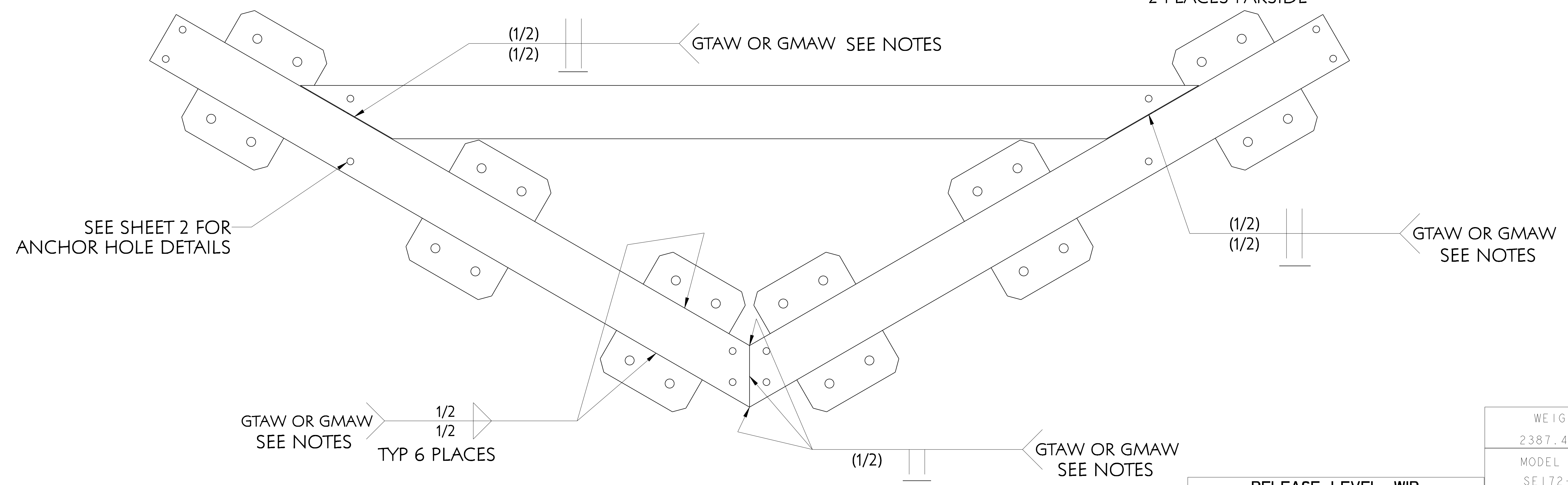
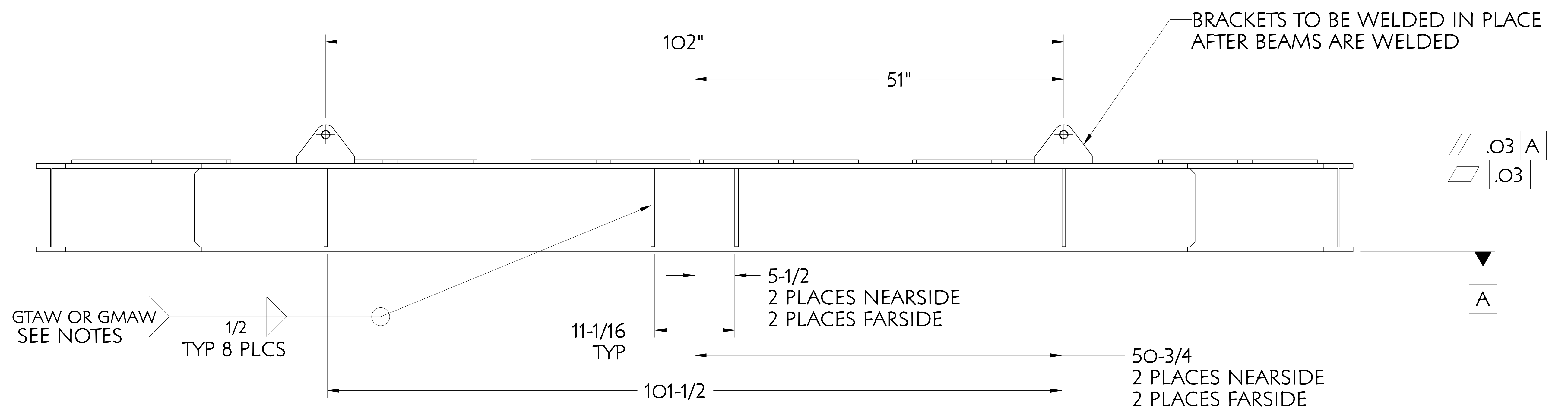


- DRAWINGS PREPARED IN ACCORDANCE WITH ASME Y14.100-2000
- INTERPRET DIMENSIONS & TOLERANCES PER ASME Y14.5-1994.
- DIMENSIONS ARE IN INCHES.
- SEE SPECIFICATION NCSX-CSPEC-XXX-XX-XX FOR ADDITIONAL INFORMATION AND/OR MATERIAL REQUIREMENTS.
- WELDING SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF AWS D1.6 (STRUCTURAL WELDING OF AUSTENITIC STAINLESS STEEL) AND PPPL PROCEDURE NO. ENG-037. VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH THE ACCEPTANCE CRITERIA OF AWS D1.6.
- REFERENCE PERMEABILITY

BASE MATERIAL	1.05
FABRICATED PART	1.05
WELD	1.05
- NOTE ORIENTATION OF ALL PARTS BEFORE WELDING.
- DRAWING DEPICTS FINAL REQUIRED ASSEMBLED STATE. MANUFACTURING TO DETERMINE MATERIAL ALLOWANCES AND WELD DISTORTION ALLOWANCES REQUIRED TO ACHIEVE DIMENSIONS/TOLERANCES INDICATED.



3 ASSEMBLIES REQUIRED

PART NO.	DRAWING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY	RECD
5	SE172-252-3	CENTER SUPPORT STRUCTURE BRIDGING BEAM GUSSET	304L ST STL	8	
4	SE172-203-2	BASE SUPPORT STRUCTURE BRACKET	304L ST STL	2	
3	SE172-207-3	OUTER SUPPORT BASE MOUNTING PLATE	304L ST STL	6	
2	SE172-207-2	OUTER SUPPORT BASE CROSS BEAM - W12" x 50#	304L ST STL	1	
1	SE172-207-1	OUTER SUPPORT BASE ANGLED BEAM - W12" x 50#	304L ST STL	2	

PARTS LIST			
COMPUTER GENERATED DRAWING	CENTRAL FILES:	PRINCETON PLASMA PHYSICS LABORATORY	
MANUAL CHANGES NOT PERMITTED	UNLESS OTHERWISE SPECIFIED	PRINCETON, NJ 08542-0801	
PROJ: E	DIMENSIONS ARE IN INCHES	NATIONAL COMPACT STELLARATOR EXPERIMENT	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	MACHINE SURFACES	STELLARATOR CORE	
	BREAK SHARP EDGES .005/.020	BASE SUPPORT STRUCTURE	
	TOLERANCES - NON-CUMULATIVE	DSN: T. CRUICKSHANK	DRAWING NO:
	DECIMAL - INCH FRACTIONS	CHK: ENGR: F. DAHLGREN	SE172-207
	.XX ±.030 .12"-.12" ±.110	SUPV: SUPV:	SHEET 1 OF 5
	.XXX ±.005 .72"-.120" ±.114		REV 0
	ANGULAR ±.0°-15° OVER 120° ±.112		

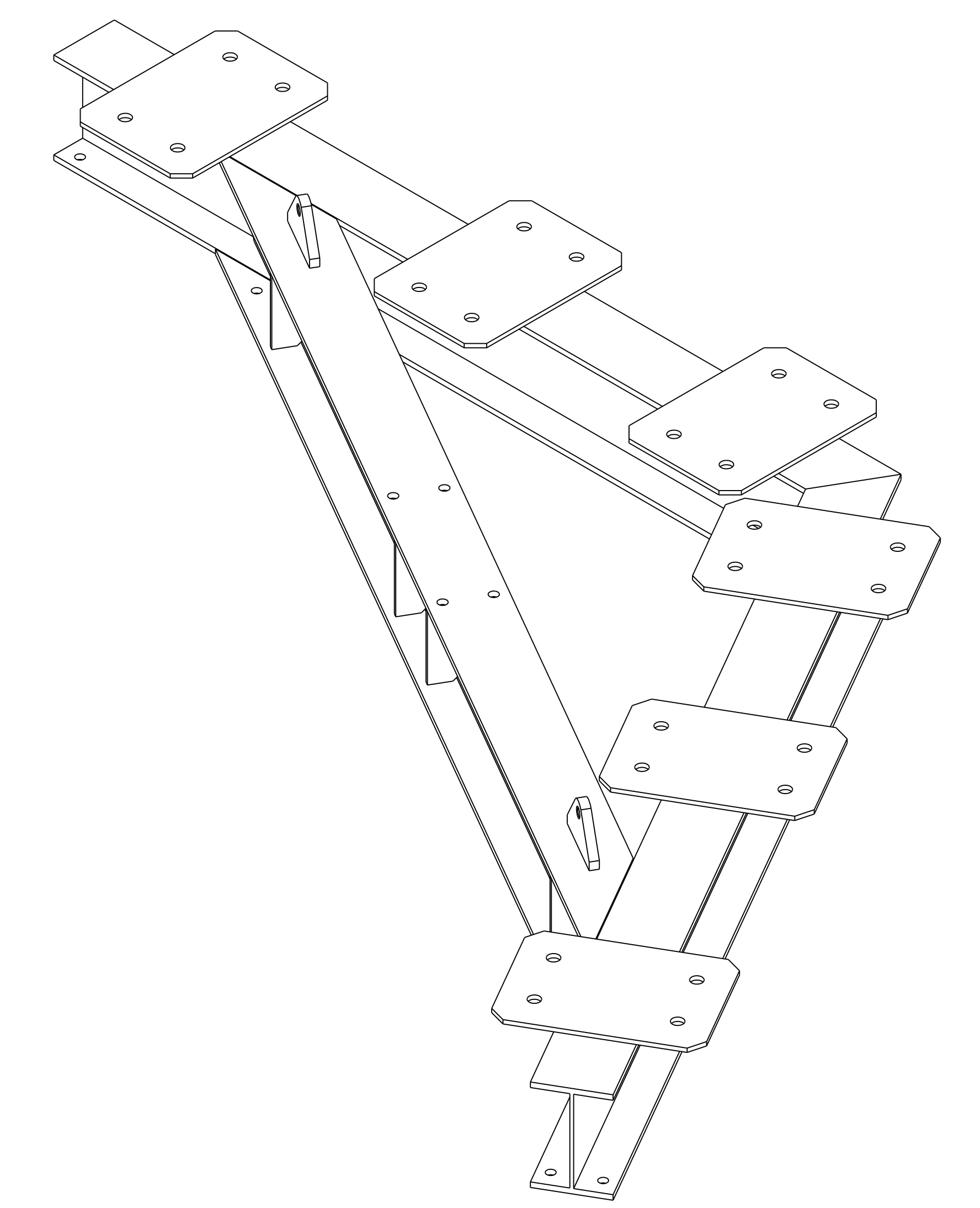
WEIGHT
2387.4 lbs

MODEL NAME
SE172-207

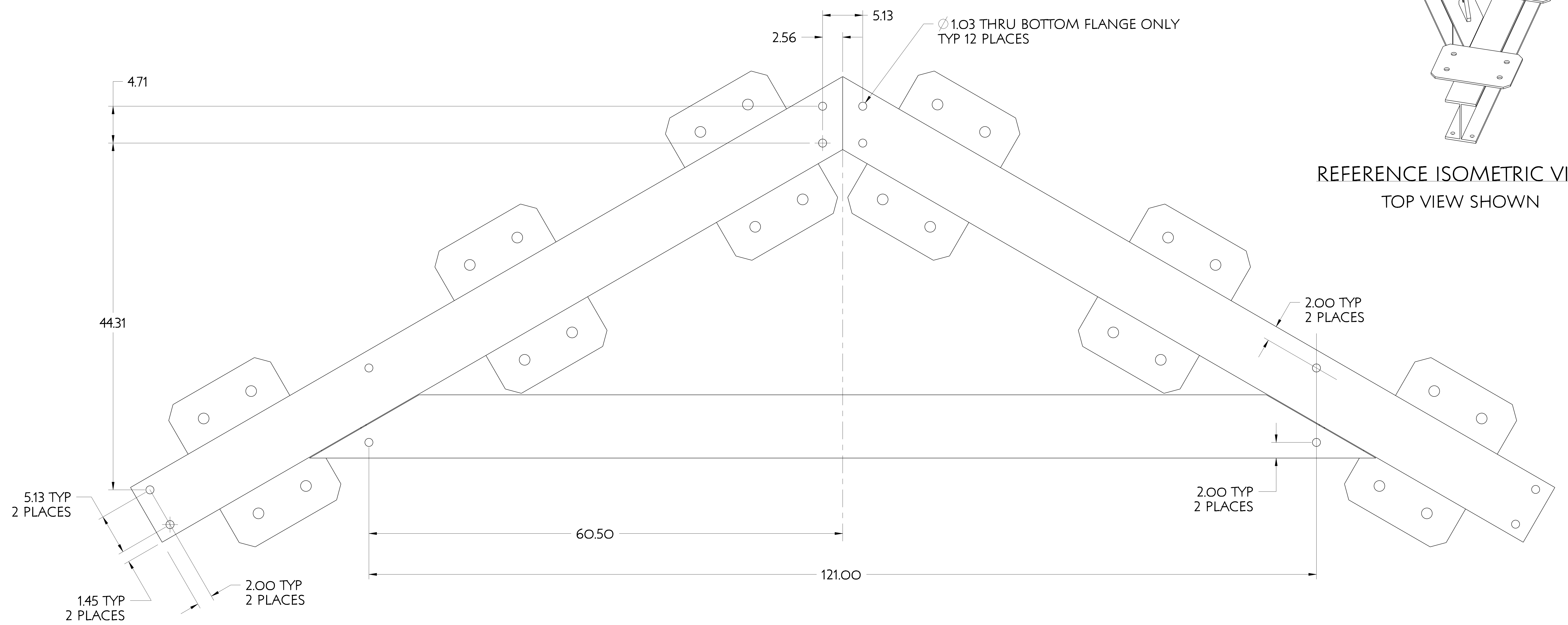
RELEASE LEVEL: WIP
DWG VERSION NO: 13

NCSX-SE172-207

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



REFERENCE ISOMETRIC VIEW
TOP VIEW SHOWN



BOTTOM VIEW

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

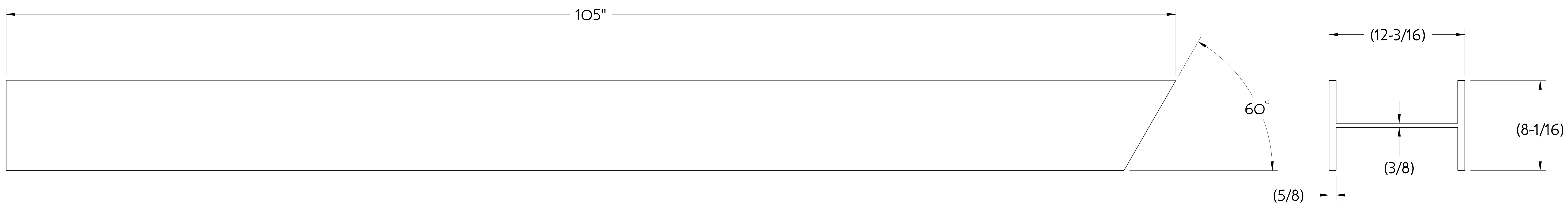
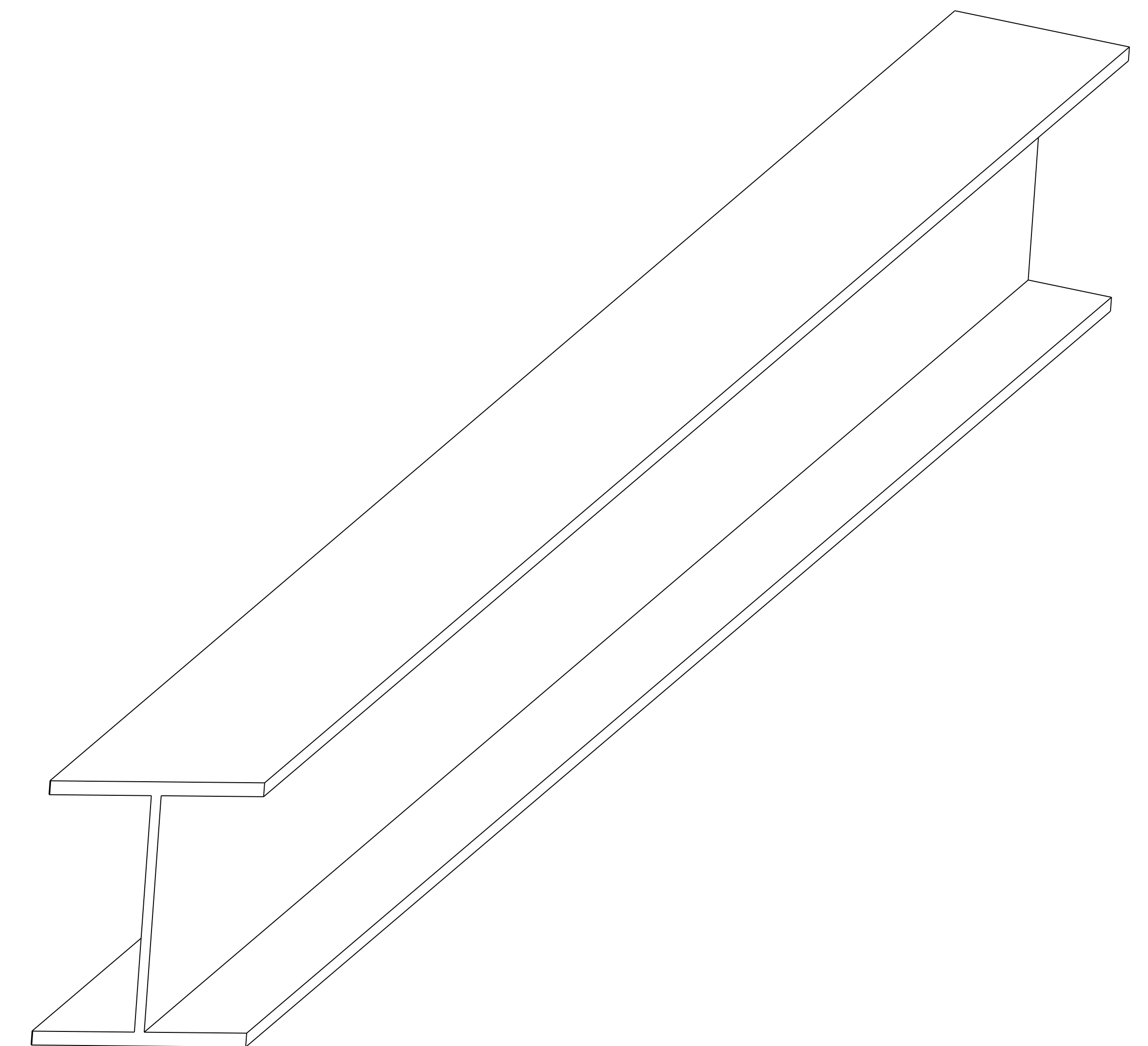
RELEASE LEVEL: WIP
DWG VERSION NO: 13

WEIGHT	152.3 lbs
MODEL NAME	SE172-207-3
WELDING ENGINEER	

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	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	STELLARATOR CORE BASE SUPPORT STRUCTURE OUTER SUPPORT BASE WELDMENT
NEXT ASSEMBLY	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .X ±.000 .XX ±.000 .XXX ±.005 ANGULAR ±.0°/15°	DSN: T. CRUICKSHANK CHK: ENGR: F. DAHLGREN SUPV: DRAWING NO: SE172-207
		SHEET 2 OF 5 REV 0.8

NCSX-SE172-207

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



1 OUTER SUPPORT BASE ANGLED BEAM - W12" x 50#

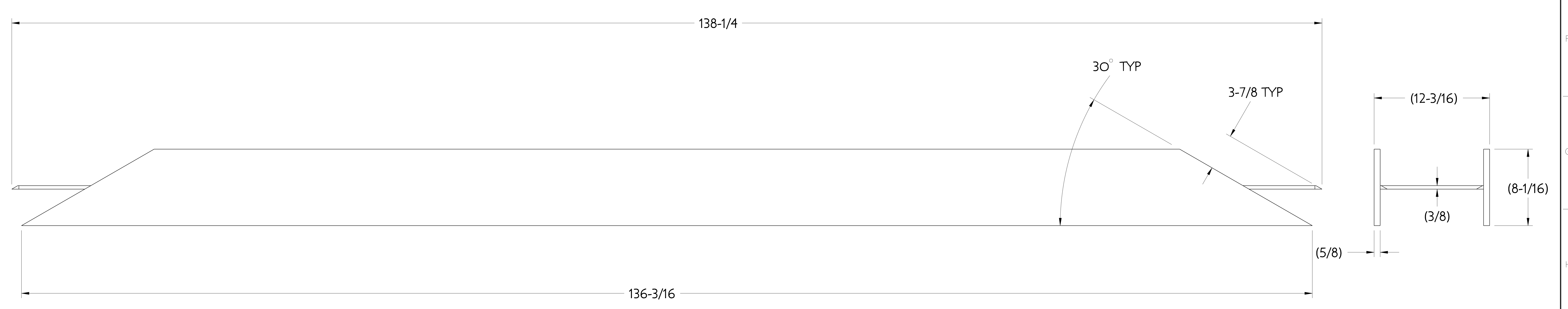
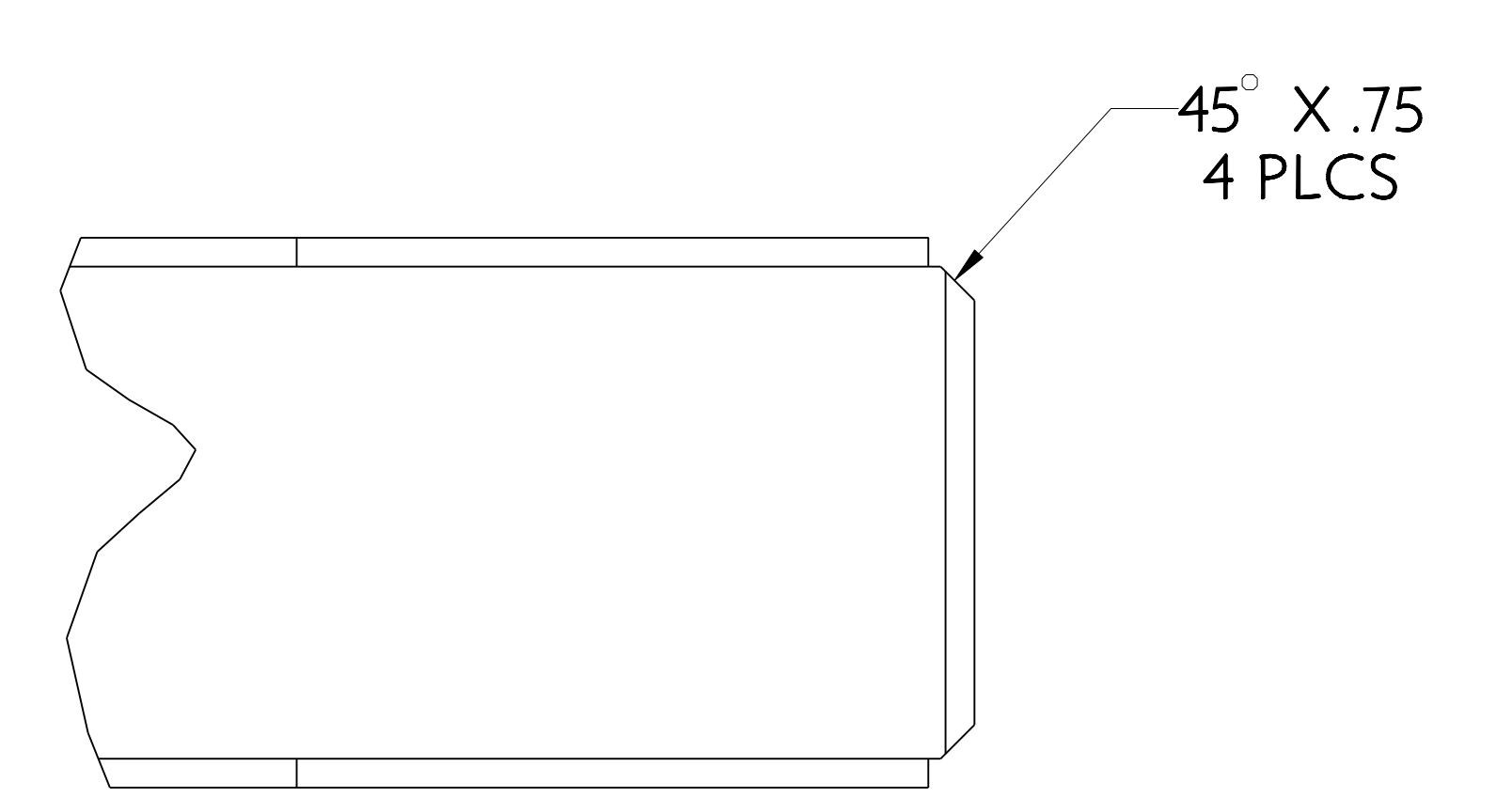
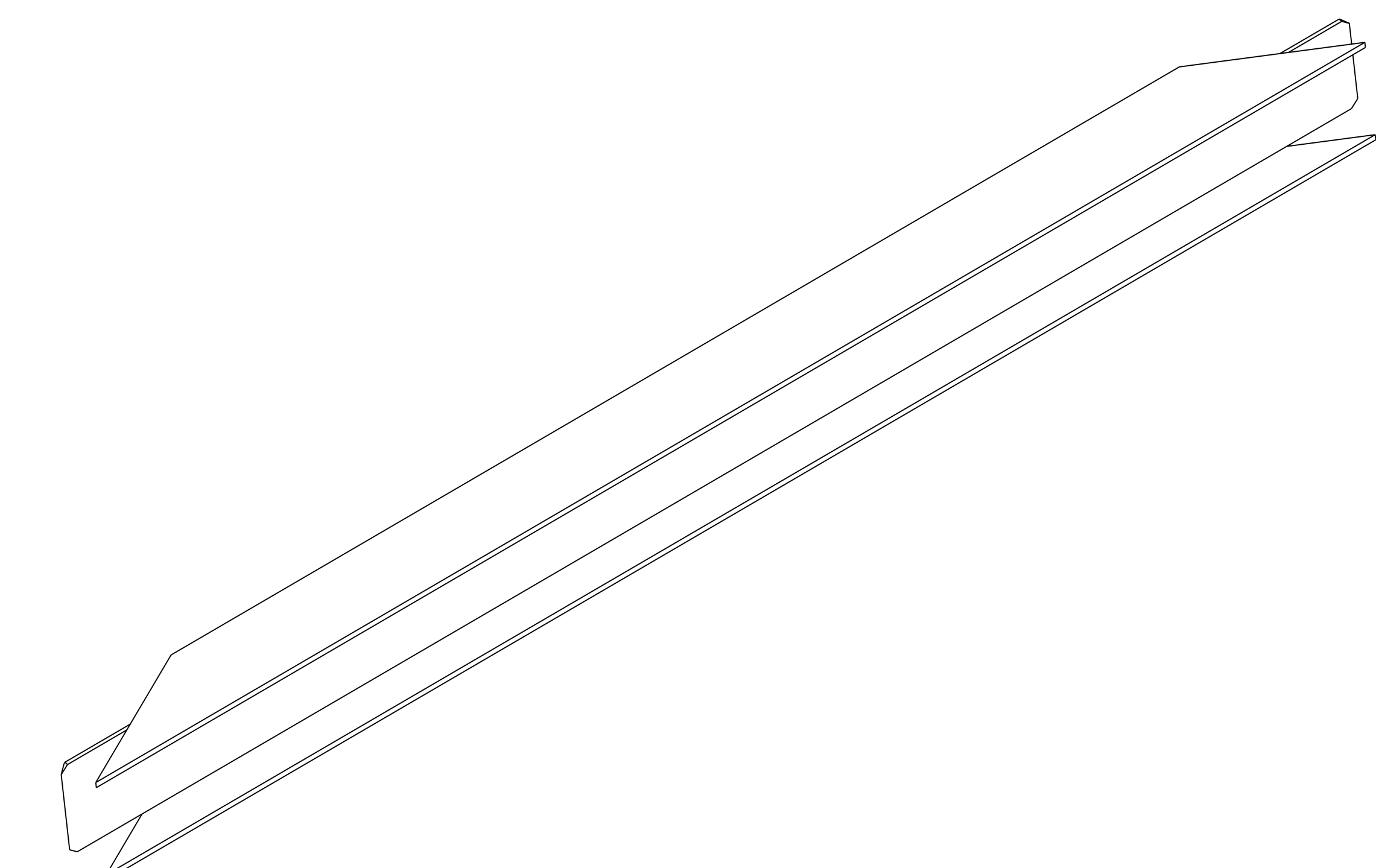
6 REQUIRED

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

COMPUTER GENERATED DRAWING MANUAL 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 428.2 lbs	DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	STELLARATOR CORE BASE SUPPORT STRUCTURE OUTER SUPPORT BASE WELDMENT	
MODEL NAME SE172-207-1	TOLERANCES NON-CUMULATIVE	DSN: T. CRICKSHANK	DRAWING NO:
RELEASE LEVEL: WIP DWG VERSION NO: 8	DECIMAL-INCH FRACTIONS	CHK:	SE172-207
WELDING ENGINEER	.XX ±.030 0°-12° ±.124 .XX ±.005 12°-120° ±.114 ANGULAR ±.0°-15° OVER 120° ±.112	ENGR: F. DAHLGREN	SHEET 3 OF 5 REV 0.6
NEXT ASSEMBLY	SUPV:		

NCSX-SE172-207

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



2 OUTER SUPPORT BASE CROSS BEAM - W12" x 50#

3 REQUIRED

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

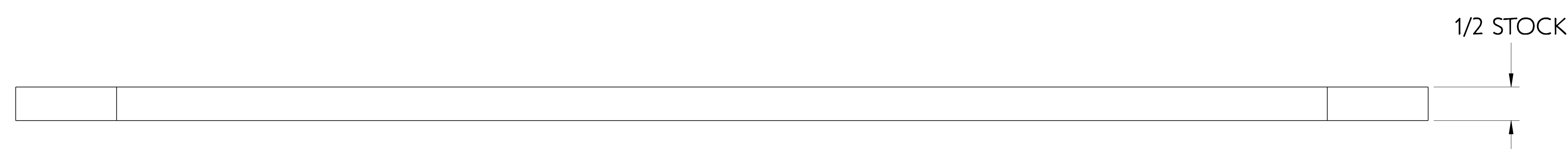
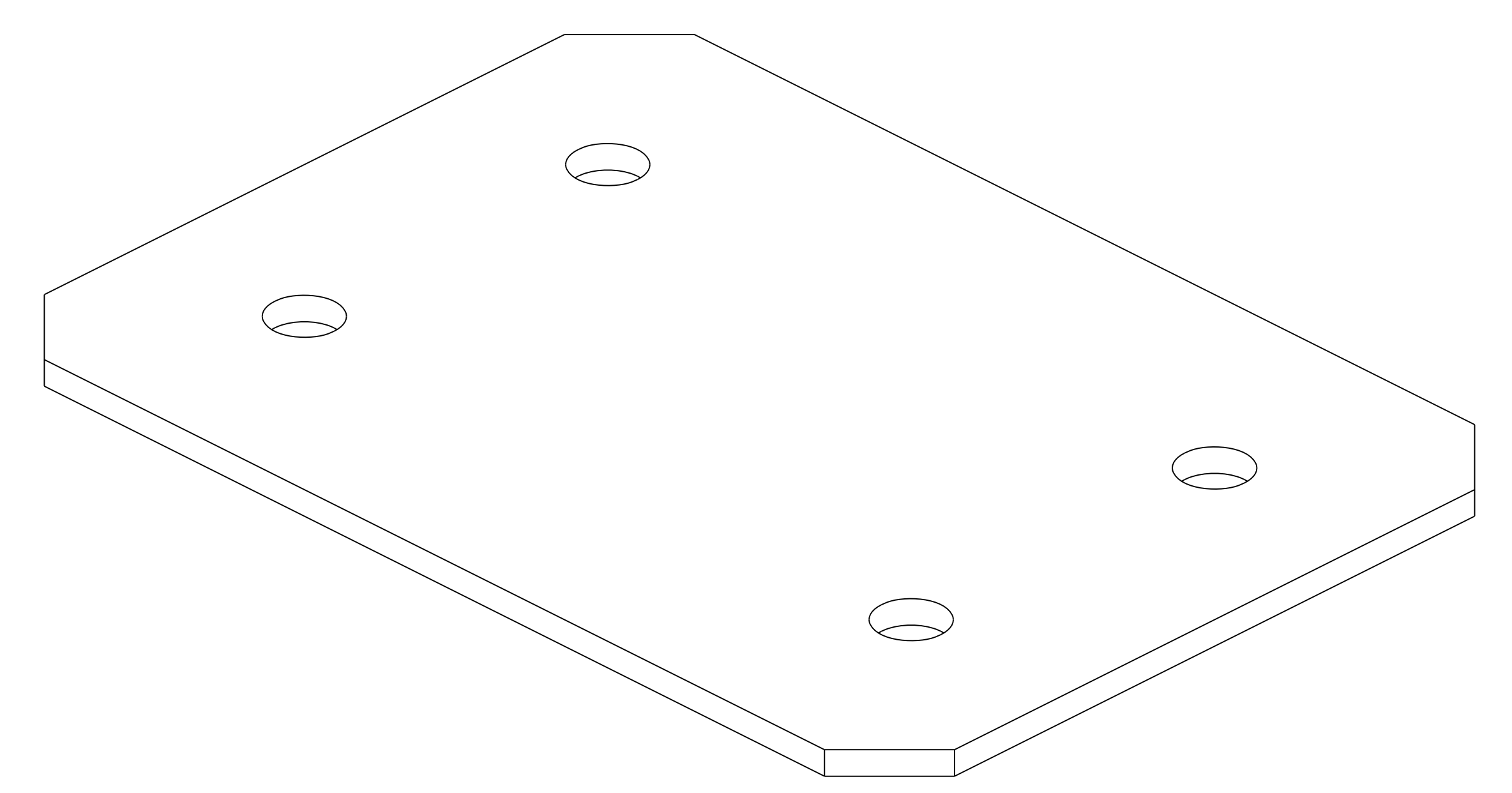
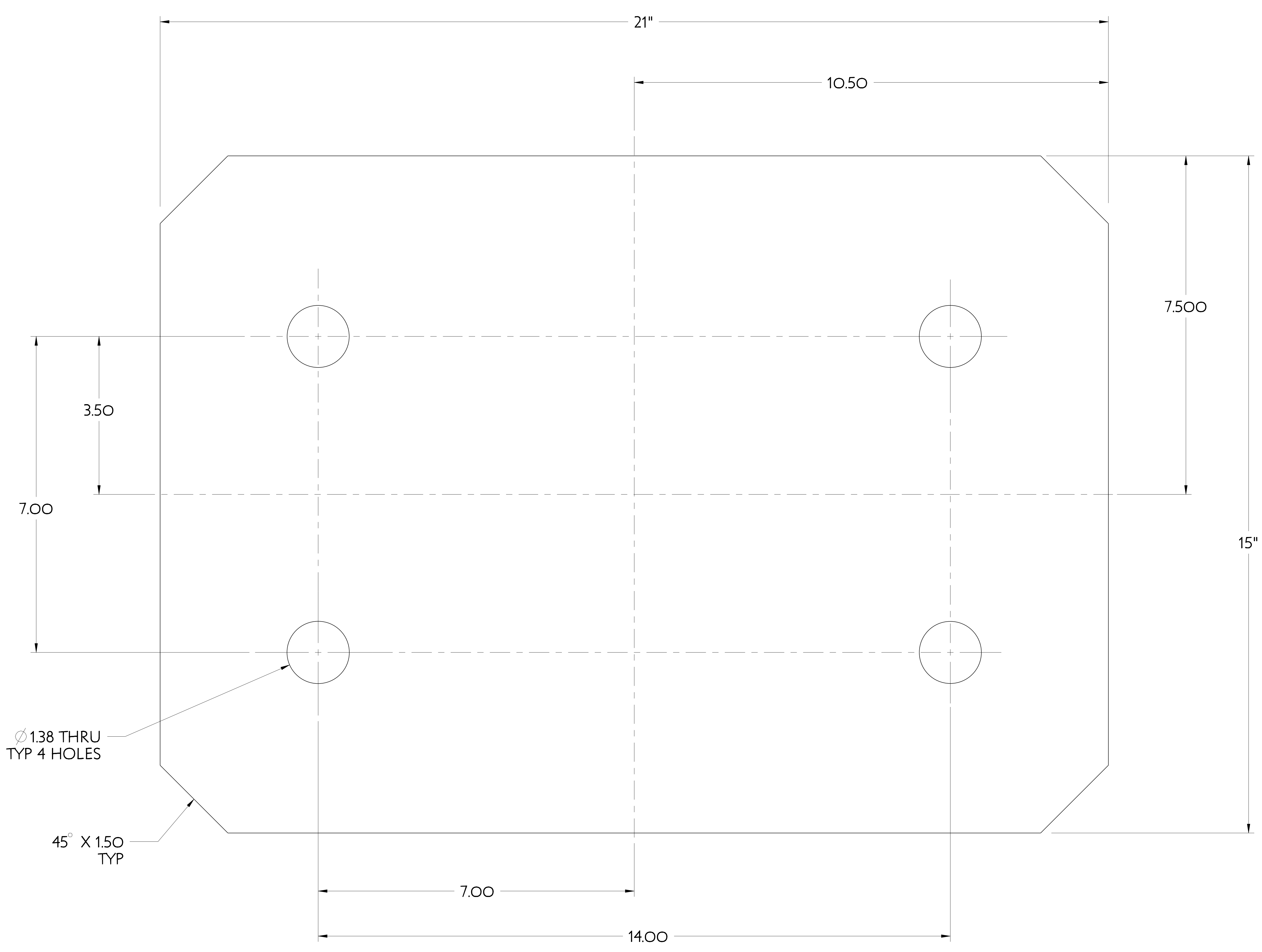
RELEASE LEVEL: WIP
DWG VERSION NO: 7

WEIGHT
527.4 lbs
MODEL NAME
SE172-207-1
WELDING
ENGINEER

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY NATIONAL COMPACT STELLARATOR EXPERIMENT	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	STELLARATOR BASE BASE SUPPORT STRUCTURE OUTER SUPPORT BASE WELDMENT	
NEXT ASSEMBLY	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .X ±.010 0°-120° ±.125 .XX ±.030 120°-120° ±.125 .XXX ±.005 120°-120° ±.125 ANGULAR ±.0°-15° OVER 120° ±.125	DSN: T. CRICKSHANK CHK: ENGR: F. DAHLGREN SUPV:	DRAWING NO: SE172-207 SHEET 4 OF 5 REV 0.6

NCSX-SE172-207

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



18 REQUIRED

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

3 OUTER SUPPORT BASE MOUNTING PLATE

RELEASE LEVEL: WIP
DWG VERSION NO: 13

WEIGHT	152.3 lbs
MODEL NAME	SE172-207-1
WELDING ENGINEER	

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY NATIONAL COMPACT STELLARATOR EXPERIMENT
DO NOT VERIFY INFORMATION BY SCALING DRAWING	DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	STELLARATOR CORE BASE SUPPORT STRUCTURE OUTER SUPPORT BASE WELDMENT
NEXT ASSEMBLY	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX +/- .005 ANGULAR +/- .15	DSN: T. CRICKSHANK CHK: ENGR: F. DAHLGREN SUPV: DRAWING NO: SE172-207
		SHEET 5 OF 5 REV 0.6

NCSX-SE172-207