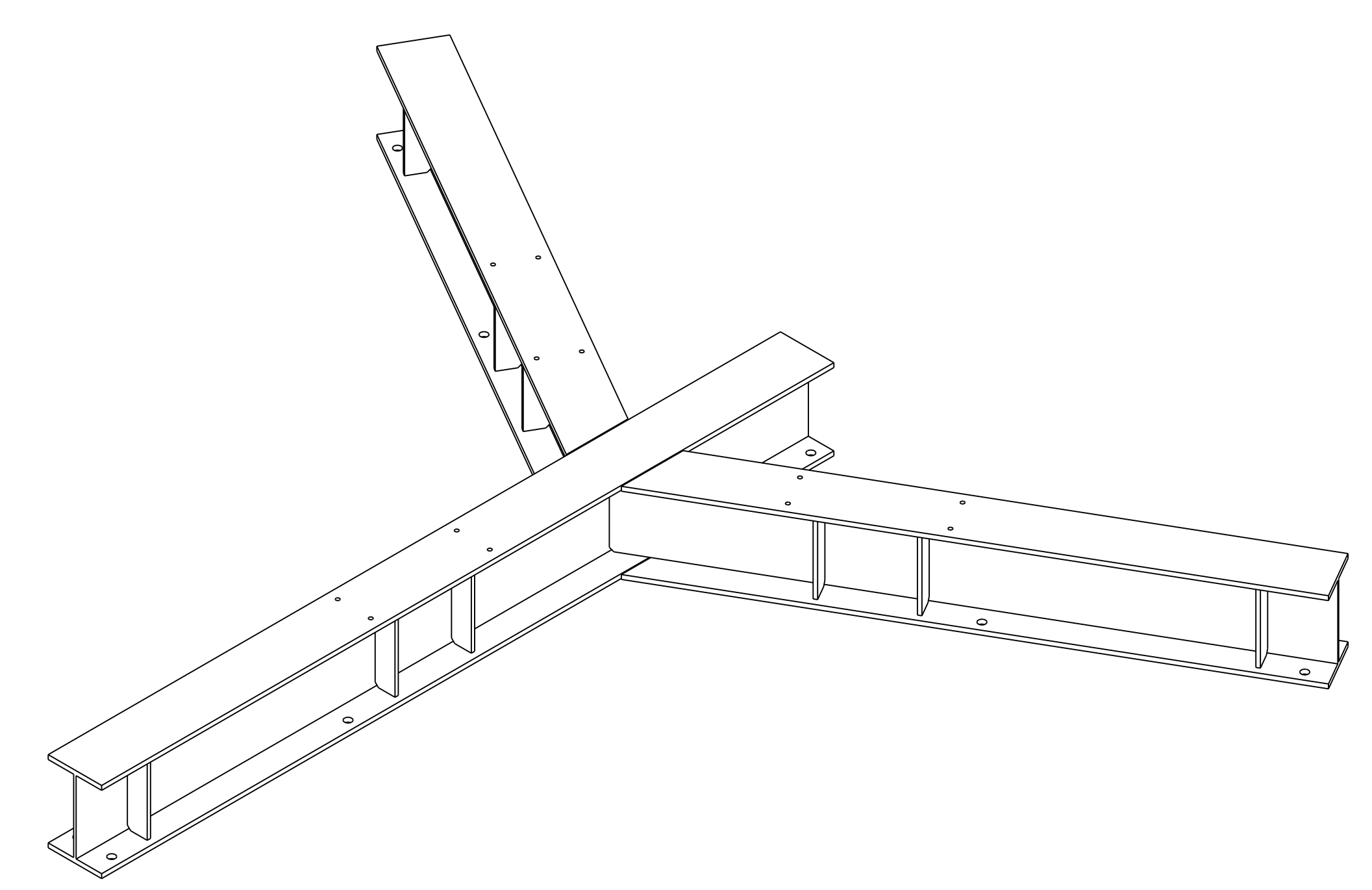
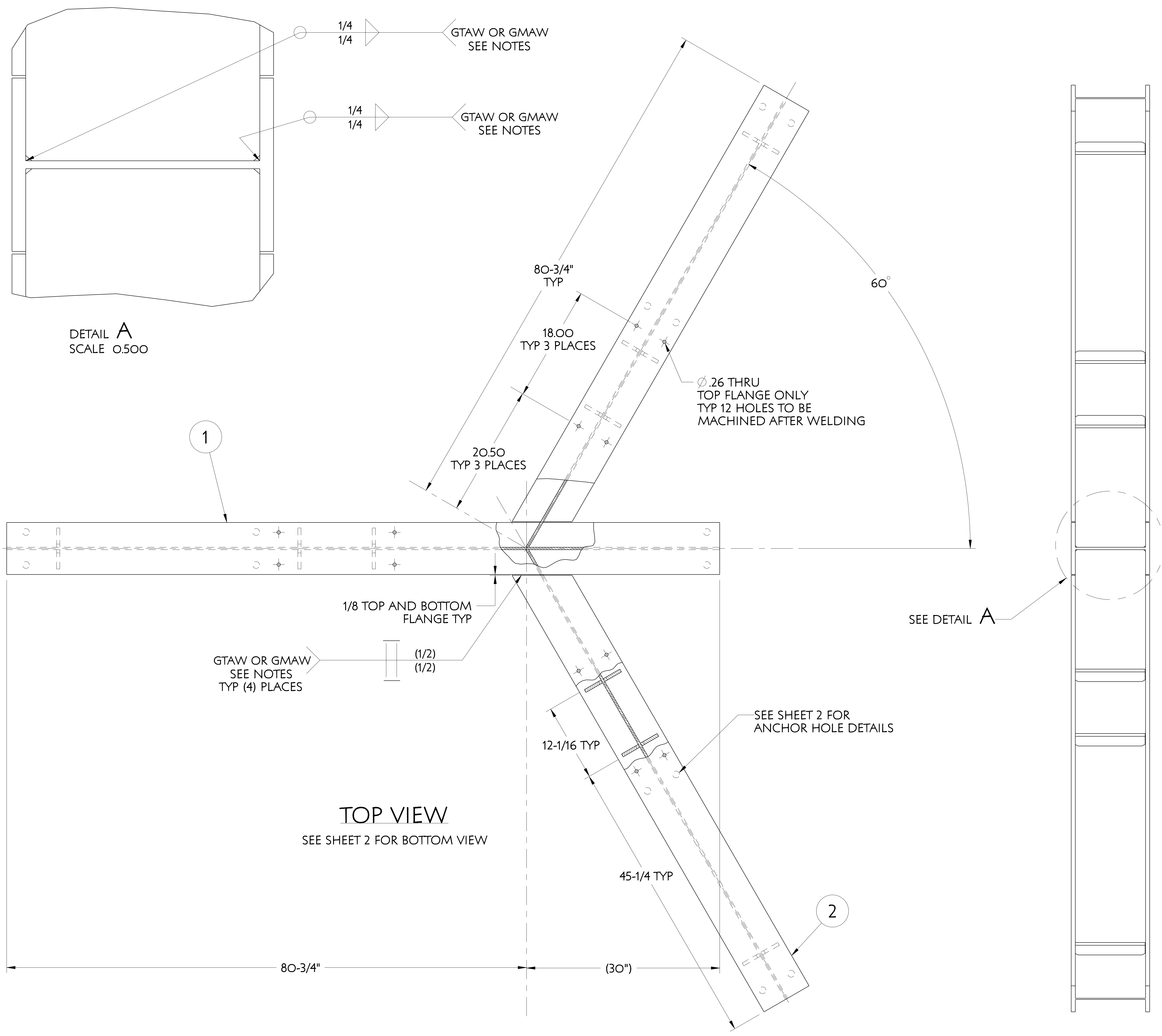


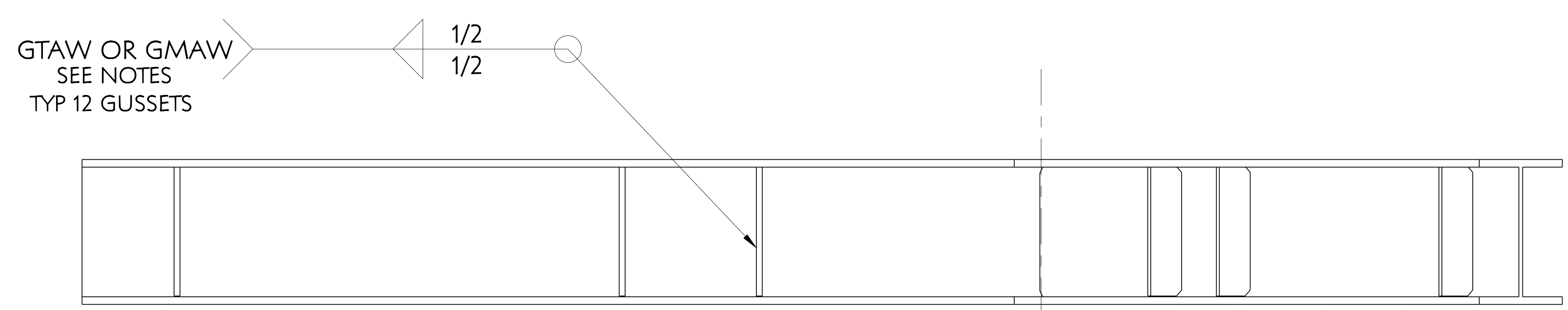
NO.	REVISION	BY	CH	SUP	APPROVED	DATE



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 D1.6 (STRUCTURAL WELDING OF AUSTENITIC STAINLESS STEEL) AND PPPL PROCEDURE NO. ENG-O37. VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH THE ACCEPTANCE CRITERIA OF AWS D1.6.
6. REFERENCE PERMEABILITY

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

**ONE ASSEMBLY REQUIRED**



PART NO.	DRAWING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY REQ
3	SE172-252-3	CENTER SUPPORT STRUCTURE BRIDGING BEAM GUSSET	304L ST STL	18
2	SE172-252-2	CENTER COLUMN SUPPORT SIDE BRIDGING BEAM - W12" x 50#	304L ST STL	2
1	SE172-252-1	CENTER COLUMN SUPPORT CENTER BRIDGING BEAM - W12" x 50#	304L ST STL	1

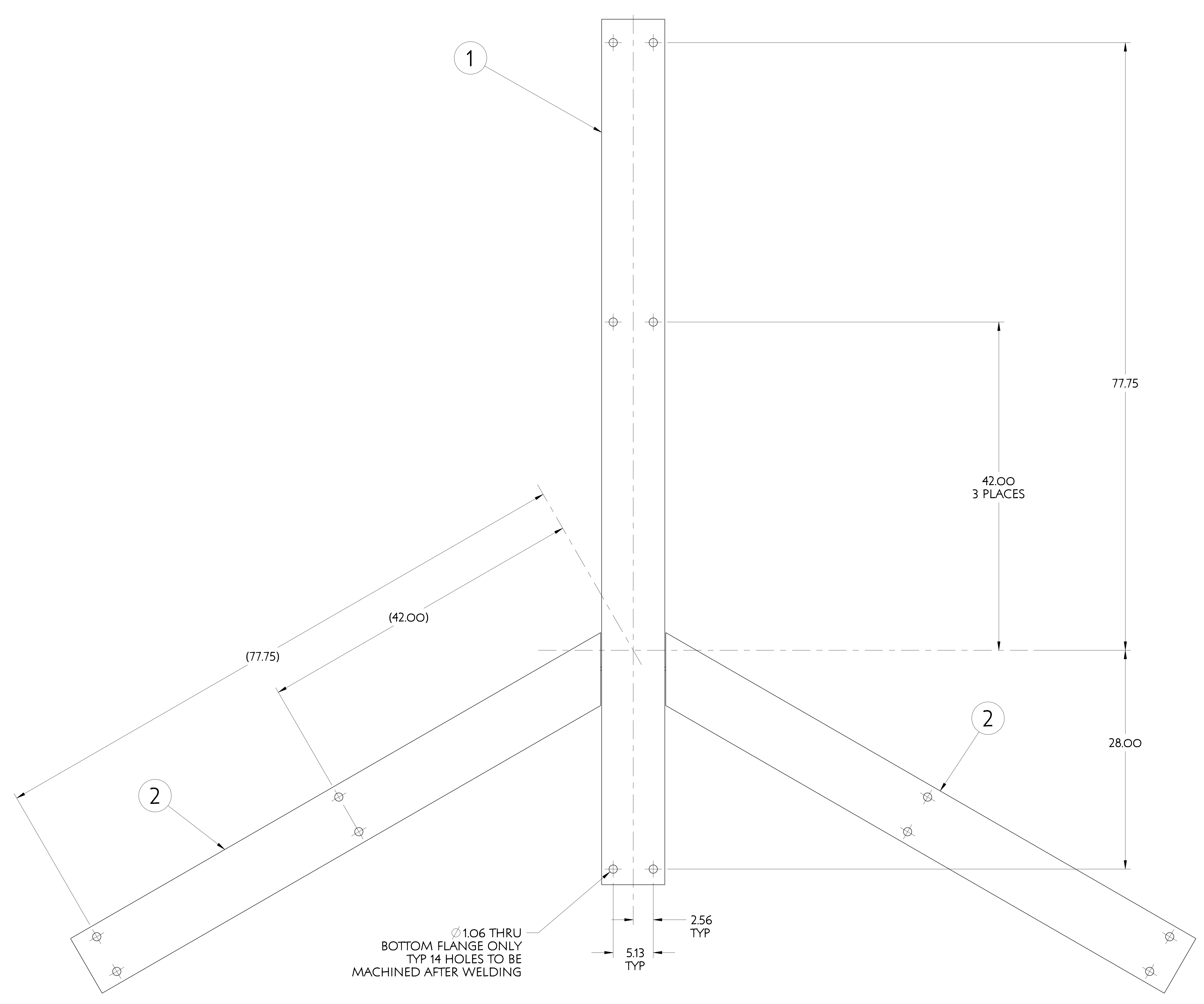
PARTS LIST

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY <b>NATIONAL COMPACT STELLARATOR EXPERIMENT</b>
Pro E	DIMENSIONS ARE IN INCHES MACHINE SURFACES V	STELLARATOR CORE BASE SUPPORT STRUCTURE CENTER SUPPORT BRIDGING BEAM WELDMENT
DO NOT VERIFY INFORMATION BY SCALING DRAWING	BREAK SHARP EDGES .005/.020	DSN: T. CRUICKSHANK
TOLERANCES NON-CUMULATIVE	DECIMAL - INCH FRACTIONS	CHK: ENGR: F. DAHLGREN
NEXT ASSEMBLY	.X ±.100 0-.12" ±.1/16 .XX ±.000 12"-12" ±.010 .XXX ±.005 12"-120" ±.1/16 ANGULAR ±.0°/15' OVER 120° ±.1/2	SUPV: SHEET 1 OF 5

RELEASE LEVEL: WIP  
DWG VERSION NO: 8

WEIGHT	1188.0 lbs
MODEL NAME	SE172-252
WELDING ENGINEER	
DRAWING NO:	SE172-252
SHEET 1 OF 5	REV D. 5

NO:	13	REVISION	BY	CH	SUP	APPROVED	DATE



Ø1.06 THRU  
BOTTOM FLANGE ONLY  
TYP 14 HOLES TO BE  
MACHINED AFTER WELDING

**BOTTOM VIEW**

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

RELEASE LEVEL: WIP  
DWG VERSION NO: 8

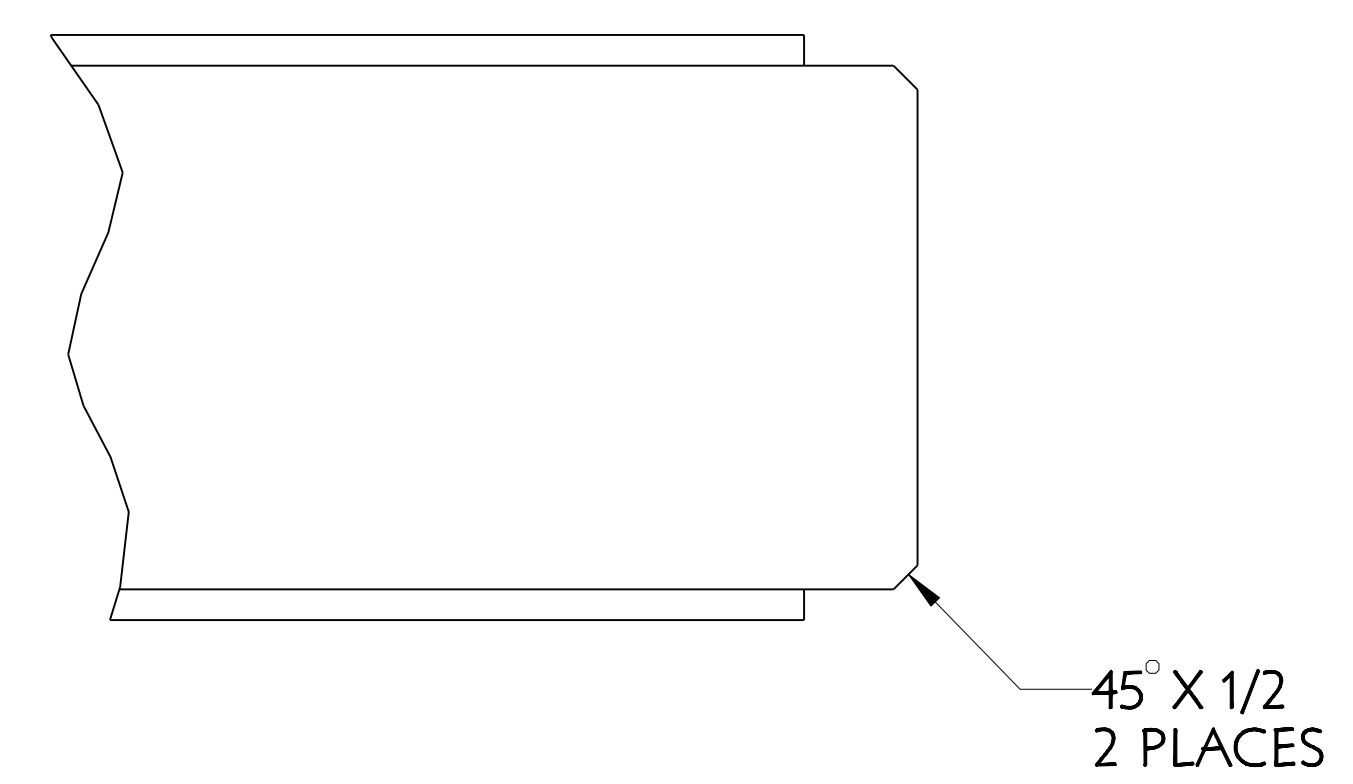
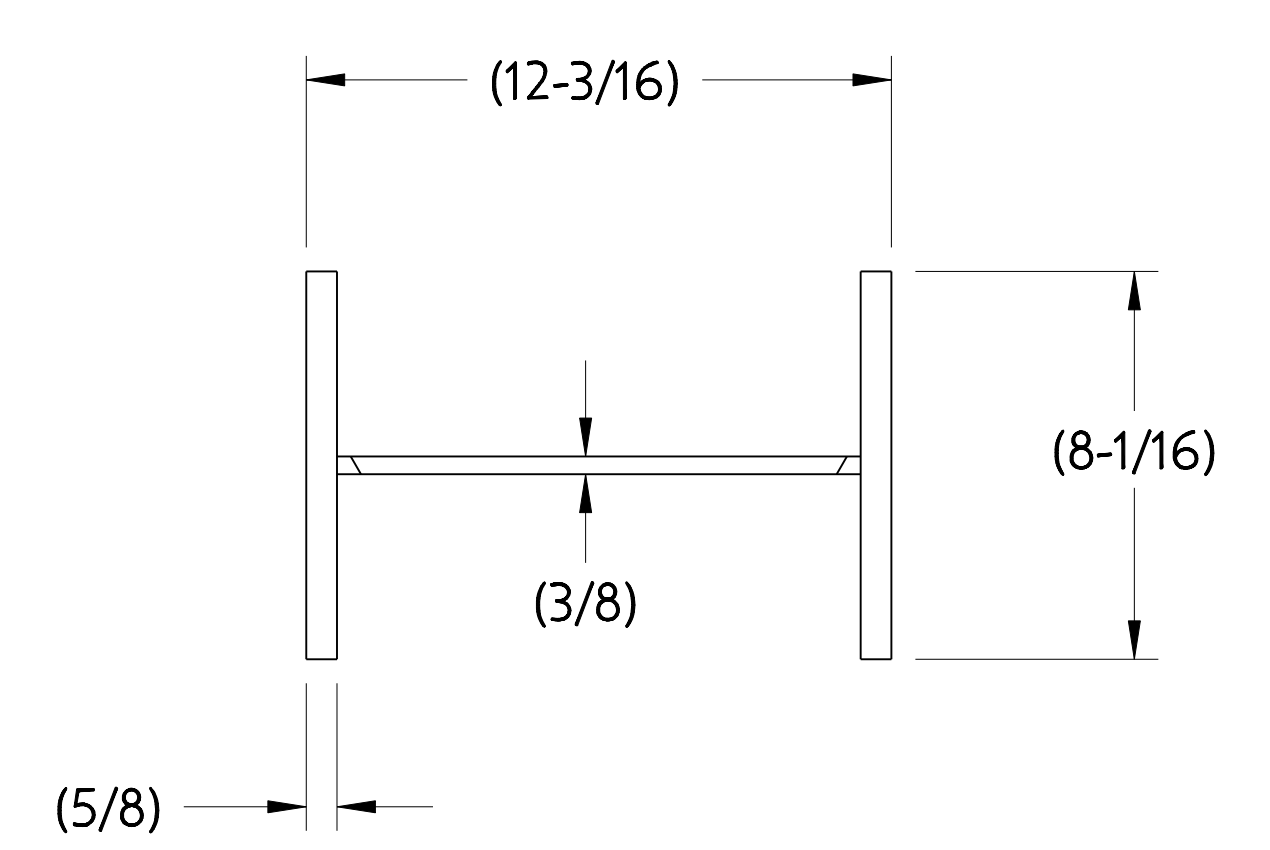
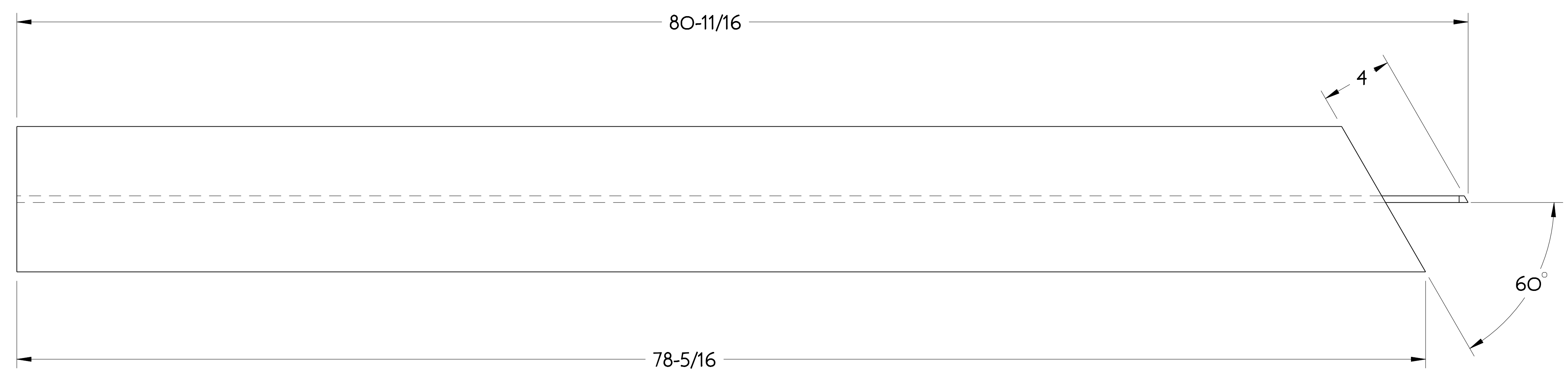
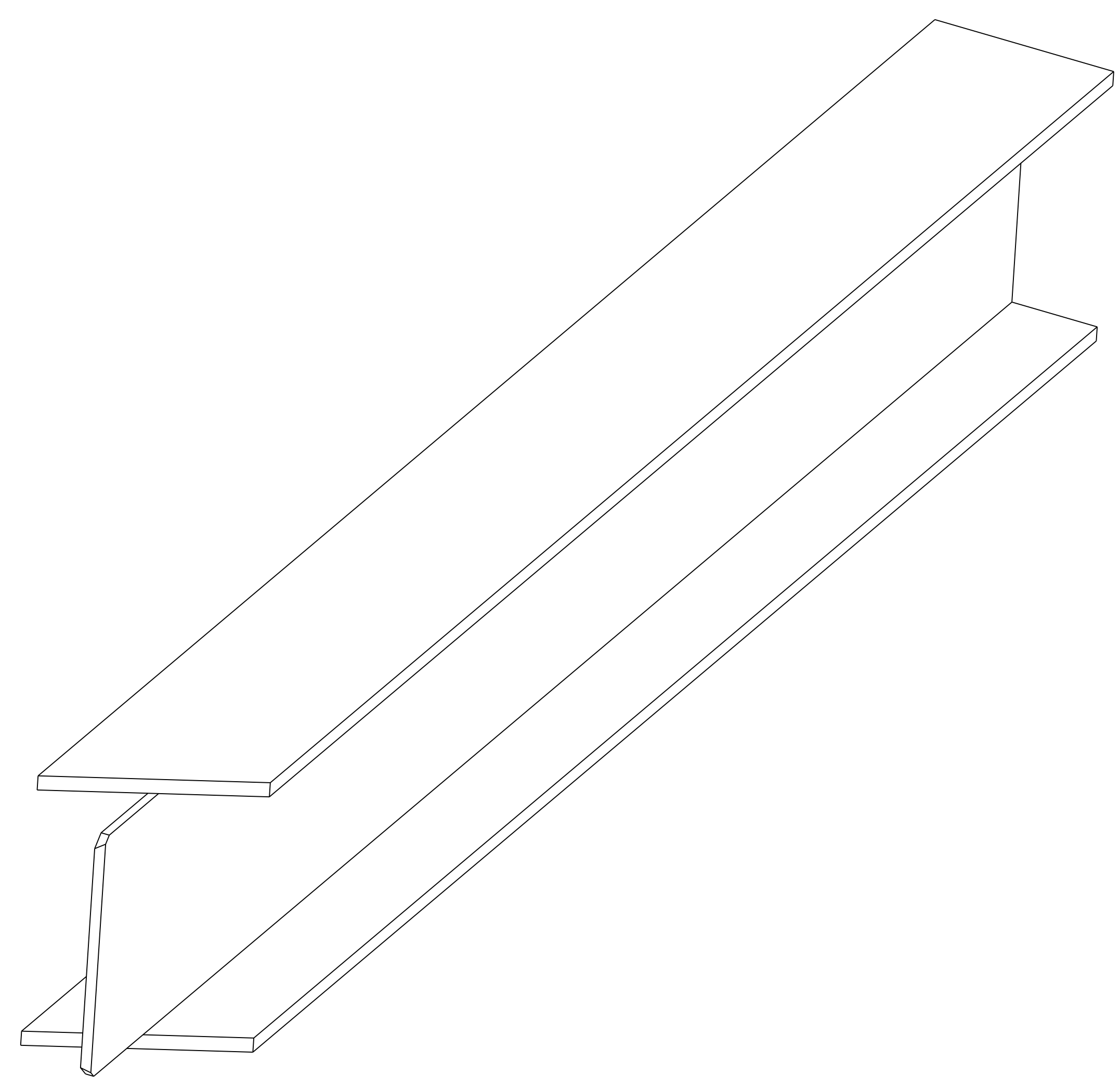
WEIGHT	1188.0 lbs
MODEL NAME	SE172-252
WELDING ENGINEER	

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED
Pro E	DIMENSIONS ARE IN INCHES MACHINE SURFACES
DO NOT VERIFY INFORMATION BY SCALING DRAWING	BREAK SHARP EDGES .005/.020
NEXT ASSEMBLY	TOLERANCES NON-CUMULATIVE
DECIMAL-INCH FRACTIONS:	CHK:
.X +/- .100 0°-12° +/- .174	ENGR: F. DAHLGREN
.XX +/- .030 12°-12° +/- .118	SUPV:
.XXX +/- .005 12°-120° +/- .174	
ANGULAR +/- 0°-15° OVER 120° +/- .172	

PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY	
<b>NATIONAL COMPACT STELLARATOR EXPERIMENT</b>	
STELLARATOR CORE BASE SUPPORT STRUCTURE CENTER SUPPORT BRIDGING BEAM WELDMENT	
DSN: T. CRUICKSHANK	DRAWING NO:
	<b>SE172-252</b>
SHEET 2 OF 5	REV D. 5



NO.	REVISION	BY	CH	SUP	APPROVED	DATE



2 CENTER COLUMN SUPPORT SIDE BRIDGING BEAM - W12" x 50#

**2 REQUIRED**

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

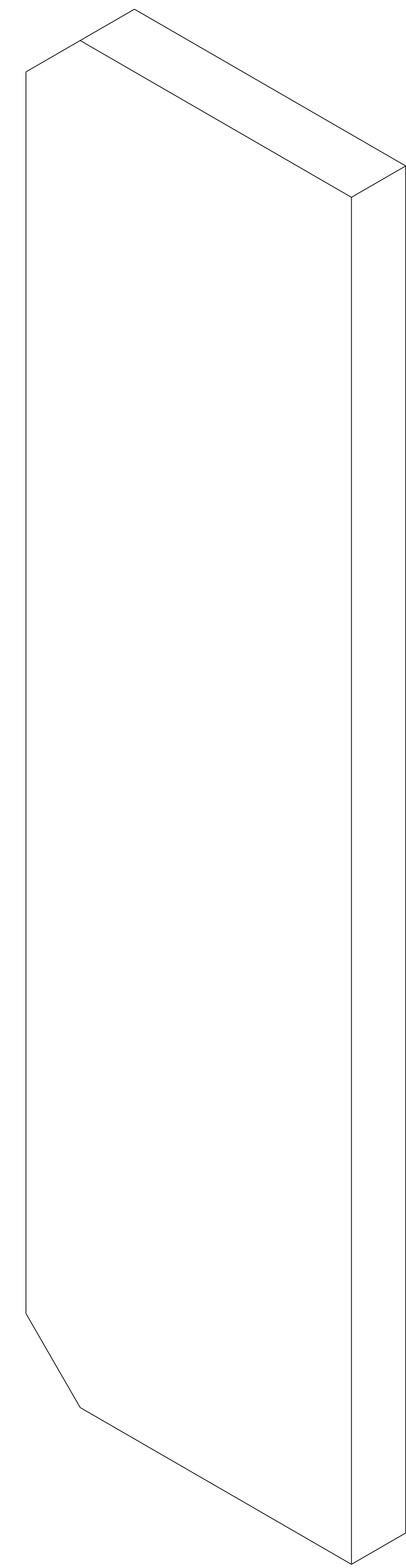
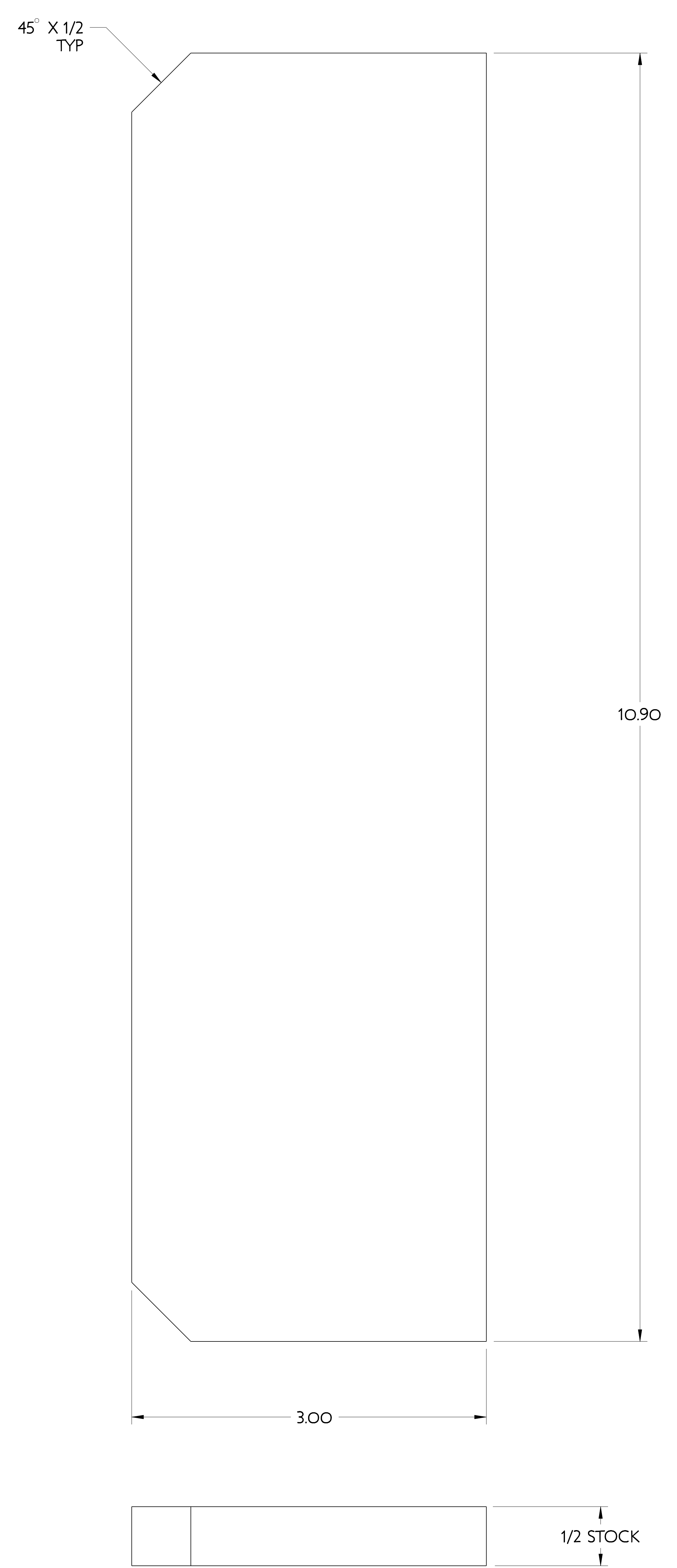
COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED	CENTRAL FILES:	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY	
	UNLESS OTHERWISE SPECIFIED	NATIONAL COMPACT STELLARATOR EXPERIMENT	
PRO E	DIMENSIONS ARE IN INCHES MACHINE SURFACES	STELLARATOR CORE	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	BREAK SHARP EDGES .005/.020	BASE SUPPORT STRUCTURE	
	TOLERANCES NON-CUMULATIVE	CENTER SUPPORT BRIDGING BEAM WELDMENT	
NEXT ASSEMBLY	DECIMAL-INCH FRACTIONS	DSN: T. CRUICKSHANK	DRAWING NO:
	.X +/- .100 0°-12° +/- .174	CHK:	<b>SE172-252</b>
	.XX +/- .030 12°-120° +/- .149	ENGR: F. DAHLGREN	SHEET 4 OF 5
	.XXX +/- .005 120°-120° +/- .174	SUPV:	REV D. 5
	ANGULAR +/- 0°-15° OVER 120° +/- .172		

RELEASE LEVEL: WIP  
DWG VERSION NO: 6

WEIGHT  
322.1 lbs  
MODEL NAME  
SE172-252-1

NO.	REVISION	BY	CH	SUP	APPROVED	DATE

A  
B  
C  
D  
E  
F  
G  
H  
I  
J  
K



20 REQUIRED

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

3 CENTER SUPPORT STRUCTURE BRIDGING BEAM GUSSET

RELEASE LEVEL: WIP  
DWG VERSION NO: 4

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/-0.00	STELLARATOR CORE BASE SUPPORT STRUCTURE CENTER SUPPORT BRIDGING BEAM WELDMENT
WEIGHT 4.7 lbs	TOLERANCES NON-CUMULATIVE	DSN: T. CRUICKSHANK
MODEL NAME SE172-252-1	DECIMAL-INCH FRACTIONS: .X +/- .100 0"-12" +/- .124 .XX +/- .030 12"-24" +/- .118 .XXX +/- .005 24"-100" +/- .114 ANGULAR +/- 0°-15' OVER 120° +/- .112	CHK: ENGR: F. DAHLGREN
WELDING ENGINEER	NEXT ASSEMBLY	DRAWING NO: SE172-252
		SHEET 5 OF 5 REV D