

**NOTE**

INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5

DIMENSIONS ARE IN INCHES UNLESS OTHERWISE INDICATED.

DRAWING DEPICTS FINAL MACHINED STATE OF ASSEMBLY. MANUFACTURING TO DETERMINE MATERIAL ALLOWANCES REQUIRED TO ACHIEVE FINAL MACHINED STATE.

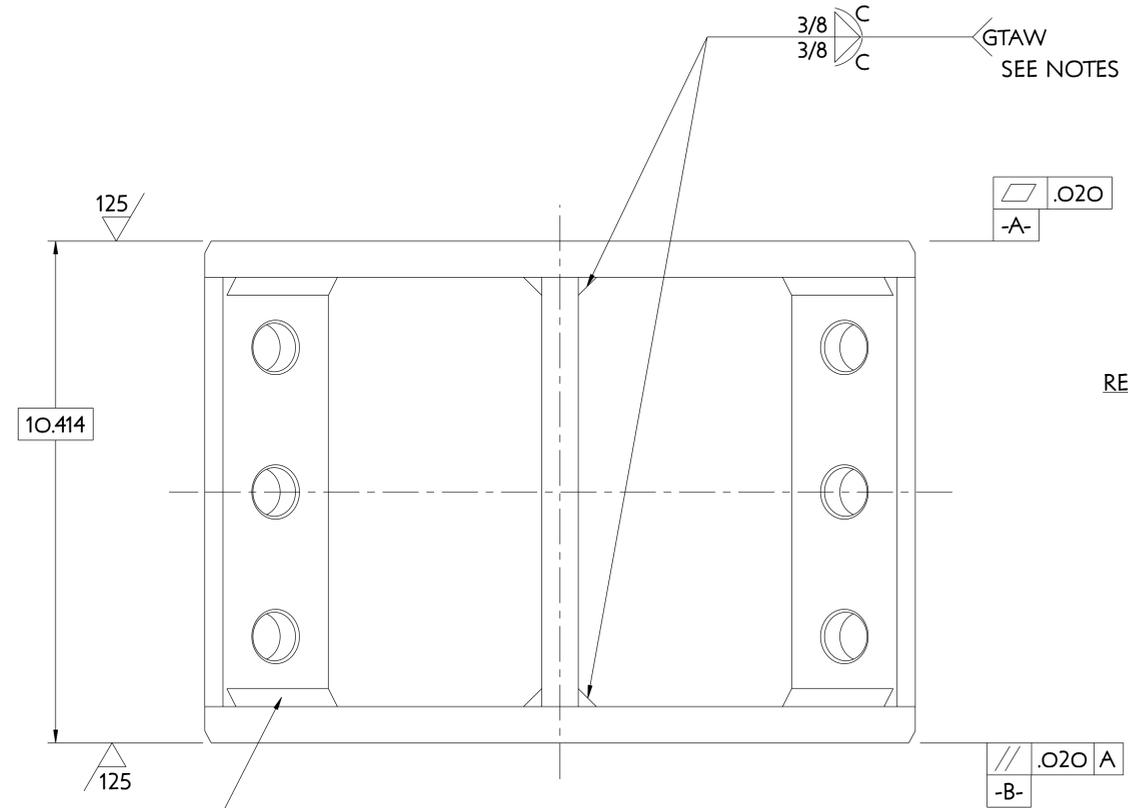
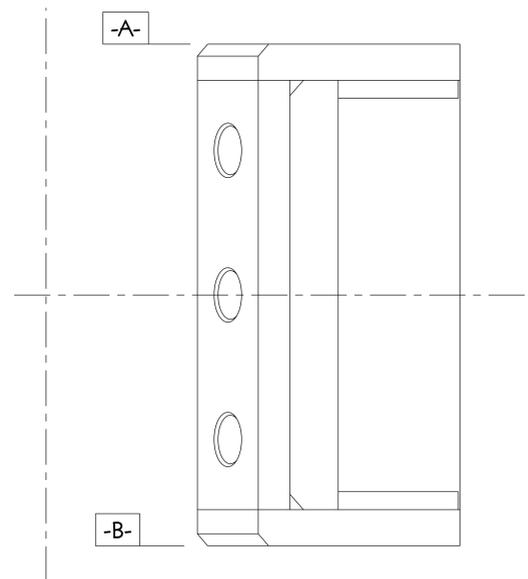
WELDING SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF AWS D1.6. WELDING PERFORMED ONSITE SHALL ALSO MEET THE REQUIREMENTS OF PPPL PROCEDURE ENG-O37.

VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH THE ACCEPTANCE CRITERIA OF AWS D1.6.

NOTE ORIENTATION OF ALL PARTS PRIOR TO WELDING.

REFERENCE PERMEABILITY:

BASE MATERIAL	1.05
FABRICATED PART	1.2
WELD	2.0



**REFERENCE DRAWINGS**

SE132-204 CENTER SUPPORT ASSEMBLY

SE132-230 CENTER SUPPORT PLATE DETAILS

**3 ASSEMBLIES REQ'D**

PART NO.	DRAWING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY REQD
3	SE132-230-3	CENTER SOLENOID CENTER SUPPORT PLATE 3	304 STN STL	2
2	SE132-230-2	CENTER SOLENOID CENTER SUPPORT PLATE 2	304 STN STL	1
1	SE132-230-1	CENTER SOLENOID CENTER SUPPORT PLATE 1	304 STN STL	2

PARTS LIST

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED	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 UNLESS OTHERWISE SPECIFIED	STELLARATOR CORE CONVENTIONAL COILS CENTER SOLENOID CENTER SUPPORT SEGMENT WELDMENT/ASSEMBLY	
SCALE 0.750	TOLERANCES NON-CUMULATIVE	DSN: J. RUSHINSKI	DRAWING NO:
NEXT ASSEMBLY	DECIMAL-INCH FRACTIONS	CHK: ENGR. F. DAHLGREN	<b>SE132-211</b>
	.XX +/- .005 0°-120° +/- .010 .XXX +/- .005 120°-120° +/- .010 ANGULAR +/- .0°-15° OVER 120° +/- .125	SUPV:	SHEET 1 OF 1 REV 0

RELEASE LEVEL: WIP  
DWG VERSION NO: 11

WEIGHT  
29.6 lbs

MODEL NAME  
SE132-211

WELDING ENGINEER

NCSX-SE132-211