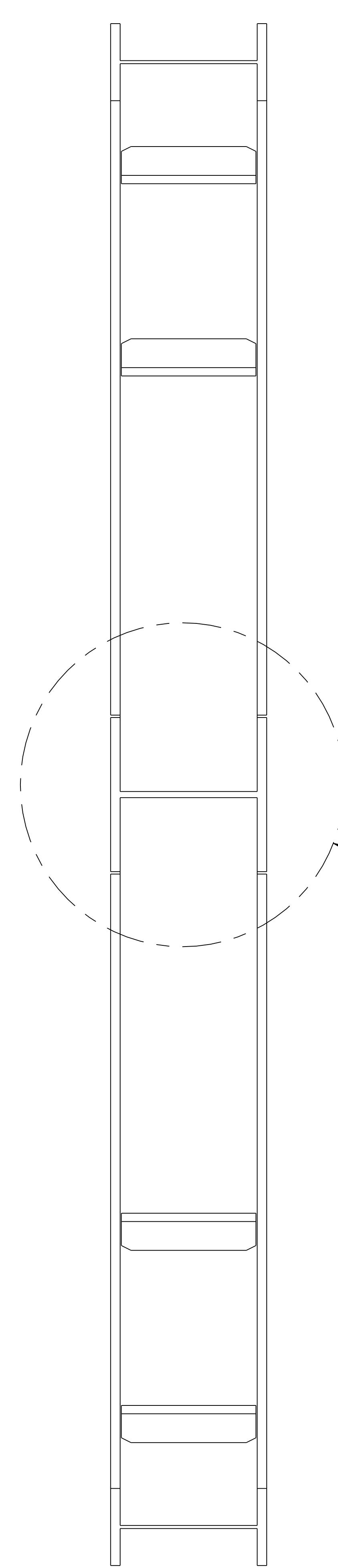
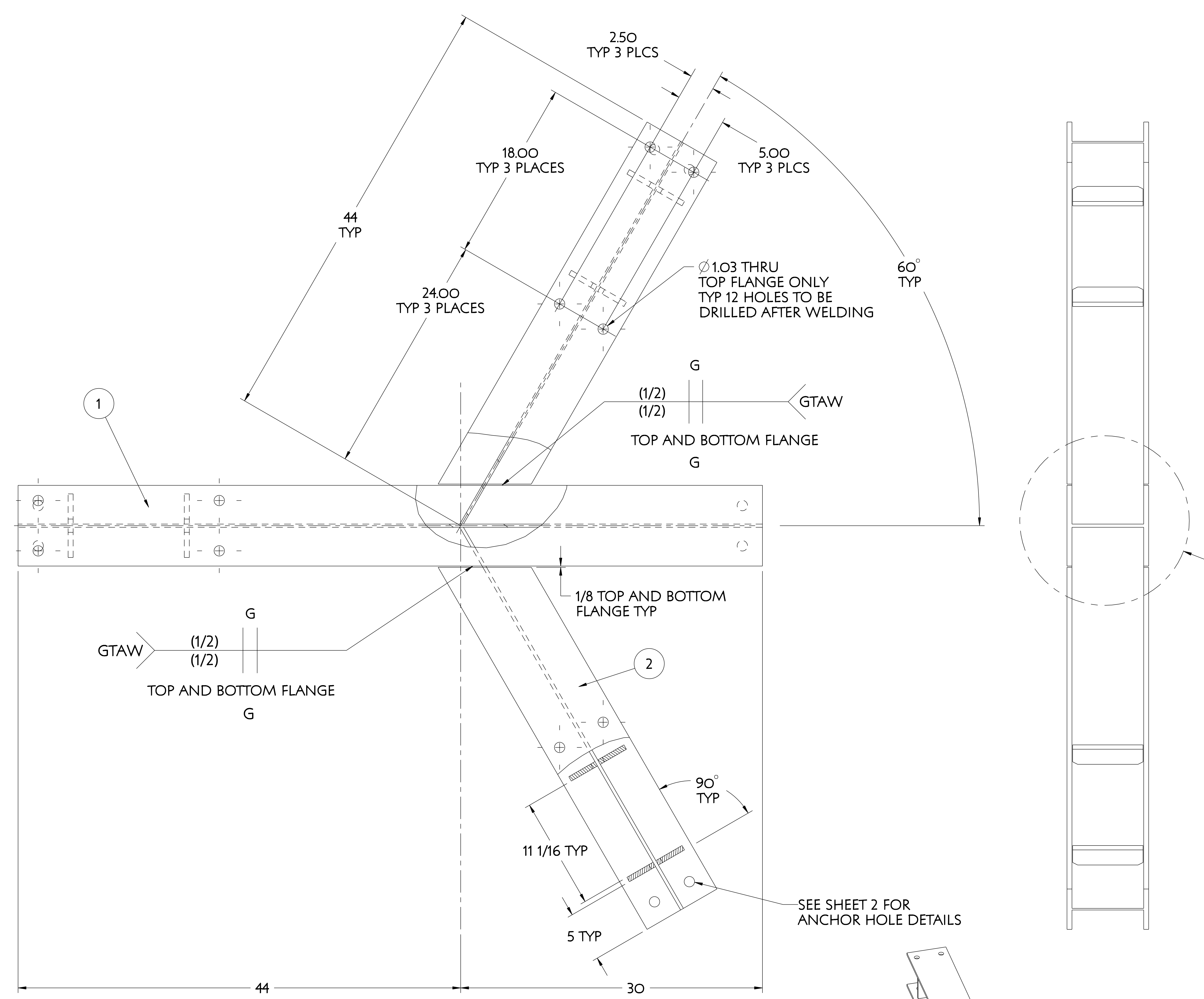


- DRAWINGS PREPARED IN ACCORDANCE WITH ASME Y14.100-2000
- INTERPRET DIMENSIONS & TOLERANCES PER ASME Y14.5-1994.
- DIMENSIONS ARE IN INCHES.
- SEE SPECIFICATION NCSX-CSPEC-XXX-XX-XX FOR ADDITIONAL INFORMATION AND/OR MATERIAL REQUIREMENTS.
- WELDING SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS 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.

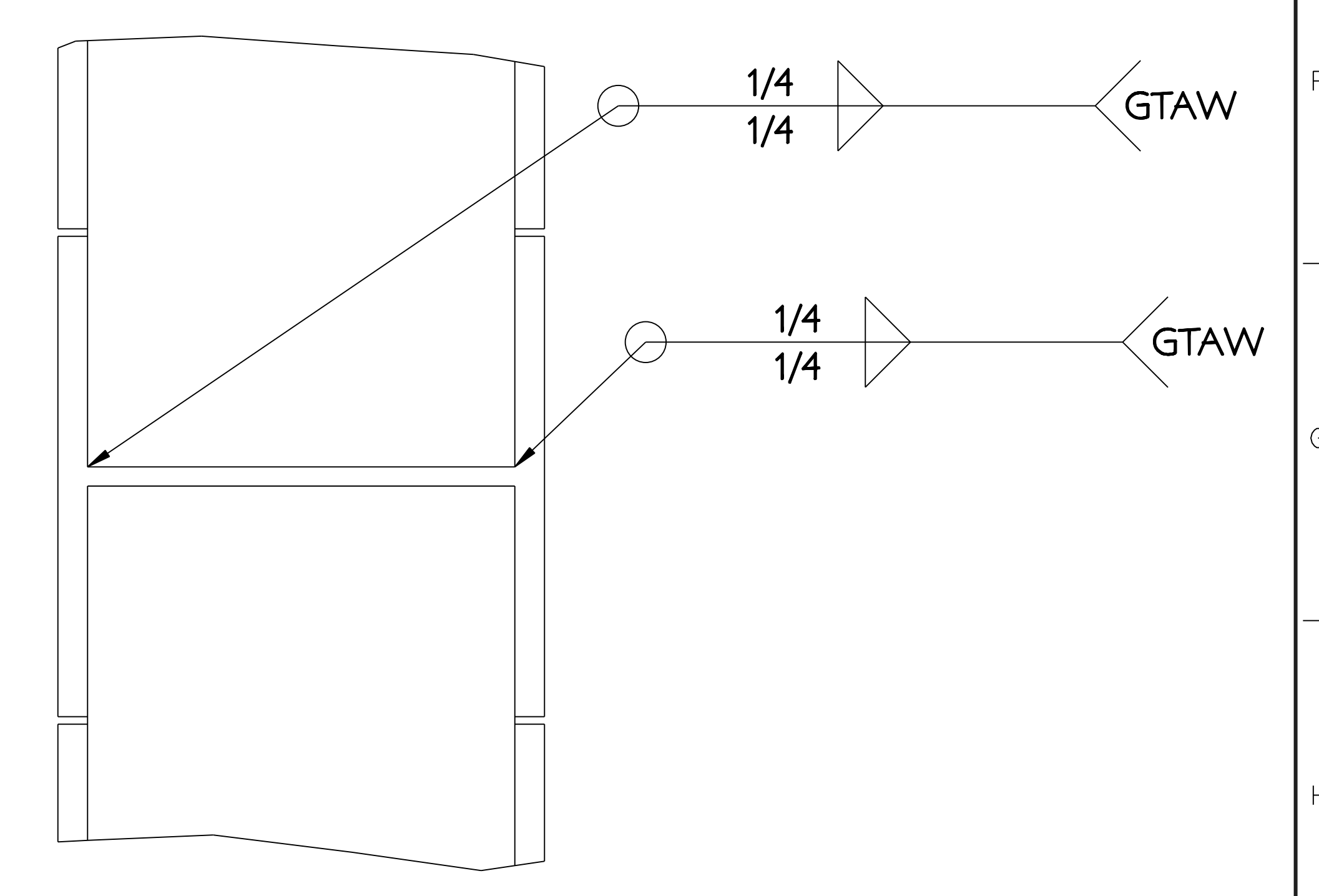
REFERENCE PERMEABILITY

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.

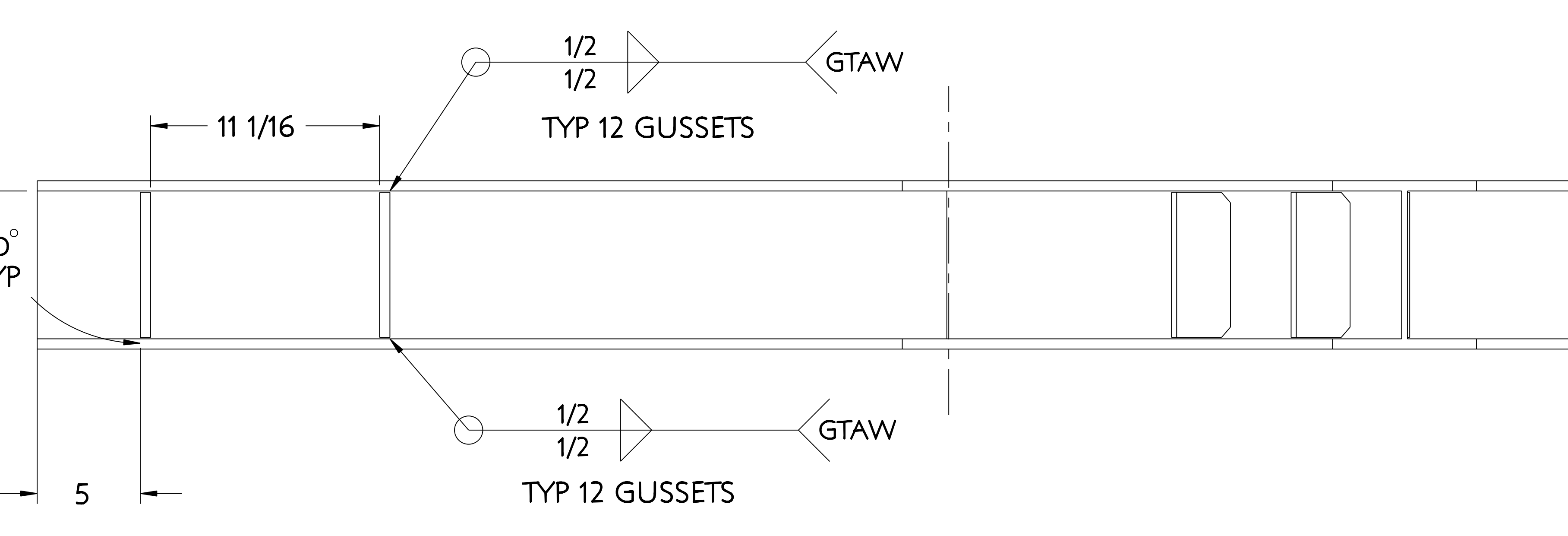
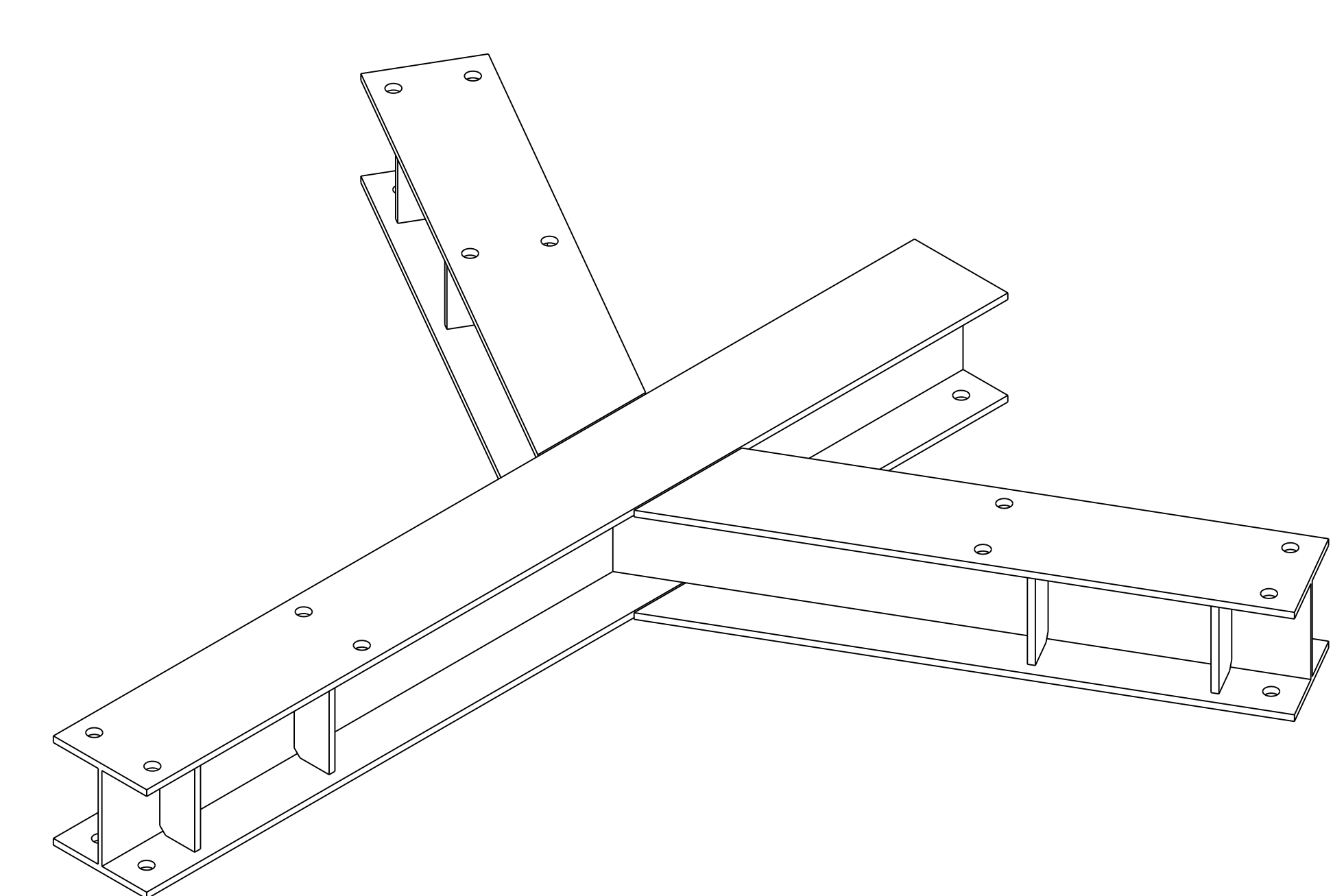


SEE DETAIL A



DETAIL A
SCALE 0.500

SEE SHEET 2 FOR ANCHOR HOLE DETAILS



PART NO.	DRAWING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY	RECD
3	SE172-252-3	BASE SUPPORT STRUCTURE BASE GUSSET	304 STN STL	12	
2	SE172-252-2	WB X 35 CENTER COLUMN SUPPORT SIDE BRIDGING BEAM	304 STN STL	2	
1	SE172-252-1	WB X 35 CENTER COLUMN SUPPORT CENTER BRIDGING BEAM	304 STN STL	1	

PARTS LIST

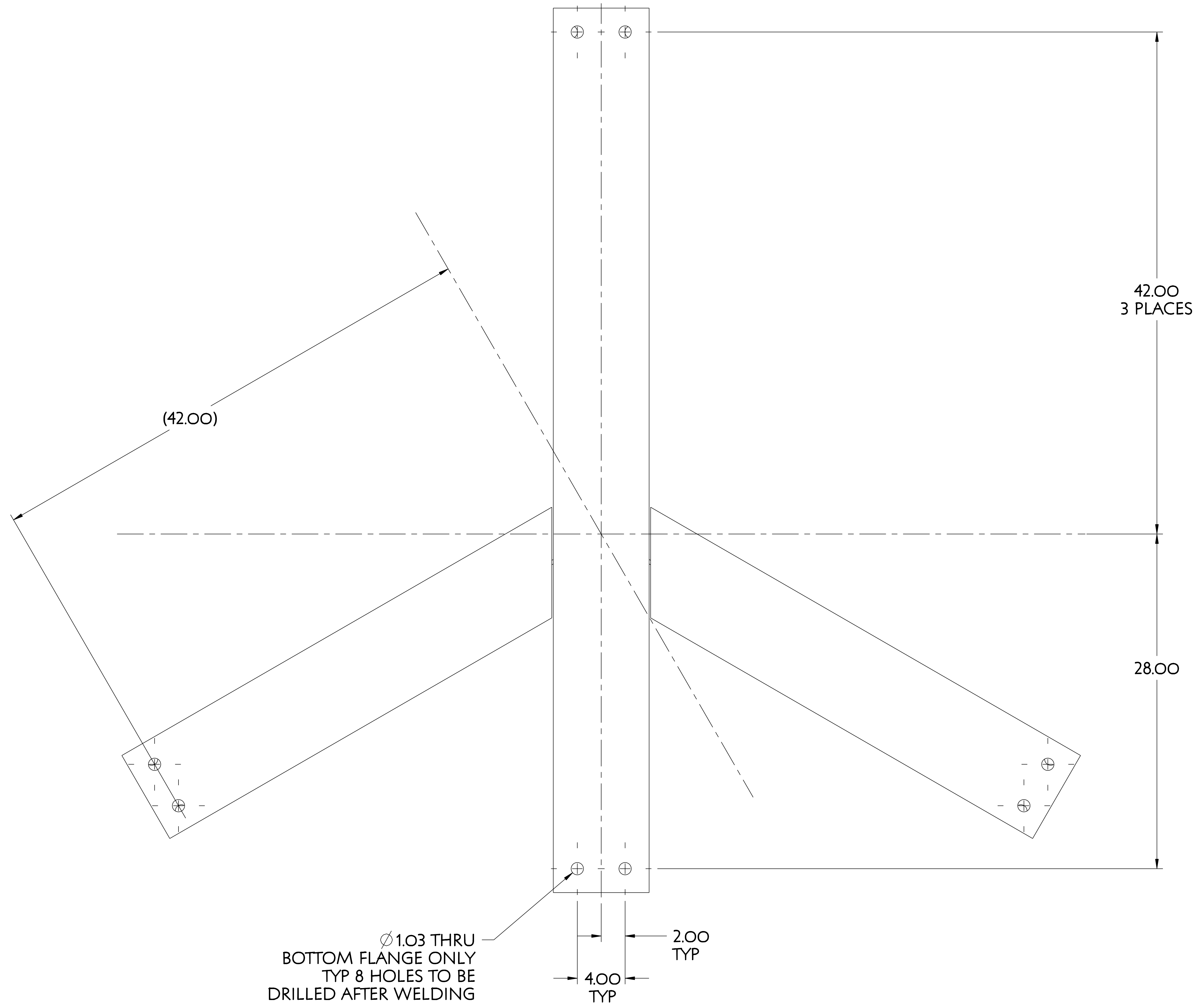
COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY NATIONAL COMPACT STELLARATOR EXPERIMENT STELLARATOR CORE BASE SUPPORT STRUCTURE CENTER SUPPORT BRIDGING BEAM DRILLING/WELDMENT	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX +/- .000 .XXX +/- .005 ANGULAR +/- 0°15'	DSN: T. CRUICKSHANK ENGR: F. DAHLGREN SUPV:	DRAWING NO: SE172-252 SHEET 1 OF 5 REV D, 2

RELEASE LEVEL: WIP
DWG VERSION NO: 2

WEIGHT	491.7 lbs
MODEL NAME	SE172-252
WELDING ENGINEER	

NCSX-SE172-252

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



Ø 1.03 THRU
BOTTOM FLANGE ONLY
TYP 8 HOLES TO BE
DRILLED AFTER WELDING

4.00
TYP

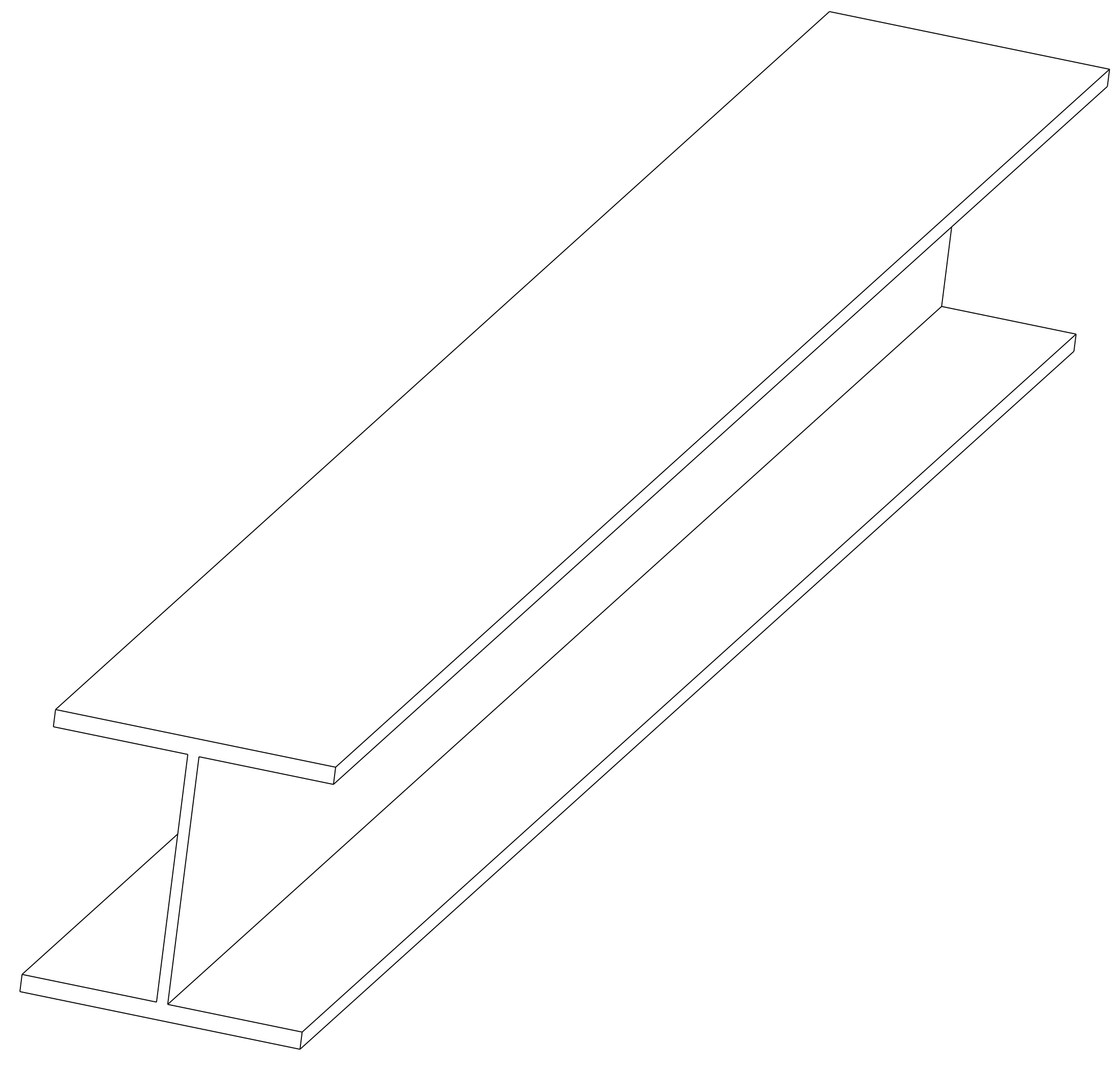
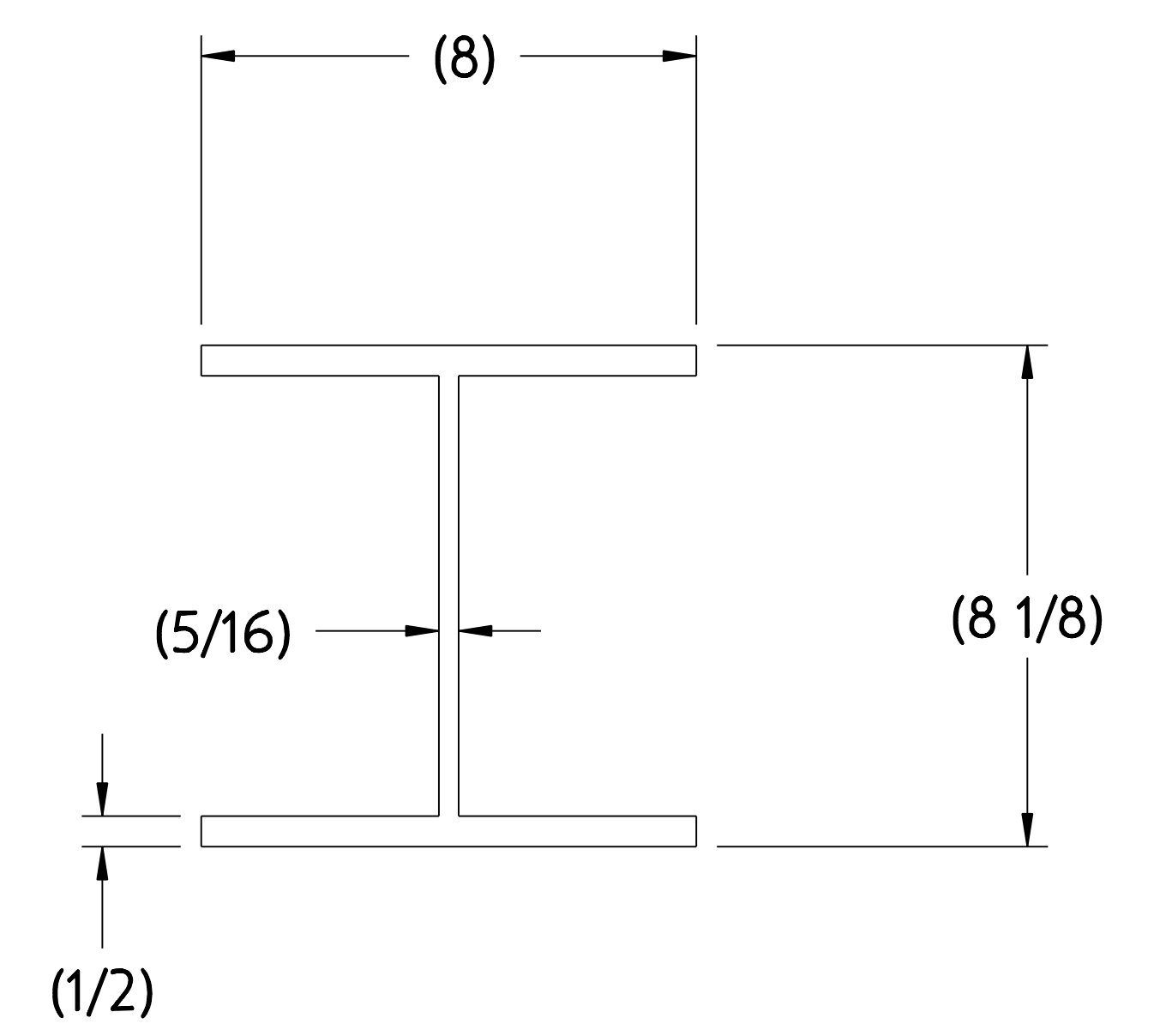
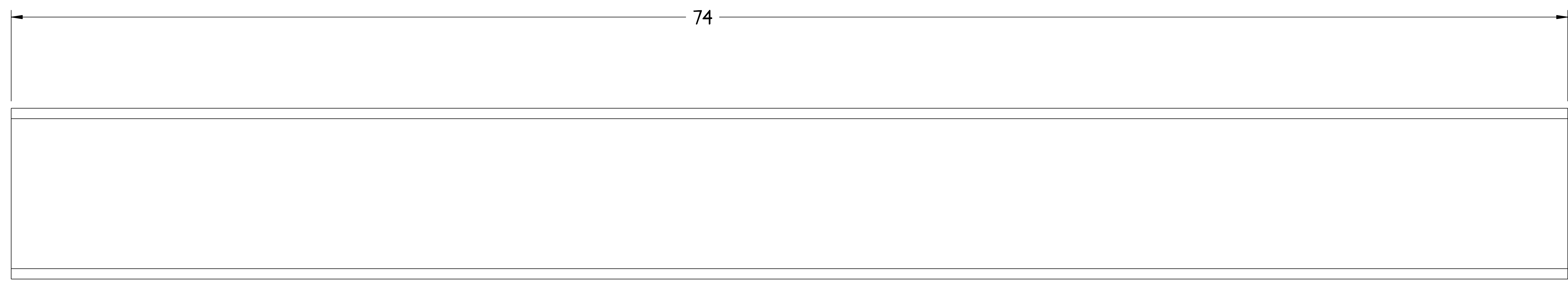
2.00
TYP

SE172-252	CENTER SUPPORT BRIDGING BEAM ASSEMBLY	304 STN STL	
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 CENTER BASE ASSEMBLY ANCHOR HOLES	
WEIGHT 491.7 lbs	MODEL NAME SE172-252	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS XX +/- .000 0°-120° +/- .010 XXX +/- .005 120°-120° +/- .010 ANGULAR +/- .0°-15° OVER 120° +/- .172	DSN: T. CRUICKSHANK CHK: ENGR: F. DAHLGREN SUPV: DRAWING NO: SE172-252
RELEASE LEVEL: WIP DWG VERSION NO: 2		WELDING ENGINEER	SHEET 2 OF 5 REV D, 2

NCSX-SE172-252

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.



RELEASE LEVEL: WIP
 DWG VERSION NO: 3

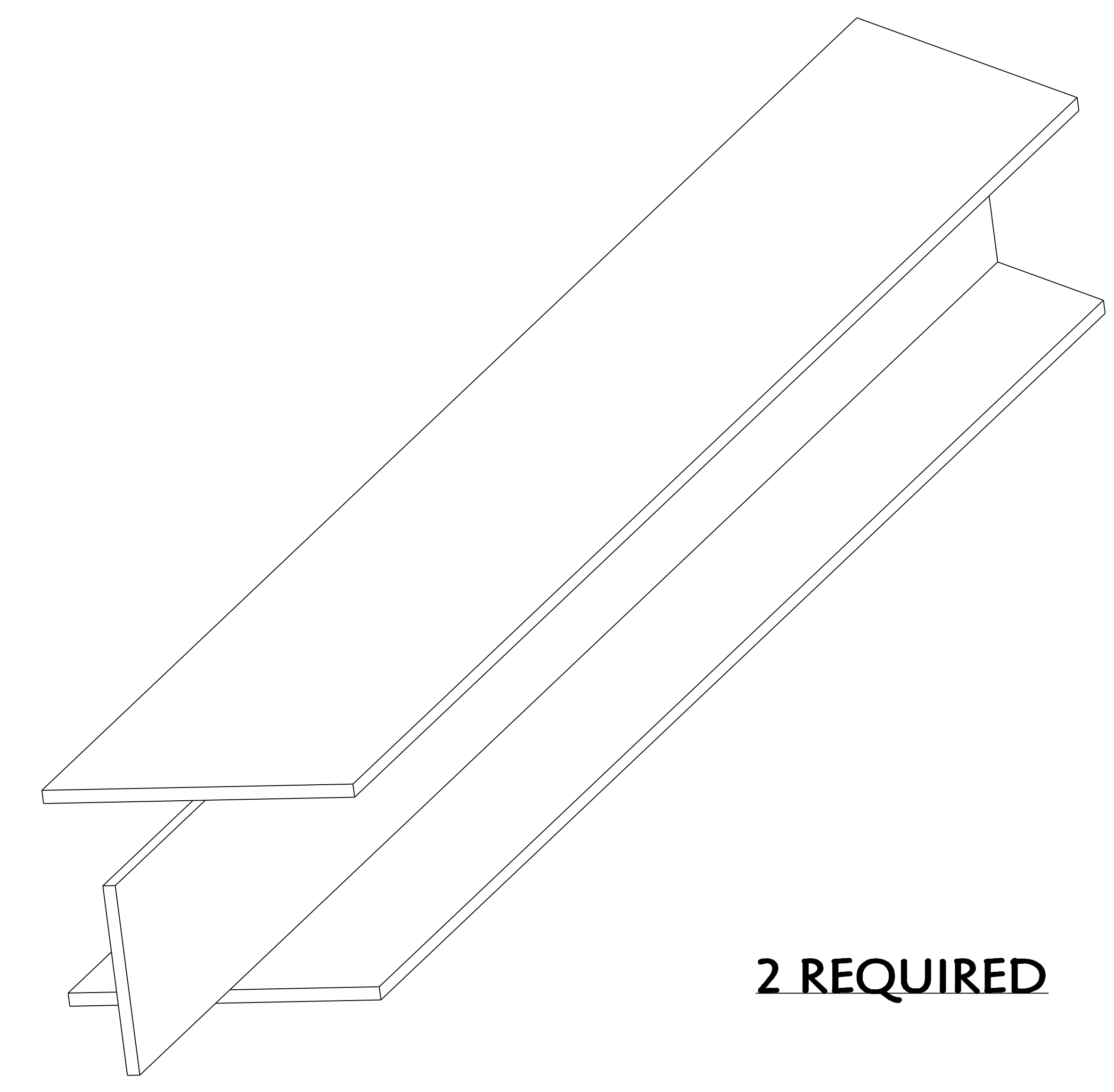
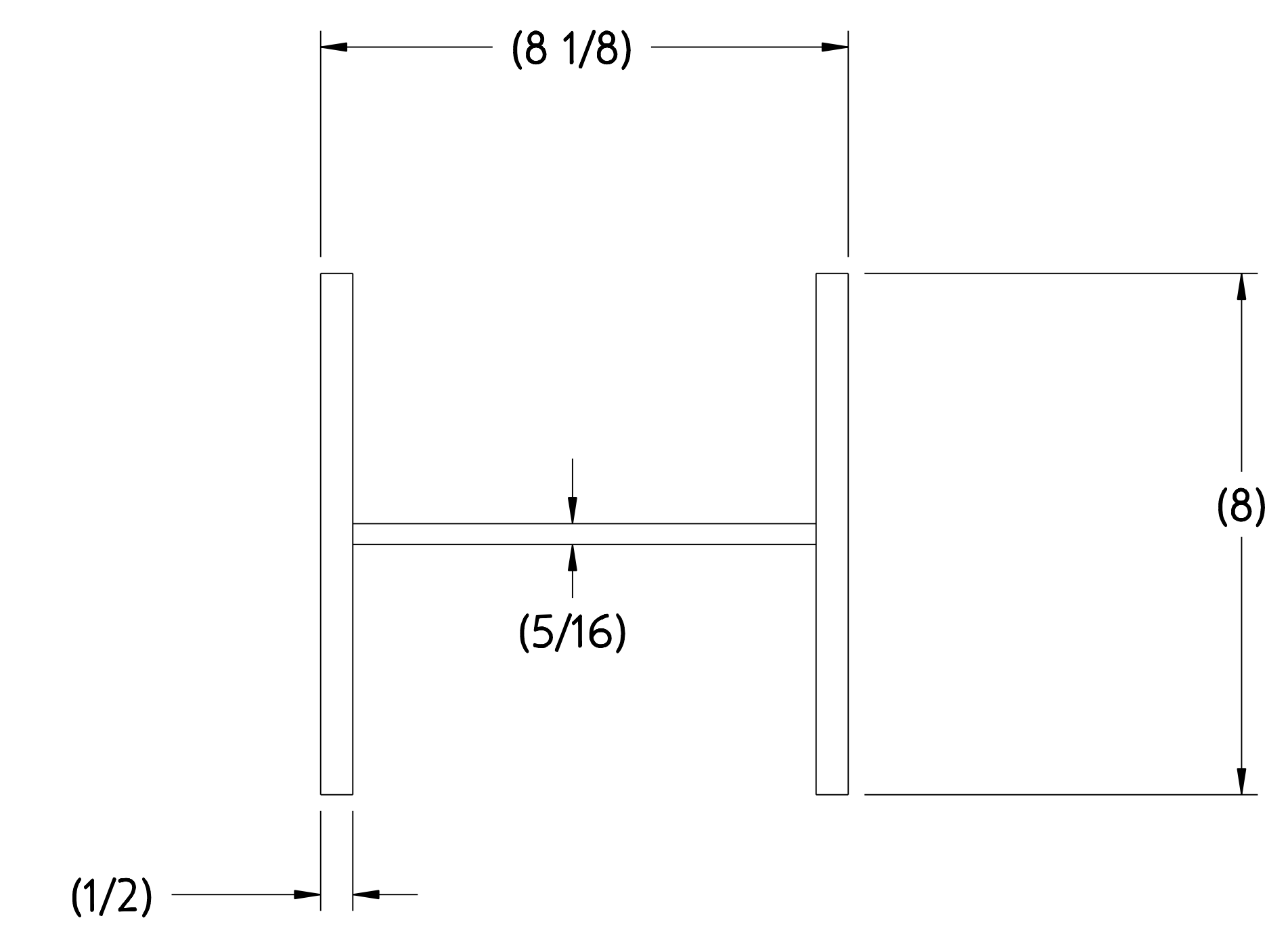
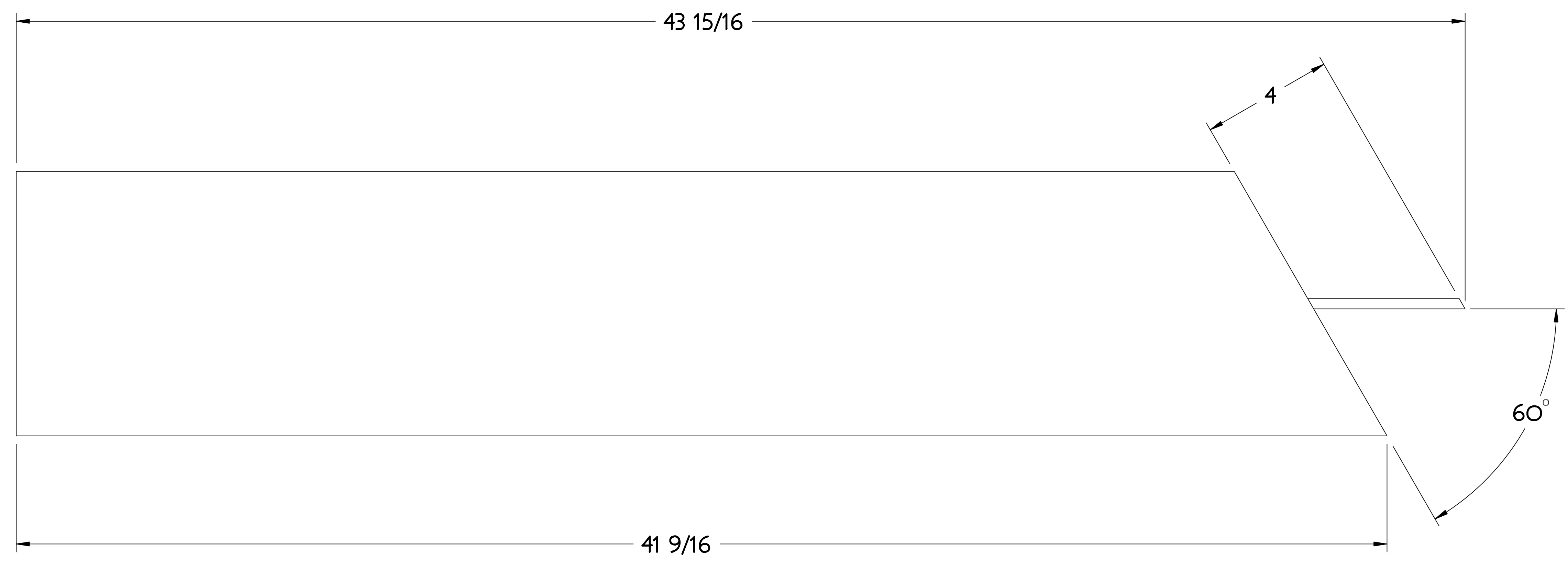
WEIGHT	219.4 lbs
MODEL NAME	SE172-252-1
WELDING ENGINEER	

PART NO.	DRAWING/MODEL NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY RECD
	SE172-252-1	W8 X 35 CENTER COLUMN SUPPORT CENTER BRIDGING BEAM	304 STN STL	
PARTS LIST				
COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED		CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY	
Pro E		DIMENSIONS ARE IN INCHES MACHINE SURFACES	NATIONAL COMPACT STELLARATOR EXPERIMENT	
DO NOT VERIFY INFORMATION BY SCALING DRAWING		BREAK SHARP EDGES .005/.020	STELLARATOR CORE BASE SUPPORT STRUCTURE CENTER COLUMN SUPPORT CENTER BRIDGING BEAM	
NEXT ASSEMBLY		TOLERANCES NON-CUMULATIVE	DSN: T. CRUICKSHANK	DRAWING NO:
		DECIMAL-INCH FRACTIONS	CHK: ENGR: F. DAHLGREN	SE172-252
		.XX +/- .000 0°-120° +/- .004		
		.XXX +/- .005 120°-120° +/- .004		
		ANGULAR +/- .0°-15° OVER 120° +/- .172		
			SUPV:	SHEET 3 OF 5 REV B, 24

NCSX-SE172-252

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.



2 REQUIRED

RELEASE LEVEL: WIP
DWG VERSION NO: 2

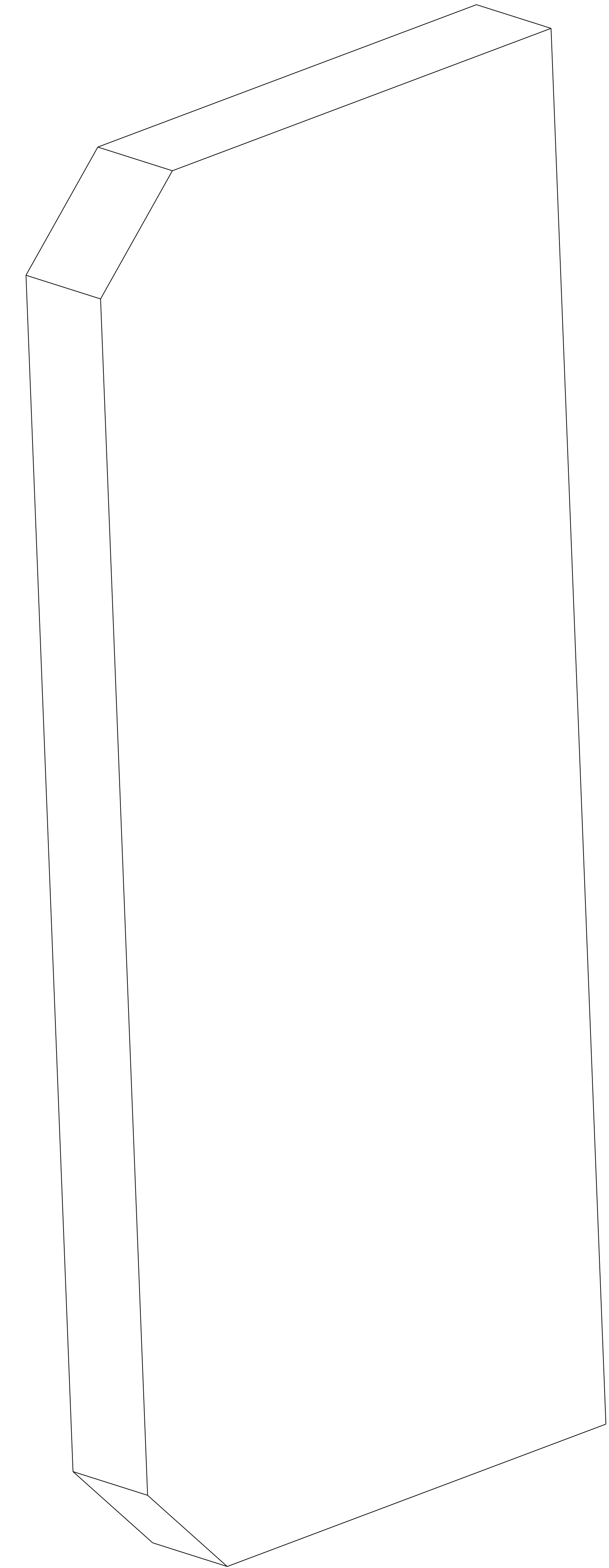
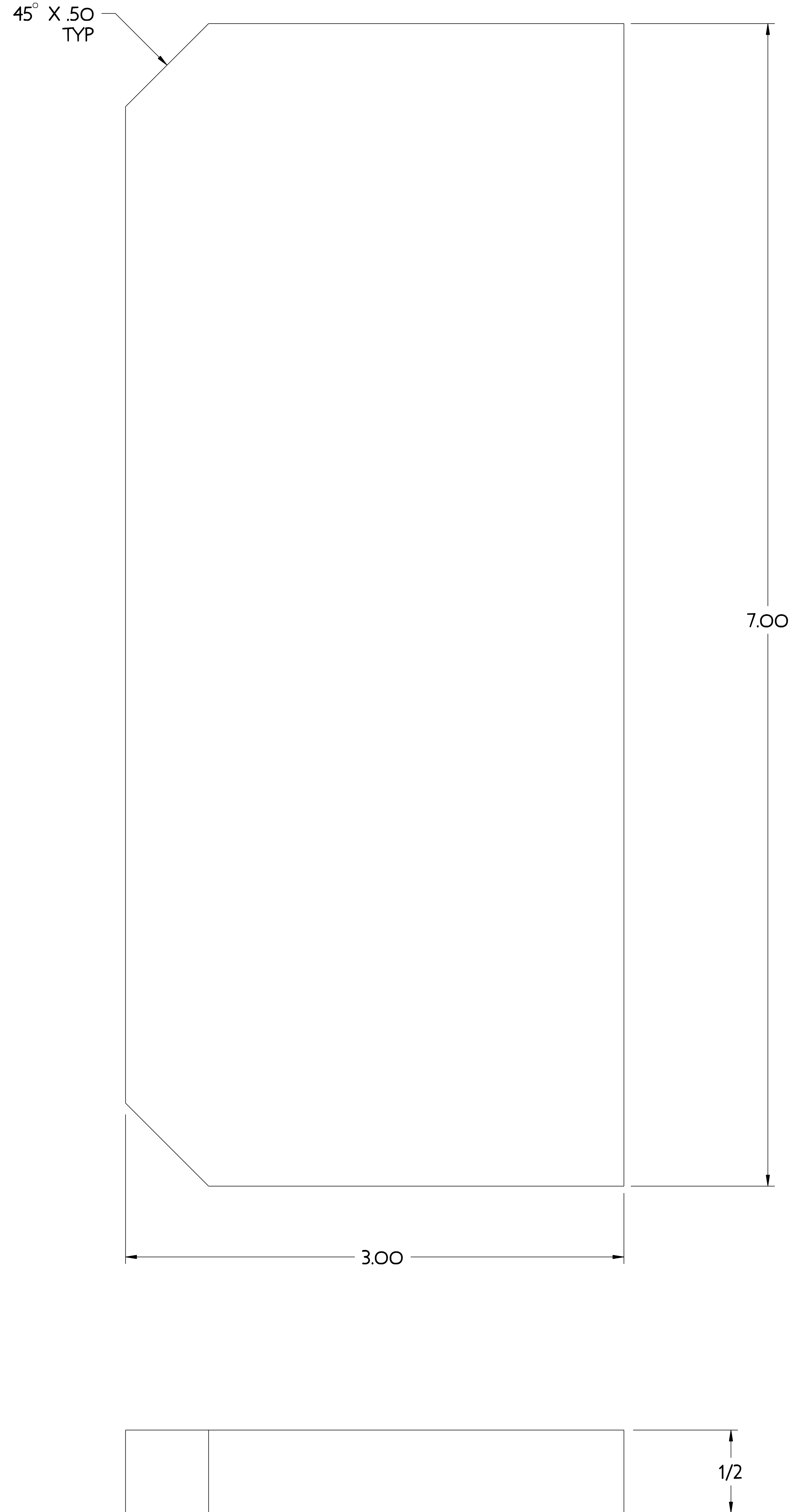
WEIGHT	119.3 lbs
MODEL NAME	SEI72-252-1
WELDING ENGINEER	

2	SEI72-252-2	W8 X 35 CENTER COLUMN SUPPORT SIDE BRIDGING BEAM	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	STELLARATOR CORE BASE SUPPORT STRUCTURE CENTER SUPPORT COLUMN SIDE BRIDGING BEAM		
	BREAK SHARP EDGES .005/.020	TOLERANCES NON-CUMULATIVE	DSN: T. CRUICKSHANK	DRAWING NO:
		DECIMAL-INCH FRACTIONS	CHK:	SEI72-252
		.XX +/- .000 0°-12° +/- .010	ENGR: F. DAHLGREN	
		.XXX +/- .005 12°-120° +/- .010	SUPV:	SHEET 4 OF 5
		ANGULAR +/- .0°-15° OVER 120° +/- .010		REV B, 2

NCSX-SEI72-252

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.



RELEASE LEVEL: WIP
 DWG VERSION NO: 0

WEIGHT	3.0 lbs
MODEL NAME	SEI72-252-1
WELDING ENGINEER	

PART NO.	DRAWING/MODEL NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY RECD
3	SEI72-252-3	BASE SUPPORT STRUCTURE BASE GUSSET	304 STN STL	

PARTS LIST

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY
Pro E	DIMENSIONS ARE IN INCHES MACHINE SURFACES	NATIONAL COMPACT STELLARATOR EXPERIMENT
DO NOT VERIFY INFORMATION BY SCALING DRAWING	BREAK SHARP EDGES .005/.020	STELLARATOR CORE BASE SUPPORT STRUCTURE BASE SUPPORT STRUCTURE BASE GUSSET
NEXT ASSEMBLY	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX +/- .000 .XXX +/- .005 ANGULAR +/- .05	DSN: T. CRUICKSHANK CHK: ENGR: F. DAHLGREN SUPV: DRAWING NO: SEI72-252
		SHEET 5 OF 5 REV B, 2

NCSX-SEI72-252