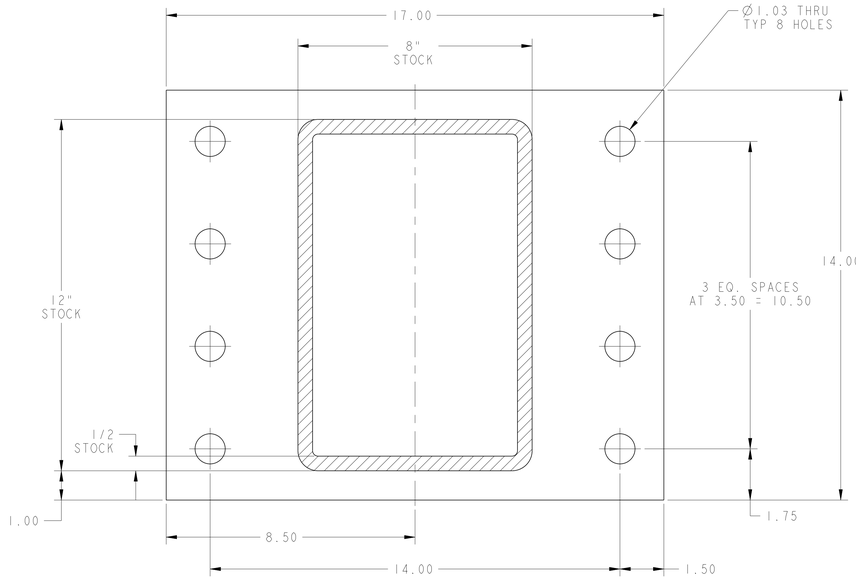
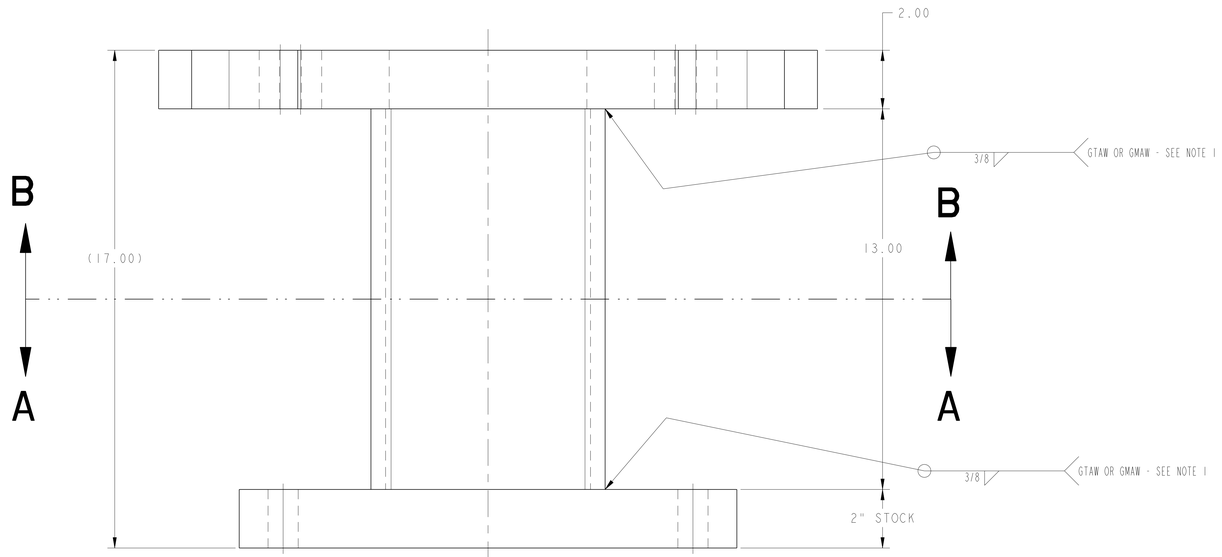
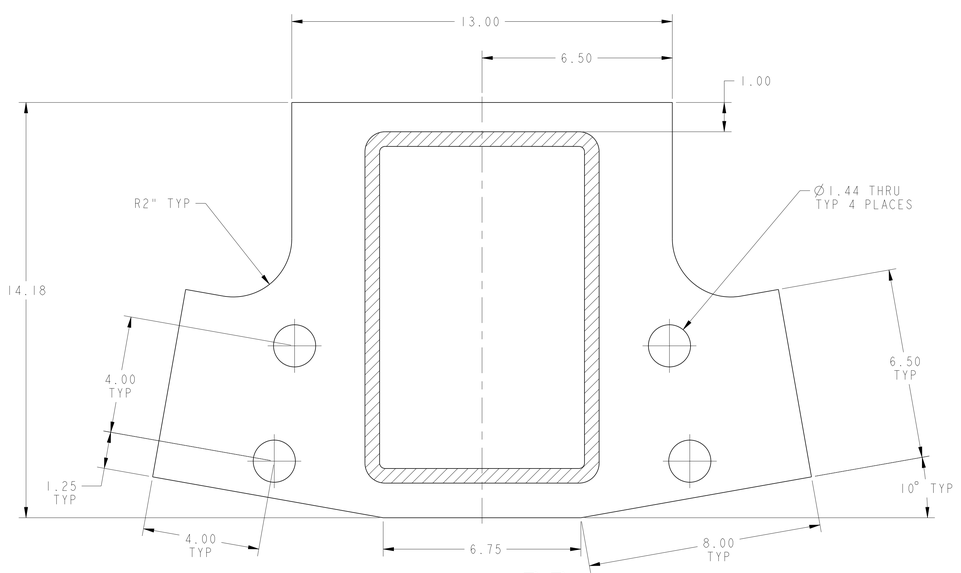
NO.	REVISION	BY	CH	SUP	APPROVED	DATE



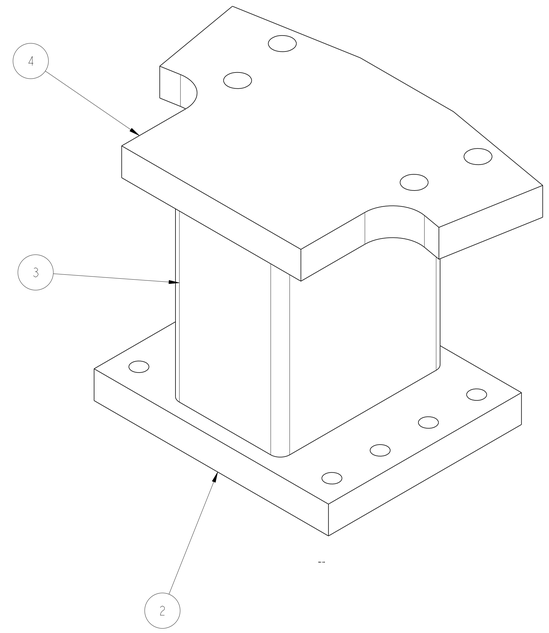
SECTION A-A





SECTION B-B

INNER SUPPORT PEDESTAL WELDMENT



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NOTES

1. WELDING SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF AWS D1.6 (STRUCTURAL WELDING OF AUSTENITIC STAINLESS STEEL) AND/OR PPPL PROCEDURE ENG-037. VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH THE ACCEPTANCE CRITERIA OF AWS D1.6.
2. ALL MACHINING IS TO BE PERFORMED AFTER ALL WELDING IS COMPLETE.
3. REFERENCE PERMEABILITY:

BASE MATERIAL	1.05
FABRICATED PART	1.05
WELD	1.05

4. NOTE ORIENTATION OF ALL PARTS PRIOR TO WELDING.
5. DRAWING DEPICTS FINAL REQUIRED WELDED STATE. MANUFACTURING IS 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 REQD
4	SE172-247-3	INNER SUPPORT PEDESTAL TOP PLATE	304L ST STL	1
3	SE172-247-2	INNER SUPPORT PEDESTAL POST	304L ST STL	1
2	SE172-247-1	INNER SUPPORT PEDESTAL BASE PLATE	304L ST STL	1
1	SE172-247	INNER SUPPORT PEDESTAL WELDMENT	--	1

PARTS LIST

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY NATIONAL COMPACT STELLARATOR EXPERIMENT
Pro E	DIMENSIONS ARE IN INCHES MACHINE SURFACES 125	STELLARATOR CORE BASE SUPPORT STRUCTURE INNER SUPPORT PEDESTAL WELDMENT - A TO A JOINT
DO NOT VERIFY INFORMATION BY SCALING DRAWING	BREAK SHARP EDGES .005/.020	
	TOLERANCES NON-CUMULATIVE	DSN:L. MORRIS
NEXT ASSEMBLY	DECIMAL-INCH: X +/-.100, XX +/-.030, XXX +/-.005, ANGULAR +/-0°-15' / FRACTIONS: 0°-12° +/-1/16, 12°-72° +/-1/8, 72°-120° +/-1/4, OVER 120° +/-1/2	CHK:
		ENGR:F. DAHLGREN
		SUPV:

DRAWING NO: SE172-247

SHEET 1 OF 1 REV

WEIGHT	RELEASE LEVEL: WIP
340.1 lbs	DWG VERSION NO: 1
MODEL NAME SE172-247	
WELDING ENGINEER	

NCSX_ASSY_FORMAT_E

NCSX-SE172-247