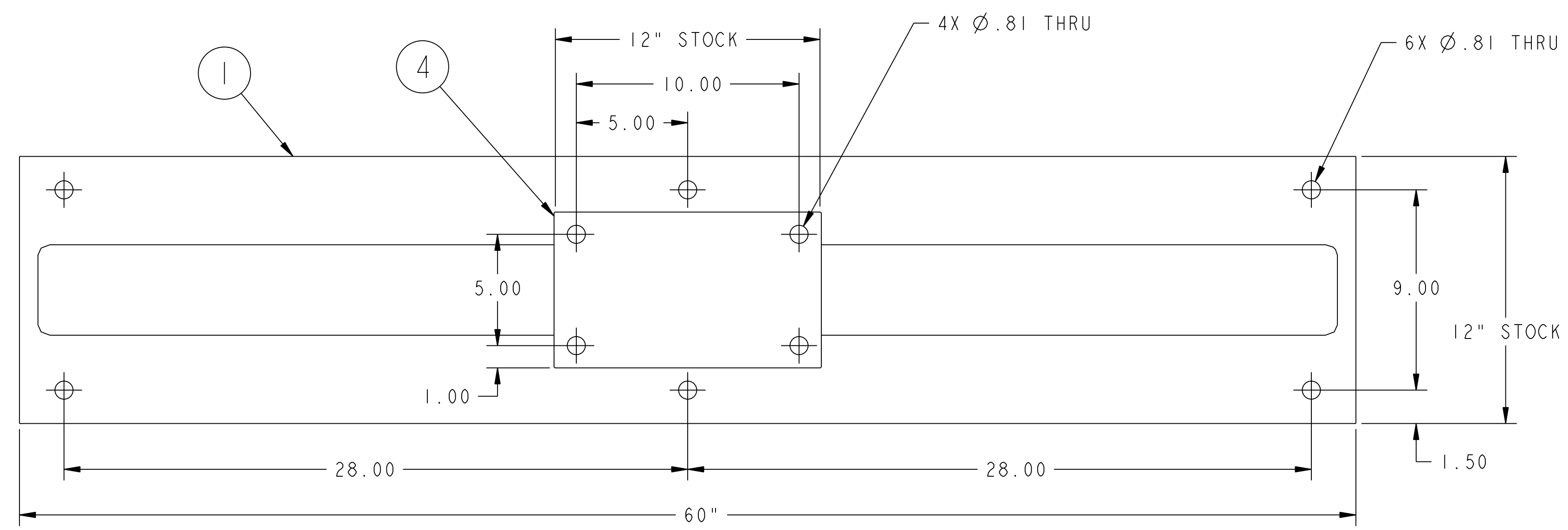
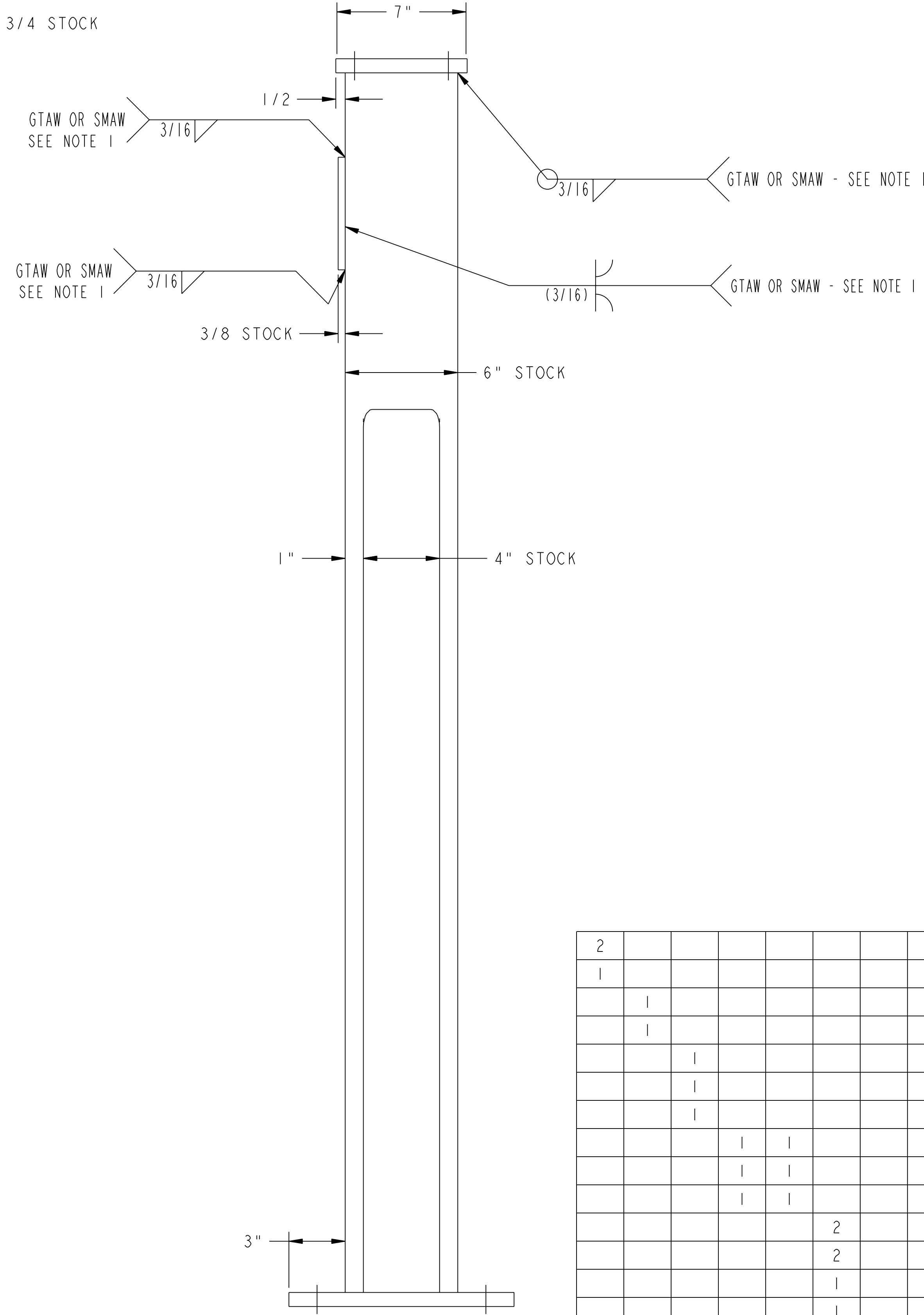
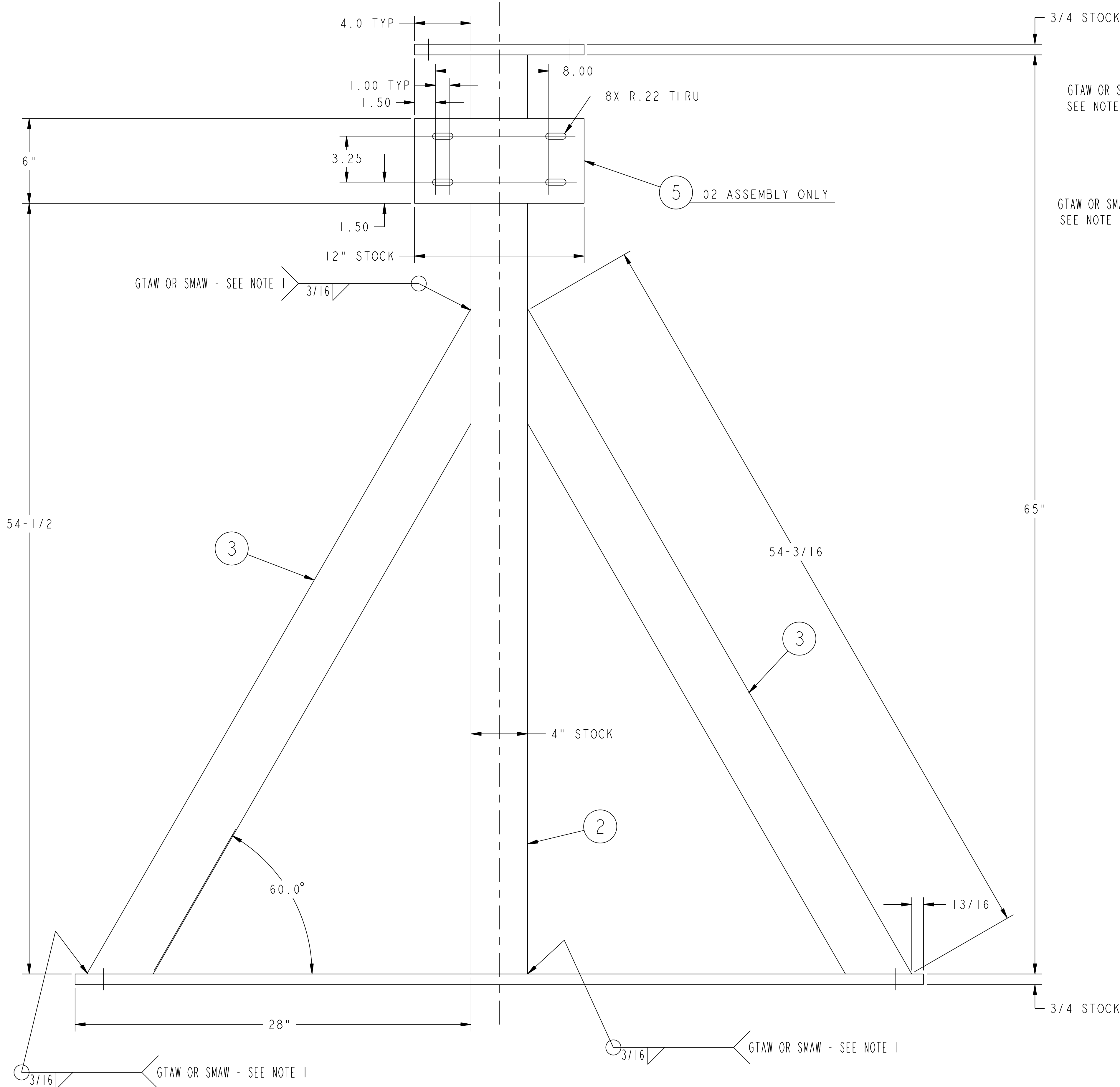


NO.	REVISION	BY	CH	SUP	APPROVED	DATE



**NOTES**

1. WELDS SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF THE APPLICABLE CODE AND PPPL PROCEDURE ENG-037. VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH THE ACCEPTANCE CRITERIA OF AWS D1.1 Section 6 AND AWS D1.3 AS APPLICABLE.



01 ASSEMBLY SUPPORT STAND WELDMENT - WITHOUT BRACKET  
 02 ASSEMBLY SUPPORT STAND WELDMENT - WITH BRACKET

2					19	THIS DWG	AXLE LOCKING CAP TAB	ASTM A36	
1					18	THIS DWG	AXLE LOCKING CAP CRADLE - 7" O.D. TUBE X 3/4" WALL	ASTM A513	
	1				17	THIS DWG	WORM GEAR AXLE - Ø 1 1/2 O.D. TUBE X 5/16 WALL	ASTM A513	
		1			16	THIS DWG	WORM GEAR AXLE BASE FLANGE	ASTM A36	
			1		15	THIS DWG	SUPPORT BRACKET GUSSET	ASTM A36	
				1	14	THIS DWG	SUPPORT BRACKET TOP PLATE	ASTM A36	
					13	THIS DWG	SUPPORT BRACKET SIDE PLATE	ASTM A36	
					12	THIS DWG	SUPPORT AXLE CAP	ASTM A36	
					11	THIS DWG	SUPPORT AXLE - Ø 5.50 O.D. TUBE X 1/2 WALL	ASTM A513	
					10	THIS DWG	SUPPORT AXLE BASE FLANGE	ASTM A36	
					9	THIS DWG	CRADLE GUSSET	ASTM A36	
					8	THIS DWG	CRADLE TAB	ASTM A36	
					7	THIS DWG	CRADLE - Ø 7" O.D. TUBE X 3/4" WALL	ASTM A513	
					6	THIS DWG	CRADLE BASE PLATE	ASTM A36	
					5	THIS DWG	WORM SUPPORT BRACKET MOUNTING PLATE	ASTM A36	
					4	THIS DWG	SUPPORT STAND TOP PLATE	ASTM A36	
					3	THIS DWG	SUPPORT STAND BRACE - 4" X 4" X 1/4" STRUCT TUBING	ASTM A36	
					2	THIS DWG	SUPPORT STAND UPRIGHT - 6" X 4" X 1/4" STRUCT TUBING	ASTM A36	
					1	THIS DWG	SUPPORT STAND BASE PLATE	ASTM A36	
						THIS DWG	AXLE LOCKING CAP WELDMENT	---	2
						THIS DWG	WORM GEAR AXLE WELDMENT	---	1
						THIS DWG	WORM SUPPORT BRACKET WELDMENT	---	1
						THIS DWG	SUPPORT AXLE WELDMENT - TYPE "B"	---	1
						THIS DWG	SUPPORT AXLE WELDMENT - TYPE "A"	---	1
						THIS DWG	AXLE CRADLE WELDMENT	---	2
						THIS DWG	SUPPORT STAND WELDMENT - WITH BRACKET	---	1
						THIS DWG	SUPPORT STAND WELDMENT - WITHOUT BRACKET	---	1

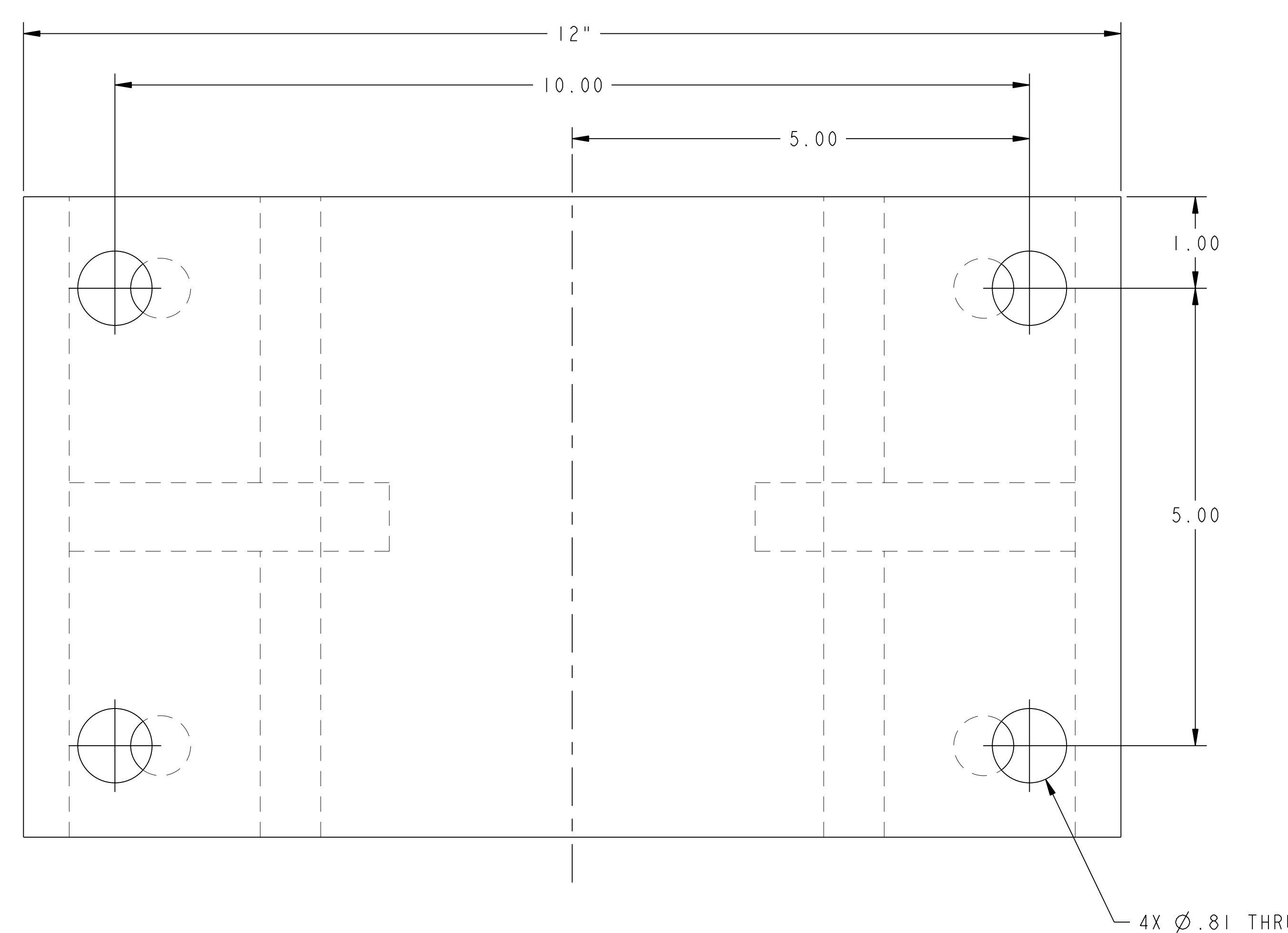
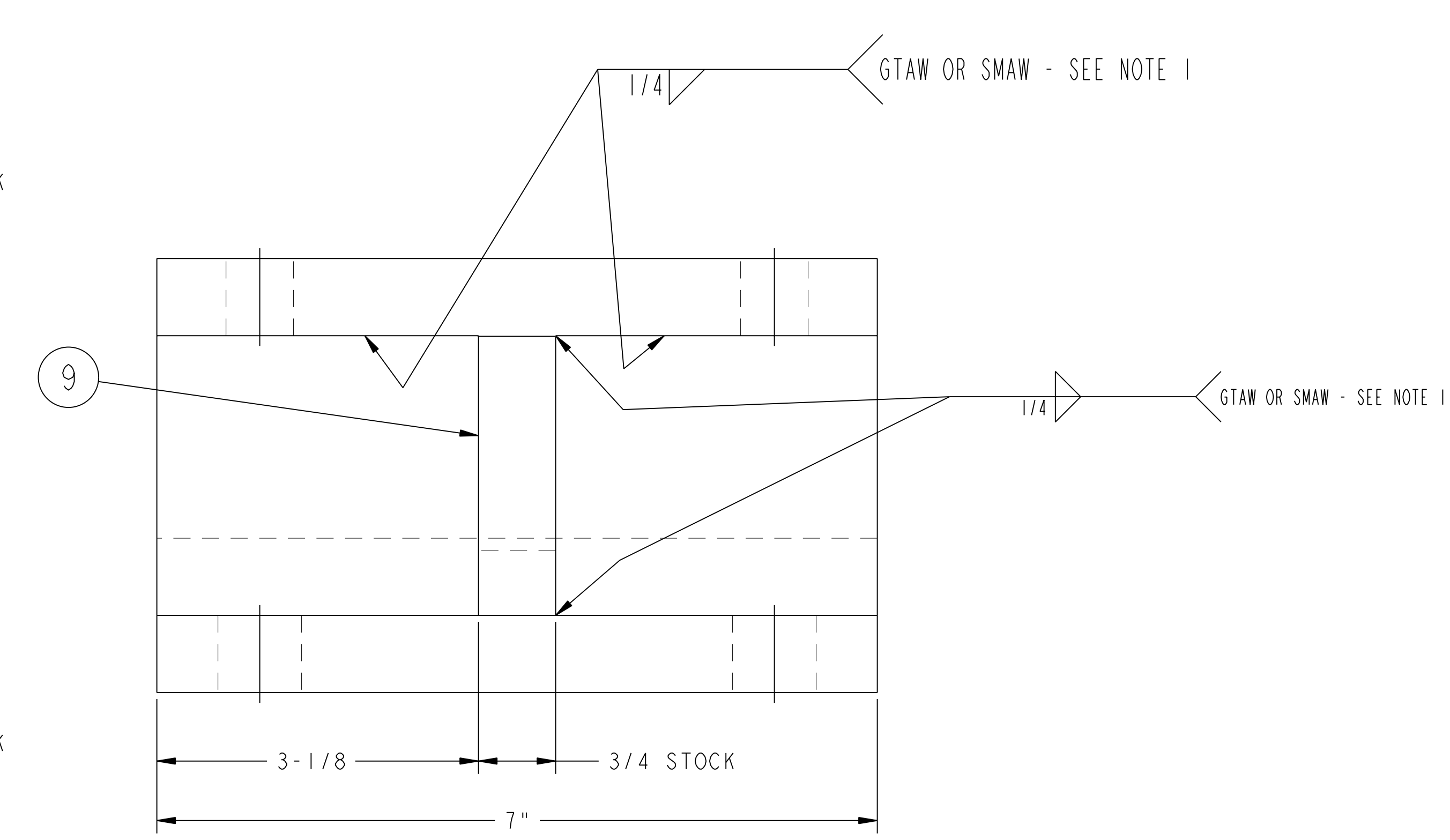
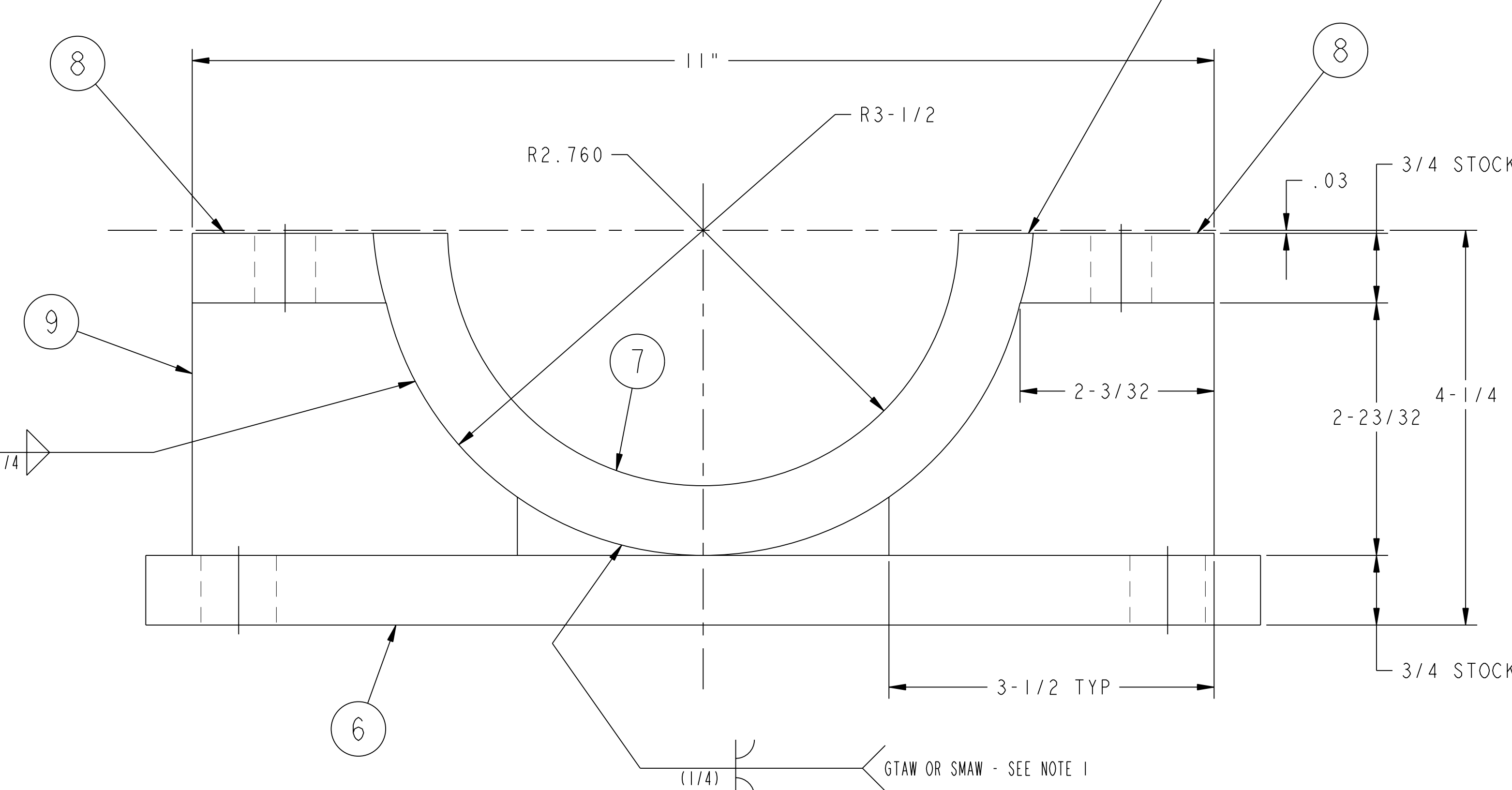
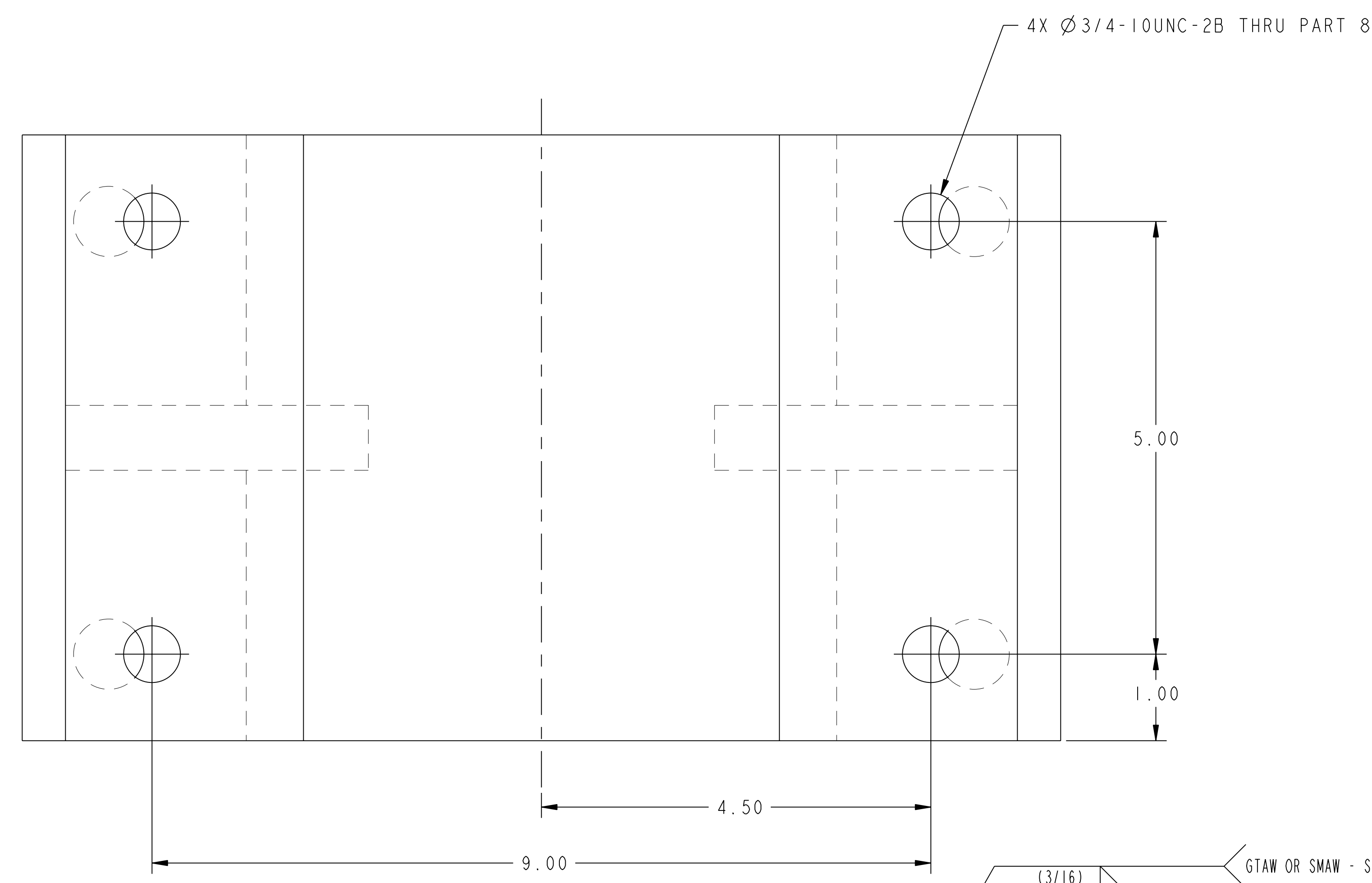
**PARTS LIST**

COMPUTER GENERATED DRAWING 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 STELLATOR EXPERIMENT	
WEIGHT: 297.2 lbs	DECIMAL-INCH FRACTIONS	EXTERNAL FLUX LOOPS VACUUM VESSEL SUPPORT STAND FIXTURE ASSEMBLY WELDMENTS AND DETAILS	
MODEL NAME: SEE 1884-0002-002	DSN: L. MORRIS	DRAWING NO: SE184-002	
WELDING ENGINEER	CHK: ENGR: T. BROWN	SHEET 1 OF 3 REV 0	

RELEASE LEVEL: WIP  
 DWG VERSION NO: 1

NCSX-SE184-002

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



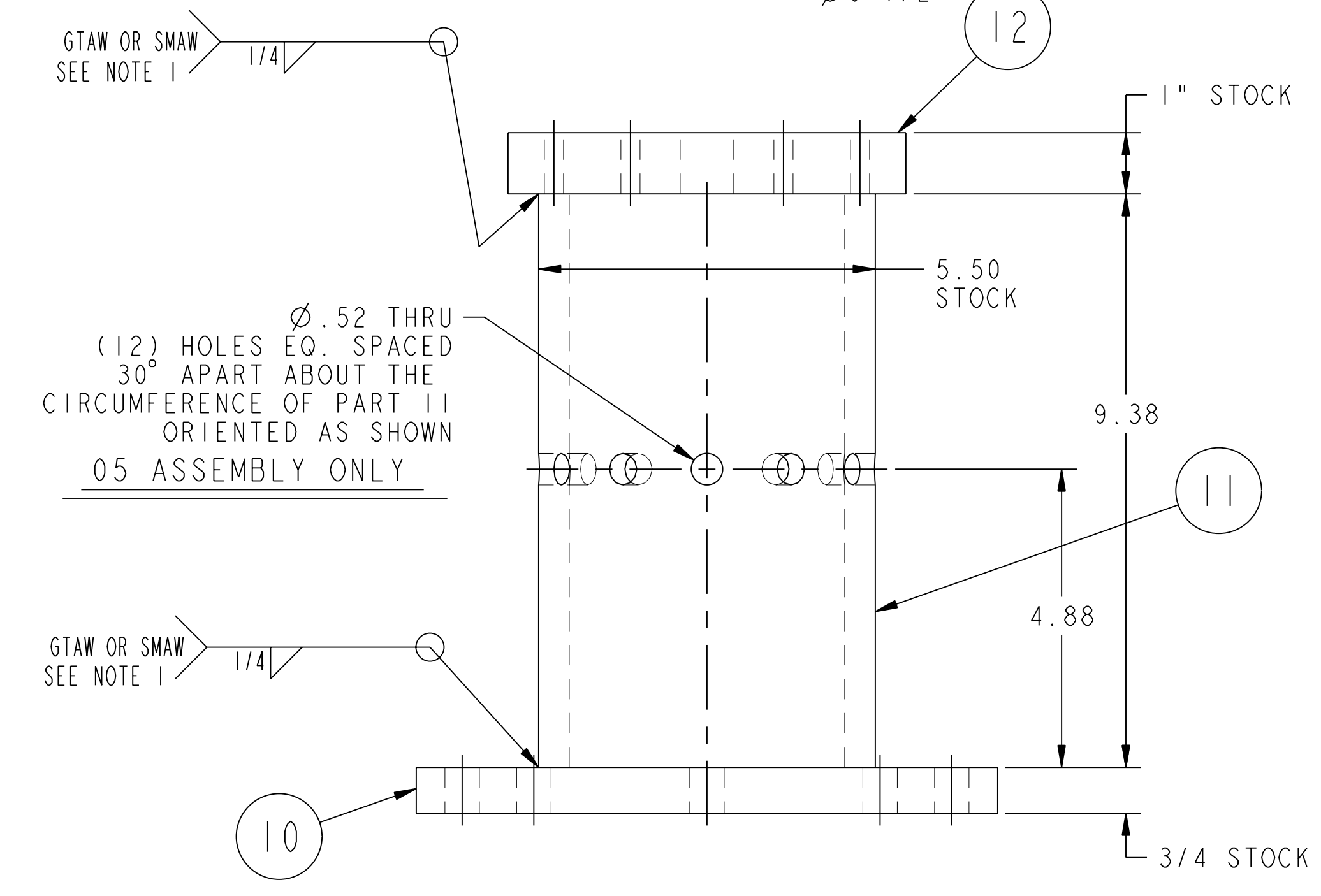
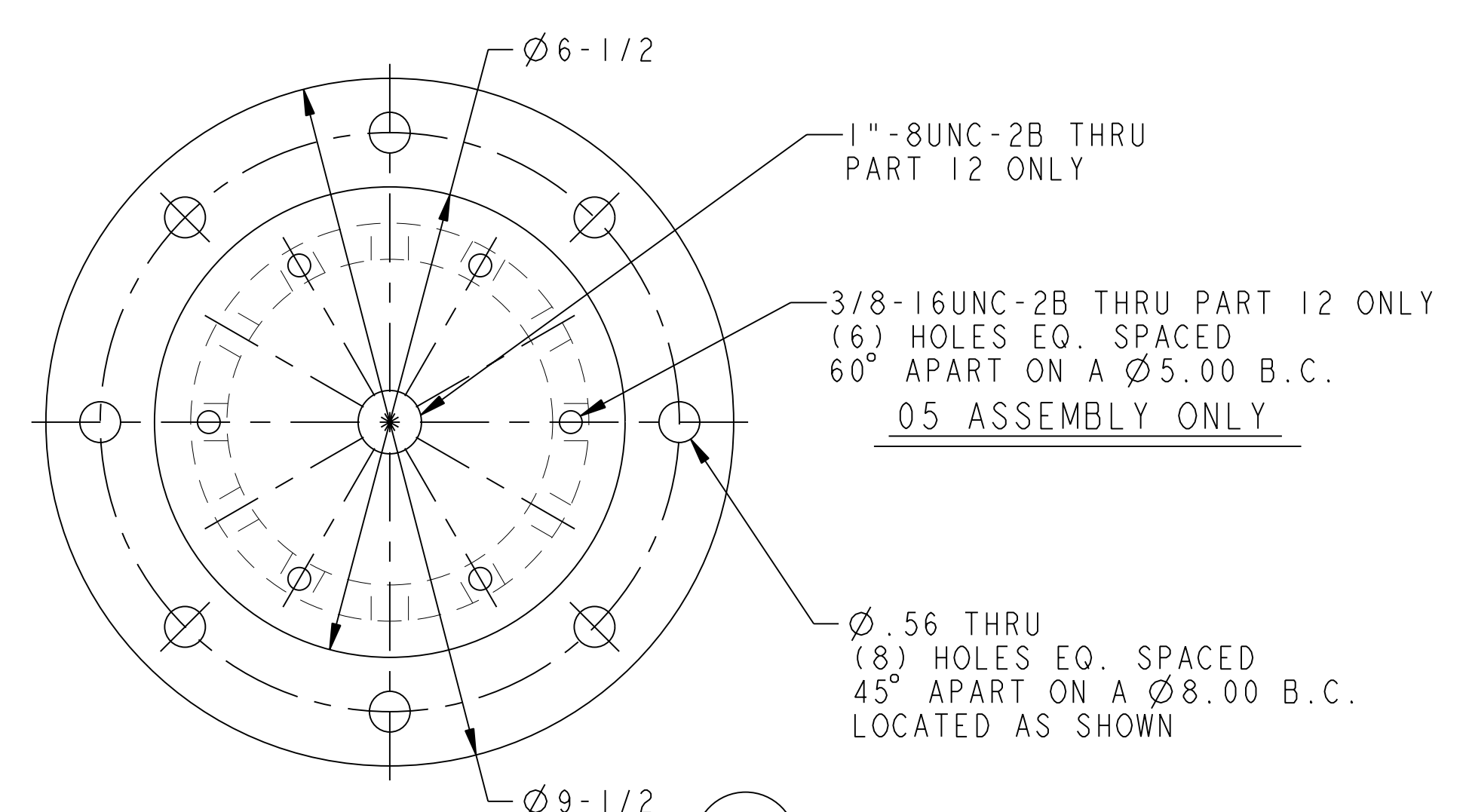
03 ASSEMBLY AXLE CRADLE WELDMENT

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

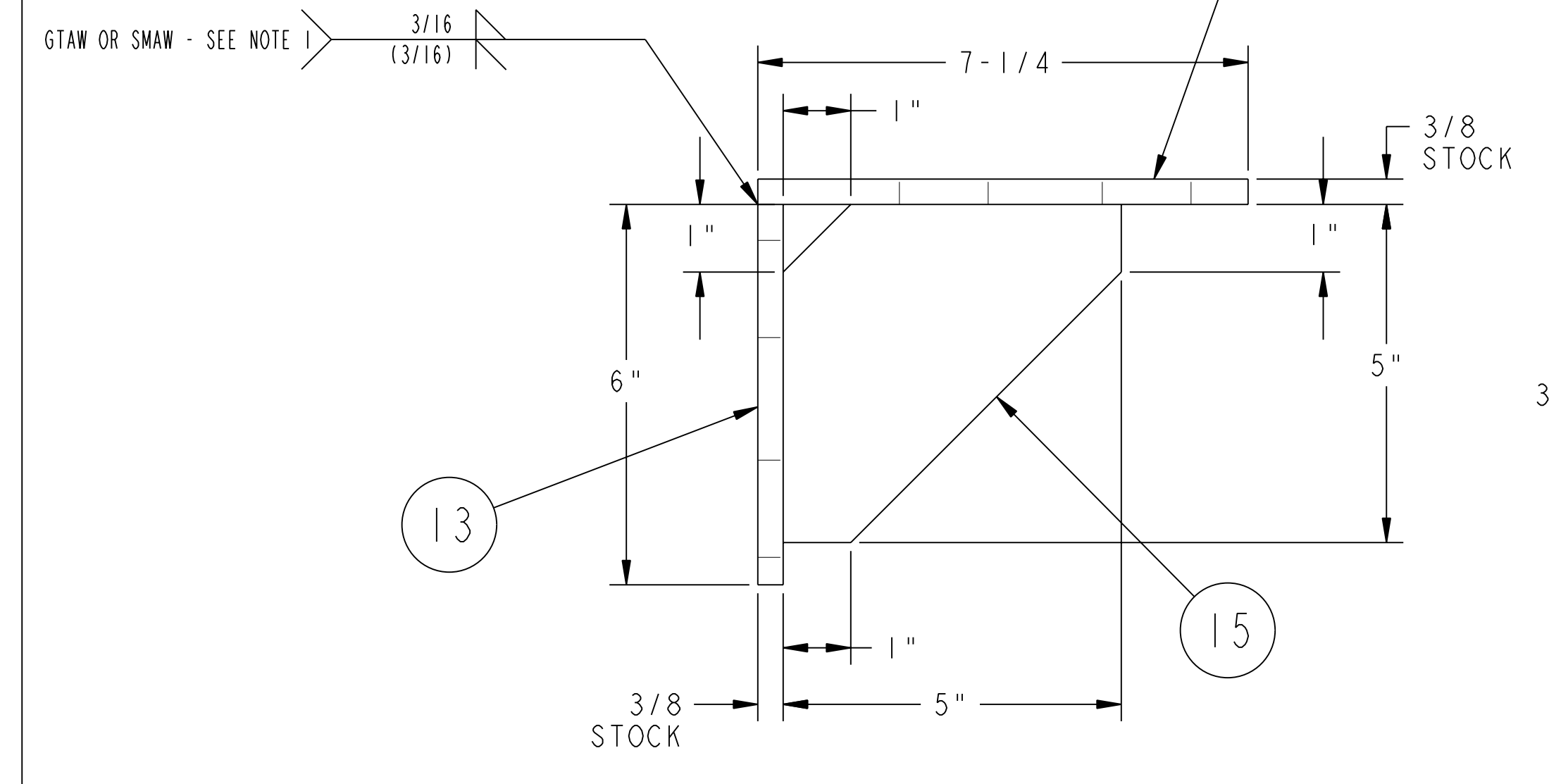
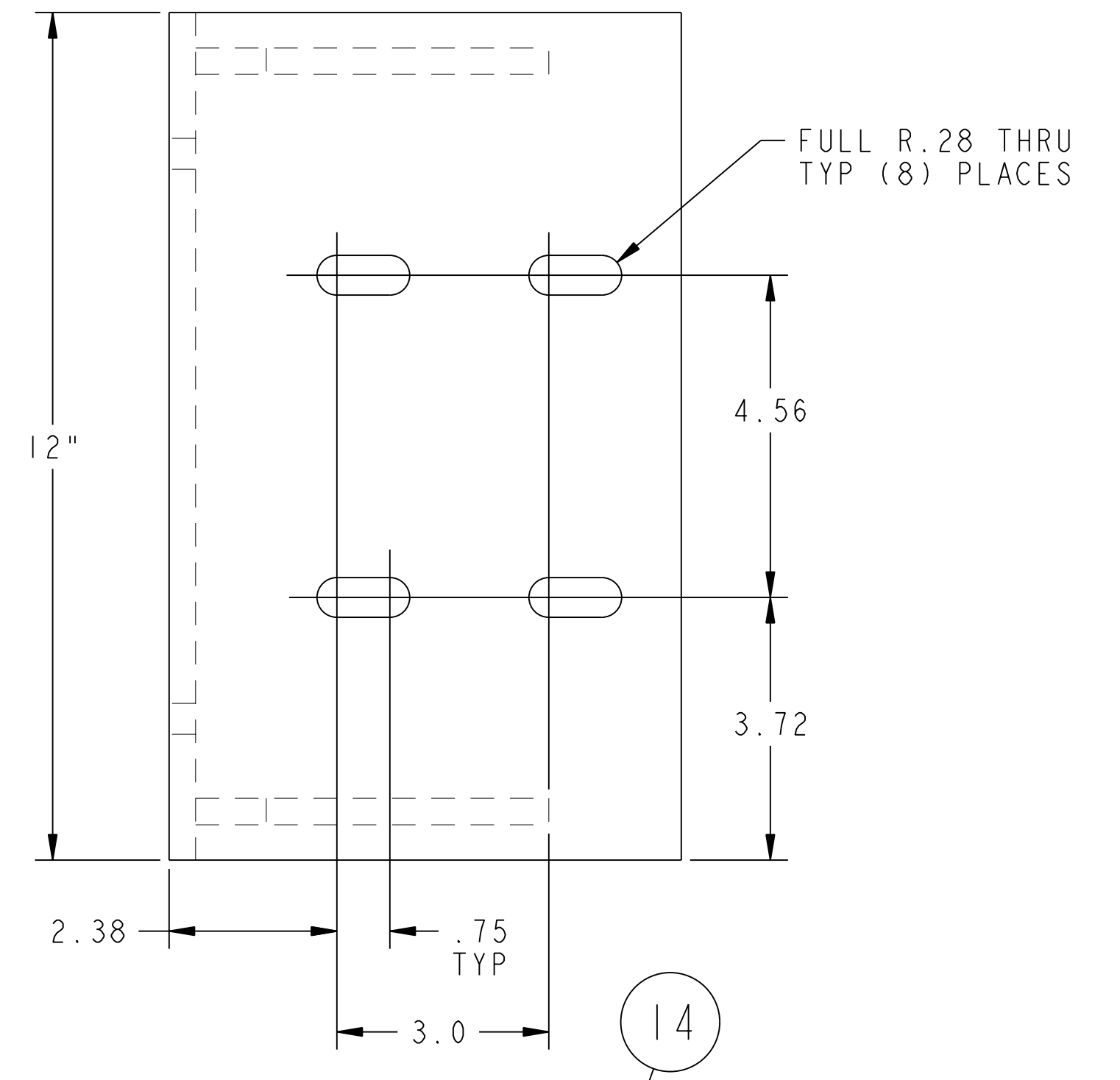
COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES:	PRINCETON PLASMA PHYSICS LABORATORY NATIONAL COMPACT STELLARATOR EXPERIMENT	
	UNLESS OTHERWISE SPECIFIED	EXTERNAL FLUX LOOPS VACUUM VESSEL SUPPORT STAND FIXTURE ASSEMBLY WELDMENTS AND DETAILS	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	TOLERANCES NON-CUMULATIVE	DSN: L. MORRIS
NEXT ASSEMBLY	DECIMAL - INCH FRACTIONS	CHK: ENGR. T. BROWN	DRAWING NO: <b>SE184-002</b>
WEIGHT 297.2 lbs	.XX +/- .030 .XXX +/- .005 ANGULAR +/- 0°-15'	ENGR: T. BROWN	SHEET 2 OF 3
MODEL NAME SE184-002-02	WELDING ENGINEER	SUPV:	REV
RELEASE LEVEL: WIP DWG VERSION NO: 1			

NCSX-SE184-002

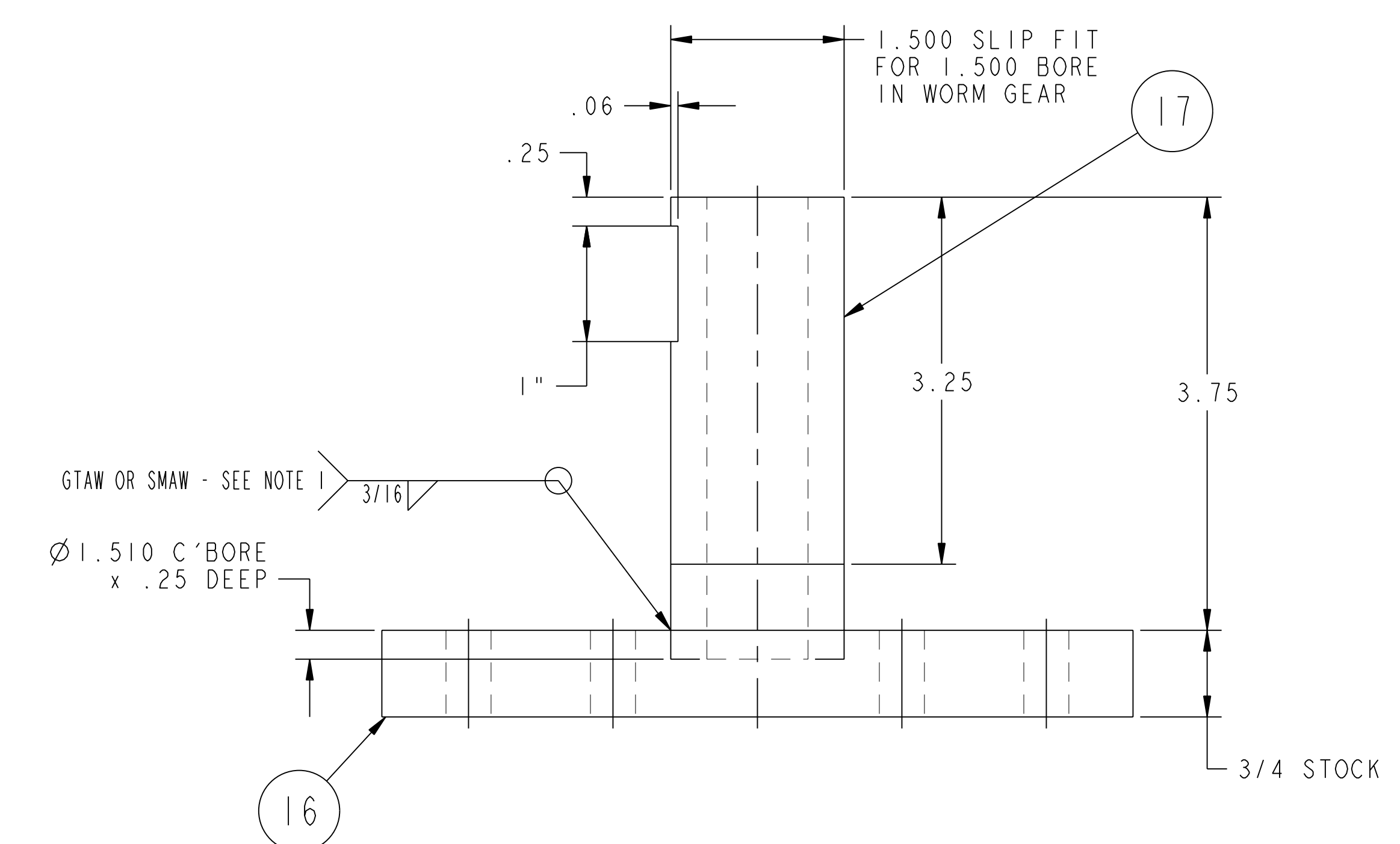
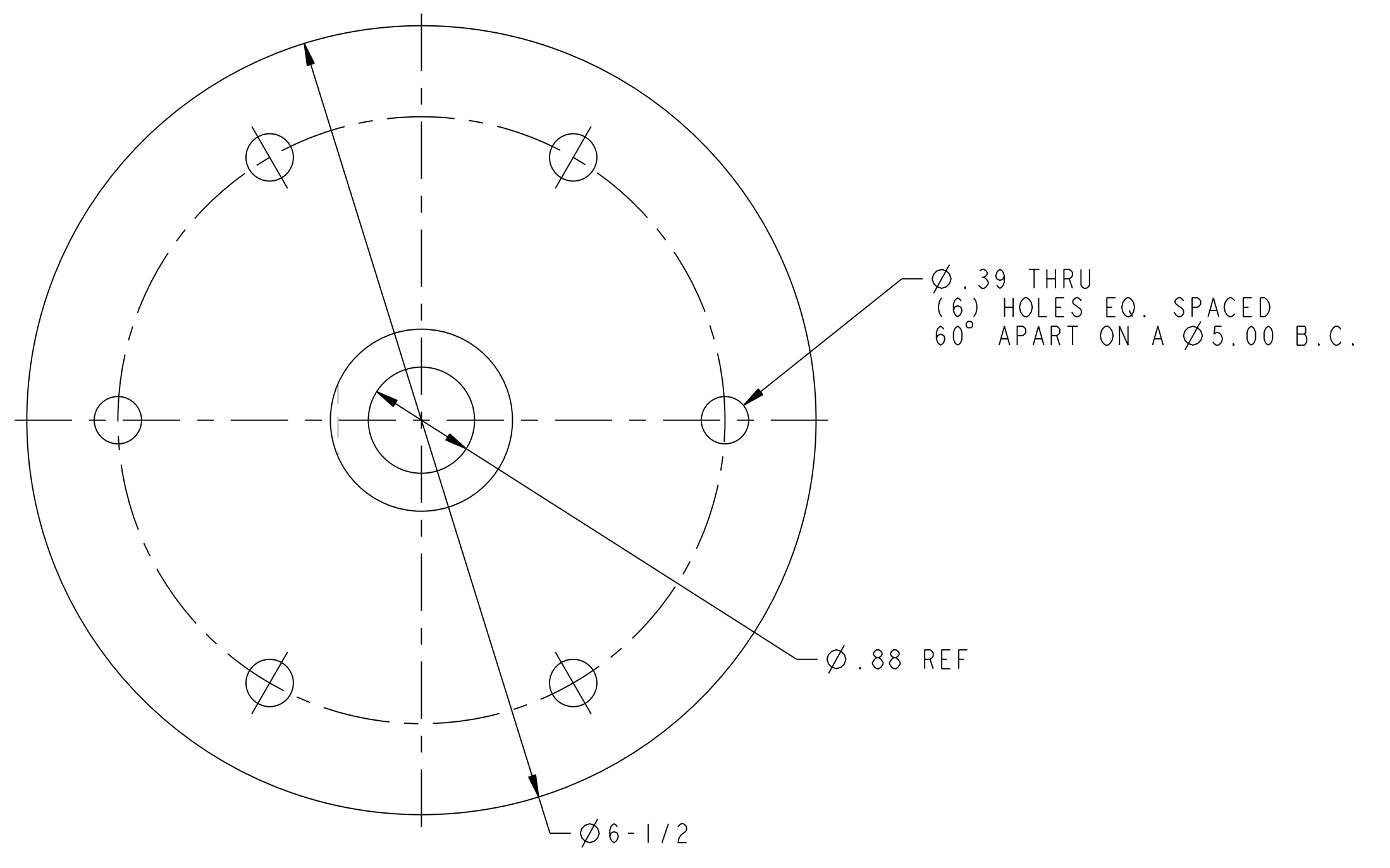
NO.	REVISION	BY	CH	SUP	APPROVED	DATE



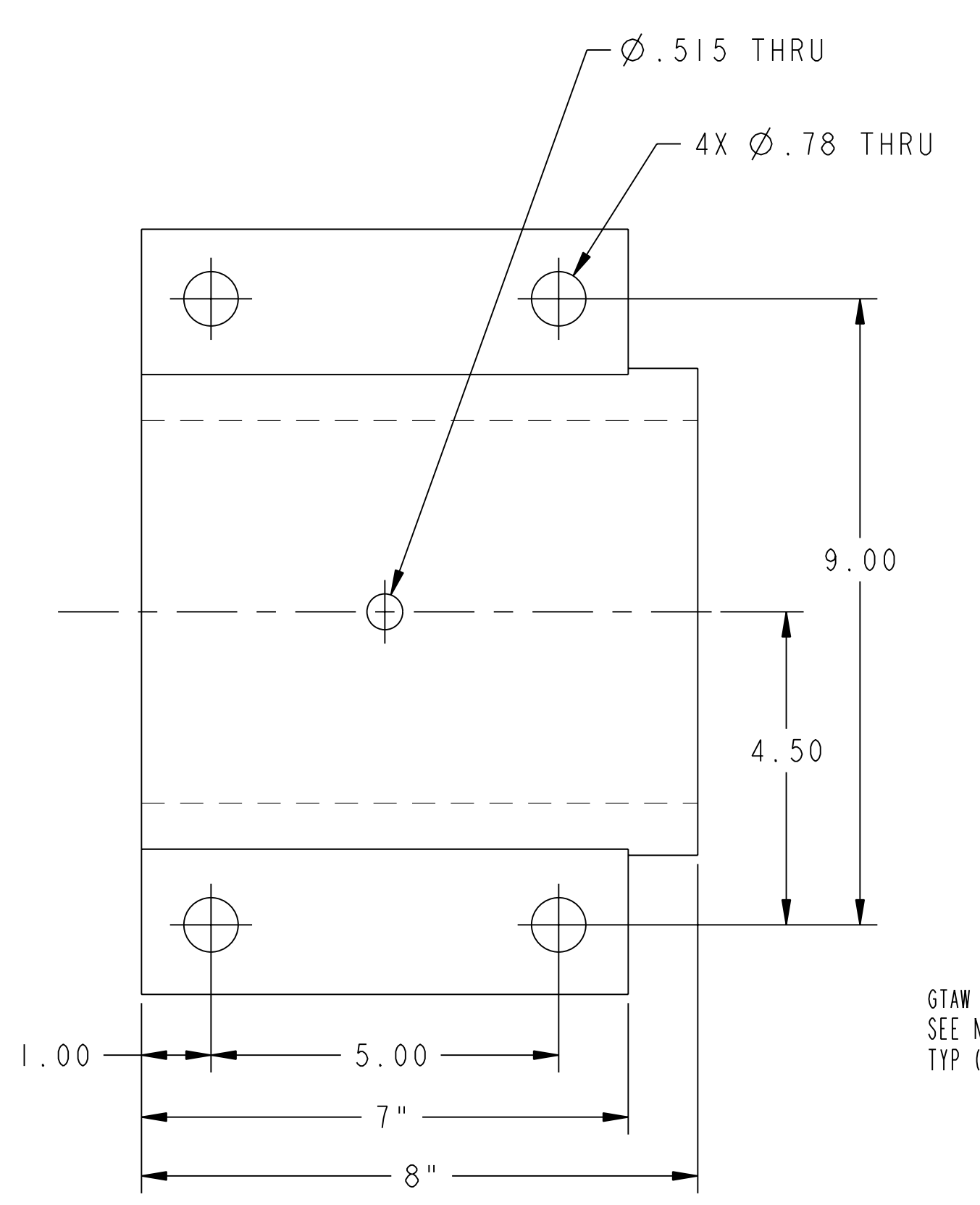
04 ASSEMBLY SUPPORT AXLE WELDMENT - TYPE "A"  
05 ASSEMBLY SUPPORT AXLE WELDMENT - TYPE "B"



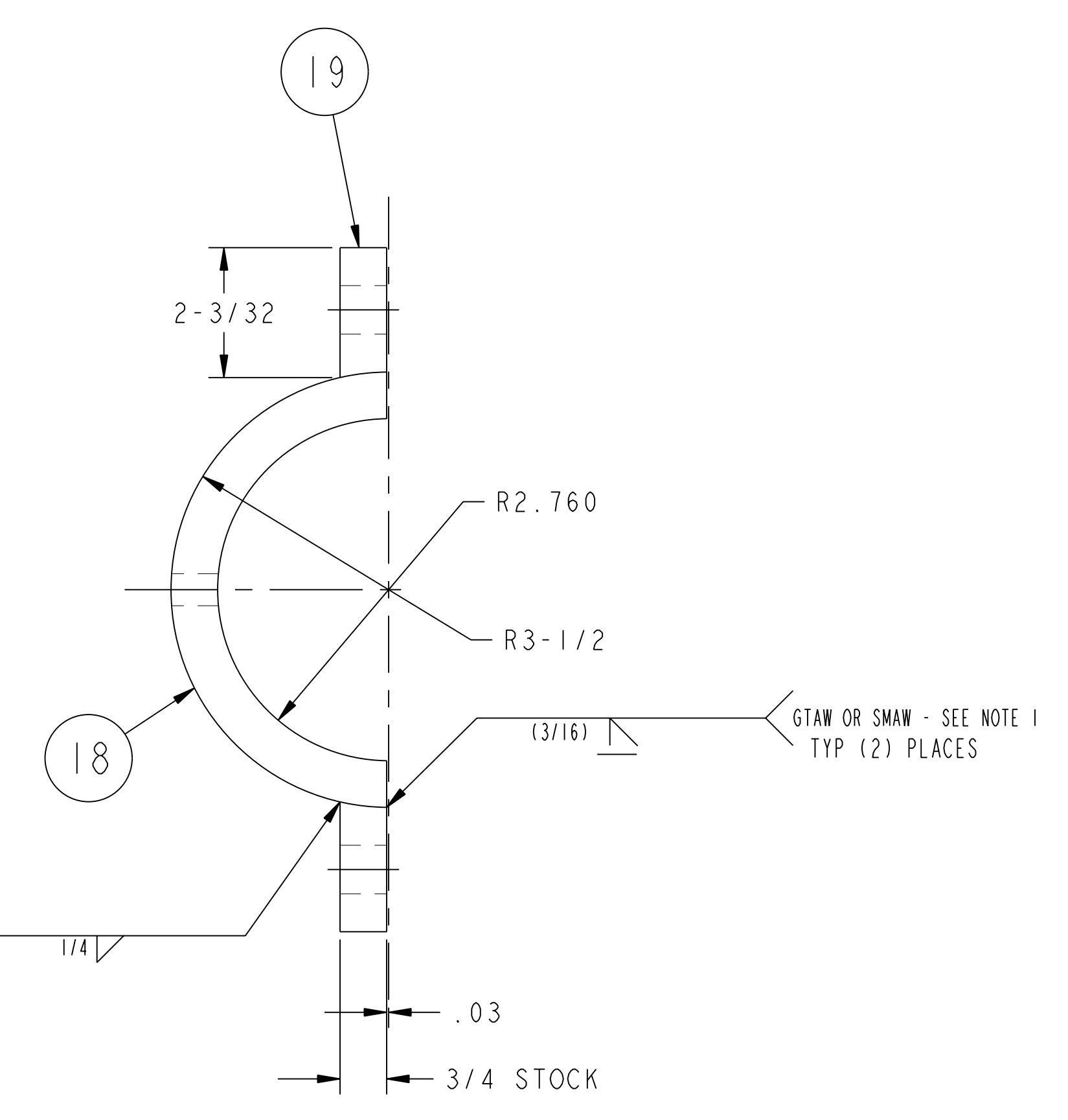
06 ASSEMBLY WORM SUPPORT BRACKET WELDMENT



07 ASSEMBLY WORM GEAR AXLE WELDMENT



08 ASSEMBLY AXLE LOCKING CAP



FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES:	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY	
	UNLESS OTHERWISE SPECIFIED	<b>NATIONAL COMPACT STELLARATOR EXPERIMENT</b>	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	EXTERNAL FLUX LOOPS VACUUM VESSEL SUPPORT STAND FIXTURE ASSEMBLY WELDMENTS AND DETAILS	
NEXT ASSEMBLY	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX ±.000 0°-12° ±.010 .XX ±.005 12°-120° ±.010 ANGULAR ±.0°-15° OVER 120° ±.125	DSN: L. MORRIS	DRAWING NO: <b>SE184-002</b>
WELDING ENGINEER	CHK: ENGR. T. BROWN	SUPV:	SHEET 3 OF 3 REV

RELEASE LEVEL: WIP  
DWG VERSION NO: 1

NCSX-SE184-002