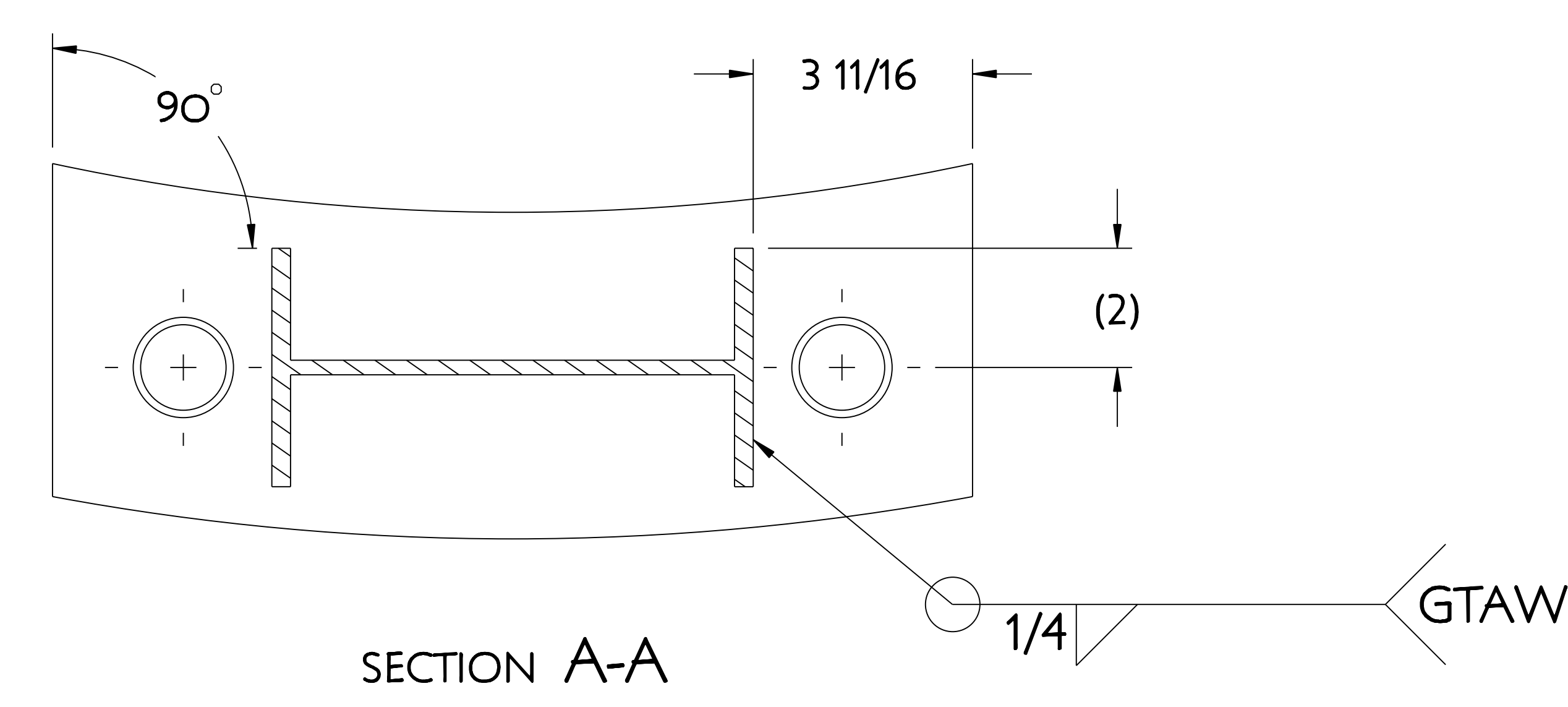


NO.	REVISION	BY	CH	SUP	APPROVED	DATE



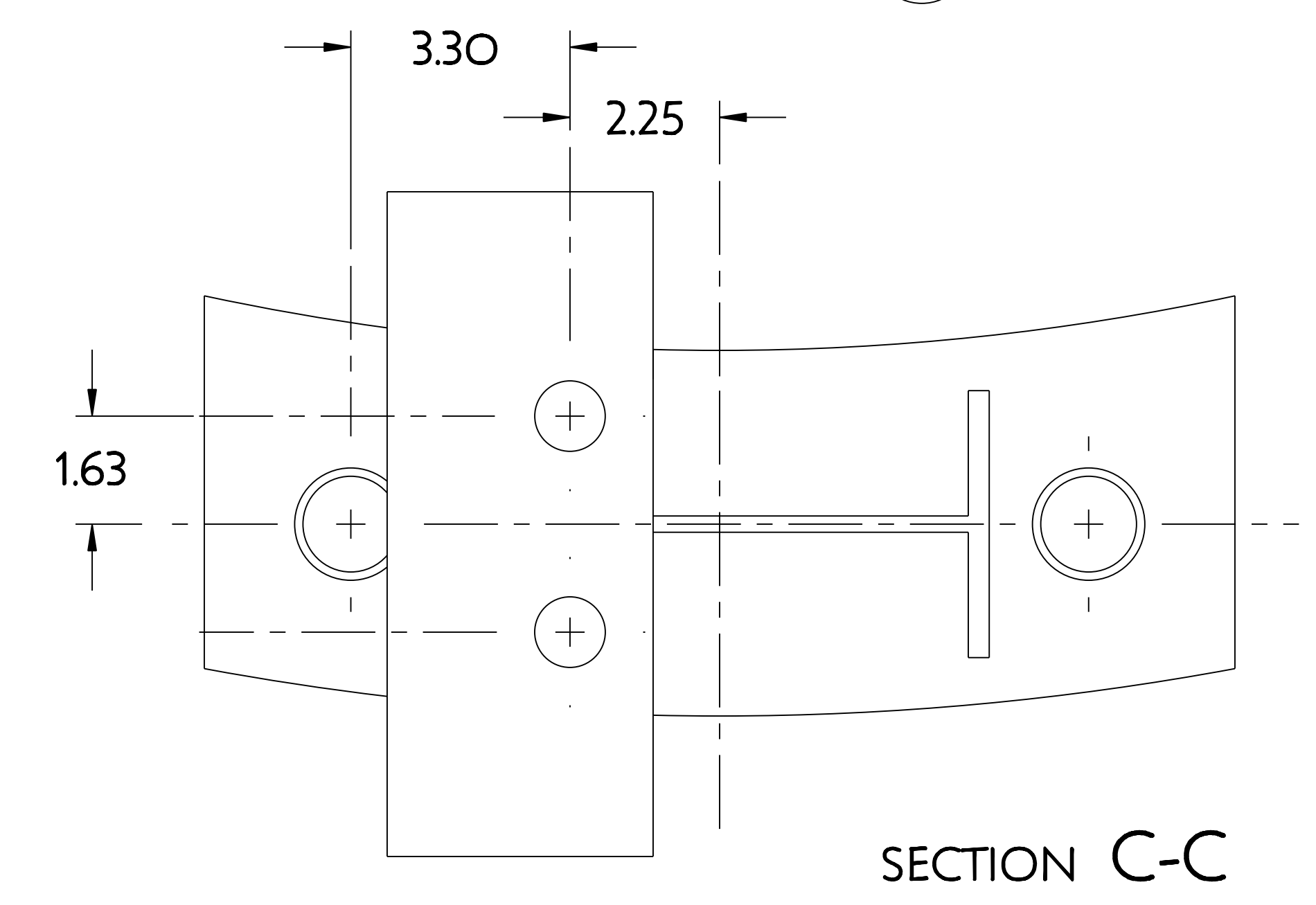
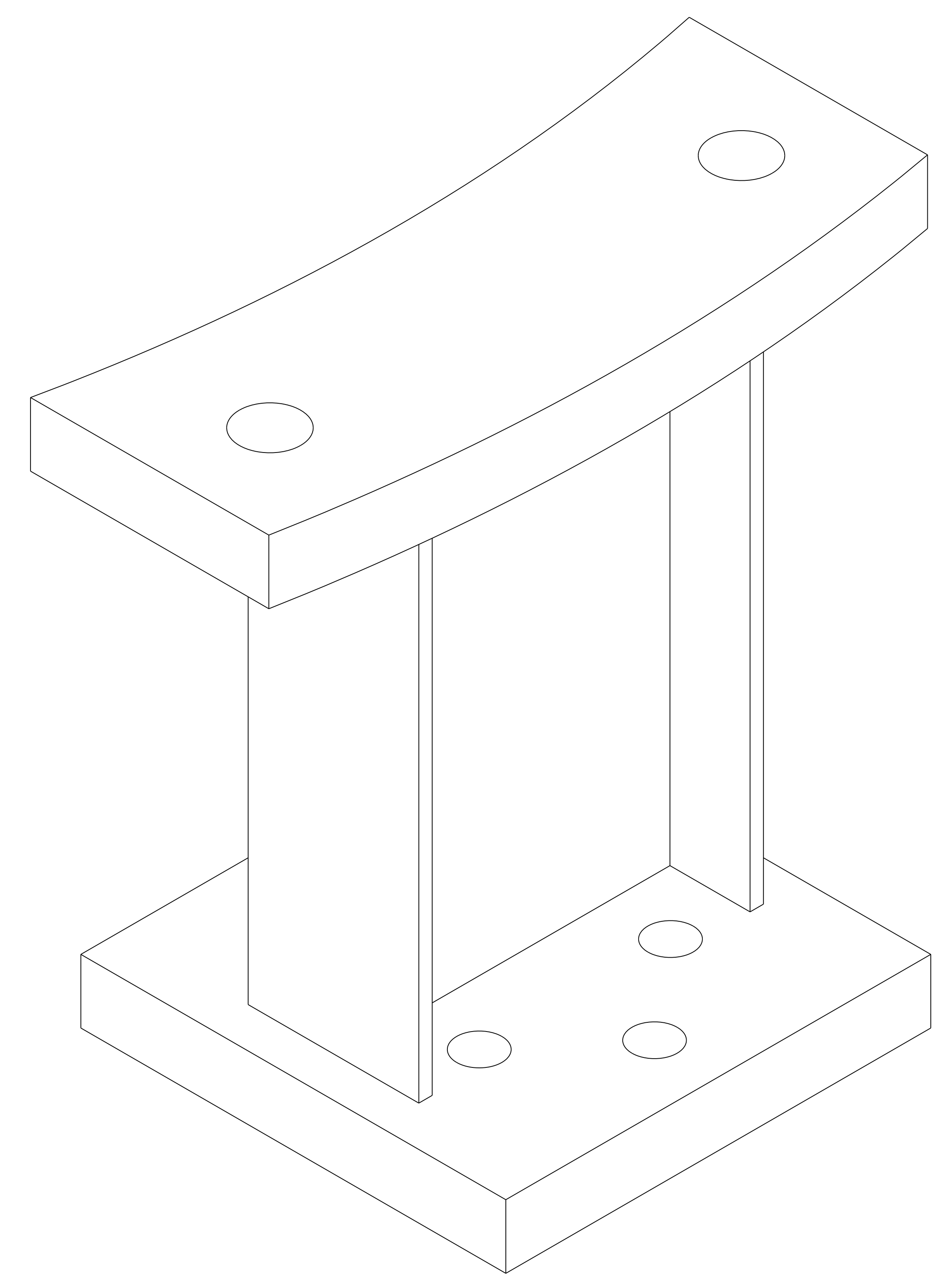
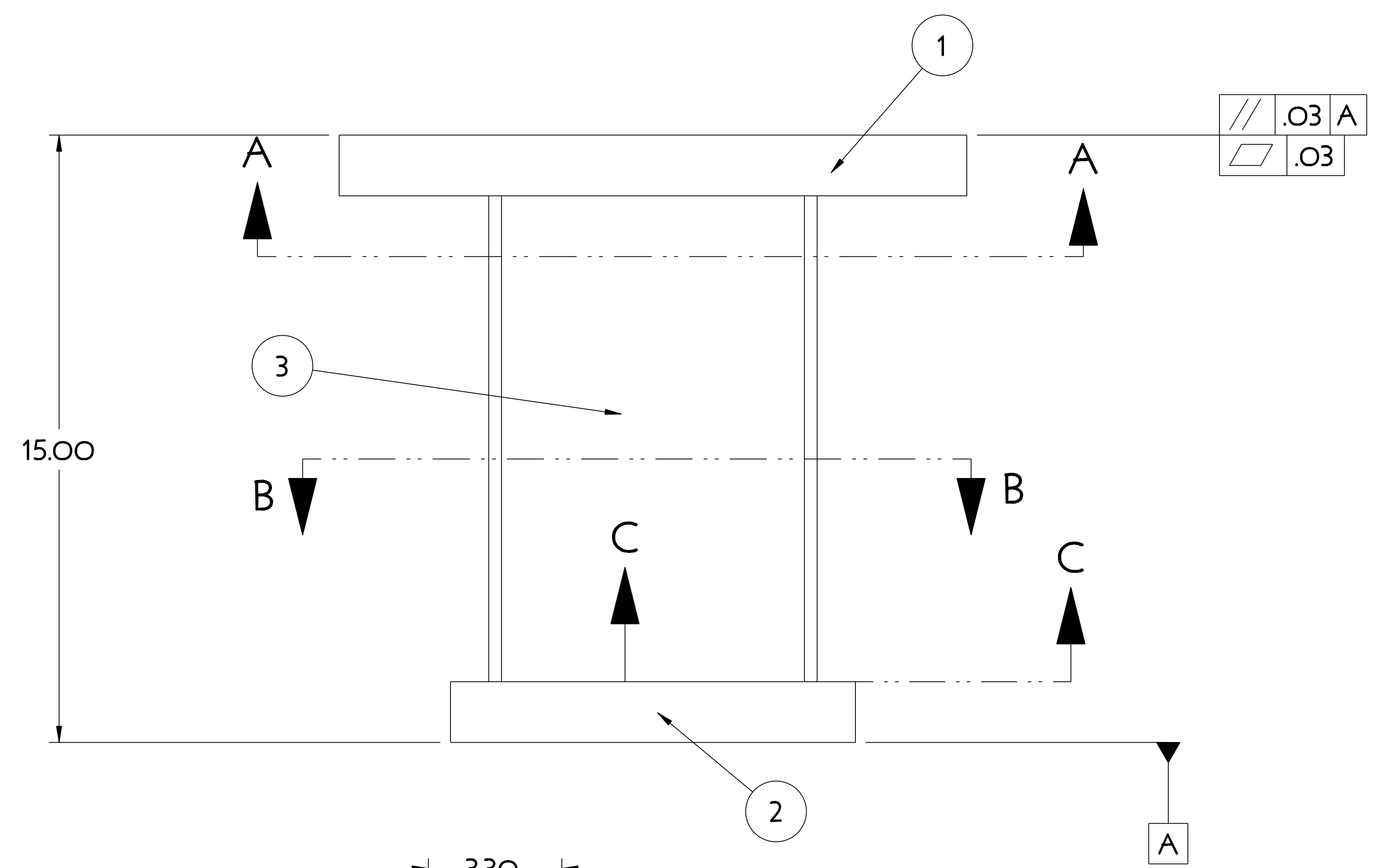
WELDING SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF AWS D1.6 (STRUCTURAL WELDING OF AUSTENITIC STAINLESS STEEL) AND PPPL PROCEDURE NO. ENG-037. VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH THE ACCEPTANCE CRITERIA OF AWS D1.6.

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.



3 ASSEMBLIES REQUIRED

3	SE172-243-3	PERIOD SUPPORT PEDESTAL BEAM	304 STN STL	1
2	SE172-243-2	PERIOD SUPPORT PEDESTAL BOTTOM PLATE	304 STN STL	1
1	SE172-243-1	PERIOD SUPPORT PEDESTAL TOP MOUNTING PLATE	304 STN STL	1
PART NO.	DRAWING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY REOD

PARTS LIST

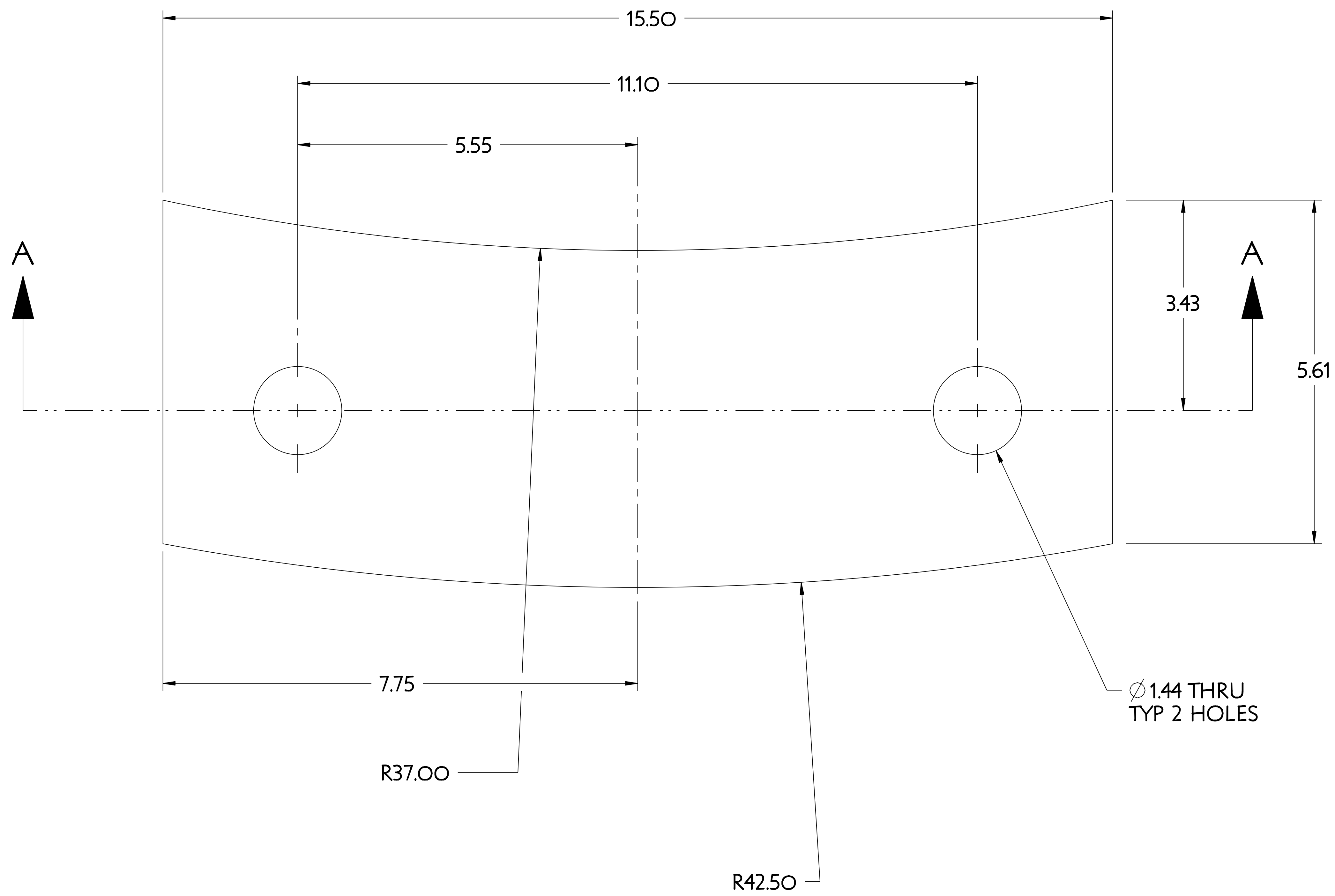
COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY NATIONAL COMPACT STELLARATOR EXPERIMENT	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	STELLARATOR CORE BASE SUPPORT STRUCTURE OUTER SUPPORT COLUMN C-C JOINT PEDESTAL WELDMENT	
NEXT ASSEMBLY	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX ±.000 .XXX ±.005 ANGULAR ±.0°-15° OVER 120° ±.1°-1.2°	DSN: T. CRUICKSHANK CHK: ENGR: F. DAHLGREN SUPV:	DRAWING NO: SE172-243 SHEET 1 OF 4 REV 0

RELEASE LEVEL: WIP
DWG VERSION NO: 7

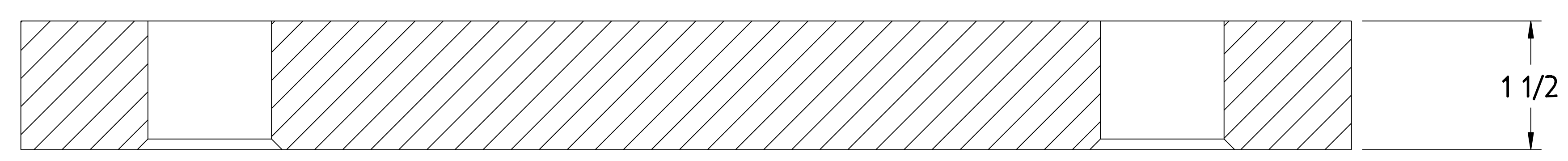
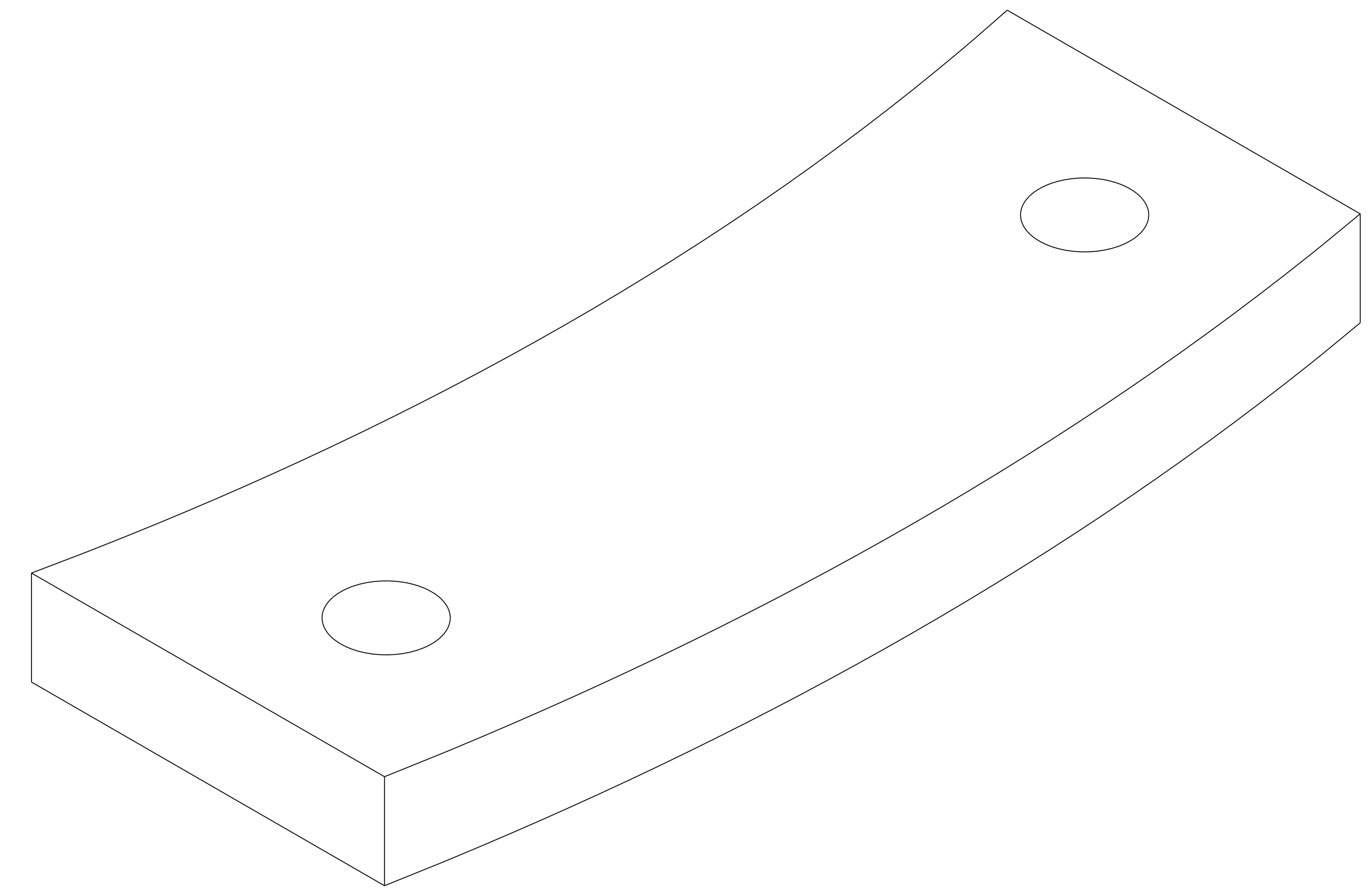
WEIGHT	129.4 lbs
MODEL NAME	SE172-243
WELDING ENGINEER	

NCSX-SE172-243

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



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.



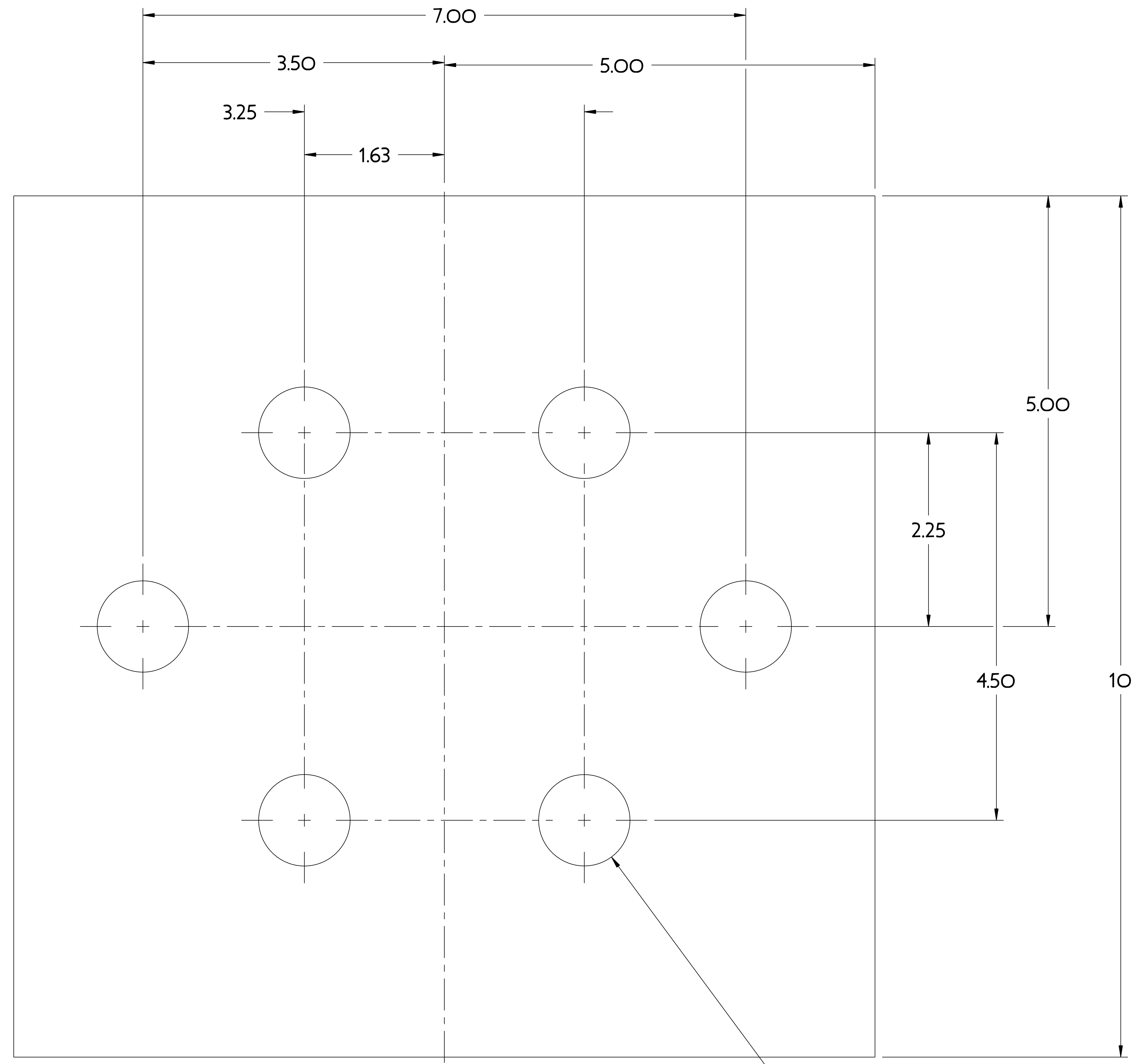
SECTION A-A

3 REQUIRED

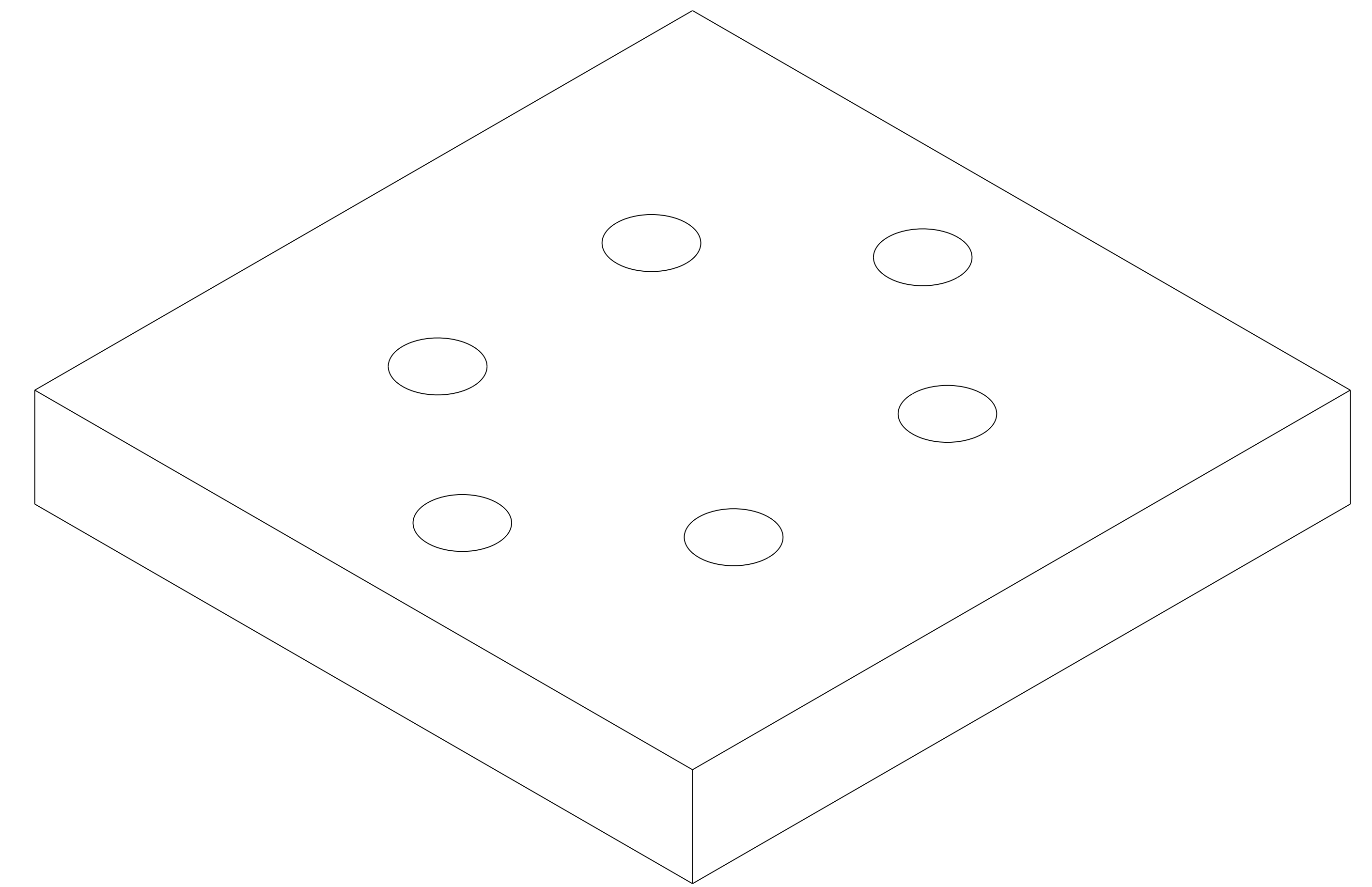
PART NO.	SEI72-243-1	PERIOD SUPPORT PEDESTAL TOP MOUNTING PLATE	304 STN STL	QTY RECD
PARTS LIST				
COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED		CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY NATIONAL COMPACT STELLARATOR EXPERIMENT	
DO NOT VERIFY INFORMATION BY SCALING DRAWING		DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	STELLARATOR CORE BASE SUPPORT STRUCTURE PERIOD SUPPORT PEDESTAL TOP MOUNTING PLATE	
WEIGHT 35.9 lbs		TOLERANCES NON-CUMULATIVE	DSN: T. CRUICKSHANK	DRAWING NO.
MODEL NAME SEI72-243-2		DECIMAL-INCH FRACTIONS	CHK: ENGR: F. DAHLGREN	SEI72-243
RELEASE LEVEL: WIP DWG VERSION NO: 2		WELDING ENGINEER	SUPV:	SHEET 2 OF 4 REV B.04

NCSX-SEI72-243

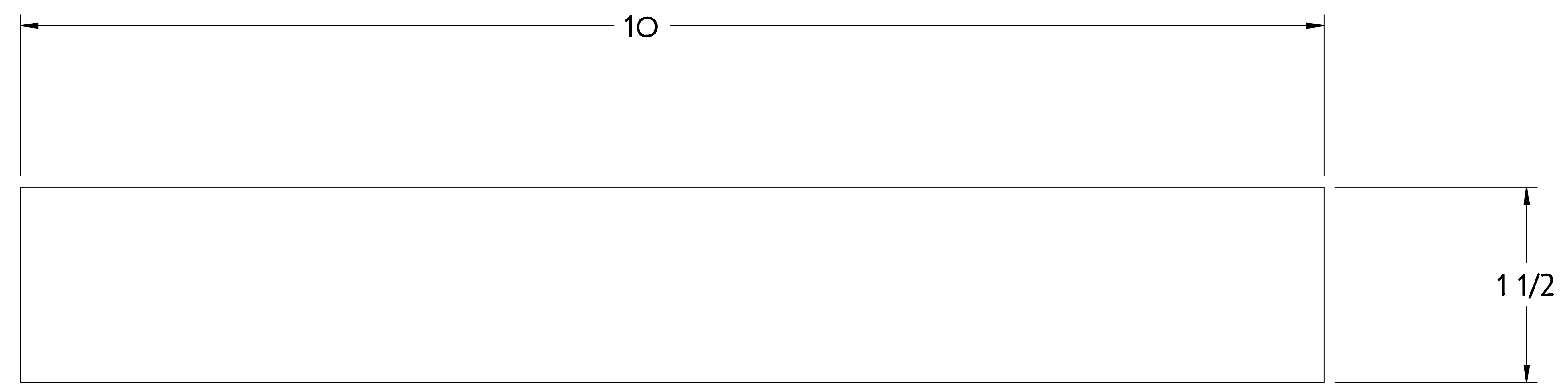
NO.	REVISION	BY	CH	SUP	APPROVED	DATE



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.



Ø1.06 THRU
TYP 6 HOLES



3 REQUIRED

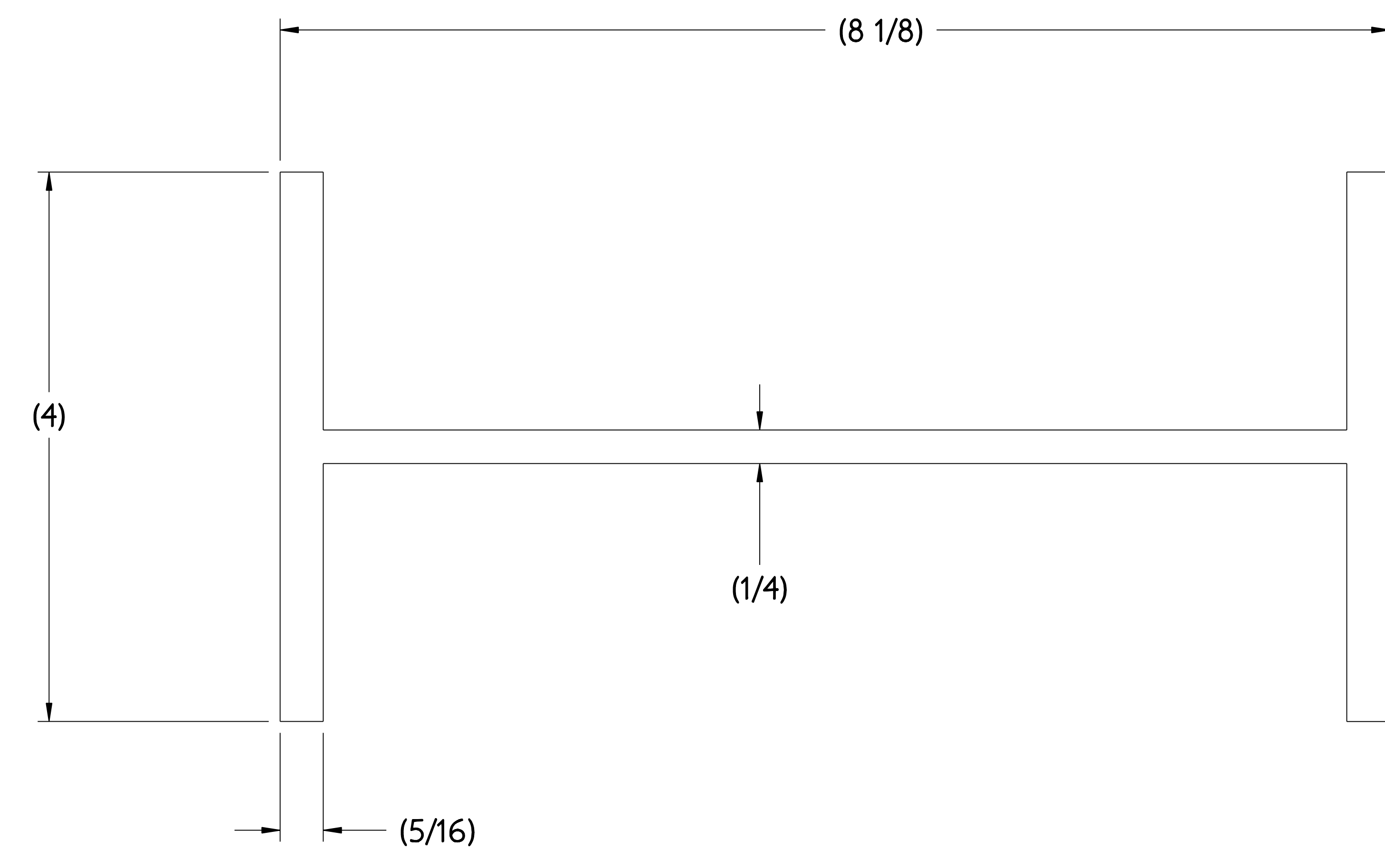
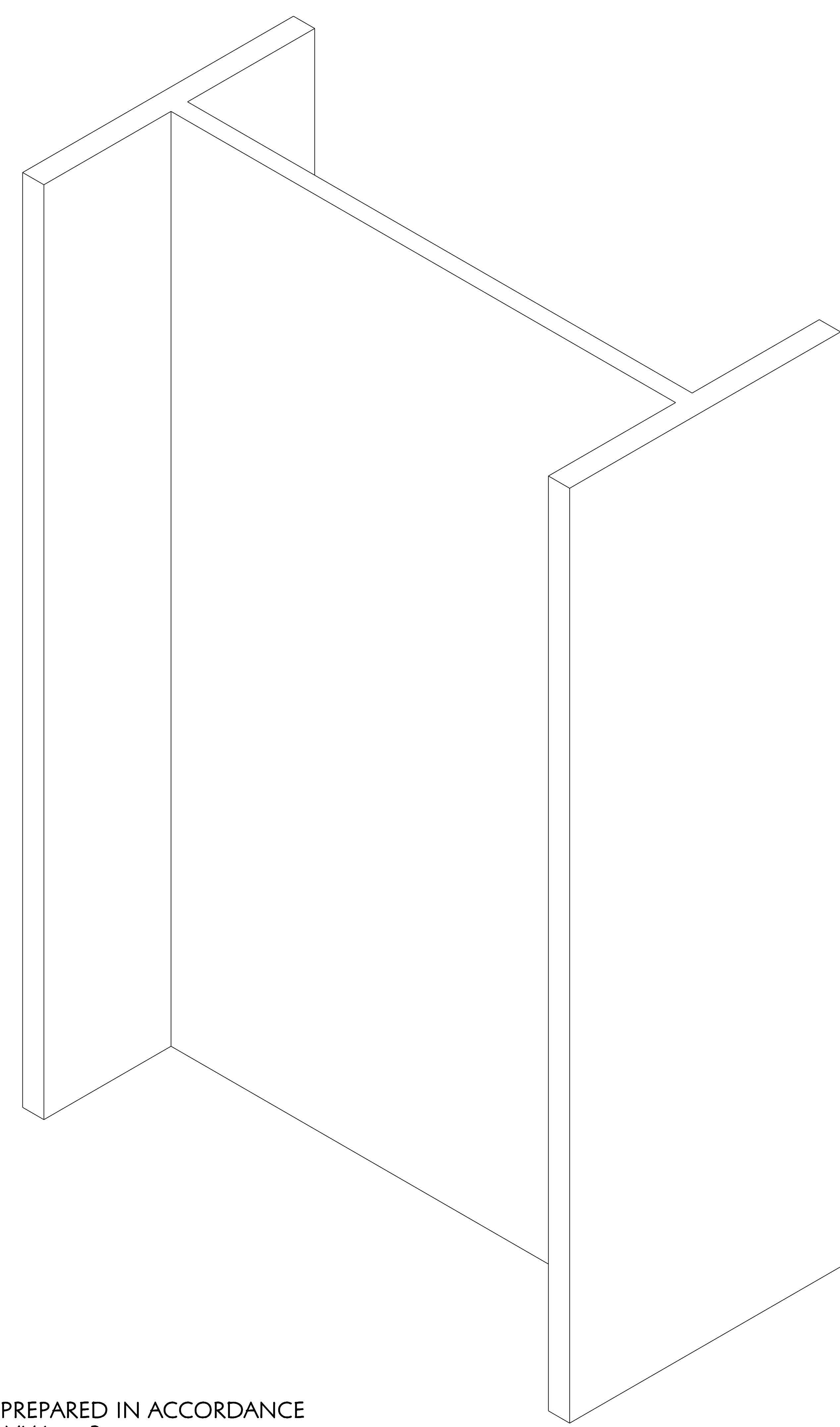
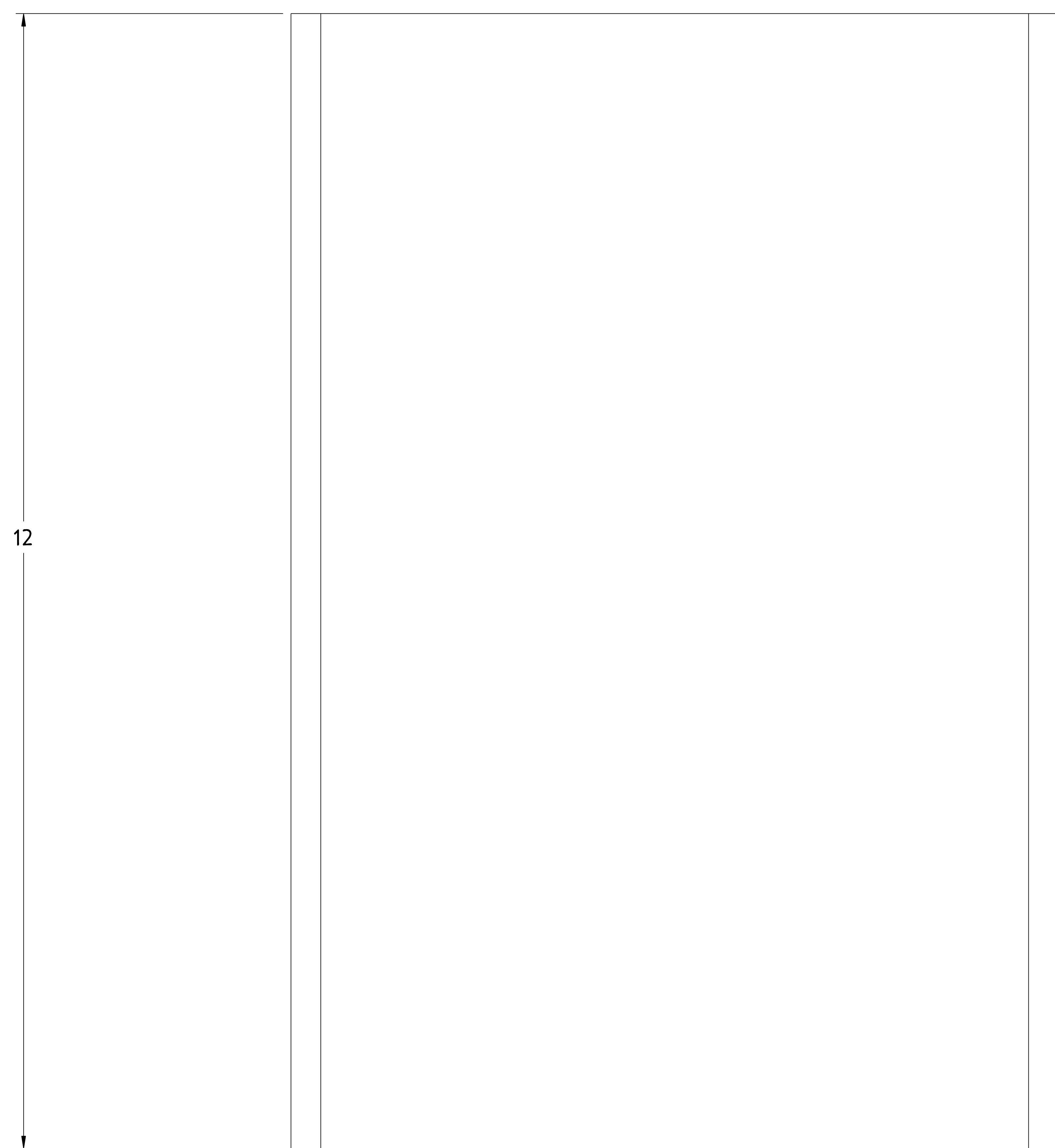
2	SE172-243-2	PERIOD SUPPORT PEDESTAL BOTTOM PLATE	304 STN STL	
PART NO.	DRAWING/MODEL NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY RECD
PARTS LIST				
COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED	CENTRAL FILES:	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY		
Pro E	UNLESS OTHERWISE SPECIFIED	NATIONAL COMPACT STELLARATOR EXPERIMENT		
DO NOT VERIFY INFORMATION BY SCALING DRAWING	DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	STELLARATOR CORE BASE SUPPORT STRUCTURE PERIOD SUPPORT PEDESTAL BOTTOM PLATE		
	TOLERANCES NON-CUMULATIVE	DSN: T. CRUICKSHANK	DRAWING NO:	
NEXT ASSEMBLY	DECIMAL-INCH FRACTIONS	CHK:	SE172-243	
	.XX +/- .000 0°-12° +/- .010	ENGR: F. DAHLGREN		
	.XXX +/- .005 12°-120° +/- .010	SUPV:		
	ANGULAR +/- .0°-15° OVER 120° +/- .010			
			SHEET 3 OF 4	REV D, 04

RELEASE LEVEL: WIP
DWG VERSION NO: 3

WEIGHT	41.2 lbs
MODEL NAME	SE172-243-2
WELDING ENGINEER	

NCSX-SE172-243

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



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.

3 REQUIRED

3	SEI72-243-3	PERIOD SUPPORT PEDESTAL BEAM	304 STN STL
PART NO.	DRAWING/MODEL NO	NOMENCLATURE OR DESCRIPTION	MATERIAL QTY REOD
PARTS LIST			
COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	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 BREAK SHARP EDGES .005/.020	STELLARATOR CORE BASE SUPPORT STRUCTURE PERIOD SUPPORT PEDESTAL CENTER SUPPORT BEAM W8 X 15	
NEXT ASSEMBLY	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .X ±.100 0°-120° ±.125 .XX ±.030 12°-120° ±.110 .XXX ±.005 12°-120° ±.110 ANGULAR ±.0°-15° OVER 120° ±.112	DSN: T. CRUICKSHANK CHK: ENGR: F. DAHLGREN SUPV:	DRAWING NO: SEI72-243
RELEASE LEVEL: WIP DWG VERSION NO: 3		WELDING ENGINEER	SHEET 4 OF 4 REV D, 04

NCSX-SEI72-243