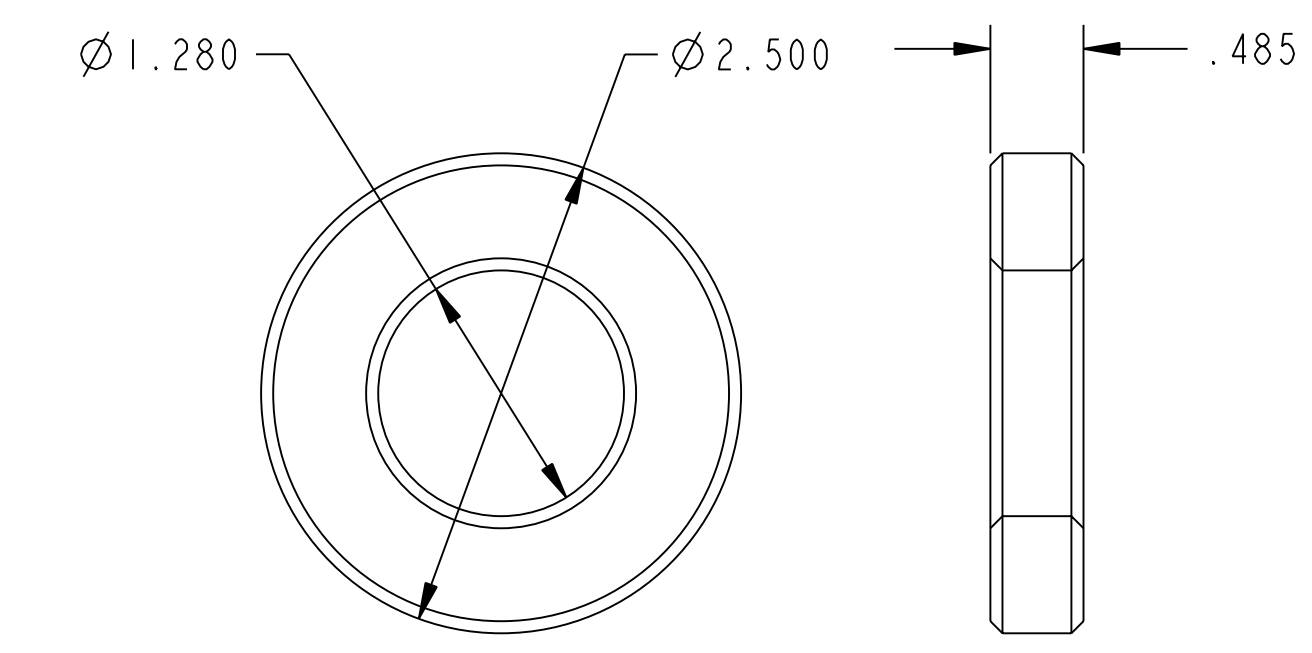


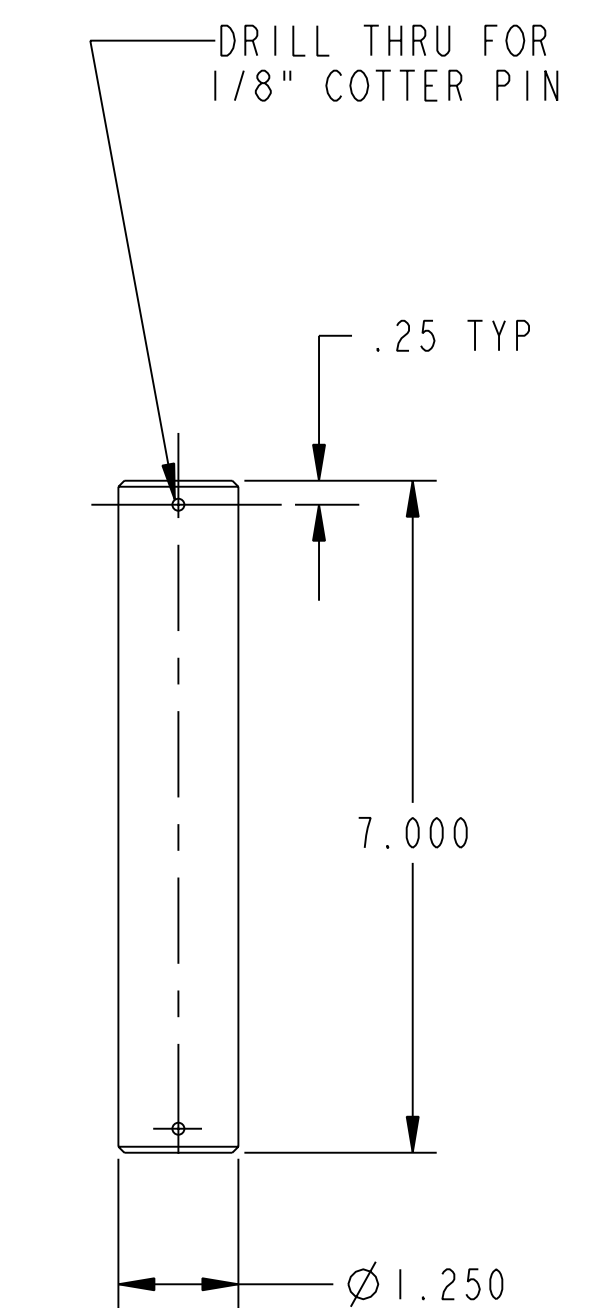
**ISOMETRIC VIEW  
COIL PRE-BEND ROLLER ASSEMBLY**

**RELEASED FOR  
FABRICATION / INSTALLATION**  
PPPL Drafting:

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



**PART 4**



**PART 3**

**NOTES:**

1. WELDING SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF AWS D1.1 AND PPPL PROCEDURE NO. ENG-037. VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH THE ACCEPTANCE CRITERIA OF AWS D1.1, 6.9.

QTY	NO.	DESCRIPTION	MATERIAL
6	17	COMM 1/4-20UNC FLAT HD SCREW X 3/4" LG	CS
1	16	THIS DWG 1/2" TH"K PLATE 6" X 14" (SEE WELDMENT)	CS
1	15	THIS DWG ALBION OG POLYURETHANE ROLLER 6" OD X 5" WD, 4-1/4" HUB LG, 1-1/4" I.D. BEARING #0G068012001	-----
1	14	THIS DWG PIN Ø.875 X 3.625 LG (SEE DETAIL)/COTTER PIN	CS
1	13	COMM WASHER NOM. 5/8" I.D. 1-3/16" O.D. X 1/8" TH"K	CS
1	12	THIS DWG 1-8UNC THREADED ROD 13.5 LG (SEE DETAIL)	304SS/CS
1	11	THIS DWG 1.25 X 3 X 3.88 LG CLEVIS (SEE DETAIL)	304SS/CS
1	10	THIS DWG ADJ. BRACKET WELDMENT (SEE DETAIL)	CS
1	9	THIS DWG ROLLER CARRIAGE WELDMENT (SEE DETAIL)	304SS
1	8	THIS DWG 3/8" TH"K PLATE 7" X 15" (SEE DETAIL)	304SS
2	7	THIS DWG 2" SQ. BAR X 15" LG (SEE DETAIL)	CS
1	6	THIS DWG 3/4" TH"K PLATE 9" X 20" (SEE DETAIL)	CS
1	5	THIS DWG 4" SQ. TUBING 1/4" WALL X 38" LG	CS
2	4	THIS DWG 2.50 O.D. WASHER (SEE DETAILS)	CS
1	3	THIS DWG Ø1.25 SHAFT X 7" LG (SEE DETAIL)/COTTER PINS	304SS
1	2	THIS DWG 3/4" PLATE 12" X 36"	CS
1	1	THIS DWG 4" SQ. TUBING 1/4" WALL X 34" LG	CS
---	---	THIS DWG COIL PRE-BEND ROLLER ASSEMBLY	-----

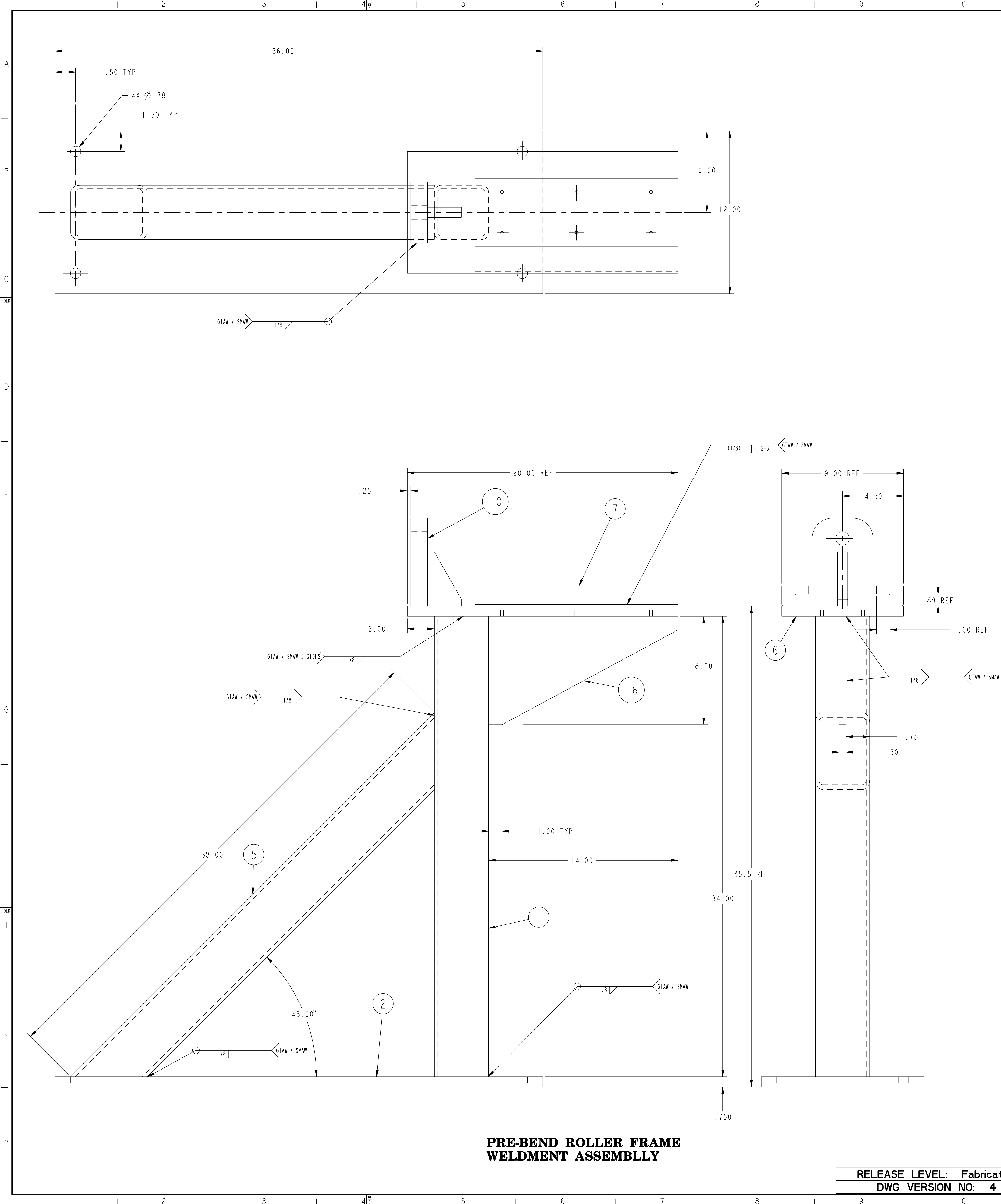
ASSY QTY	PART NO.	DRAWING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL

WEIGHT	1100.2 lbs
MODEL NAME	SE1312-024
WELDING ENGINEER	L. DUDEK

**RELEASE LEVEL: Fabrication**  
**DWG VERSION NO: 4**

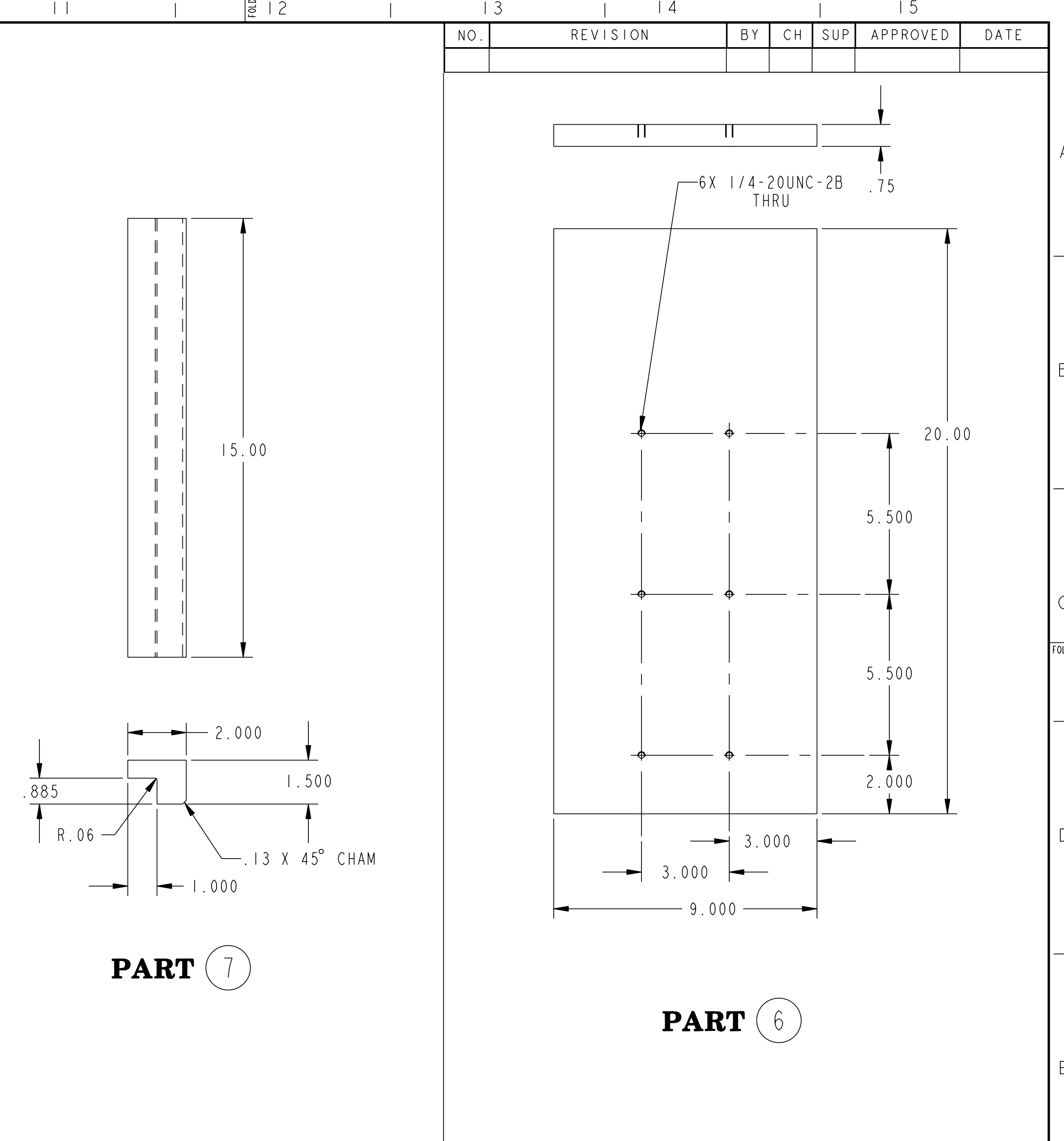
PRINCETON PLASMA PHYSICS LABORATORY NATIONAL COMPACT STELLARATOR EXPERIMENT	IF COIL WINDING ROOM COIL PRE-BEND ROLLER ASSEMBLY WELDMENT AND DETAILS	DSN: B. PAUL 8/25/05 CHK: L. DUDEK 8/25/05 ENGR: J. CHRZANOWSKI 8/25/05 SUPV: J. SIEGEL 8/25/05	DRAWING NO: <b>SE1312-024</b>	SHEET 1 OF 3 REV 0
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NCSX-SE1312-024



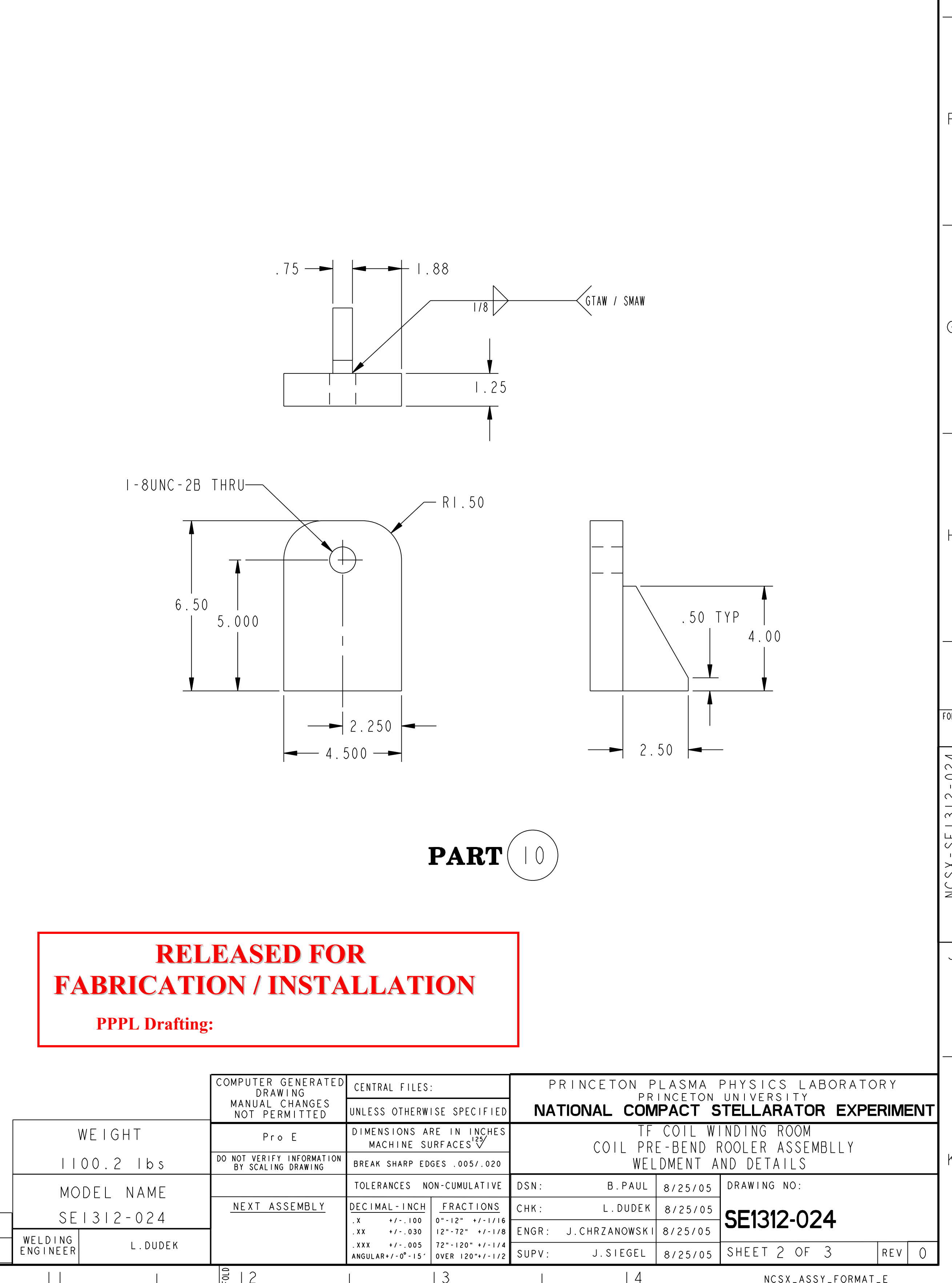
**PRE-BEND ROLLER FRAME  
WELDMENT ASSEMBLY**

RELEASE LEVEL: Fabrication  
DWG VERSION NO: 4



**PART 7**

**PART 6**



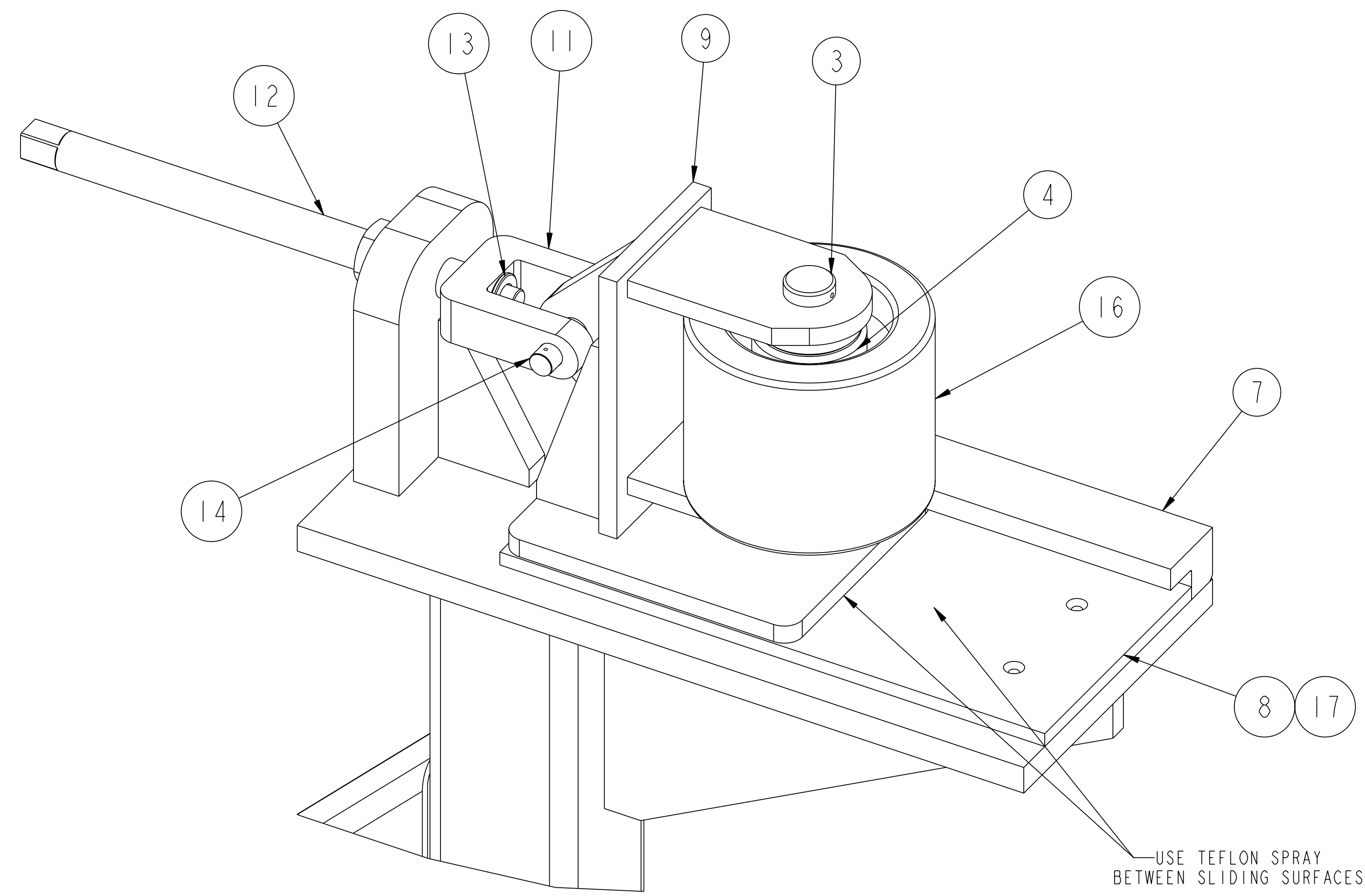
**PART 10**

**RELEASED FOR  
FABRICATION / INSTALLATION**  
PPPL Drafting:

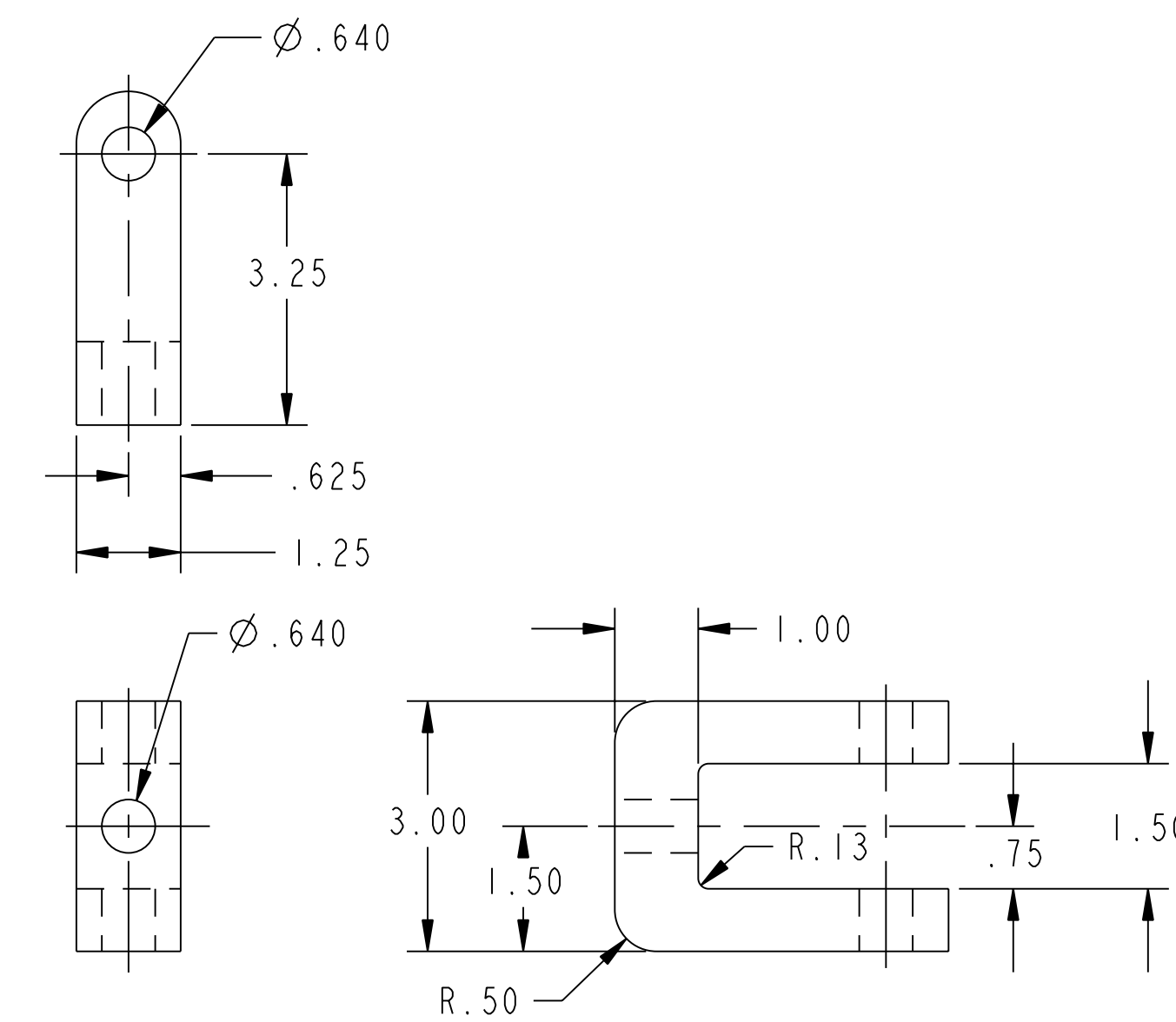
WEIGHT 1100.2 lbs	COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY	
	DO NOT VERIFY INFORMATION BY SCALING DRAWING	TOLERANCES NON-CUMULATIVE	NATIONAL COMPACT STELLARATOR EXPERIMENT	
MODEL NAME SE1312-024	Pro E	DECIMAL-INCH FRACTIONS	IF COIL WINDING ROOM COIL PRE-BEND ROLLER ASSEMBLY WELDMENT AND DETAILS	
WELDING ENGINEER L. DUDEK	NEXT ASSEMBLY	DSN: B. PAUL 8/25/05	CHK: L. DUDEK 8/25/05	DRAWING NO: <b>SE1312-024</b>
		ENGR: J. CHRZANOWSKI 8/25/05	SUPV: J. SIEGEL 8/25/05	SHEET 2 OF 3 REV 0

NCSX-SEI 1312-024

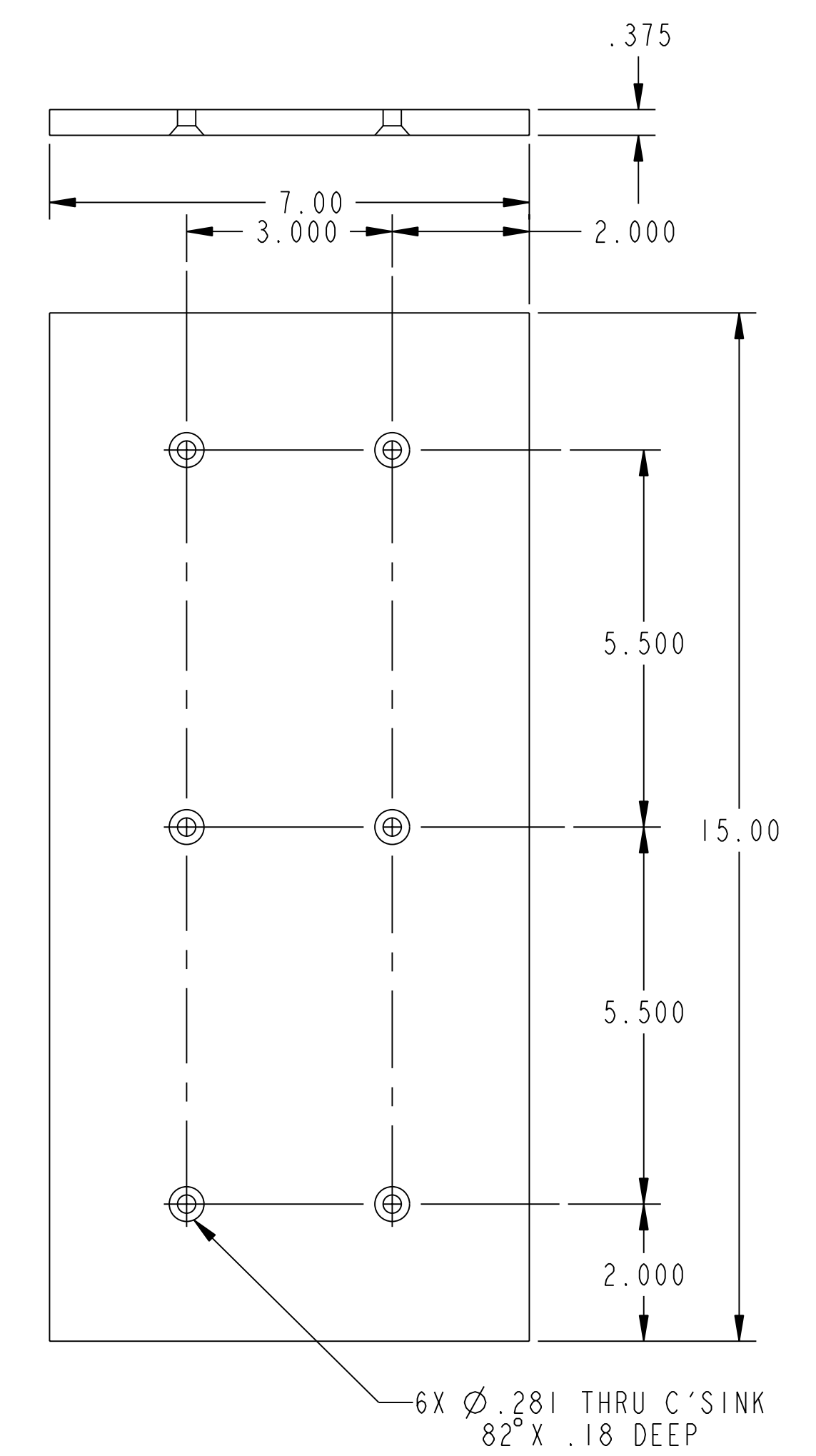




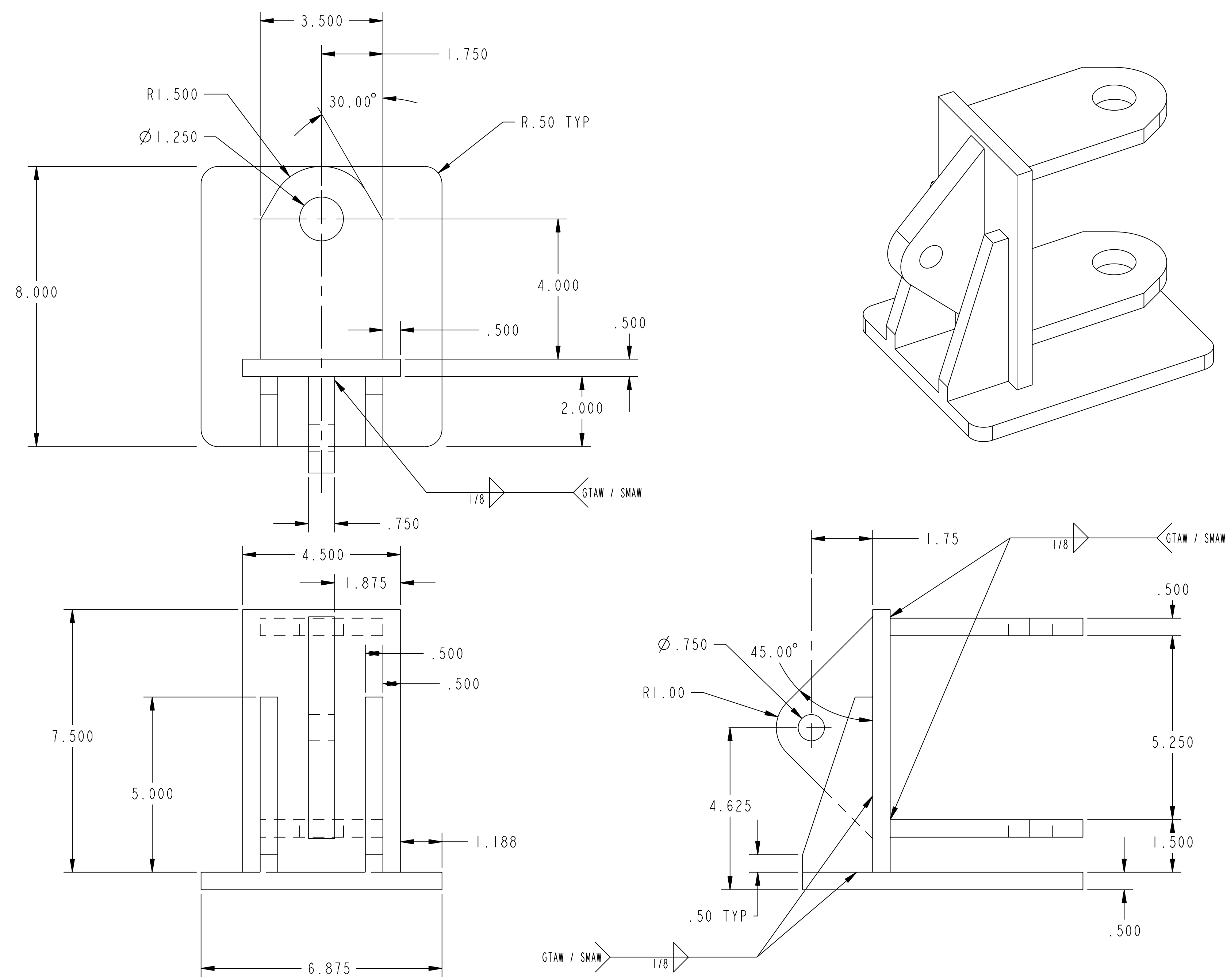
**PRE-BEND ROLLER ASSEMBLY**  
(ONE PART 7 REMOVED FOR CLARITY)



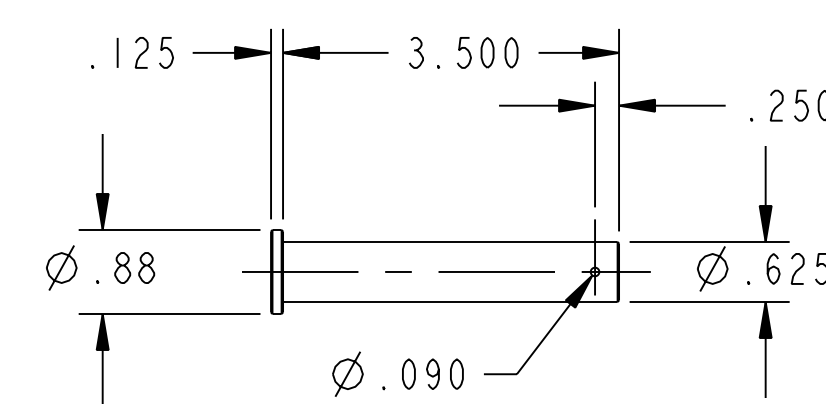
**PART 11**



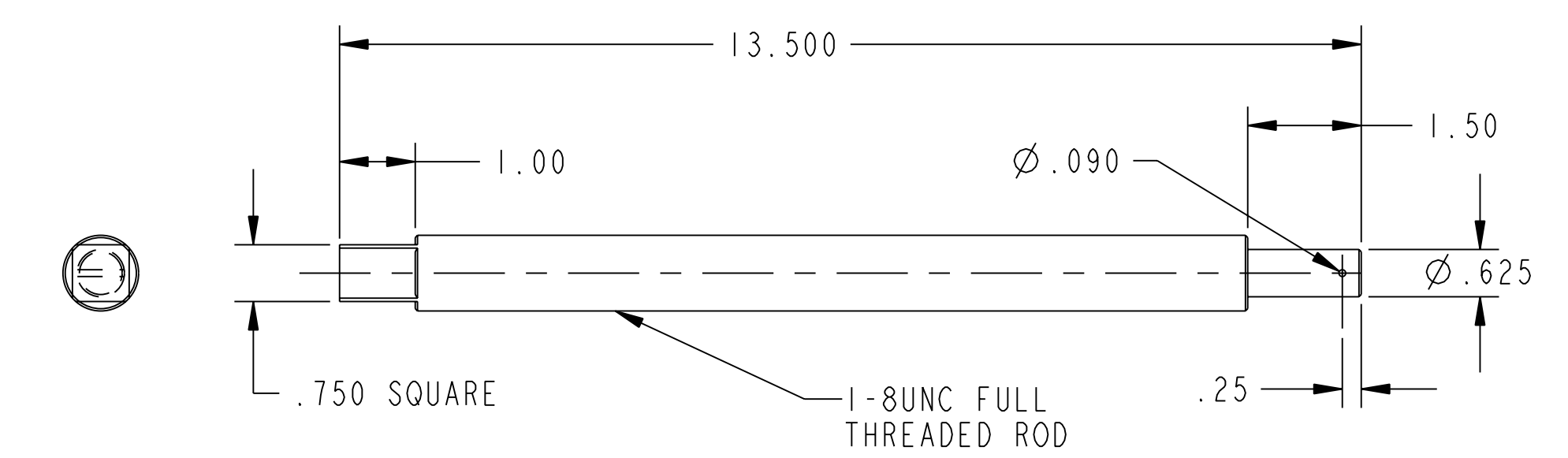
**PART 8**



**PART 9**



**PART 14**



**PART 12**

**RELEASED FOR  
FABRICATION / INSTALLATION**  
PPPL Drafting:

**RELEASE LEVEL: Fabrication**  
**DWG VERSION NO: 4**

WEIGHT	39.2 lbs
MODEL NAME	SE1312-024-10
WELDING ENGINEER	L. DUDEK

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY <b>NATIONAL COMPACT STELLATOR EXPERIMENT</b> TF COIL WINDING ROOM COIL PRE-BEND ROLLER ASSEMBLY WELDMENT AND DETAILS
DO NOT VERIFY INFORMATION BY SCALING DRAWING	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX +/- .005 .XXX +/- .005 ANGULAR +/- 0°15'	DSN: B. PAUL 8/25/05 CHK: L. DUDEK 8/25/05 ENGR: J. CHRZANOWSKI 8/25/05 SUPV: J. SIEGEL 8/25/05
NEXT ASSEMBLY	DRAWING NO: <b>SE1312-024</b>	SHEET 3 OF 3 REV 0

NCSX-SET1312-024