

1. DRAWINGS PREPARED IN ACCORDANCE WITH ASME Y14.100-2000
2. INTERPRET DIMENSIONS & TOLERANCES PER ASME Y14.5-1994.
3. DIMENSIONS ARE IN INCHES.
4. SEE SPECIFICATION NCSX-CSPEC-XXX-XX-XX FOR ADDITIONAL INFORMATION AND/OR MATERIAL REQUIREMENTS.
5. WELDING SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF AWS XXX AND/OR PPPL PROCEDURE ENG-037. VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH THE ACCEPTANCE CRITERIA OF AWS XXX.
6. ALL MACHINING TO BE COMPLETED AFTER ALL WELDS ARE COMPLETE.

6 ASSEMBLIES REQUIRED

PART NO.	DRAWING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY	RECD
7	NS151336	1/2 NOMINAL FLAT WASHER	INCONEL 718	1	
6	NS150279	1/2-6UNC-2B HEX NUT	INCONEL 718	1	
5	SE172-250-4	SUPPORT COLUMN SPHERICAL JOINT THREADED PIN	INCONEL 718	1	
4	SE172-250-3	SUPPORT COLUMN JOINT BUSHING MOUNTING EAR	INCONEL 718	2	
3	SE172-250-2	SUPPORT COLUMN SPHERICAL JOINT MOUNTING BASE PLATE	INCONEL 718	1	
2	SE172-250-1	SUPPORT COLUMN JOINT FLANGED BUSHING	INCONEL 718	1	
1	SE172-245	SUPPORT COLUMN SPHERICAL BEARING HOUSING ASSEMBLY		1	

PARTS LIST

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY NATIONAL COMPACT STELLARATOR EXPERIMENT	
Pro E	DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	STELLARATOR CORE BASE SUPPORT STRUCTURE SUPPORT COLUMN SPHERICAL JOINT ASSEMBLY	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	TOLERANCES NON-CUMULATIVE	DSN: T. CRUICKSHANK	DRAWING NO:
NEXT ASSEMBLY	DECIMAL-INCH FRACTIONS	CHK:	SE172-250
	.X +/- .000 0"-.125" +/- .0004	ENGR: F. DAHLGREN	SHEET 1 OF 4
	.XX +/- .030 12"-.32" +/- .010	SUPV:	REV 0
	.XXX +/- .005 32"-.120" +/- .014		
	ANGULAR +/- .015 OVER 120" +/- .112		

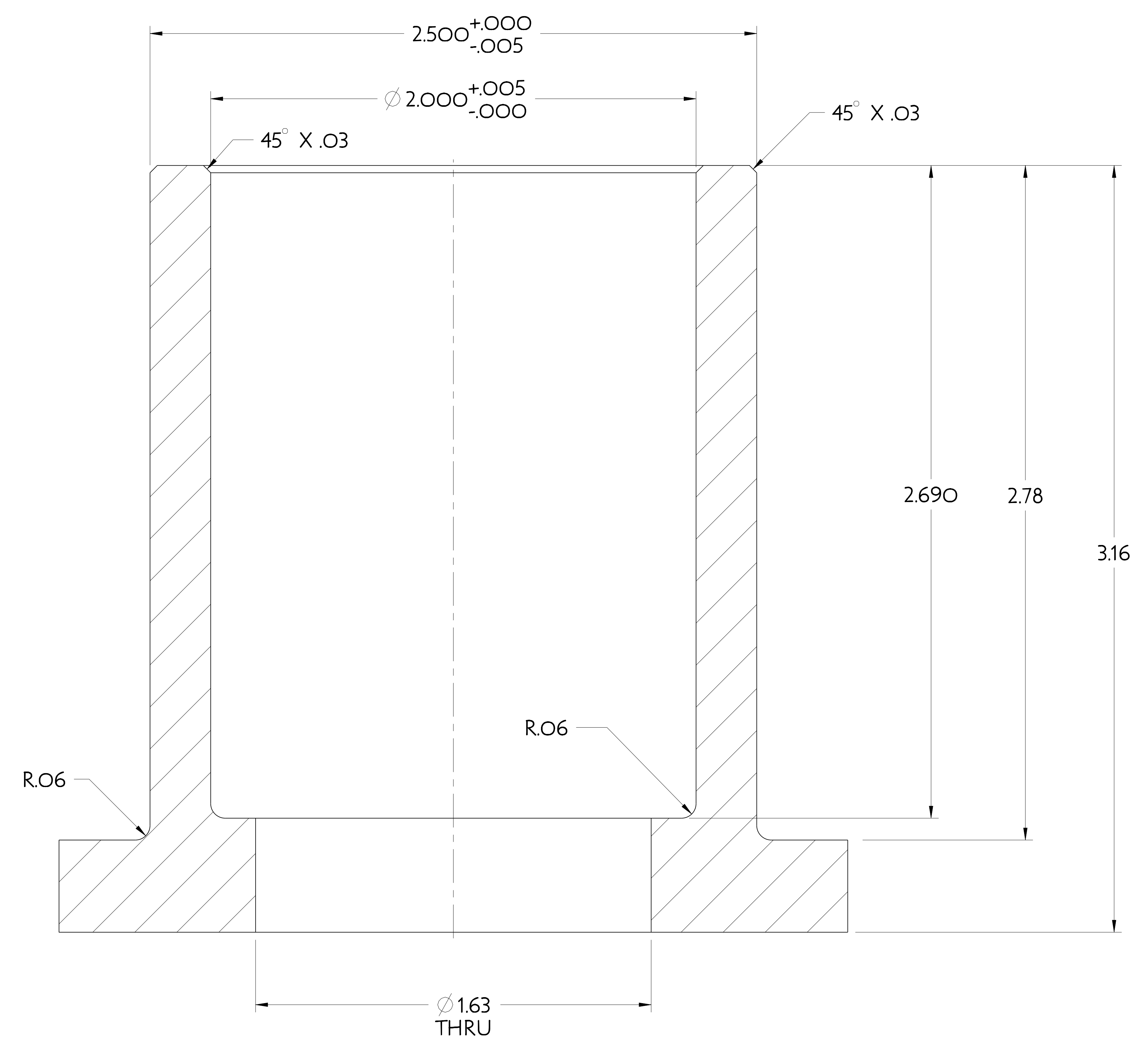
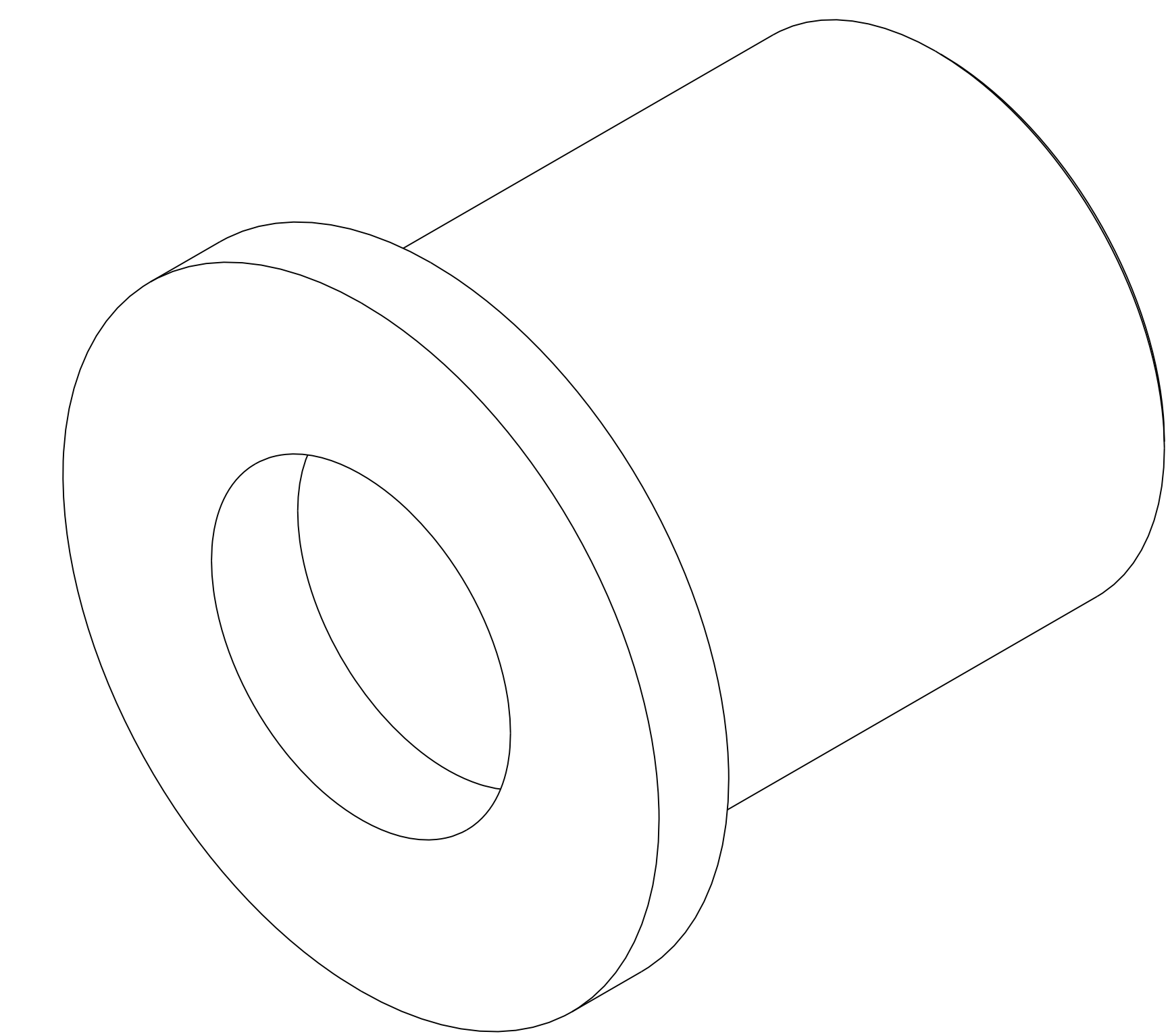
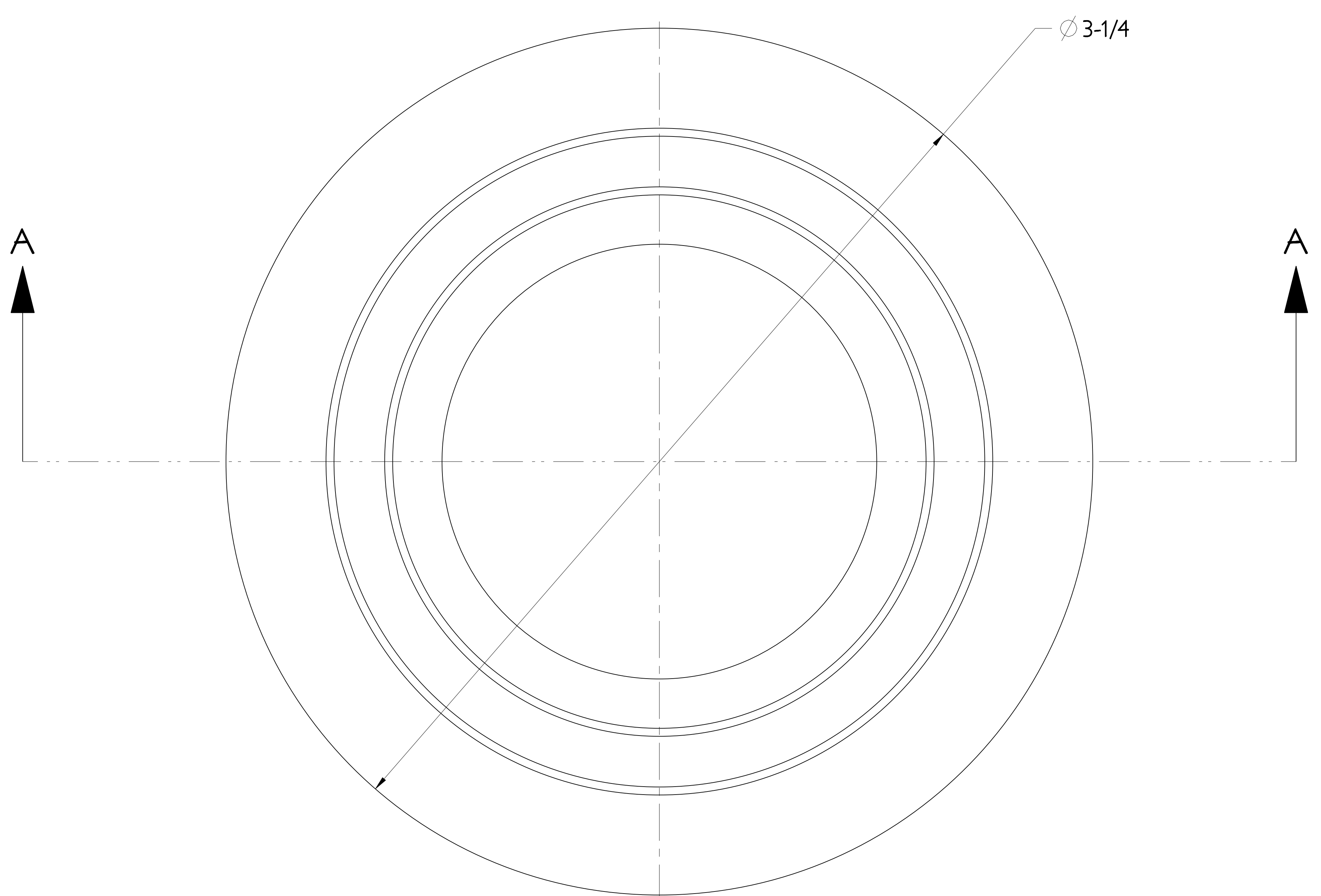
RELEASE LEVEL: WIP
DWG VERSION NO: 8

WEIGHT	252.2 lbs
MODEL NAME	SE172-250
WELDING ENGINEER	

NCSX-SE172-250

K

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



2 SUPPORT COLUMN JOINT FLANGED BUSHING
SE172-250-1

6 REQUIRED

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

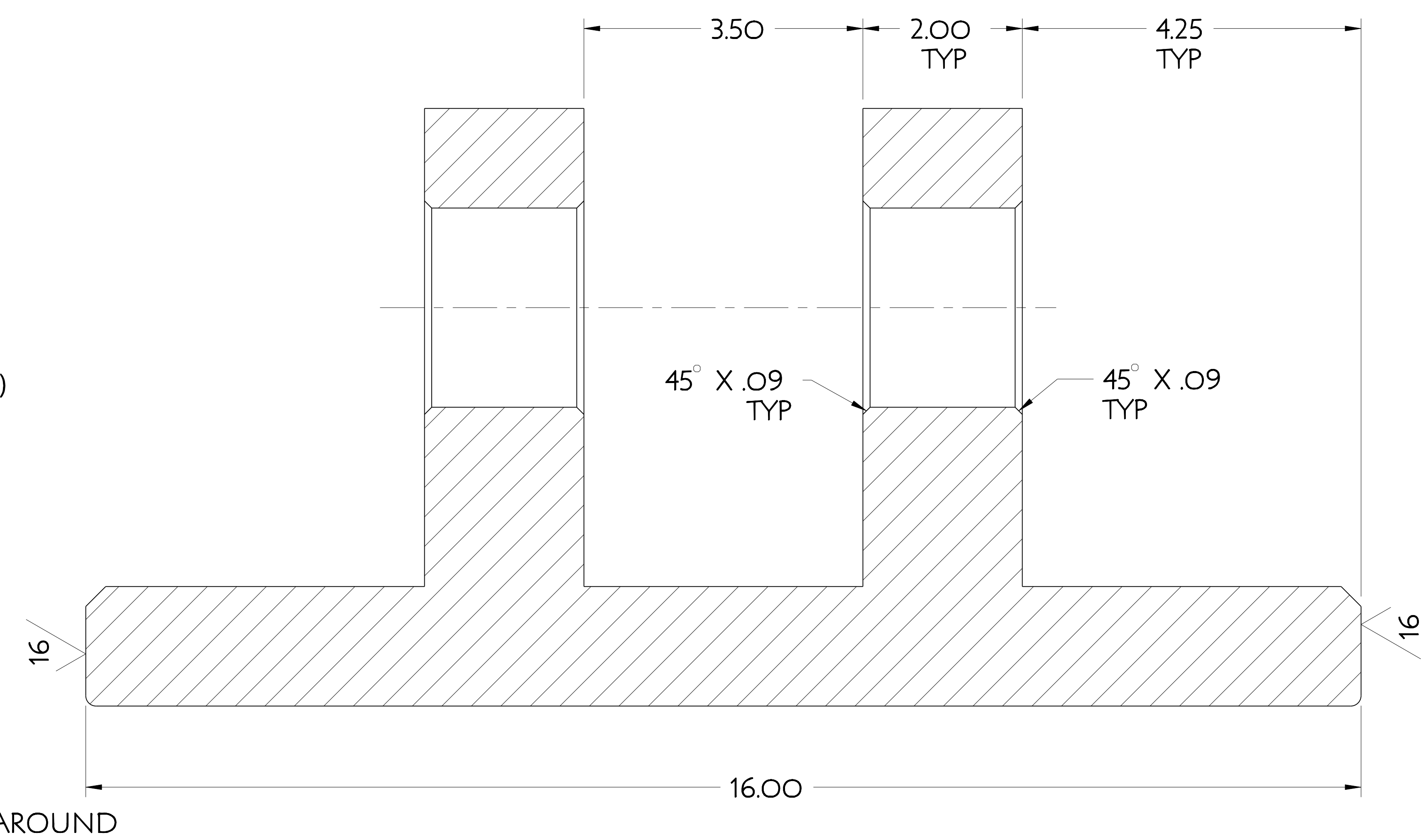
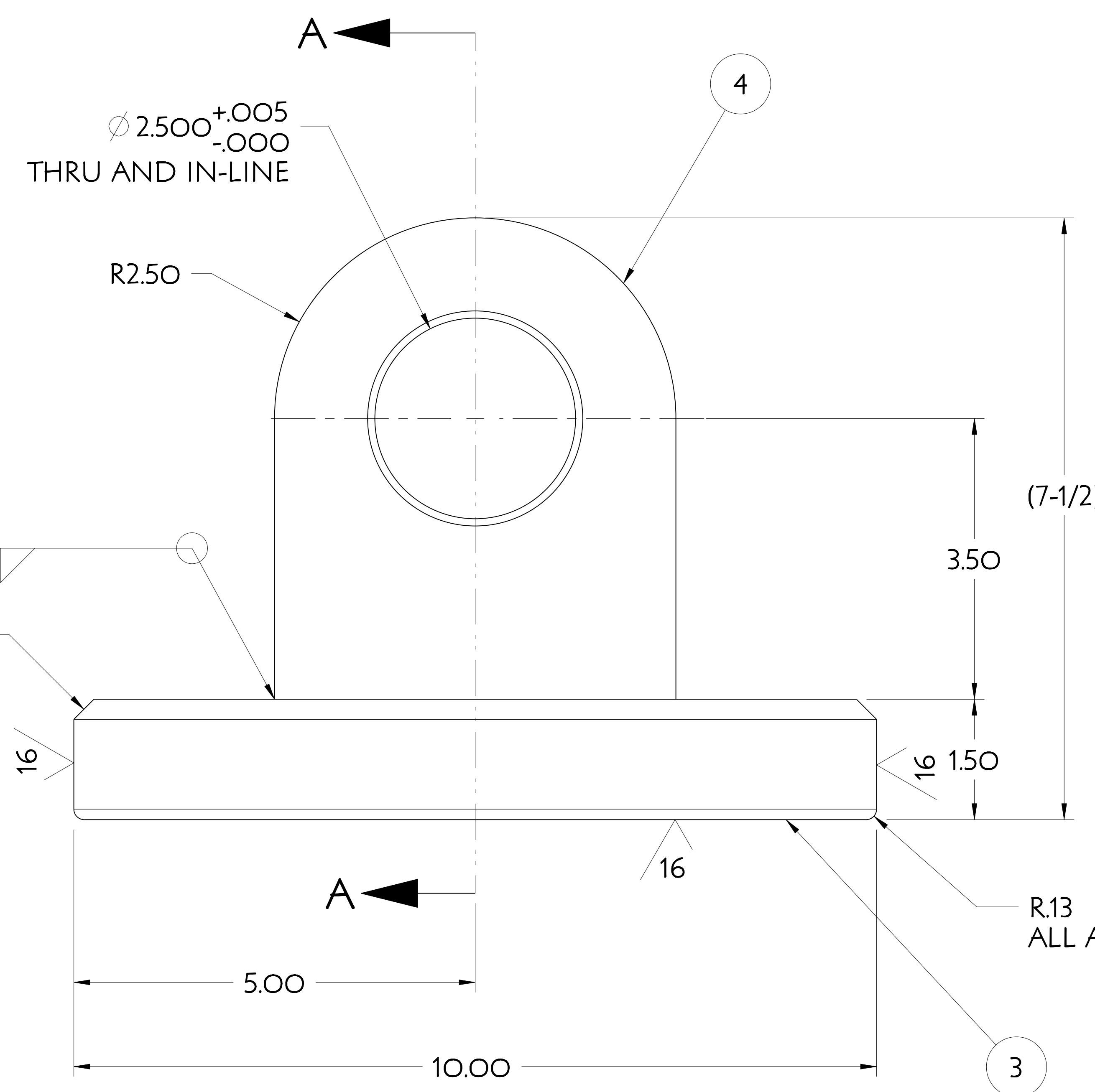
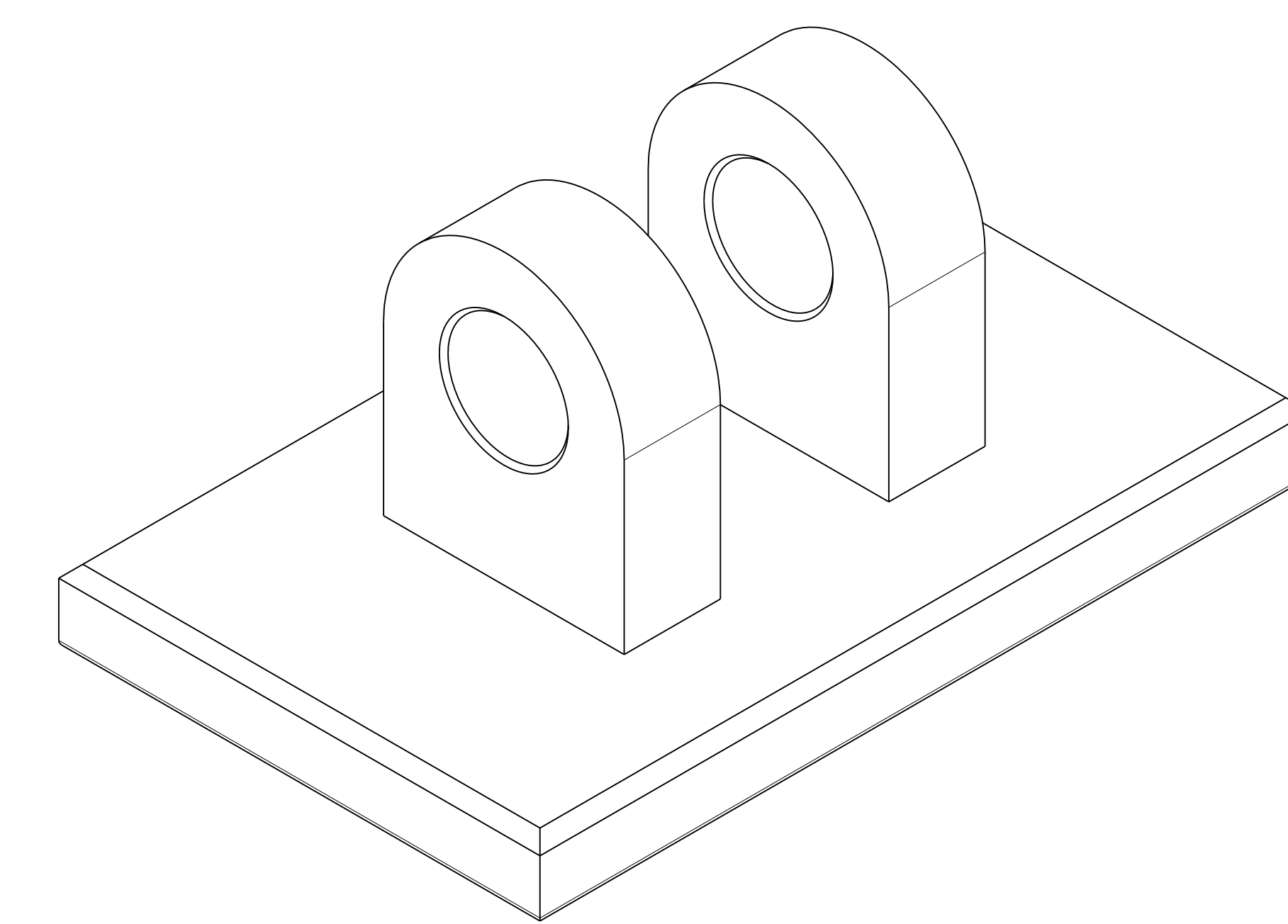
RELEASE LEVEL: WIP
DWG VERSION NO: 3

WEIGHT	2.1 lbs
MODEL NAME	SE172-250-4
WELDING ENGINEER	

COMPUTER GENERATED DRAWING CHANGES NOT PERMITTED	CENTRAL FILES:	PRINCETON PLASMA PHYSICS LABORATORY
DO NOT VERIFY INFORMATION BY SCALING DRAWING	UNLESS OTHERWISE SPECIFIED	NATIONAL COMPACT STELLARATOR EXPERIMENT
PRO E	DIMENSIONS ARE IN INCHES	STELLARATOR CORE
	BREAK SHARP EDGES .005/.020	BASE SUPPORT STRUCTURE
	TOLERANCES NON-CUMULATIVE	SUPPORT COLUMN SPHERICAL JOINT ASSEMBLY
	DECIMAL-INCH FRACTIONS	DSN: T. CRUCKSHANK
	XXX +/- .005	ENGR: F. DAHLGREN
	ANGULAR +/- .15	SUPV:
		DRAWING NO: SE172-250
		SHEET 2 OF 4
		REV 0.5

NCSX-SE172-250

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GTAW OR GMAW - SEE NOTE 5
TYP (2) PLACES

45° X .25
ALL AROUND

6 REQUIRED

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

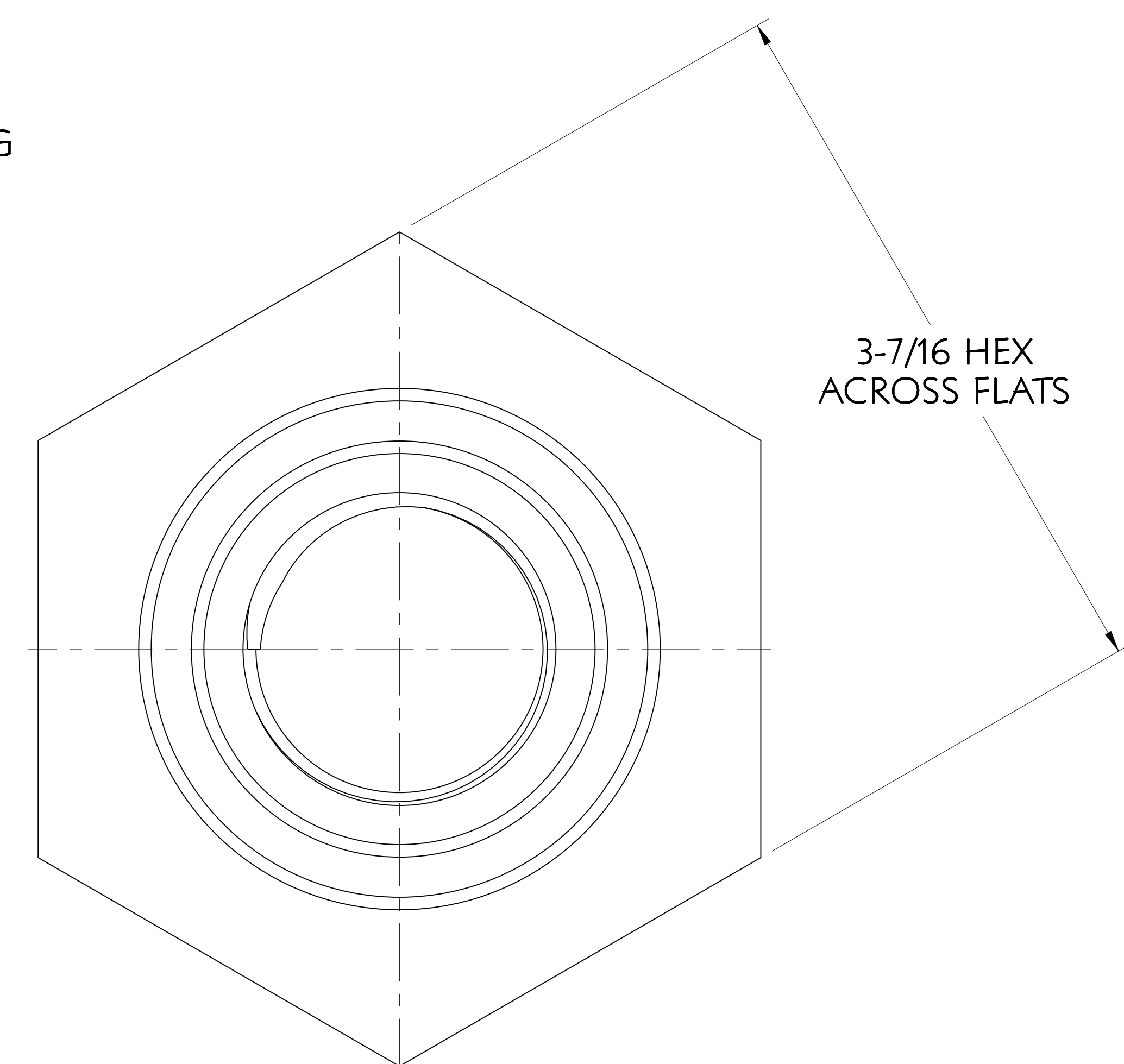
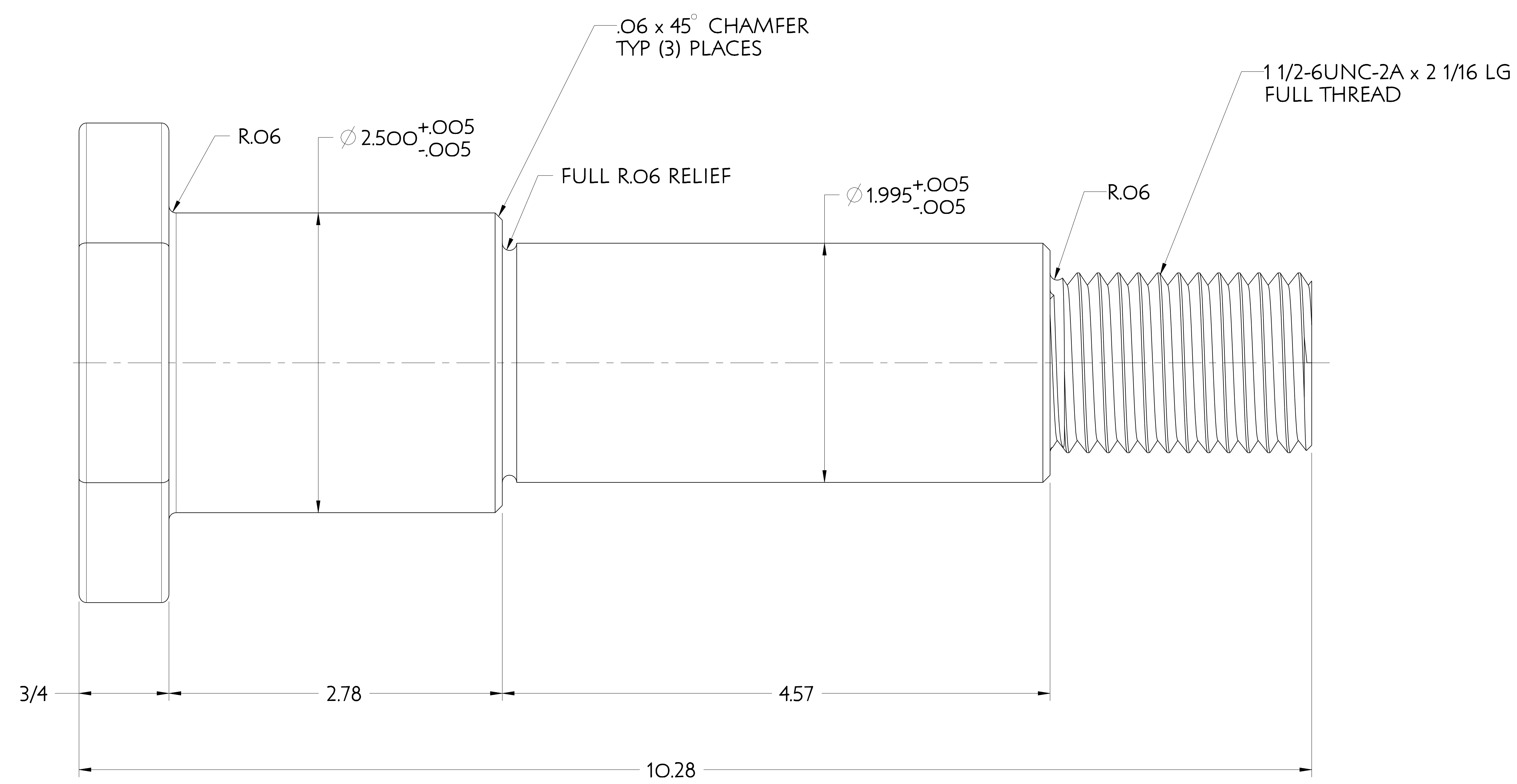
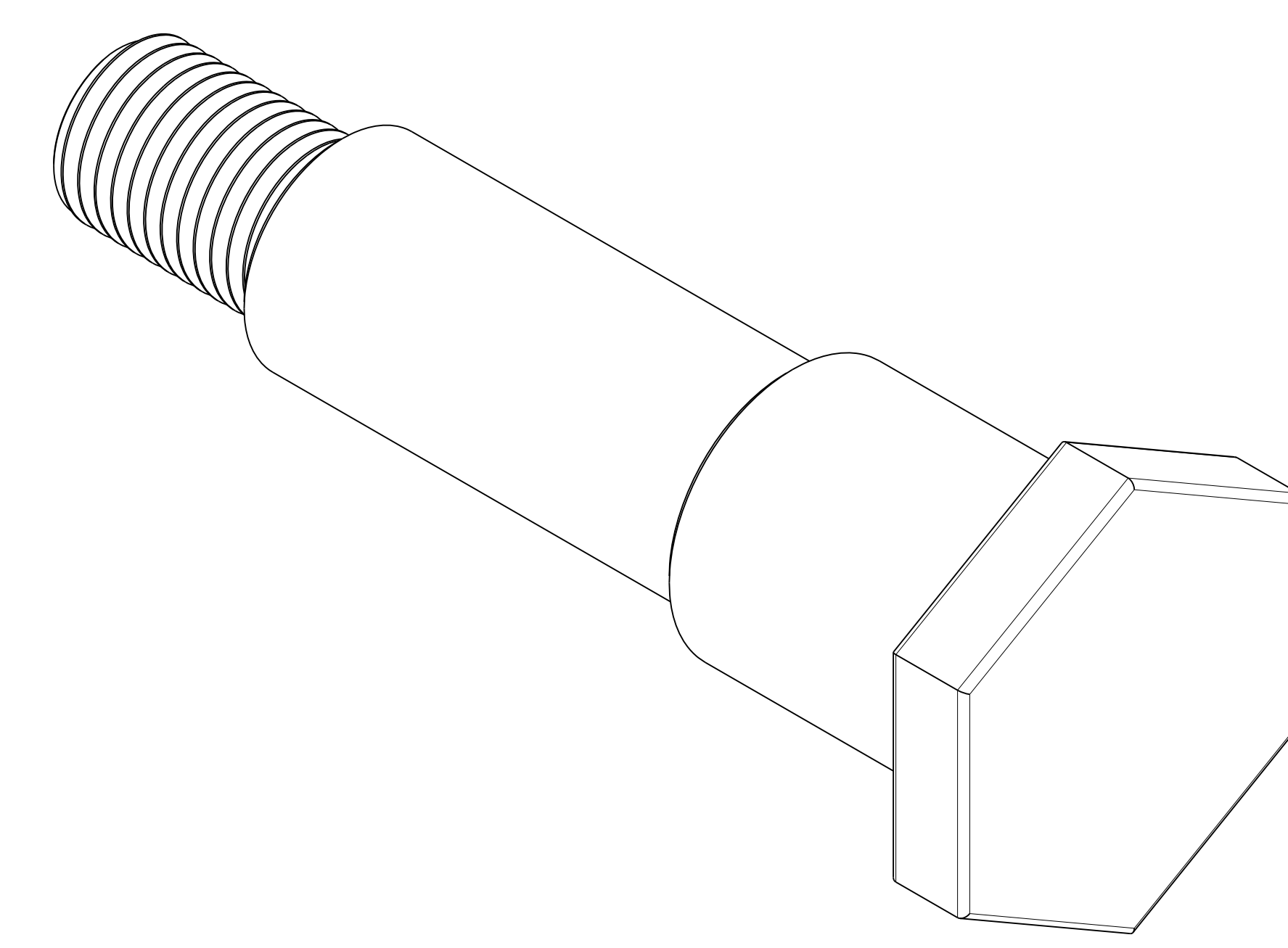
RELEASE LEVEL: WIP
DWG VERSION NO: 6

WEIGHT
95.0 lbs
MODEL NAME
SE172-250-4
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 SUPPORT COLUMN SPHERICAL JOINT ASSEMBLY	
NEXT ASSEMBLY	TOLERANCES - NON-CUMULATIVE DECIMAL-INCH FRACTIONS .X +/- .100 0°-120° +/- .010 .XX +/- .030 12°-72° +/- .010 .XXX +/- .005 72°-120° +/- .010 ANGULAR +/- .0°-15° OVER 120° +/- .125	DSN: T. CRUICKSHANK ENGR: F. DAHLGREN SUPV:	DRAWING NO: SE172-250 SHEET 3 OF 4 REV 0.5

NCSX-SE172-250

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5 SUPPORT COLUMN SPHERICAL JOINT THREADED PIN
SE172-250-4

6 REQUIRED

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

RELEASE LEVEL: WIP
DWG VERSION NO: 0

WEIGHT	13.0 lbs
MODEL NAME	SE172-250-4
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 SUPPORT COLUMN SPHERICAL JOINT ASSEMBLY
NEXT ASSEMBLY	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS XX +/- .005 12°-12° +/- .114 ANGULAR +/- .15° OVER 120° +/- .112	DSN: T. CRICKSHANK CHK: ENGR: F. DAHLGREN SUPV: DRAWING NO: SE172-250
		SHEET 4 OF 4 REV 0.5

NCSX-SE172-250