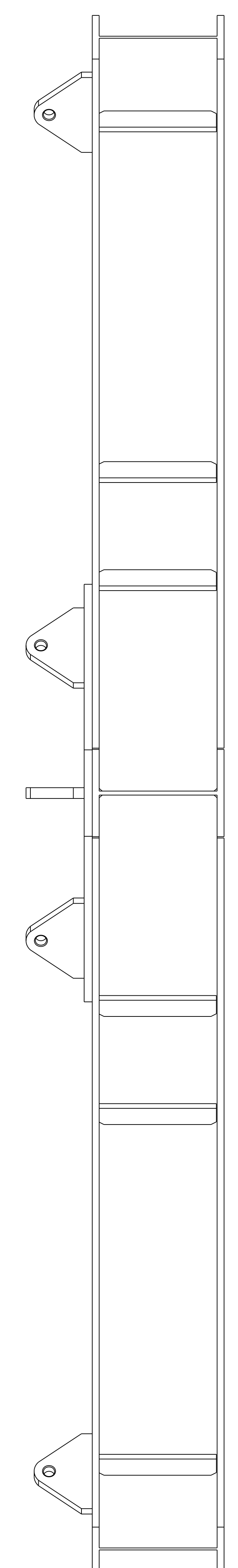
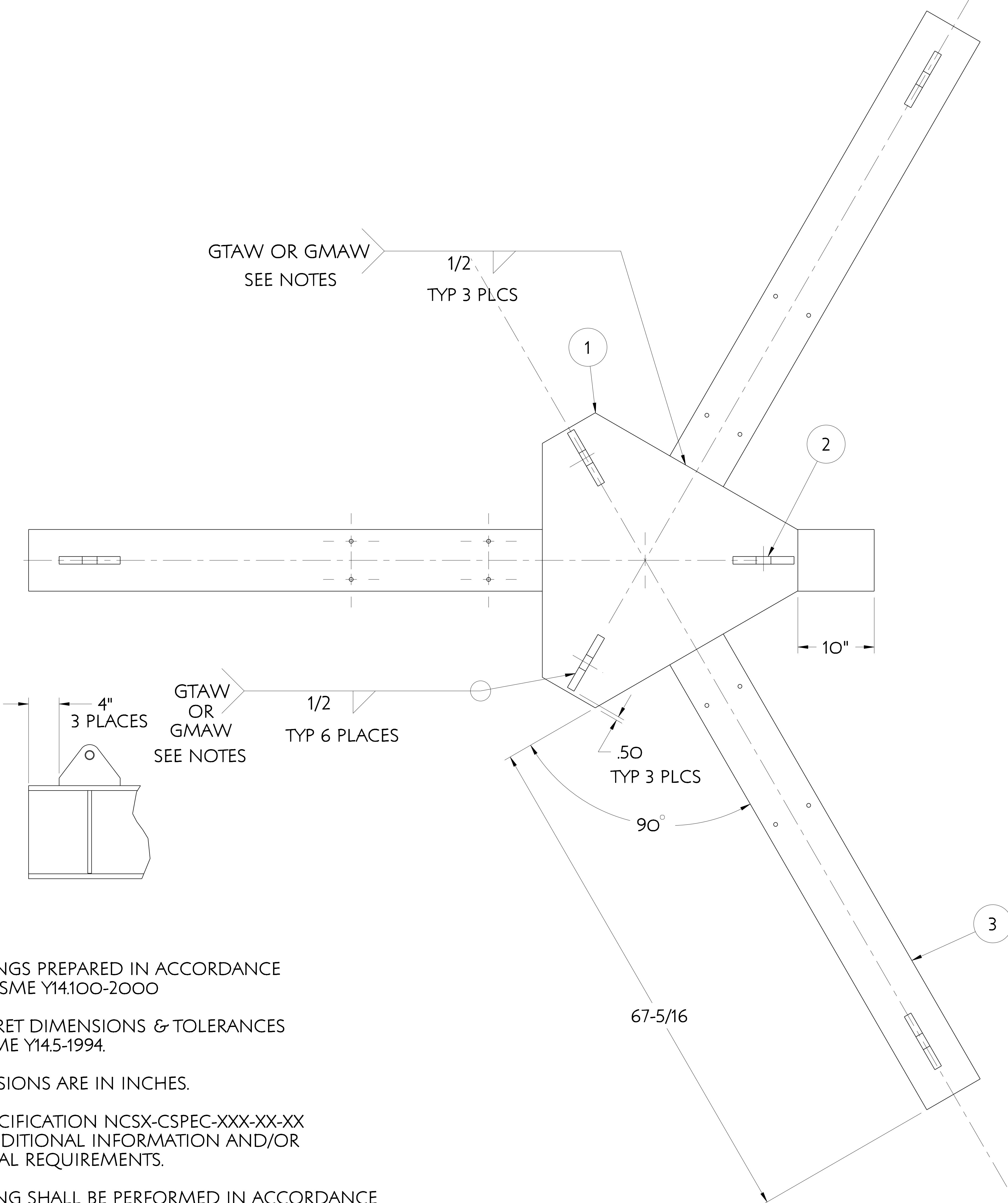
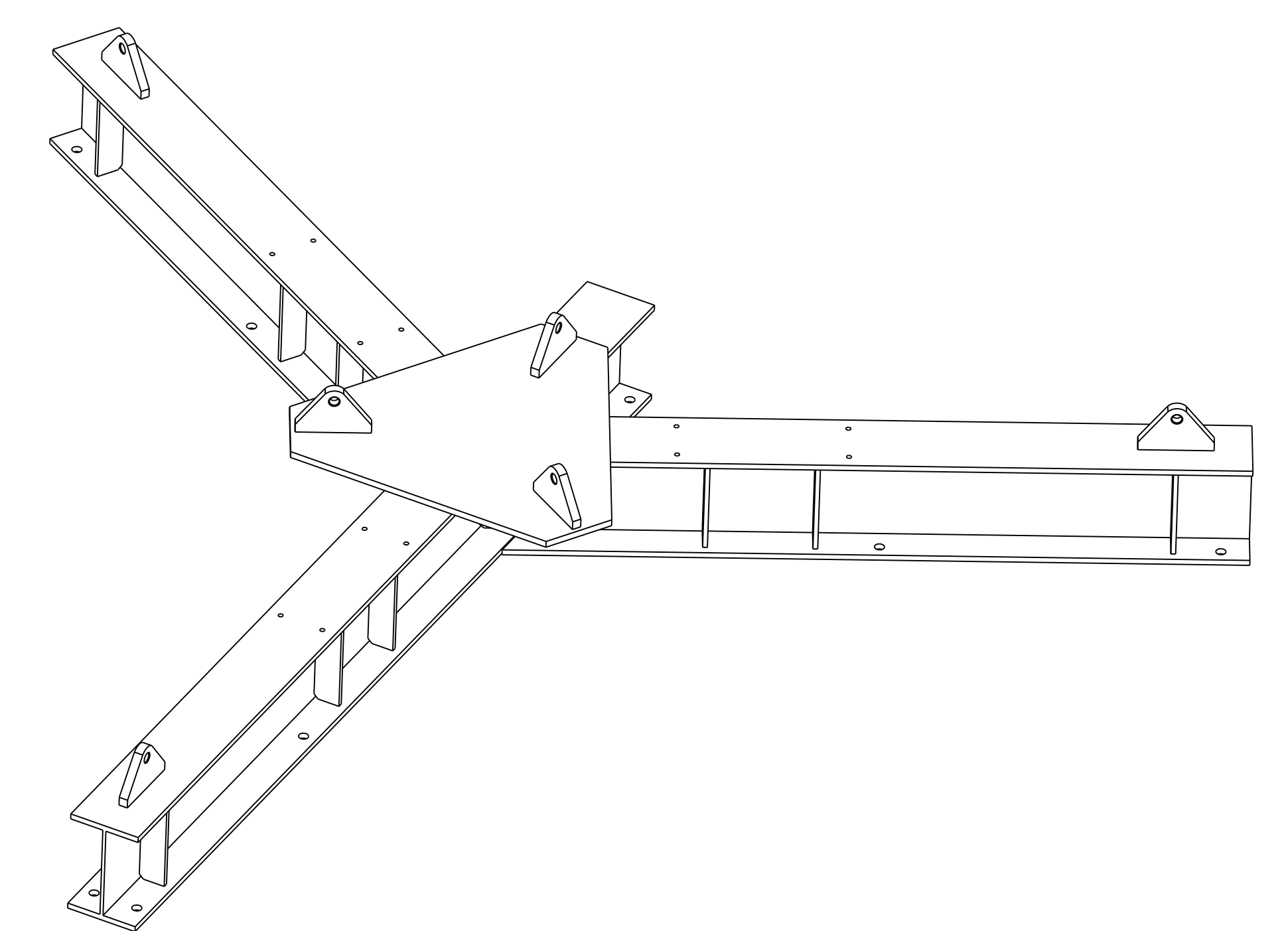


NO.	REVISION	BY	CH	SUP	APPROVED	DATE



SEE SHEET 2
FOR BOTTOM VIEW



ONE ASSEMBLY REQUIRED

- 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.

TOP VIEW

RELEASE LEVEL: WIP
DWG VERSION NO: 9

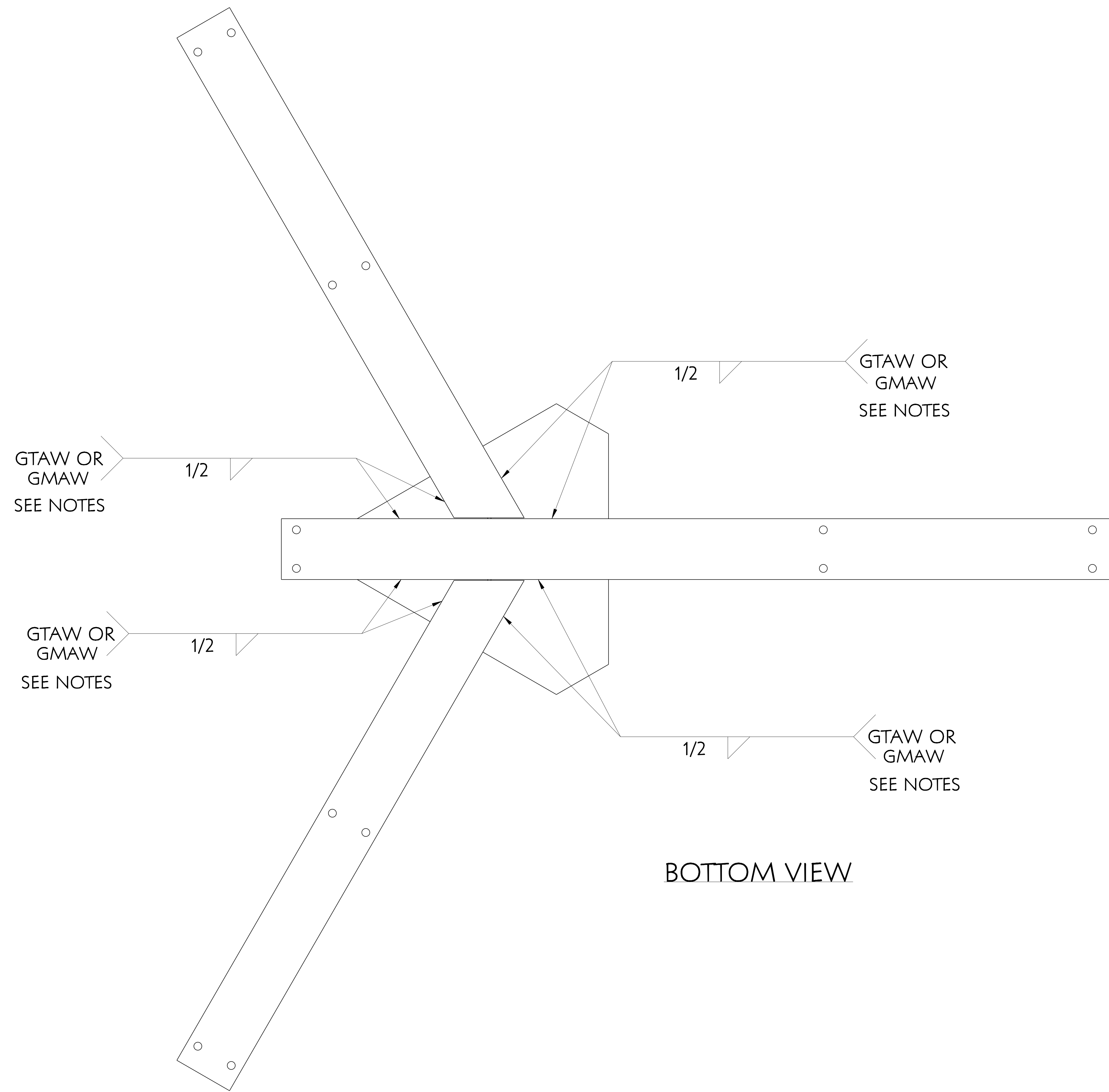
WEIGHT
1539.3 lbs

MODEL NAME
SE172-203

3	SE172-252	CENTER SUPPORT BRIDGING BEAM WELDMENT		1
2	SE172-203-2	BASE SUPPORT STRUCTURE BRACKET	304L ST STL	6
1	SE172-203-1	CENTER SUPPORT BASE PLATE	304L ST STL	1
PART NO.	DRAWING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY RECD
PARTS LIST				
COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED		CENTRAL FILES: PRINCETON PLASMA PHYSICS LABORATORY UNLESS OTHERWISE SPECIFIED		
DO NOT VERIFY INFORMATION BY SCALING DRAWING		DIMENSIONS ARE IN INCHES MACHINE SURFACES UNLESS OTHERWISE SPECIFIED BREAK SHARP EDGES .005/.020		
TOLERANCES NON-CUMULATIVE		DSN: T. CRUICKSHANK		
DECIMAL-INCH FRACTIONS		CHK: ENGR: F. DAHLGREN		
NEXT ASSEMBLY		DRAWING NO: SE172-203		
WELDING ENGINEER		SHEET 1 OF 4 REV 0		

NCSX-SE172-203

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



BOTTOM VIEW

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

RELEASE LEVEL: WIP
DWG VERSION NO: 8

WEIGHT
1188.0 lbs

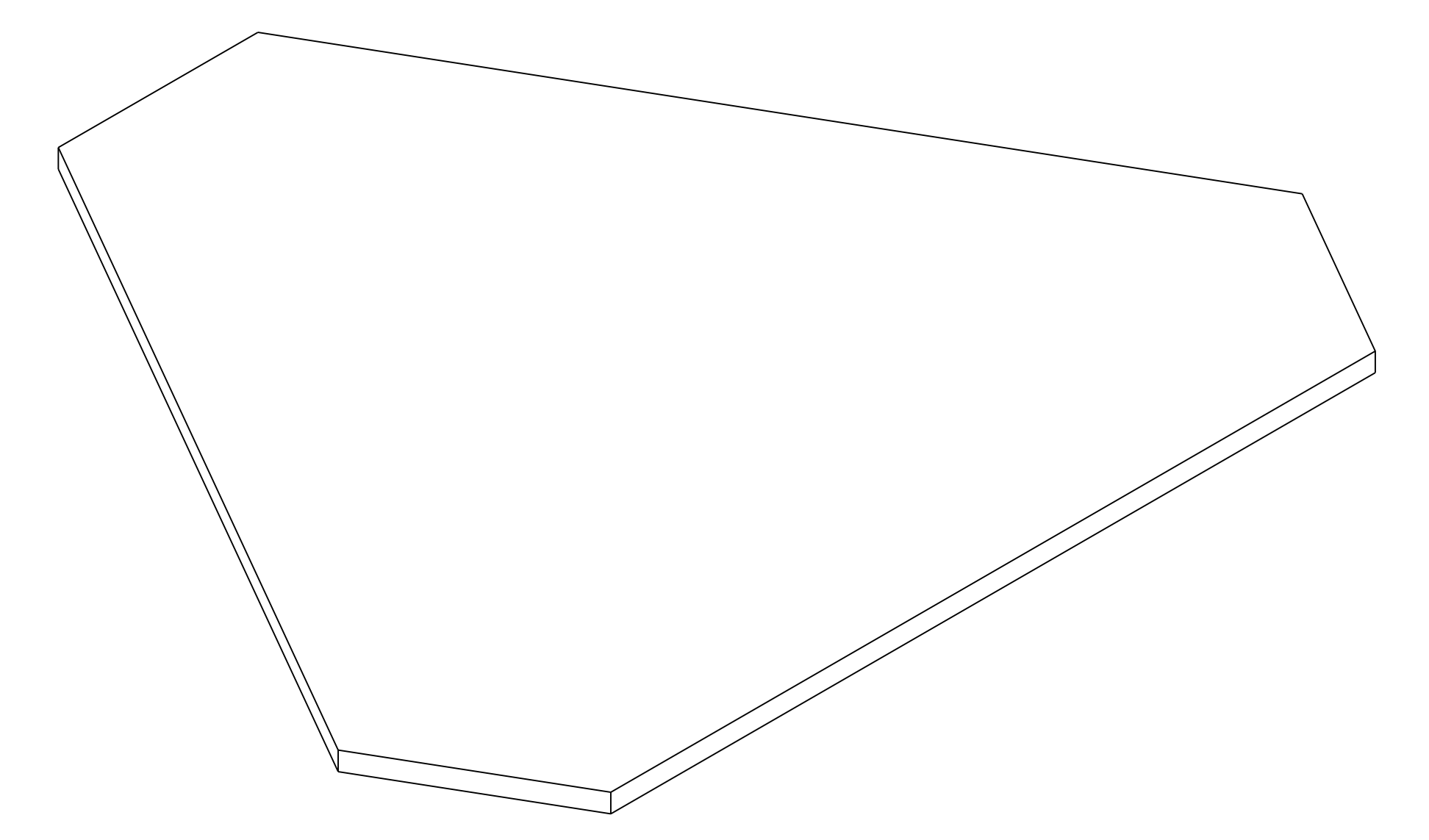
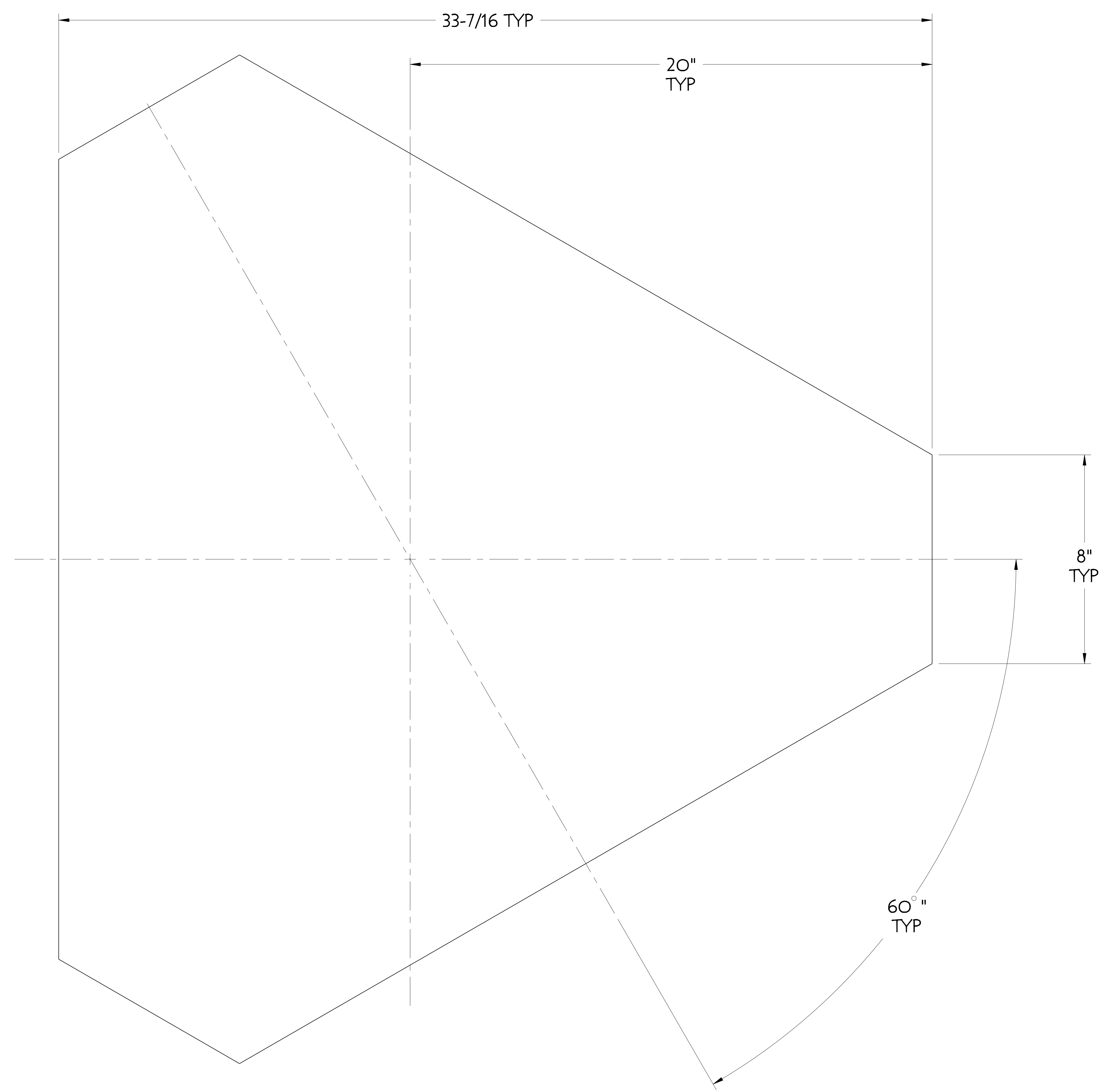
MODEL NAME
SE172-252

WELDING
ENGINEER

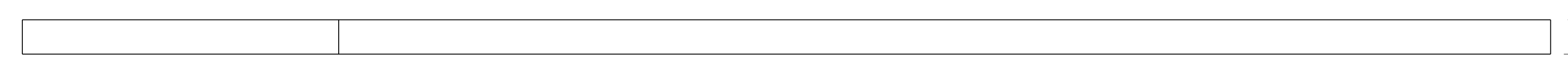
COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	NATIONAL COMPACT STELLARATOR EXPERIMENT	
NEXT ASSEMBLY	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .X ±.000 .XX ±.000 ANGULAR ±.0°-15°	DSN: H FEDER	DRAWING NO: SE172-203
		ENGR: F DAHLGREN	SHEET 2 OF 4
		SUPV:	REV D, 4

NCSX-SE172-203

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



3/4 STOCK



1 CENTER SUPPORT BASE PLATE

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

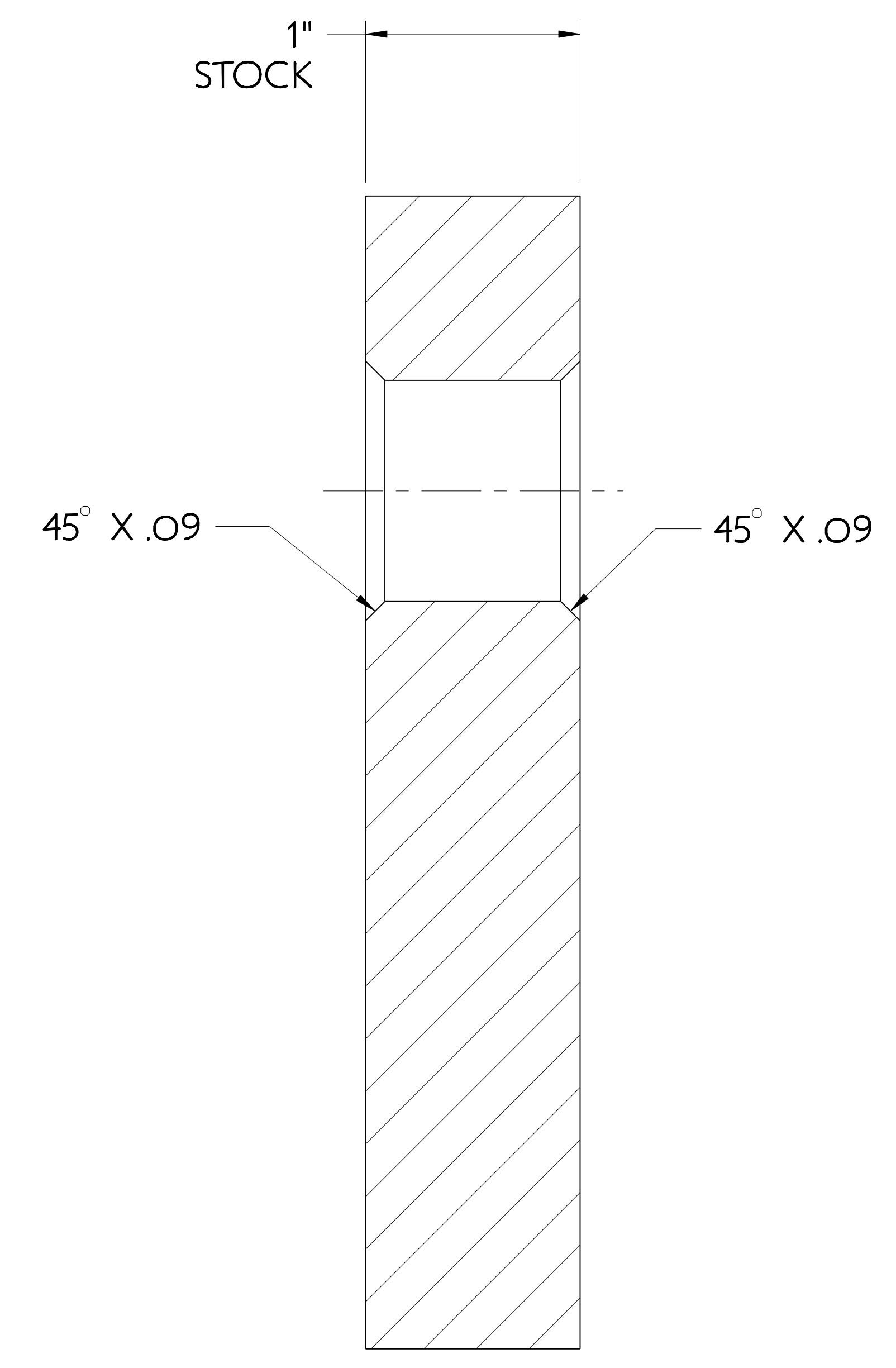
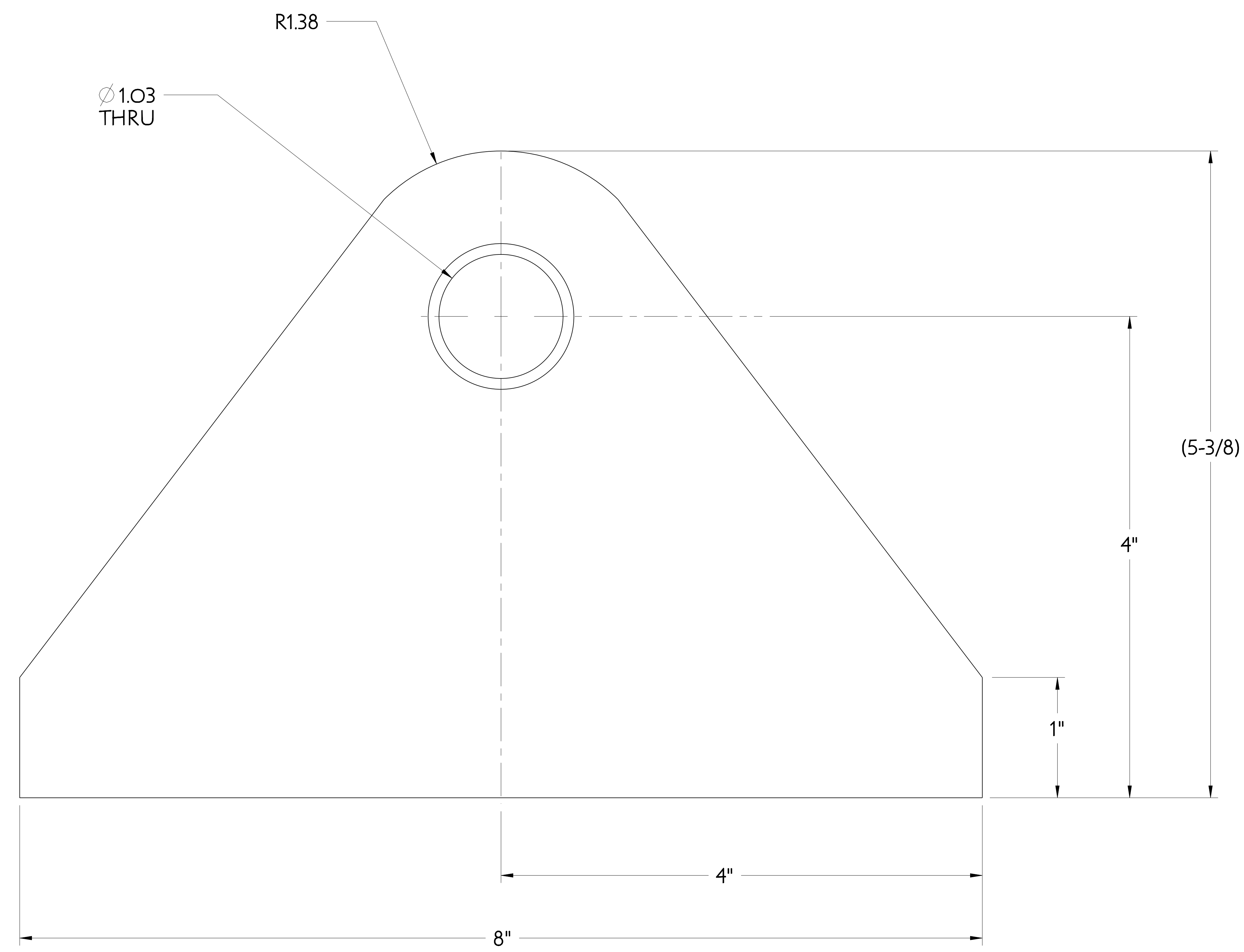
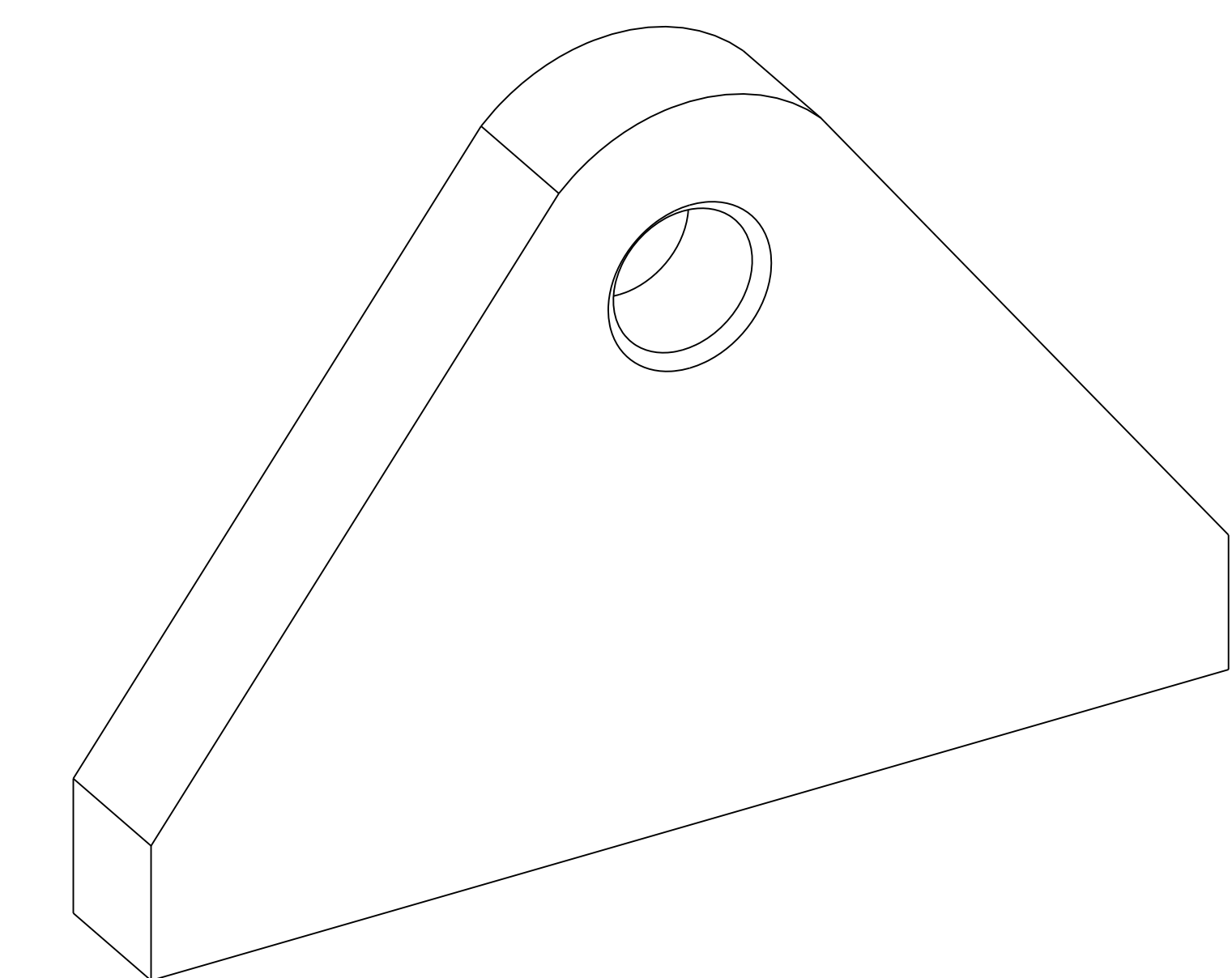
RELEASE LEVEL: WIP
DWG VERSION NO: 5

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

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 CENTER SUPPORT BASE WELDMENT	
NEXT ASSEMBLY	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .X +/- .100 0°-12° +/- .010 .XX +/- .030 12°-72° +/- .010 .XXX +/- .005 72°-120° +/- .010 ANGULAR +/- .0°-15° OVER 120° +/- .120	DSN: T. CRICKSHANK ENGR: F. DAHLGREN SUPV:	DRAWING NO: SEI72-203 SHEET 3 OF 4 REV B, 4

NCSX-SEI72-203

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



SECTION A-A

24 REQUIRED

2 BASE SUPPORT STRUCTURE BRACKET

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

RELEASE LEVEL: WIP
DWG VERSION NO: 15

WEIGHT	27.4 lbs
MODEL NAME	SE172-252-1
WELDING ENGINEER	

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 CENTER SUPPORT BASE WELDMENT	
NEXT ASSEMBLY	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .X ±.000 0°-120° ±.000 .XX ±.005 12°-120° ±.005 .XXX ±.005 12°-120° ±.005 ANGULAR ±.0°-15° OVER 120° ±.012	DSN: T. CRUICKSHANK ENGR: F. DAHLGREN SUPV:	DRAWING NO: SE172-203 SHEET 4 OF 4 REV B, 4

NCSX-SE172-203