

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.

SEE SHEET 2 FOR ANCHOR HOLE DETAILS

**3 ASSEMBLIES REQUIRED**

PART NO.	DRAWING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY	RECD
5	SE172-252-3	BASE SUPPORT STRUCTURE BASE GUSSET	304 STN STL	8	
4	SE172-203-2	BASE SUPPORT STRUCTURE BRACKET	304 STN STL	2	
3	SE172-207-3	OUTER SUPPORT BASE MOUNTING PLATE	STN STL	6	
2	SE172-207-2	8W X 35 OUTER SUPPORT BASE CROSS BEAM	304 STN STL	1	
1	SE172-207-1	8W X 35 OUTER SUPPORT BASE ANGLED BEAM	304 STN STL	2	

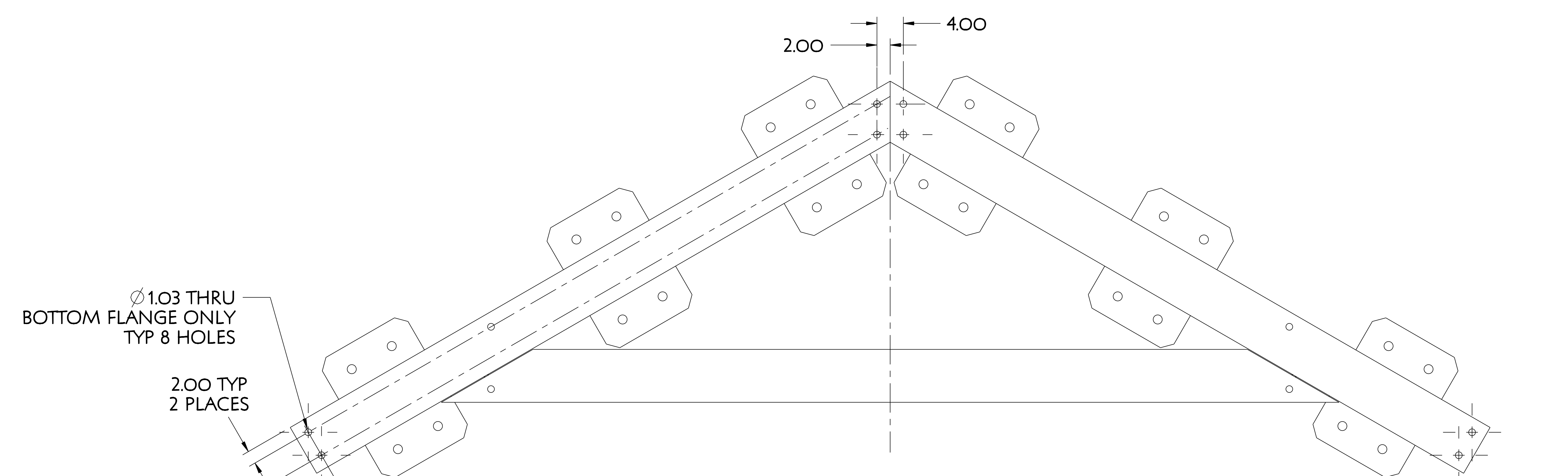
PARTS LIST					
COMPUTER GENERATED DRAWING	CENTRAL FILES:	PRINCETON PLASMA PHYSICS LABORATORY			
MANUAL CHANGES NOT PERMITTED	UNLESS OTHERWISE SPECIFIED	NATIONAL COMPACT STELLARATOR EXPERIMENT			
Pro E	DIMENSIONS ARE IN INCHES	STELLARATOR CORE			
DO NOT VERIFY INFORMATION BY SCALING DRAWING	BREAK SHARP EDGES .005/.020	BASE SUPPORT STRUCTURE			
	TOLERANCES NON-CUMULATIVE	DSN: T. CRUICKSHANK	DRAWING NO:		
	DECIMAL-INCH FRACTIONS	CHK: ENGR. F. DAHLGREN	SE172-207		
	XX +/- .030 12"-12" +/- .125	SUPV:	SHEET 1 OF 5		
	XXX +/- .005 12"-120" +/- .125		REV 0		
	ANGULAR +/- .05 OVER 120" +/- .125				

RELEASE LEVEL: WIP  
DWG VERSION NO: 5

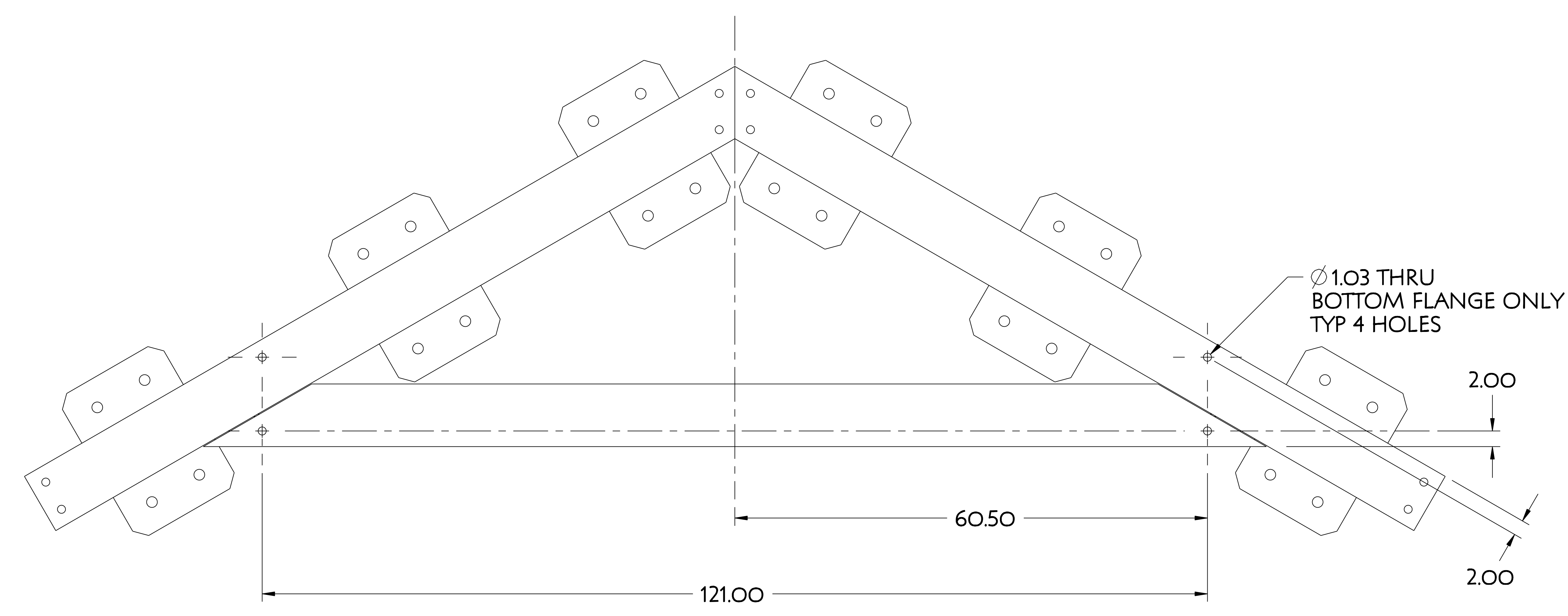
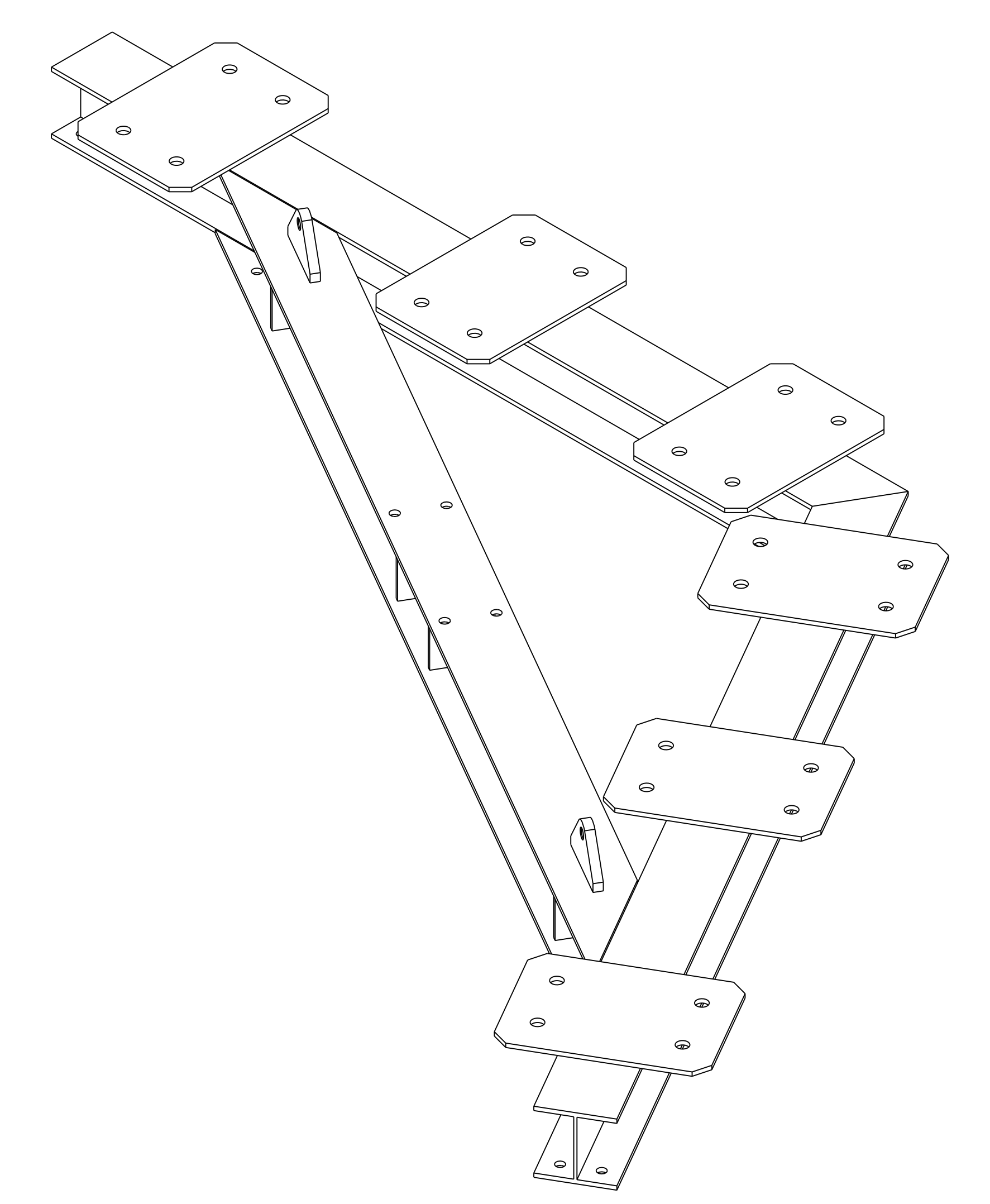
WEIGHT  
1964.7 lbs  
MODEL NAME  
SE172-207  
WELDING ENGINEER

NCSX-SE172-207

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



**8 HOLES CALLED OUT IN THIS VIEW  
TO BE DRILLED IN TWO ASSEMBLIES ONLY  
AFTER WELDING**



**4 HOLES CALLED OUT IN THIS VIEW  
TO BE DRILLED IN ONE ASSEMBLY ONLY  
AFTER WELDING**

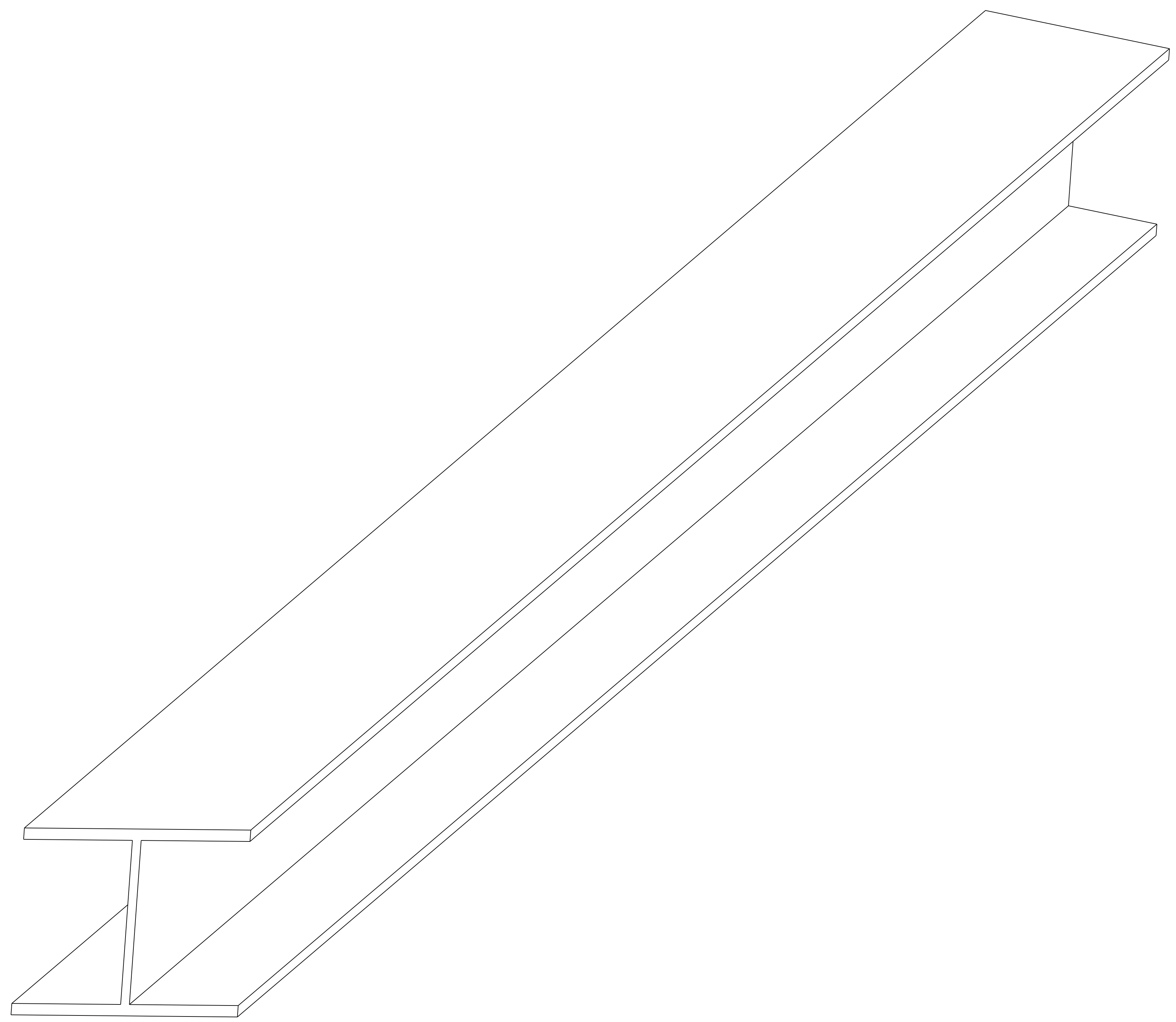
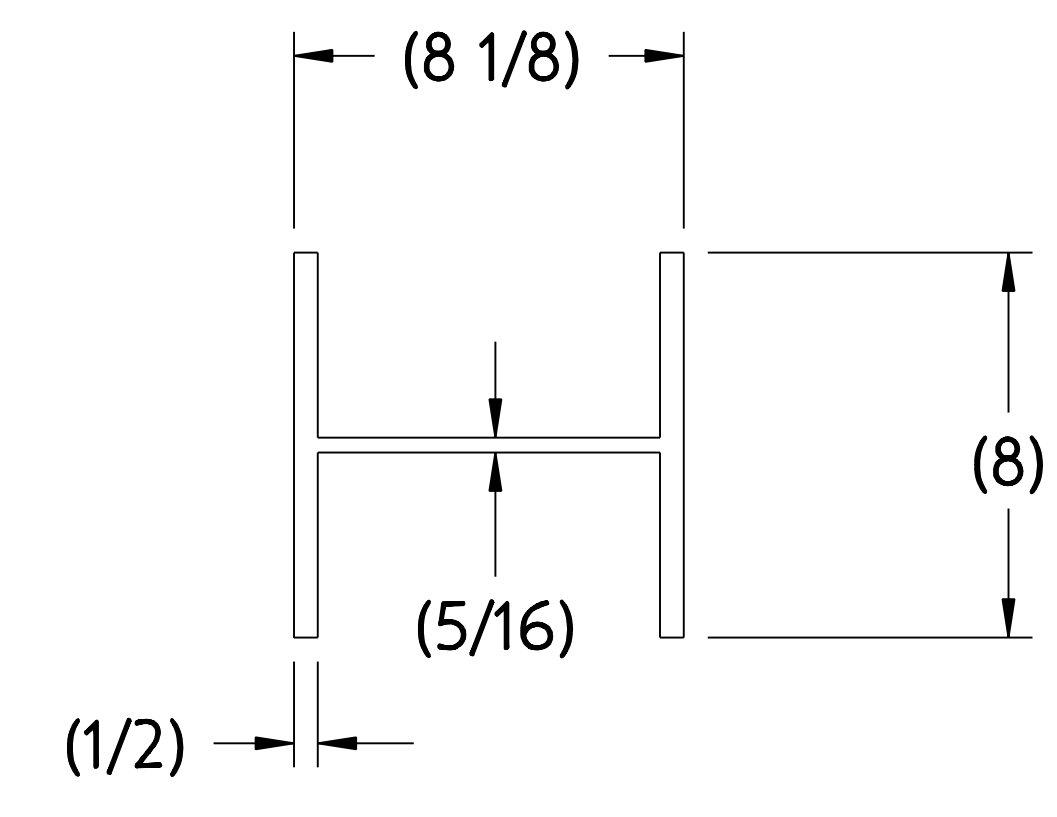
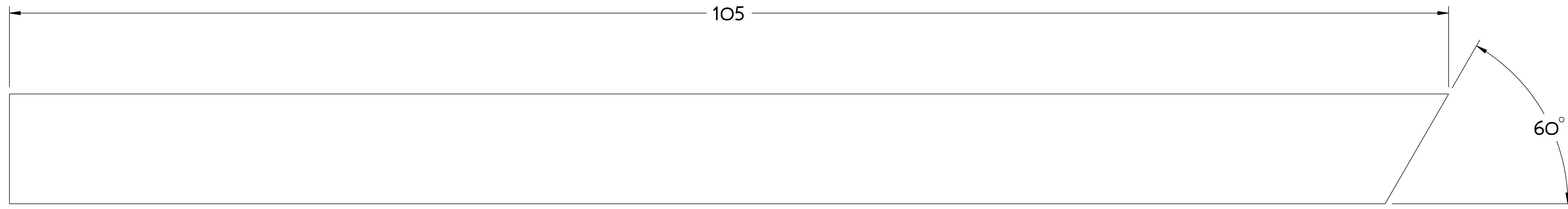
PART NO.	DRAWING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY	RECD
PARTS LIST					
COMPUTER GENERATED DRAWING DRAWING CHANGES NOT PERMITTED Pro E	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY <b>NATIONAL COMPACT STELLARATOR EXPERIMENT</b>			
DO NOT VERIFY INFORMATION BY SCALING DRAWING	DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	STELLARATOR CORE BASE SUPPORT STRUCTURE OUTER SUPPORT BASE ANCHOR HOLES			
	TOLERANCES NON-CUMULATIVE	DSN: T. CRUICKSHANK	DRAWING NO:		
NEXT ASSEMBLY	DECIMAL-INCH FRACTIONS .XX ±.030 .XXX ±.005 ANGULAR ±.0°-15'	CHK: ENGR: F. DAHLGREN SUPV:	SEI172-207		
			SHEET 2 OF 5	REV D, 2	

RELEASE LEVEL: WIP  
DWG VERSION NO: 4

WEIGHT  
152.3 lbs  
MODEL NAME  
SEI172-207-3  
WELDING  
ENGINEER

NCSX-SEI172-207

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**2 REQUIRED**

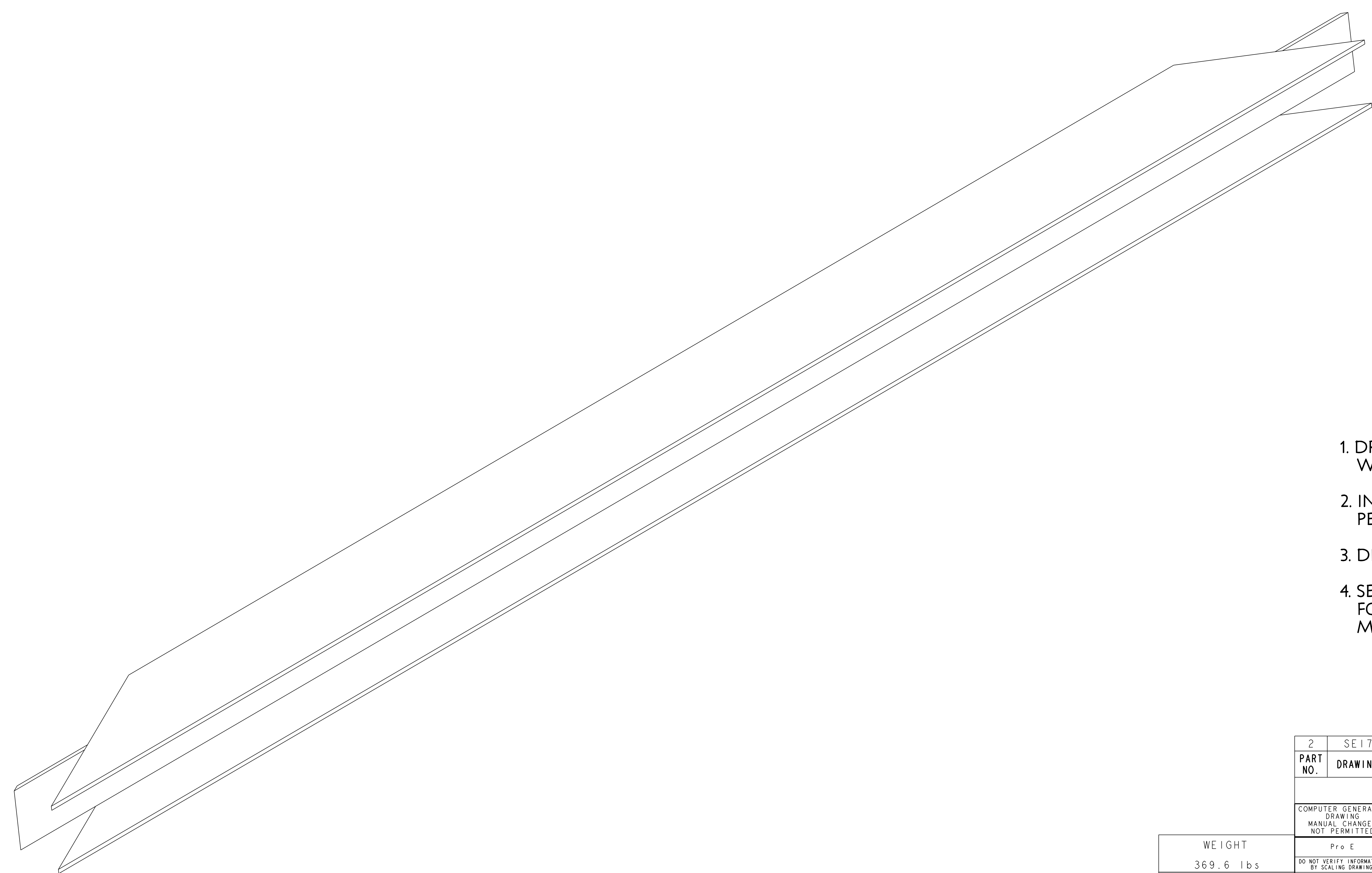
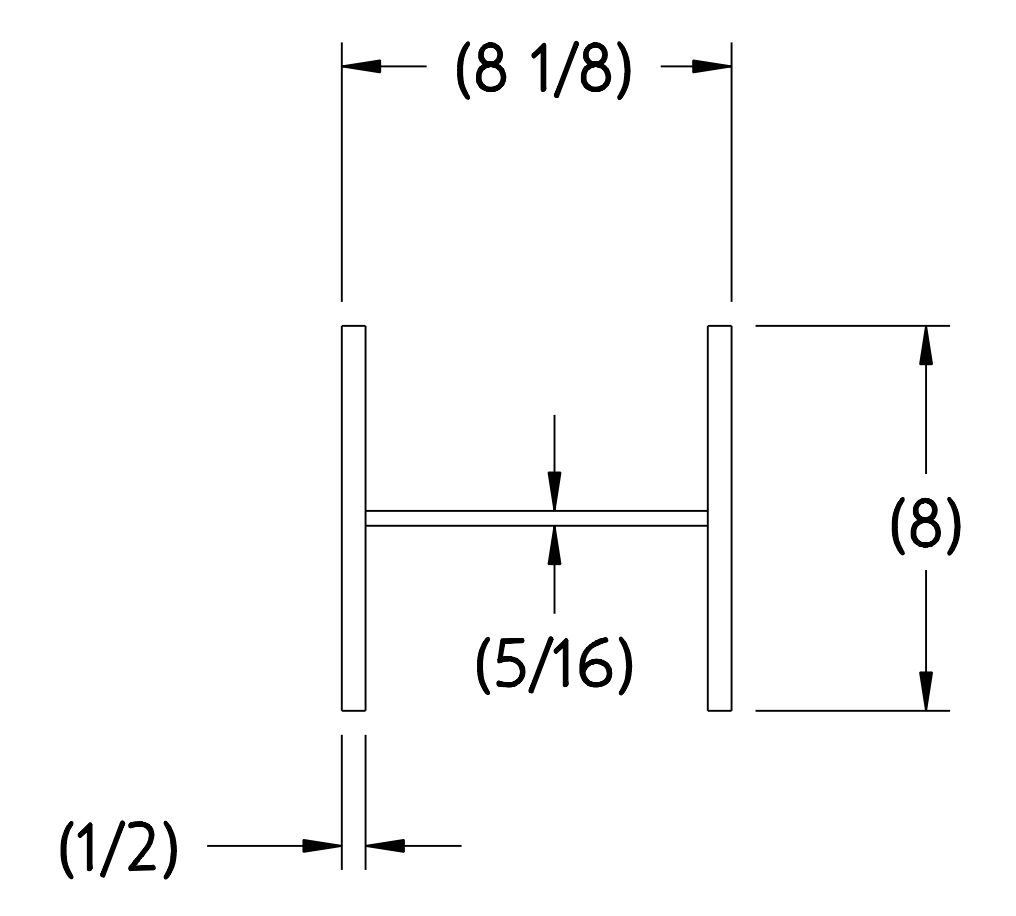
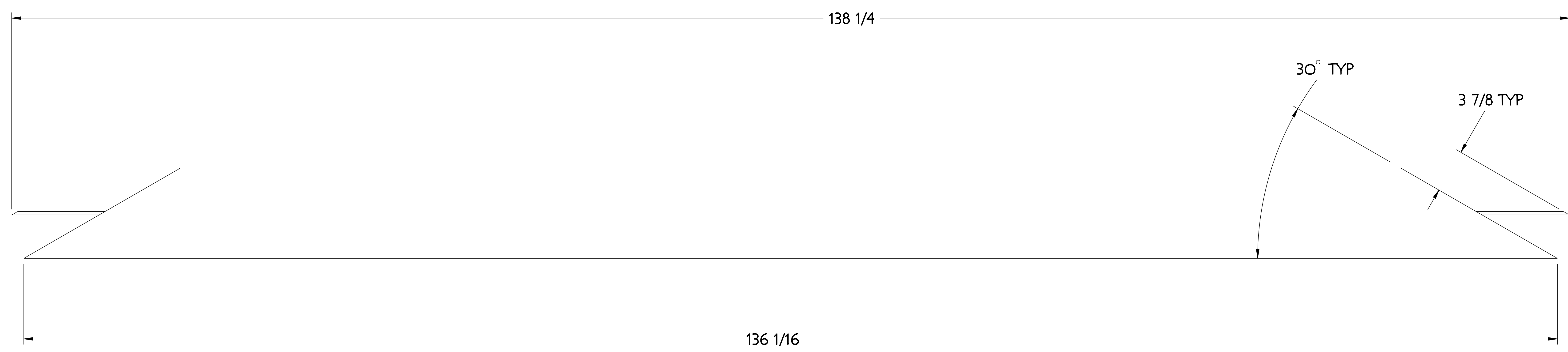
RELEASE LEVEL: WIP  
 DWG VERSION NO: 3

WEIGHT	302.3 lbs
MODEL NAME	SEI72-207-1
WELDING ENGINEER	

PART NO.	SEI72-207-1	8W X 35 OUTER SUPPORT BASE ANGLED BEAM	304 STN STL	QTY REOD
PARTS LIST				
COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E DO NOT VERIFY INFORMATION BY SCALING DRAWING				
CENTRAL FILES:		PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY		
UNLESS OTHERWISE SPECIFIED		NATIONAL COMPACT STELLARATOR EXPERIMENT		
DIMENSIONS ARE IN INCHES MACHINE SURFACES		STELLARATOR CORE BASE SUPPORT STRUCTURE 8W X 35 OUTER SUPPORT BASE ANGLED BEAM		
BREAK SHARP EDGES .005/.020		DSN: T. CRUICKSHANK		
TOLERANCES NON-CUMULATIVE		DRAWING NO:		
NEXT ASSEMBLY		SEI72-207		
DECIMAL-INCH FRACTIONS		CHK: ENGR: F. DAHLGREN		
.XX +/- .030 0°-12° +/- .124		SUPV:		
.XXX +/- .005 12°-120° +/- .124		SHEET 3 OF 5		
ANGULAR +/- .0°-15° OVER 120° +/- .124		REV B, 2		

NCSX-SEI72-207

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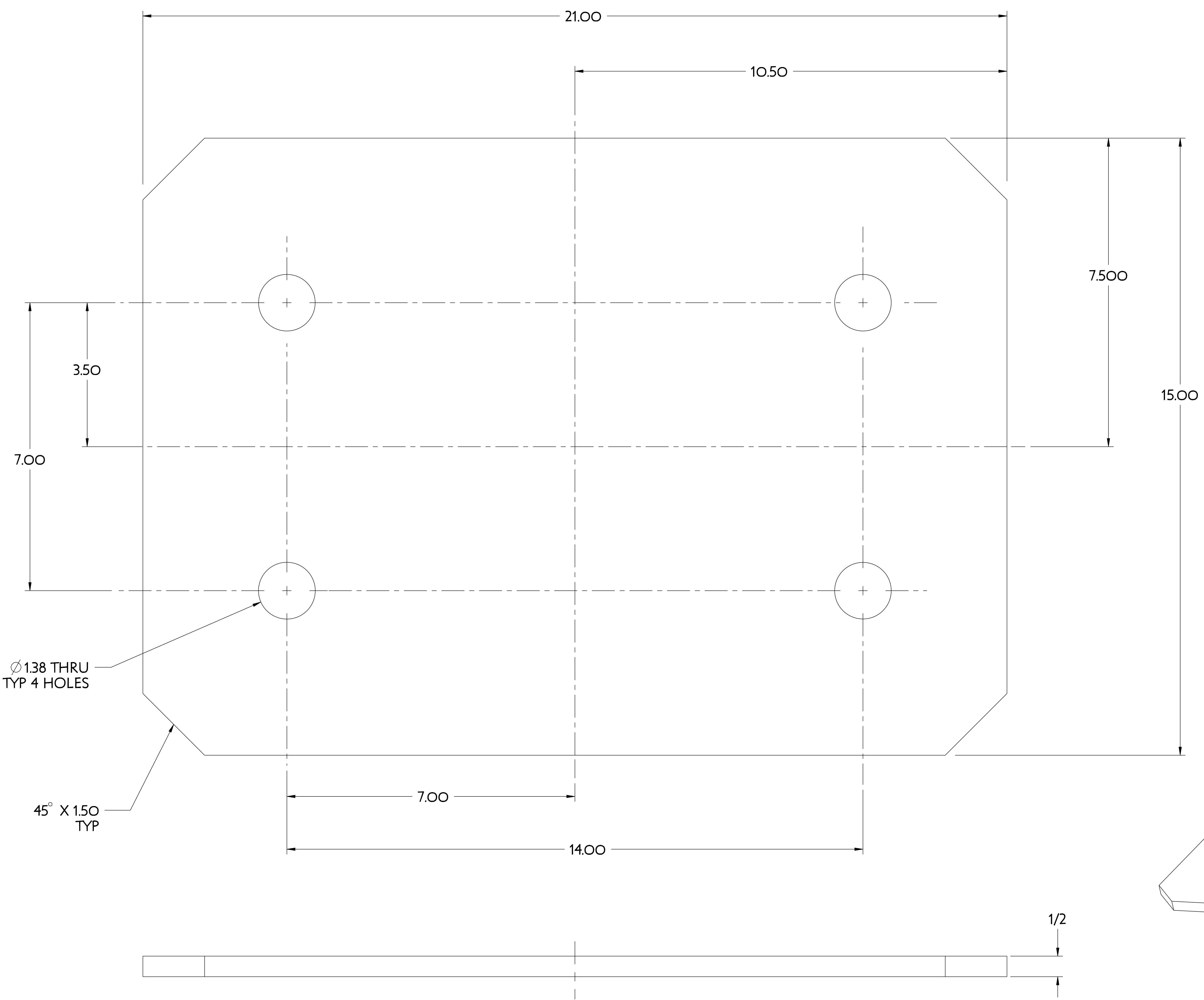
RELEASE LEVEL: WIP  
 DWG VERSION NO: 3

WEIGHT	369.6 lbs
MODEL NAME	SEI72-207-1
WELDING ENGINEER	

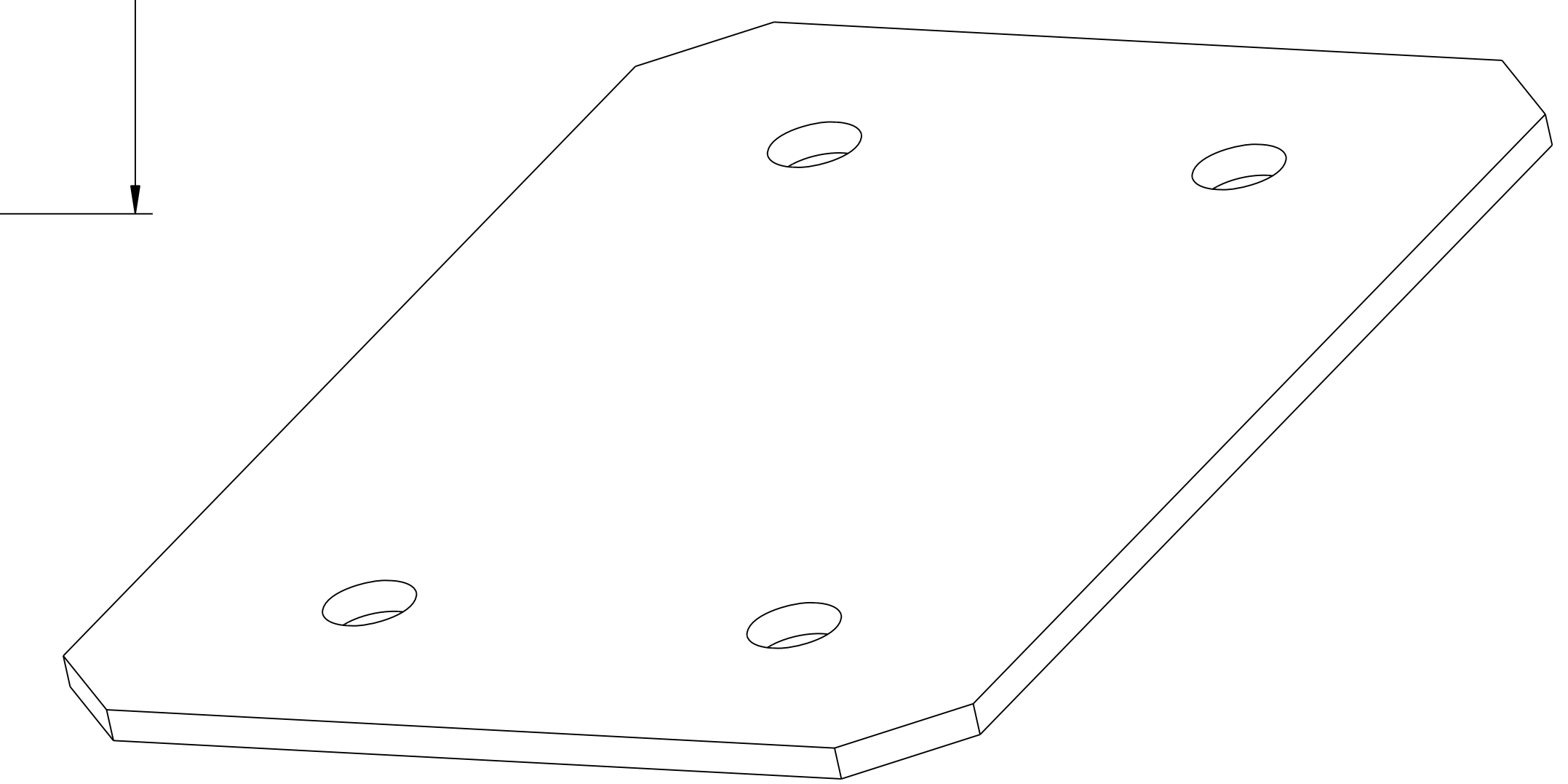
2	SEI72-207-2	8W X 35 OUTER SUPPORT BASE CROSS BEAM	304 STN STL	
PART NO.	DRAWING/MODEL NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY REOD
PARTS LIST				
COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY NATIONAL COMPACT STELLARATOR EXPERIMENT		
Pro E	DIMENSIONS ARE IN INCHES MACHINE SURFACES	STELLARATOR BASE BASE SUPPORT STRUCTURE 8W X 35 OUTER SUPPORT BASE CROSS BEAM		
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:	ENGR: F. DAHLGREN	SEI72-207
	.XX +/- .000 0°-120° +/- .010			
	.XXX +/- .005 120°-120° +/- .010			
	ANGULAR +/- .0°-15° OVER 120° +/- .010	SUPV:		SHEET 4 OF 5 REV B. 2

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**18 REQUIRED**

RELEASE LEVEL: WIP  
DWG VERSION NO: 4

WEIGHT  
152.3 lbs  
MODEL NAME  
SEI72-207-1  
WELDING ENGINEER

3	SEI72-207-3	OUTER SUPPORT BASE MOUNTING PLATE	STN STL	
PART NO.	DRAWING/MODEL NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY RECD
PARTS LIST				
COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro 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 OUTER SUPPORT BASE MOUNTING PLATE	
NEXT ASSEMBLY		TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX +/- .030 .XXX +/- .005 ANGULAR +/- .05	DSN: T. CRUICKSHANK CHK: ENGR: F. DAHLGREN SUPV:	DRAWING NO: <b>SEI72-207</b> SHEET 5 OF 5 REV B, 24

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