

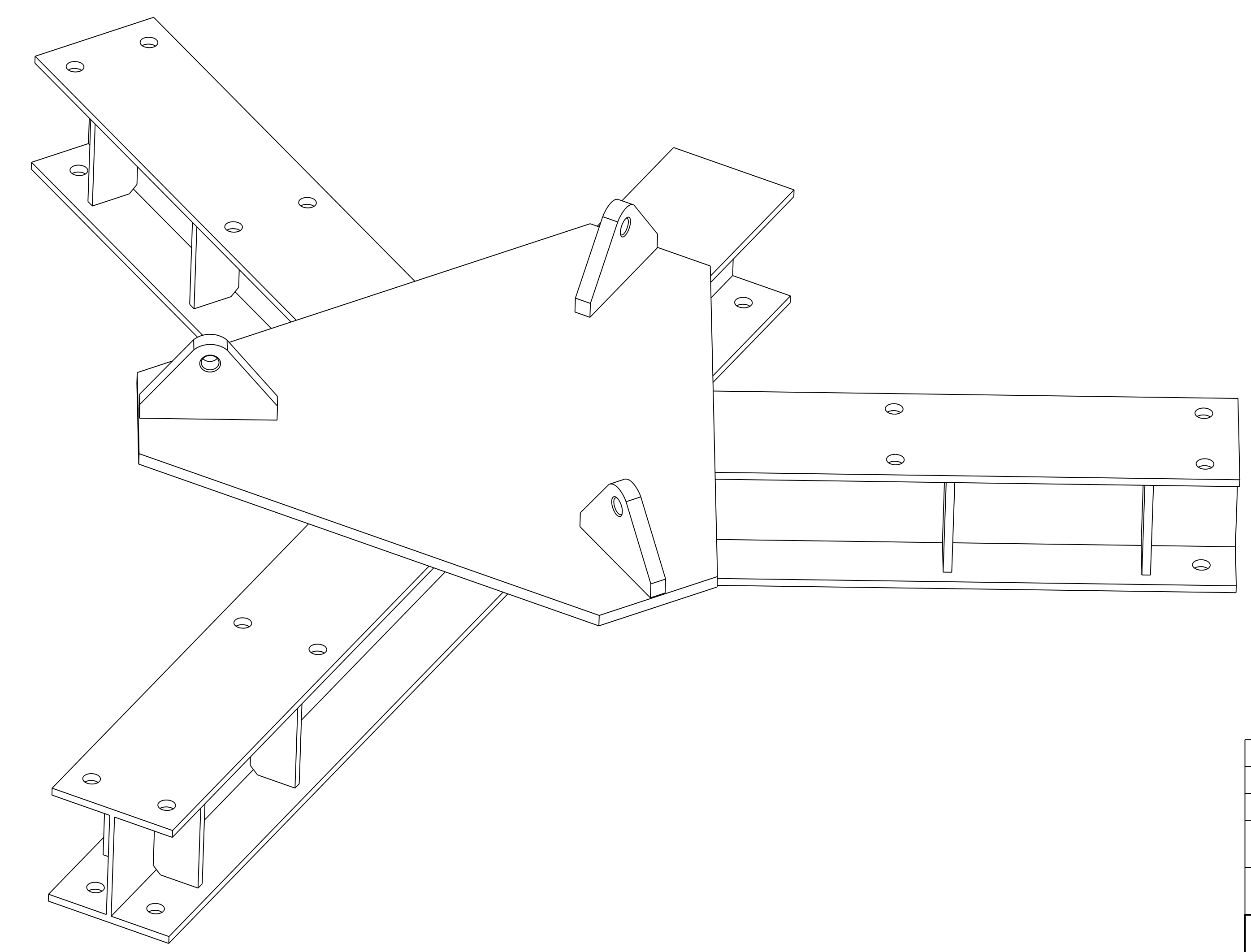
1. DRAWINGS PREPARED IN ACCORDANCE WITH ASME Y14.100-2000
2. INTERPRET DIMENSIONS & TOLERANCES PER ASME Y14.5-1994.
3. DIMENSIONS ARE IN INCHES.
4. SEE SPECIFICATION NCSX-CSPEC-XXX-XX-XX FOR ADDITIONAL INFORMATION AND/OR MATERIAL REQUIREMENTS.
5. WELDING SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF AWS D1.6 (STRUCTURAL WELDING OF AUSTENITIC STAINLESS STEEL) AND PPPL PROCEDURE NO. ENG-037. VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH THE ACCEPTANCE CRITERIA OF AWS D1.6.

REFERENCE PERMEABILITY

BASE MATERIAL	1.05
FABRICATED PART	1.05
WELD	1.05

NOTE ORIENTATION OF ALL PARTS BEFORE WELDING.

DRAWING DEPICTS FINAL REQUIRED ASSEMBLED STATE. MANUFACTURING TO DETERMINE MATERIAL ALLOWANCES AND WELD DISTORTION ALLOWANCES REQUIRED TO ACHIEVE DIMENSIONS/TOLERANCES INDICATED.



PART NO.	DRAWING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY	RECD
3	SE172-252	CENTER SUPPORT BRIDGING BEAM ASSEMBLY	304 STN STL	1	
2	SE172-203-2	BASE SUPPORT STRUCTURE BRACKET	304 STN STL	3	
1	SE172-203-1	CENTER SOLENOID SUPPORT BASE PLATE	304 STN STL	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	STELLARATOR CORE BASE SUPPORT STRUCTURE CENTER SUPPORT BASE ASSEMBLY	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	BREAK SHARP EDGES .005/.020	TOLERANCES NON-CUMULATIVE	DSN: T. CRUICKSHANK
NEXT ASSEMBLY	DECIMAL-INCH FRACTIONS	CHK:	DRAWING NO:
	.X +/- .100 0°-120° +/- .125	ENGR: F. DAHLGREN	SE172-203
	.XX +/- .030 12°-120° +/- .125	SUPV:	SHEET 1 OF 3
	.XXX +/- .005 72°-120° +/- .125		REV 0
	ANGULAR +/- .0°-15° OVER 120° +/- .125		

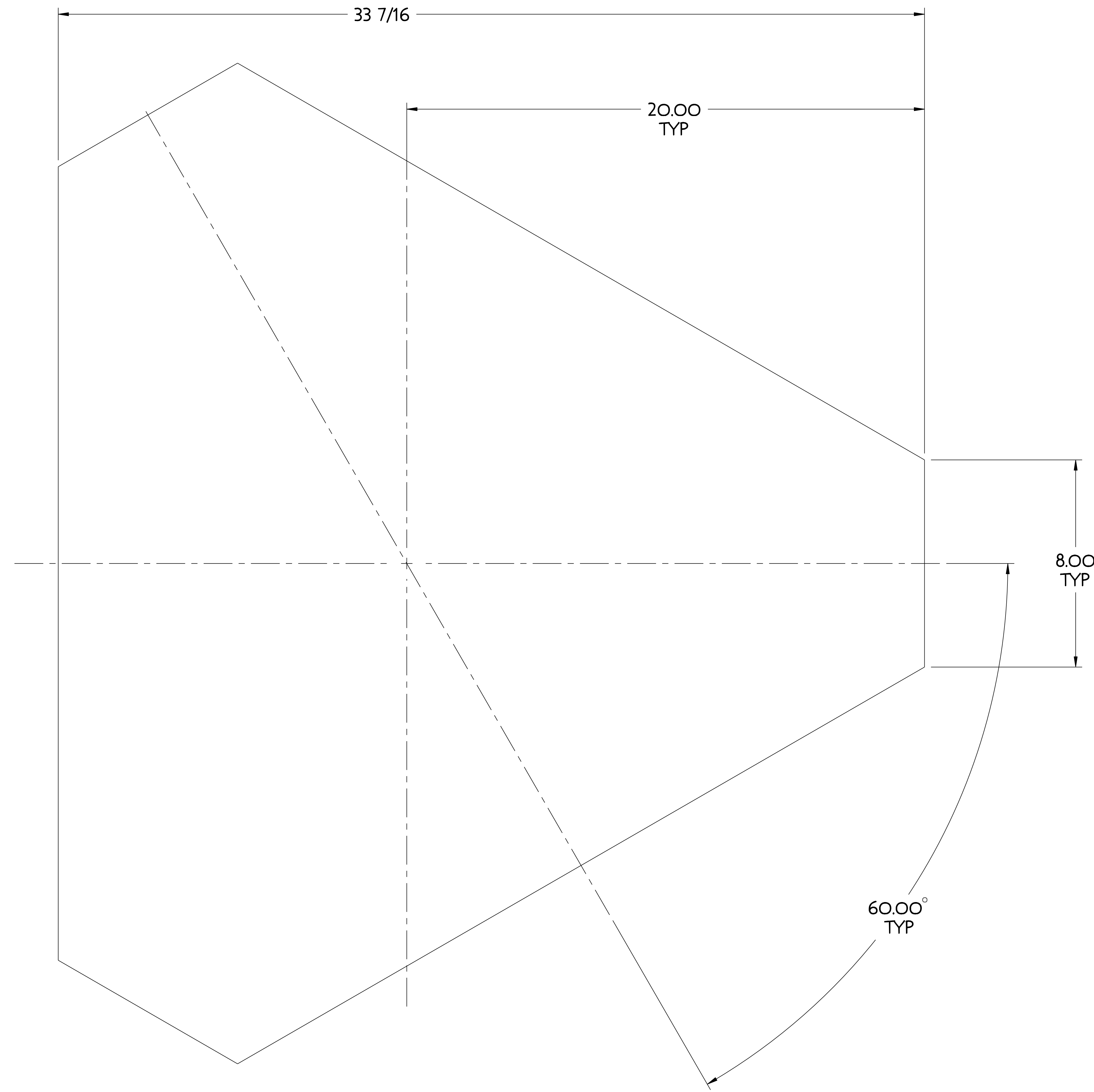
RELEASE LEVEL: WIP  
DWG VERSION NO: 4

WEIGHT  
760.8 lbs

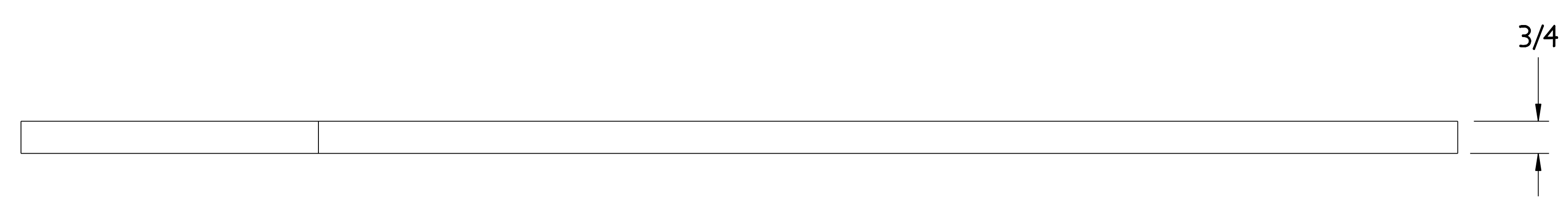
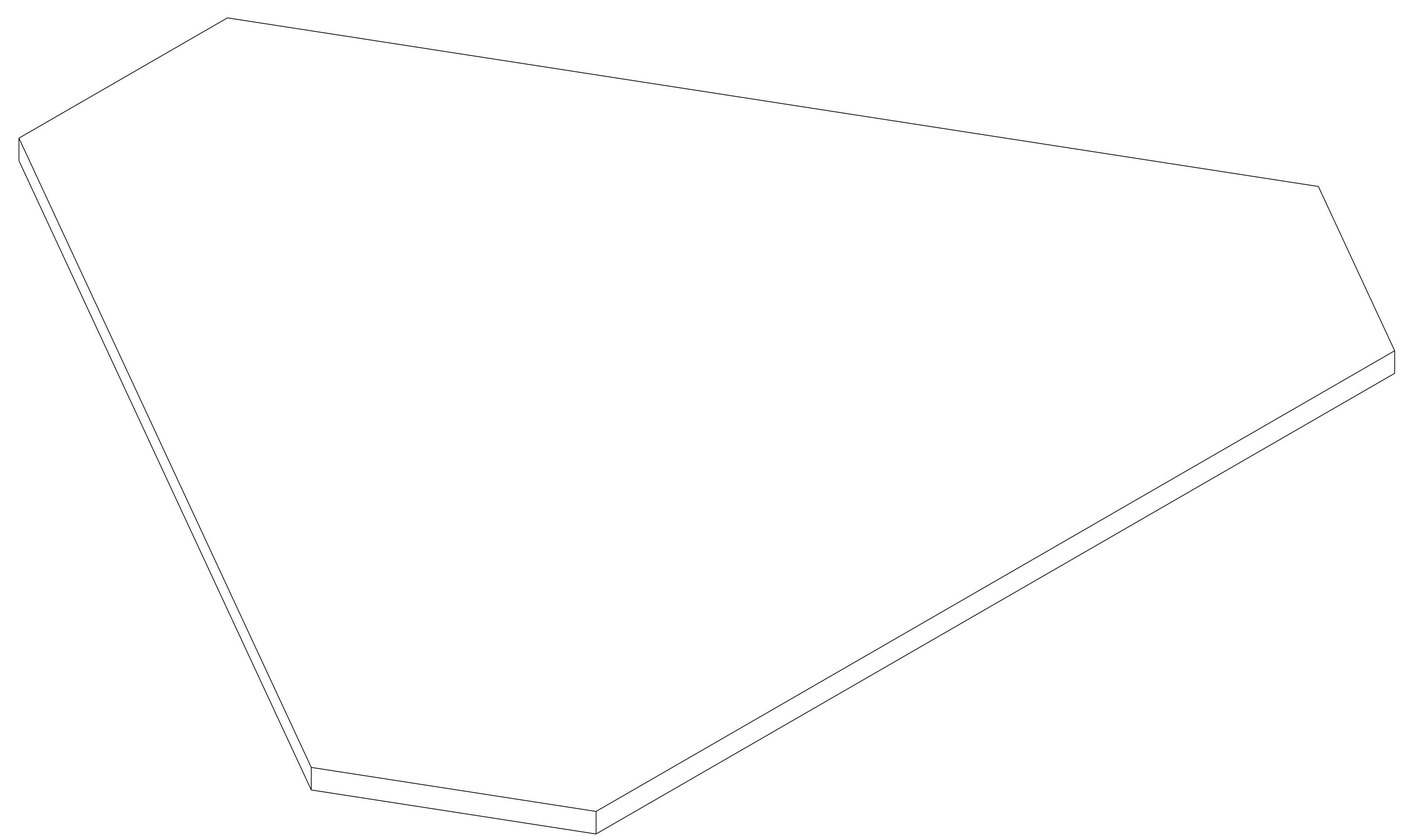
MODEL NAME  
SE172-203

WELDING ENGINEER

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



1. DRAWINGS PREPARED IN ACCORDANCE WITH ASME Y14.100-2000
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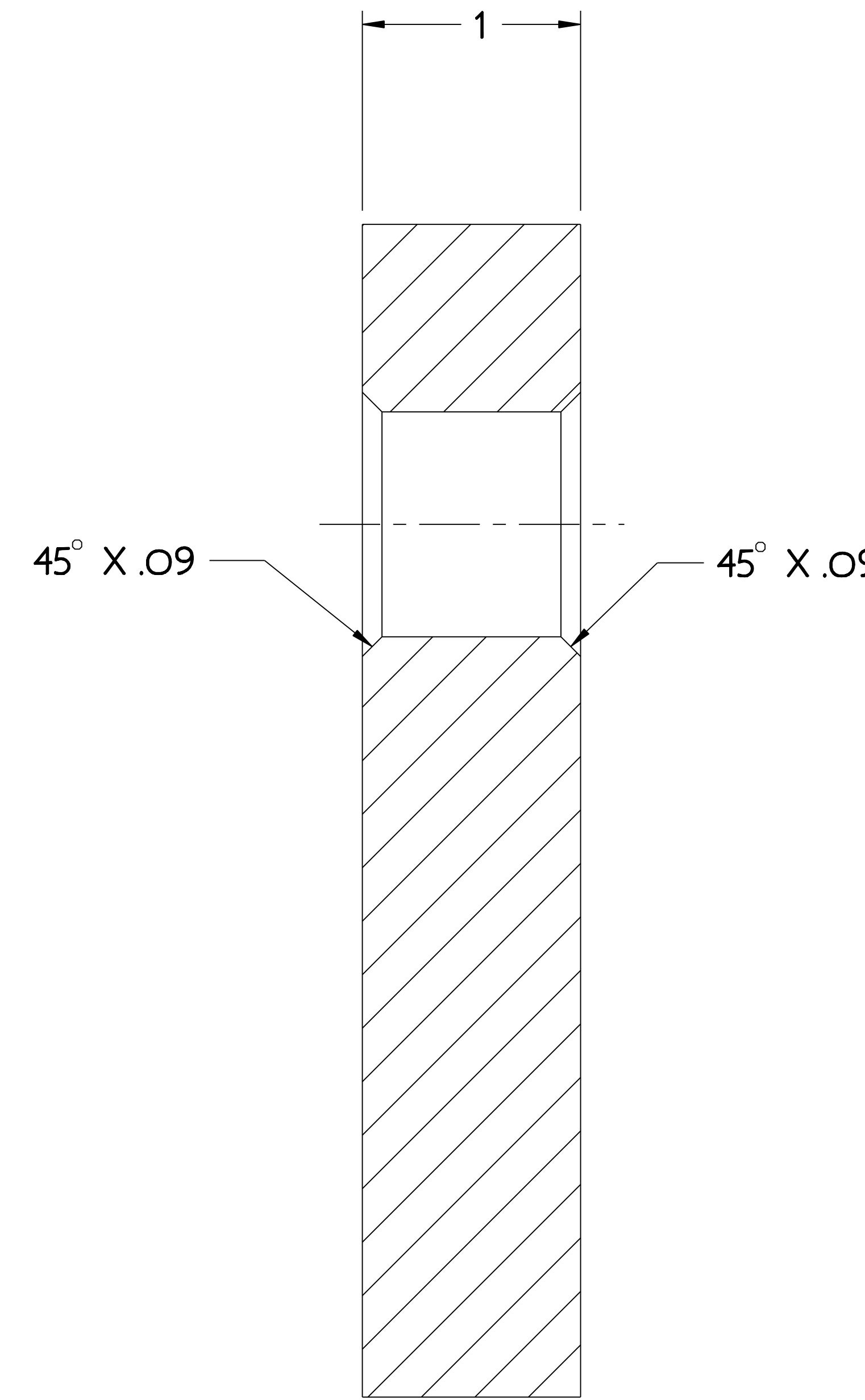
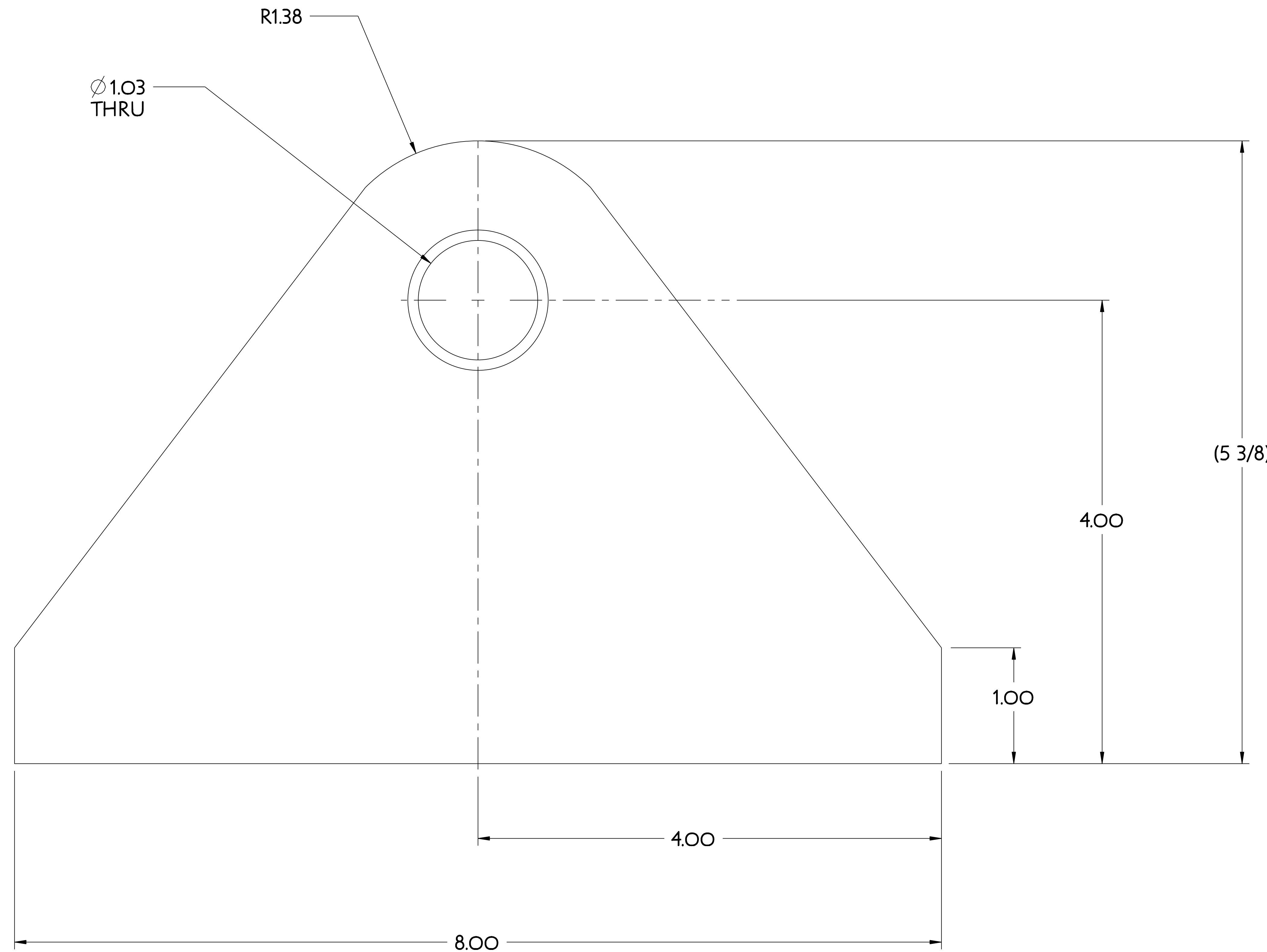
RELEASE LEVEL: WIP  
 DWG VERSION NO: 1

WEIGHT	186.8 lbs
MODEL NAME	SE172-252-1
WELDING ENGINEER	

1	SE172-203-1	CENTER SOLENOID SUPPORT BASE PLATE	304 STN STL	
PART NO.	DRAWING/MODEL NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY REOD
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	STELLARATOR CORE BASE SUPPORT STRUCTURE CENTER SOLENOID SUPPORT BASE PLATE		
DO NOT VERIFY INFORMATION BY SCALING DRAWING	BREAK SHARP EDGES .005/.020	TOLERANCES NON-CUMULATIVE	DSN: T. CRUICKSHANK	DRAWING NO:
NEXT ASSEMBLY	DECIMAL-INCH FRACTIONS	CHK:	SE172-203	
	.X +/- .100 0°-120° +/- .100	ENGR: F. DAHLGREN		
	.XX +/- .030 12°-120° +/- .100	SUPV:		
	.XXX +/- .005 72°-120° +/- .100			
	ANGULAR +/- .0°-15° OVER 120° +/- .100			
			SHEET 2 OF 3	REV D, 14

NCSX-SE172-203

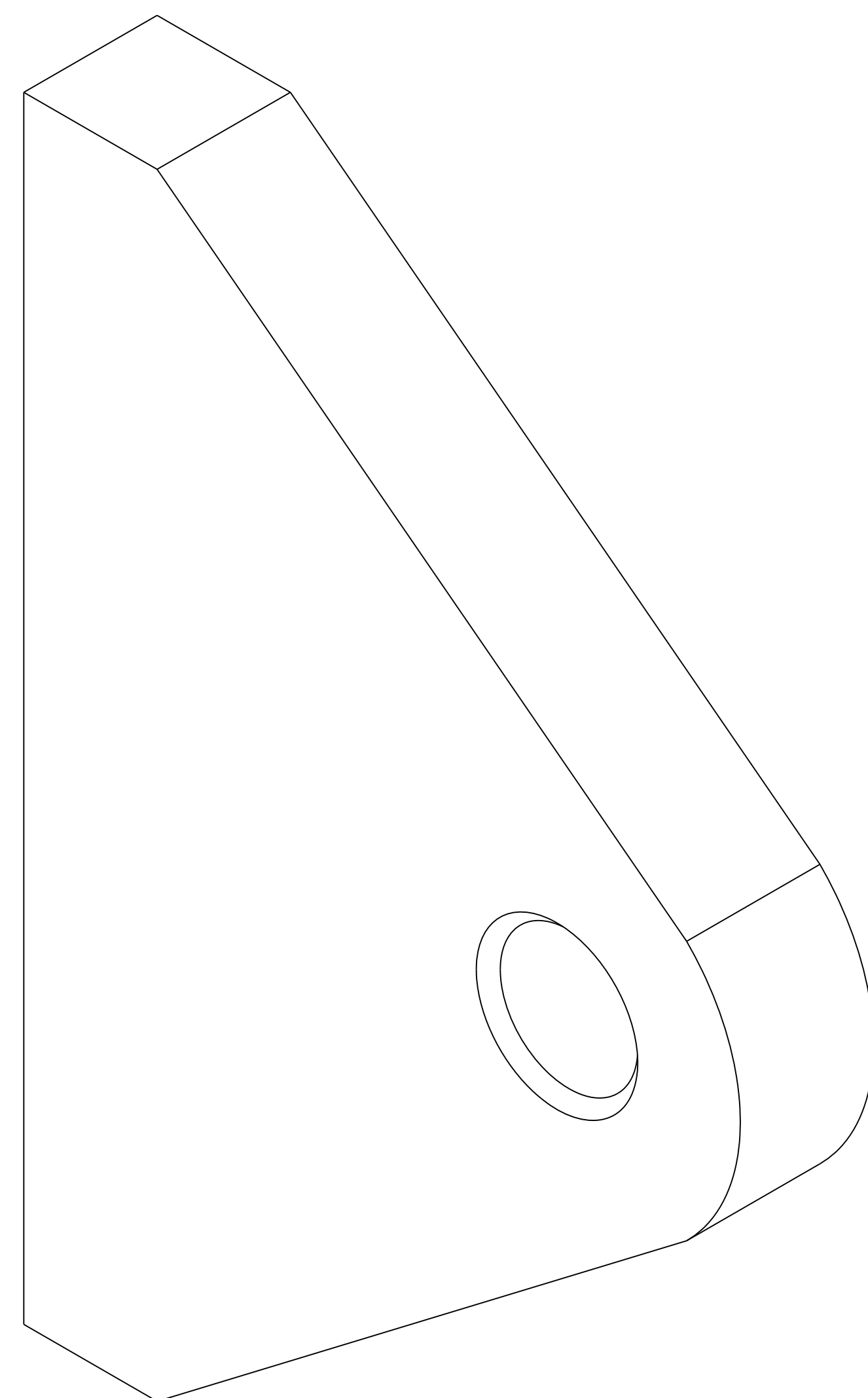
NO.	REVISION	BY	CH	SUP	APPROVED	DATE



SECTION A-A

1. DRAWINGS PREPARED IN ACCORDANCE WITH ASME Y14.100-2000
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**18 REQUIRED**



2	SE172-203-2	BASE SUPPORT STRUCTURE BRACKET	304 STN STL	
PART NO.	DRAWING/MODEL NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY REOD
PARTS LIST				
COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED P r o E		CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY	
DO NOT VERIFY INFORMATION BY SCALING DRAWING		DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	NATIONAL COMPACT STELLARATOR EXPERIMENT STELLARATOR CORE BASE SUPPORT STRUCTURE BASE SUPPORT STRUCTURE BRACKET	
NEXT ASSEMBLY		TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX +/- .030 .XXX +/- .005 ANGULAR +/- .05°	DSN: T. CRUICKSHANK ENGR: F. DAHLGREN SUPV:	DRAWING NO: <b>SE172-203</b>
RELEASE LEVEL: WIP DWG VERSION NO: 4		WELDING ENGINEER		SHEET 3 OF 3 REV D, 14

NCSX-SE172-203