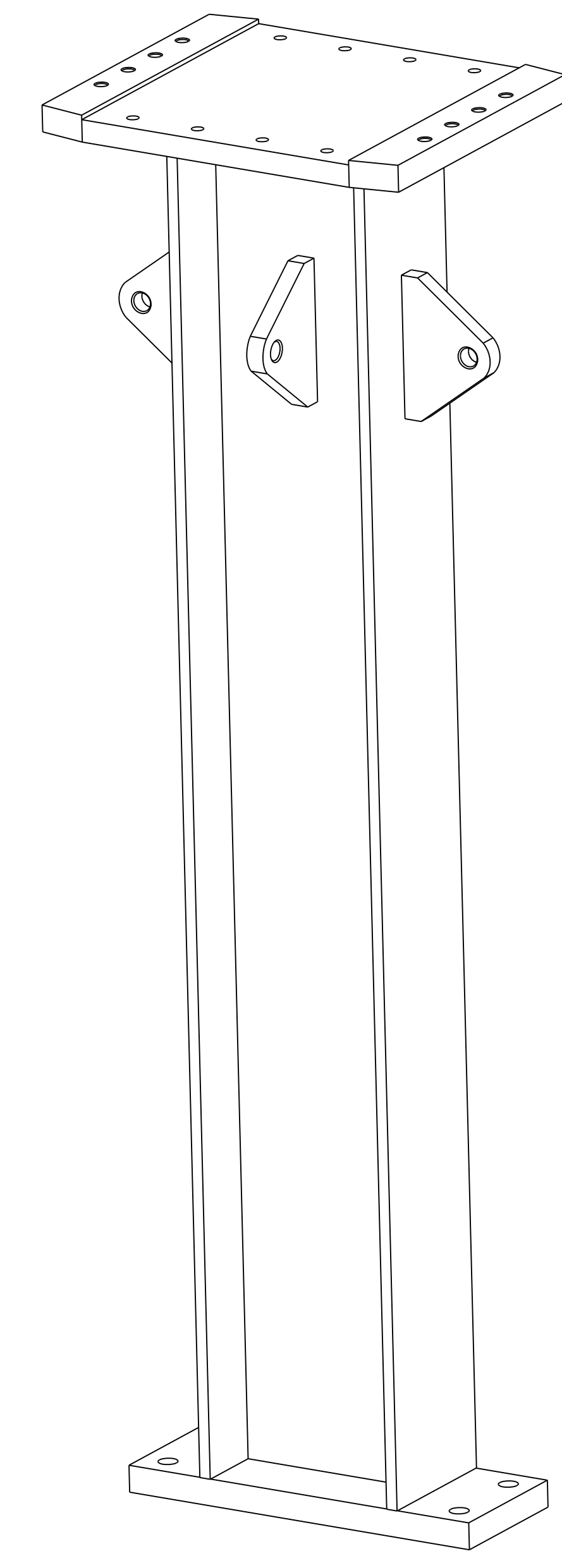
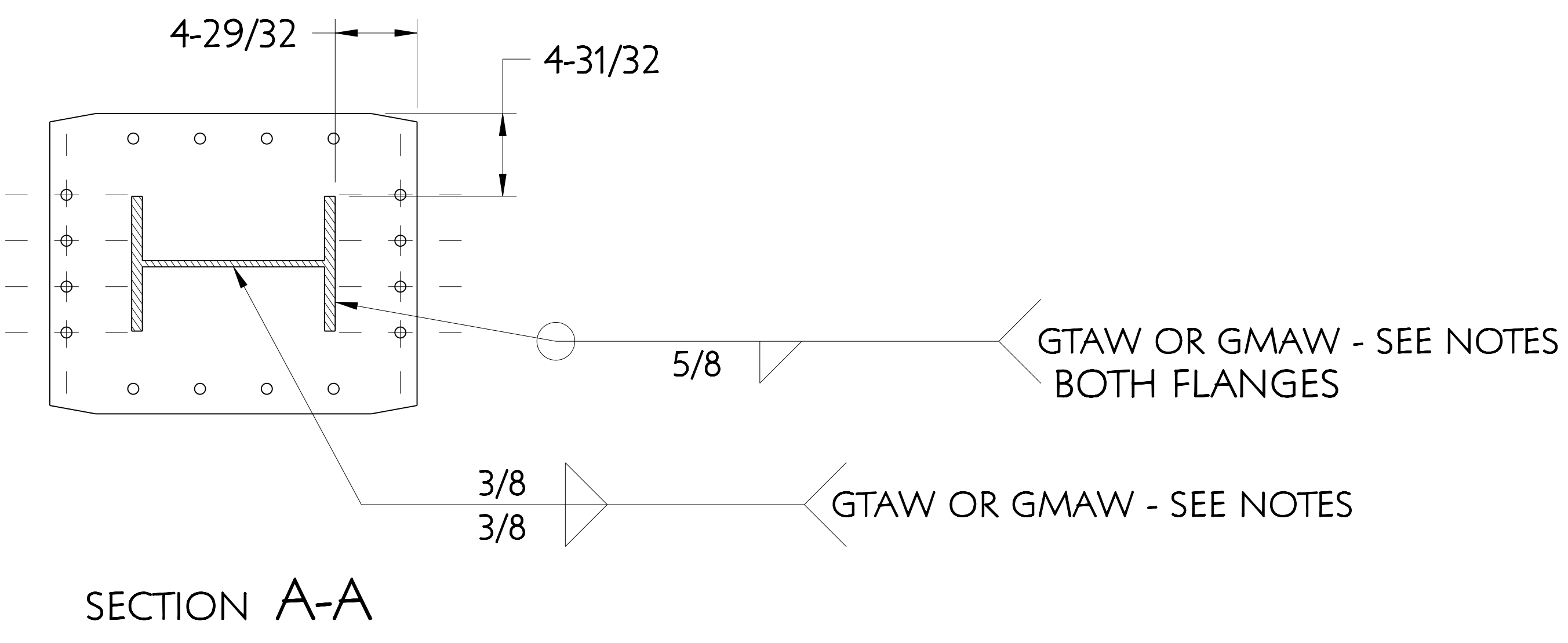
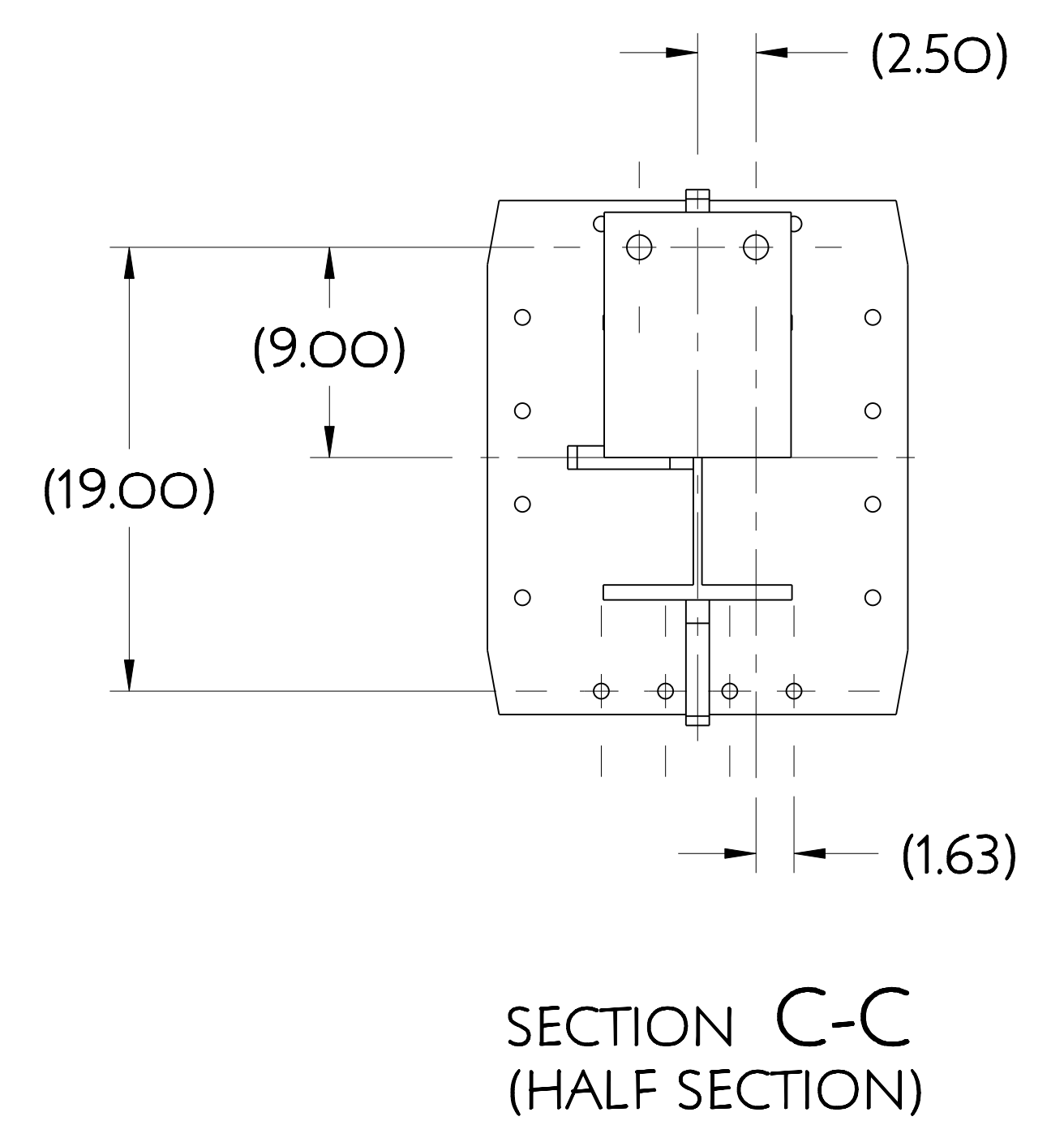
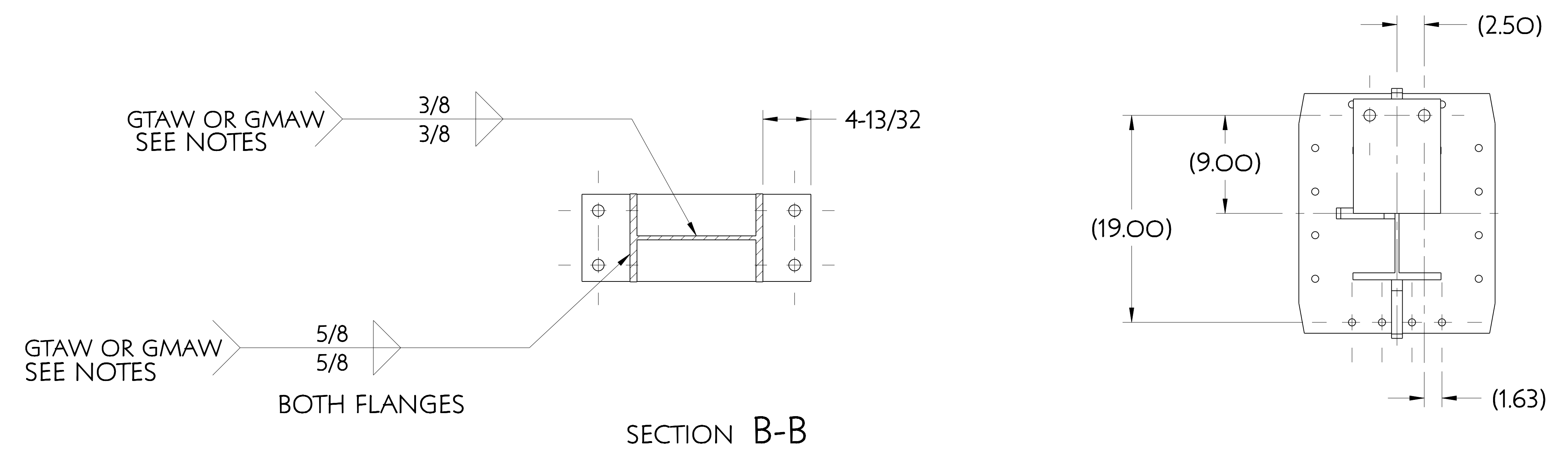
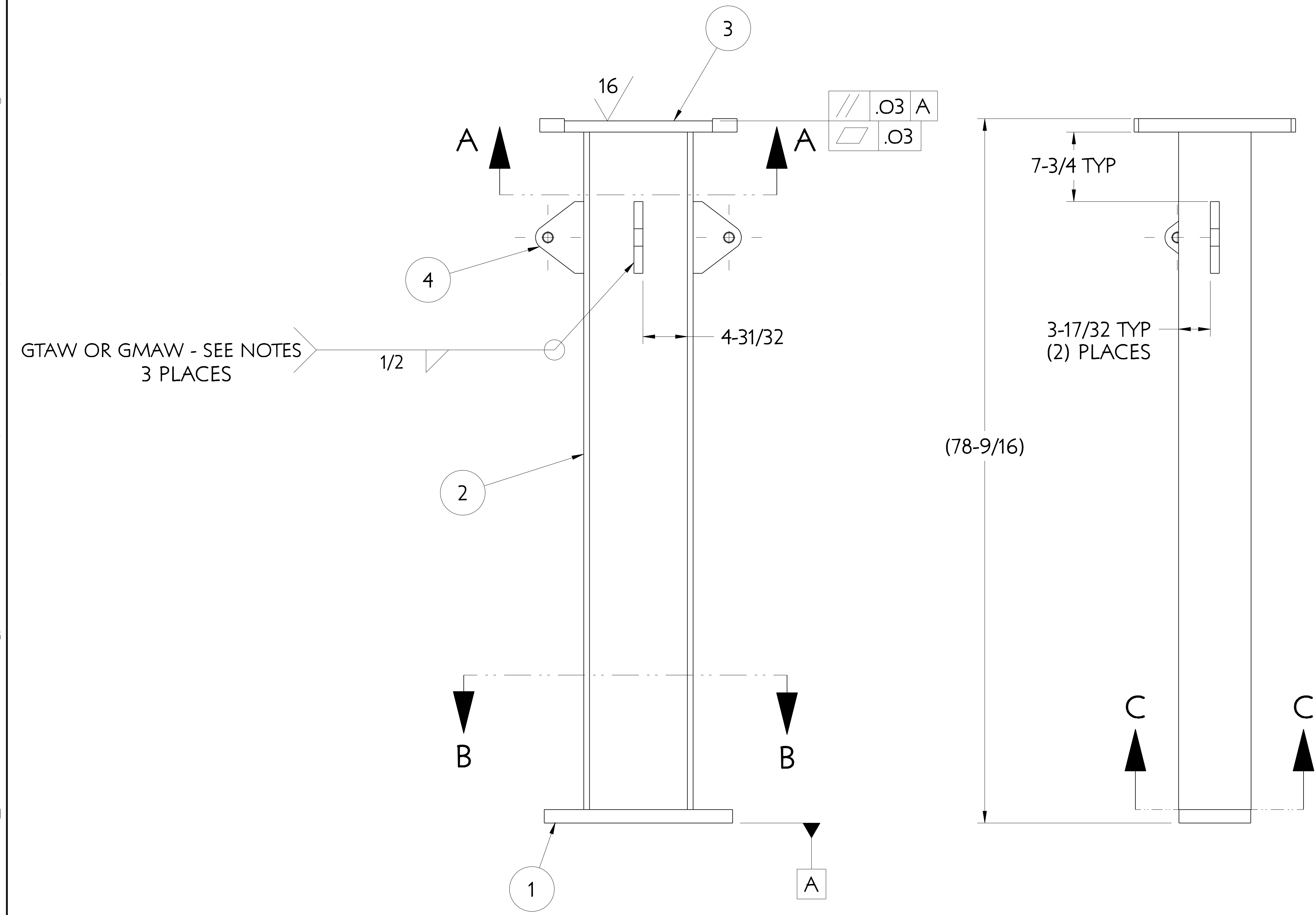


NO.	REVISION	BY	CH	SUP	APPROVED	DATE



- DRAWINGS PREPARED IN ACCORDANCE WITH ASME Y14.100-2000.
- INTERPRET DIMENSIONS AND 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.



3 ASSEMBLIES REQUIRED

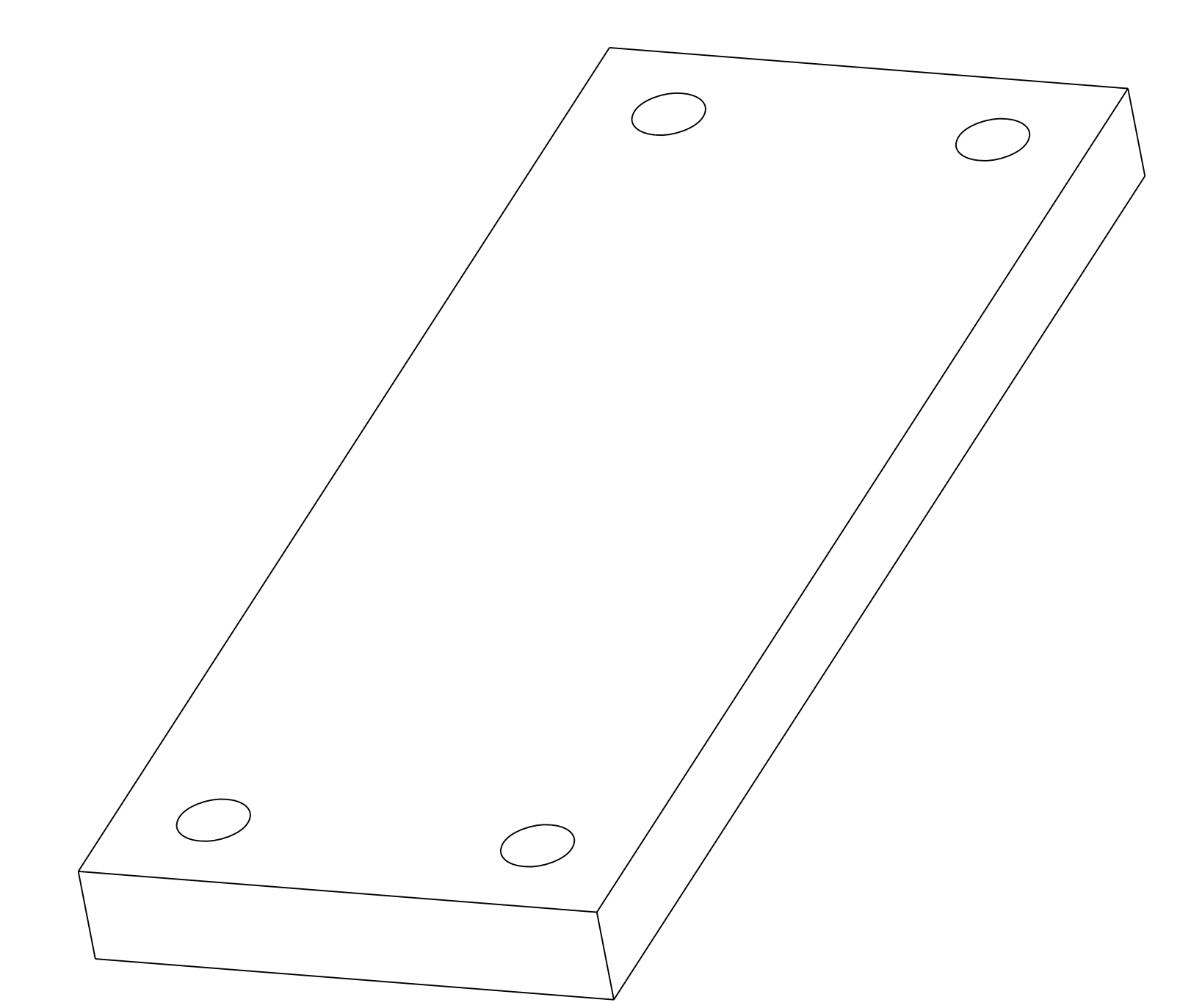
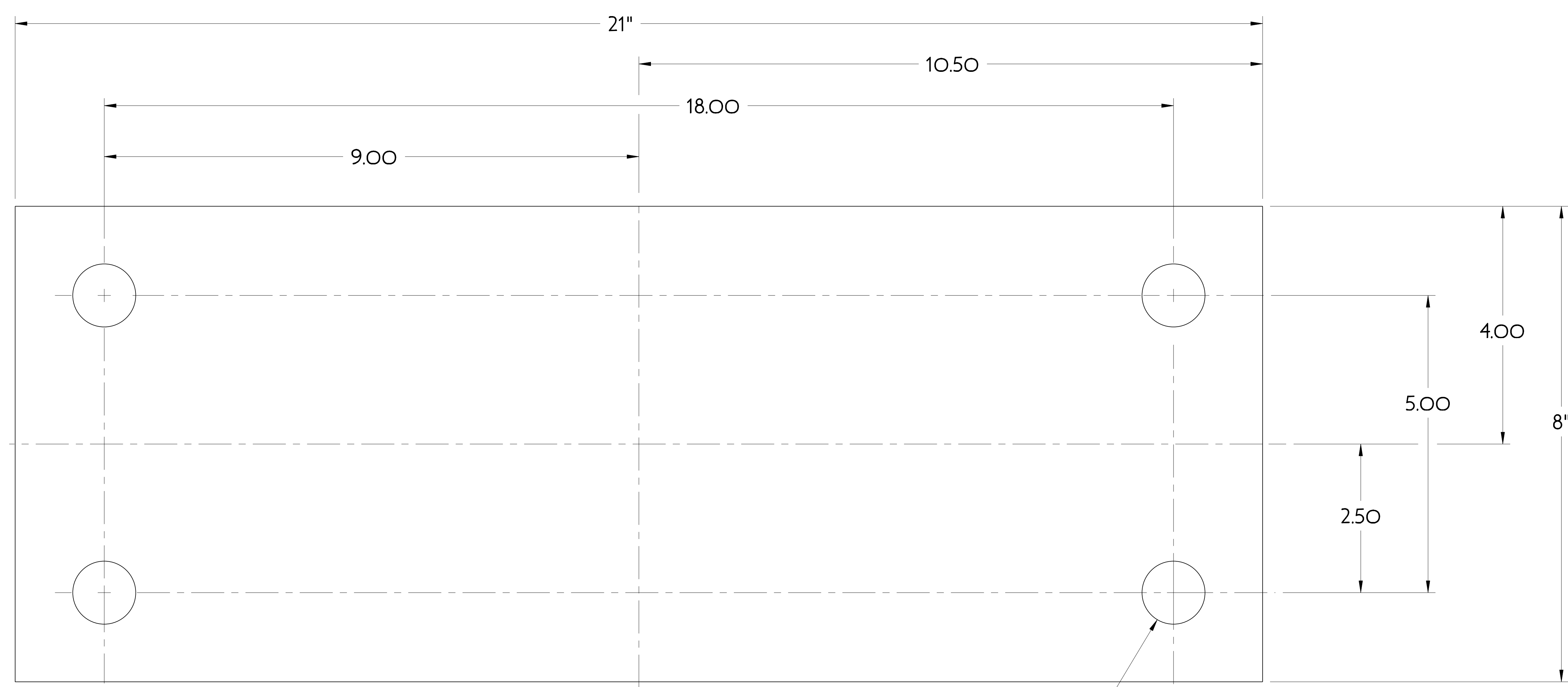
PART NO.	DRAWING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY RECD
4	SE172-203-2	BASE SUPPORT STRUCTURE BRACKET	304L ST STL	3
3	SE172-240-3	SUPPORT COLUMN TOP PLATE	304L ST STL	1
2	SE172-240-2	W12" X 50# OUTER SUPPORT COLUMN	304L ST STL	1
1	SE172-240-1	SUPPORT COLUMN BOTTOM PLATE	304L ST STL	1

PARTS LIST

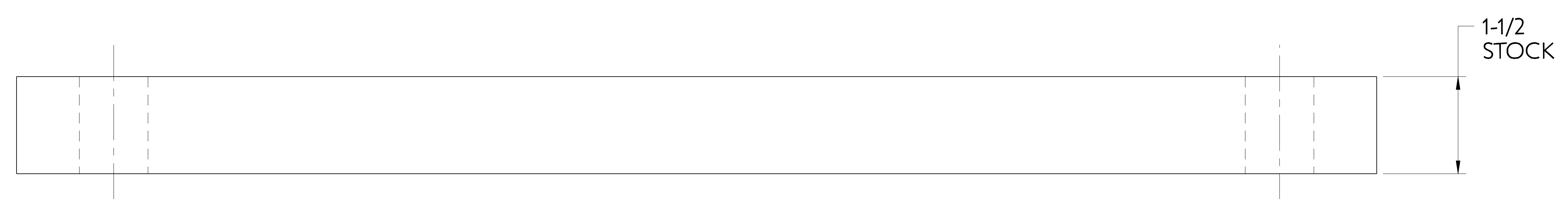
COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED PRO E	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY, TX NATIONAL COMPACT STELLARATOR EXPERIMENT	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	DIMENSIONS ARE IN INCHES MACHINE SURFACES UNLESS OTHERWISE SPECIFIED BREAK SHARP EDGES .005/.020	STELLARATOR CORE BASE SUPPORT STRUCTURE OUTER SUPPORT COLUMN WELDMENT - C TO C JOINT	
NEXT ASSEMBLY	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS XX +/- .100 0°-120° +/- .125 XX +/- .030 12°-12° +/- .110 XXX +/- .005 72°-120° +/- .110 ANGULAR +/- .0°-15° OVER 120° +/- .112	DSN: T. CRUICKSHANK	DRAWING NO: SE172-240
RELEASE LEVEL: WIP DWG VERSION NO: 17	WELDING ENGINEER	ENGR: F. DAHLGREN	SUPV: SHEET 1 OF 4 REV 0

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Ø1.06 THRU
TYP 4 HOLES



1 SUPPORT COLUMN BOTTOM PLATE

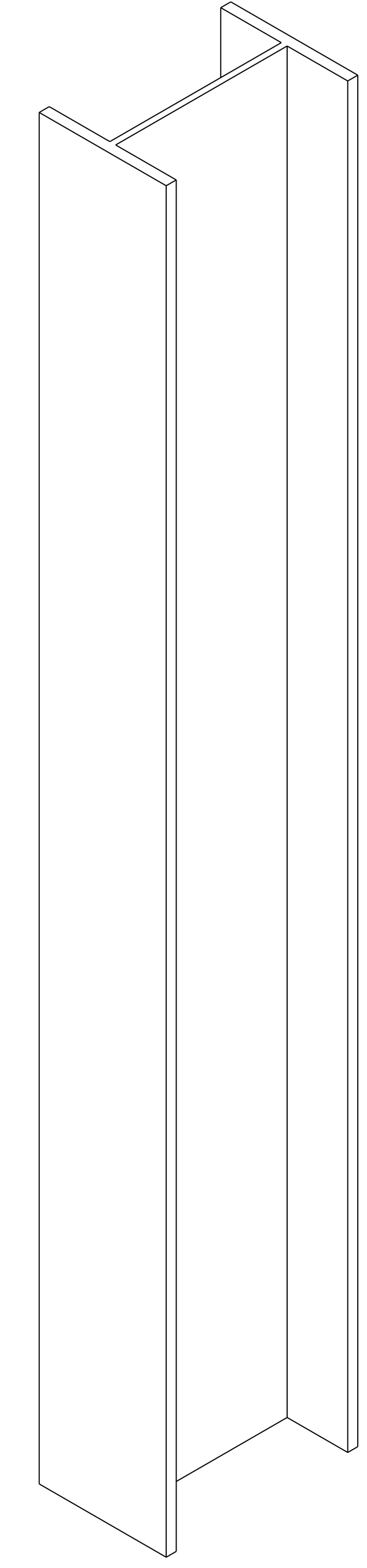
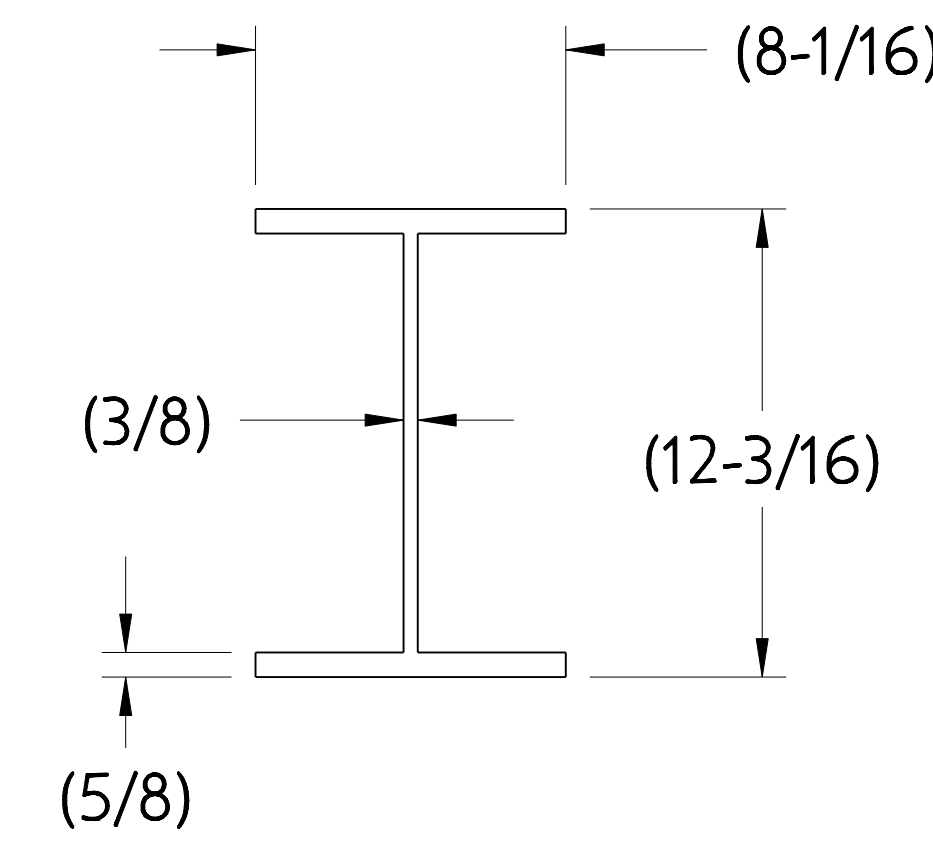
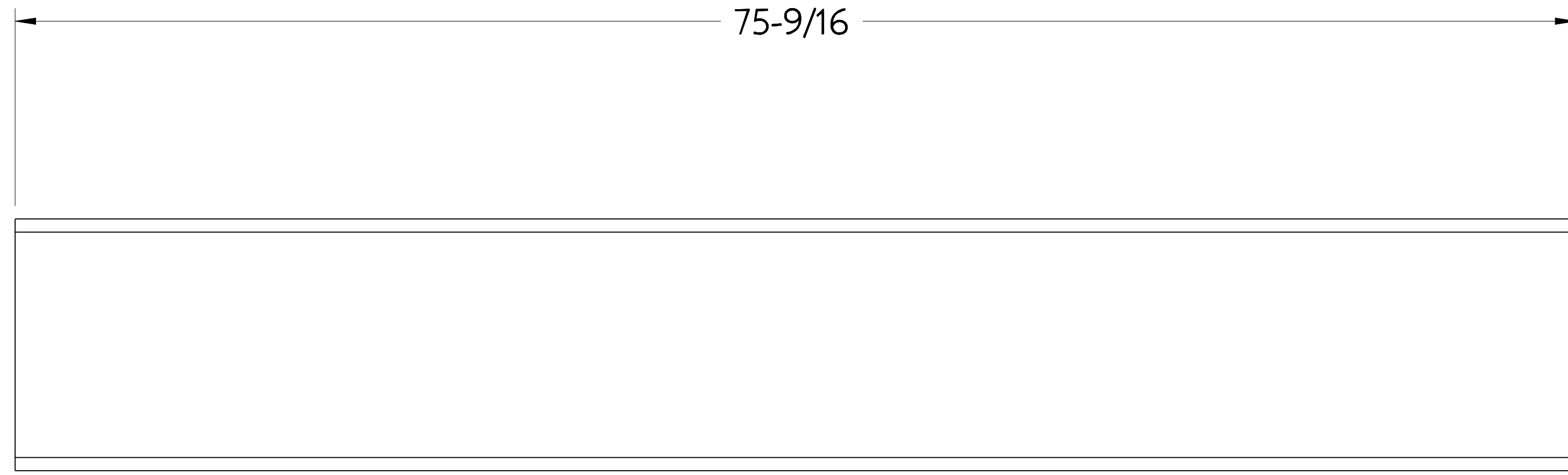
6 REQUIRED

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES:	PRINCETON PLASMA PHYSICS LABORATORY NATIONAL COMPACT STELLARATOR EXPERIMENT	
	UNLESS OTHERWISE SPECIFIED	STELLARATOR CORE BASE SUPPORT STRUCTURE OUTER SUPPORT COLUMN WELDMENT - C TO C JOINT	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	TOLERANCES NON-CUMULATIVE	DSN: T. CRUICKSHANK DRAWING NO: SEI72-240
NEXT ASSEMBLY	DECIMAL-INCH FRACTIONS	CHK: ENGR: F. DAHLGREN	REV 0.6
WEIGHT 71.5 lbs	MODEL NAME SEI72-240-3	WELDING ENGINEER	SHEET 2 OF 4
RELEASE LEVEL: WIP DWG VERSION NO: 6			REV 0.6

NCSX-SEI72-240

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2 W12" x 50# OUTER SUPPORT COLUMN

3 REQUIRED

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

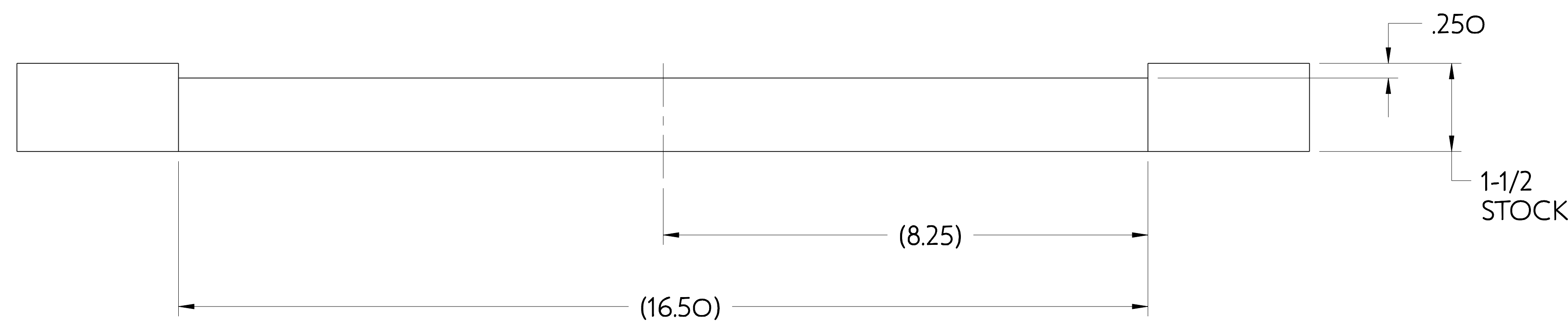
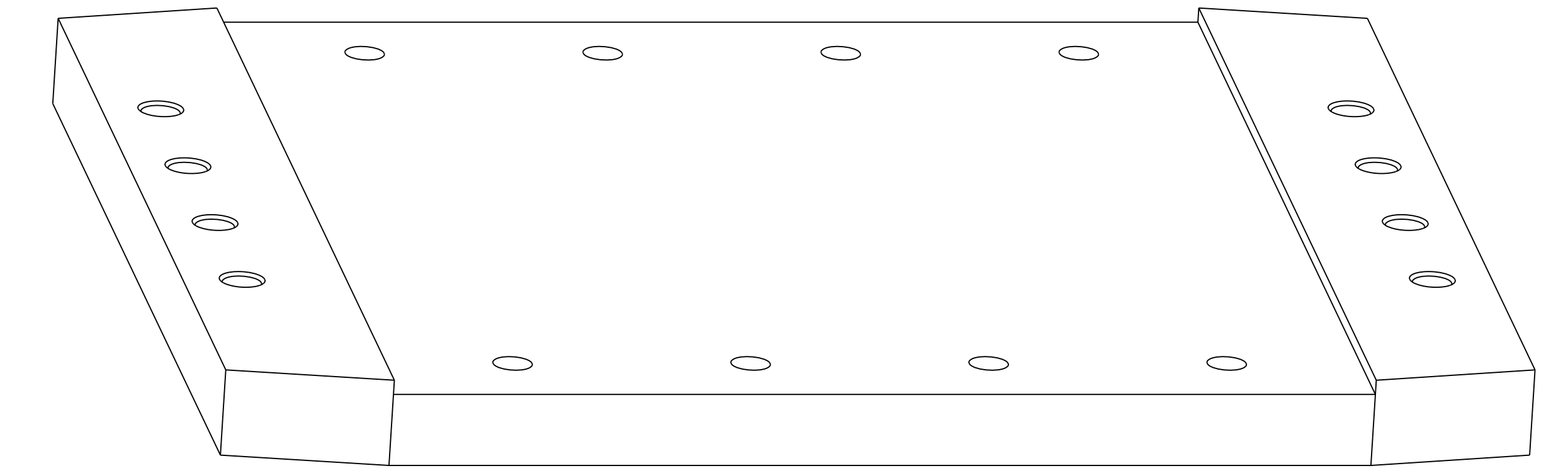
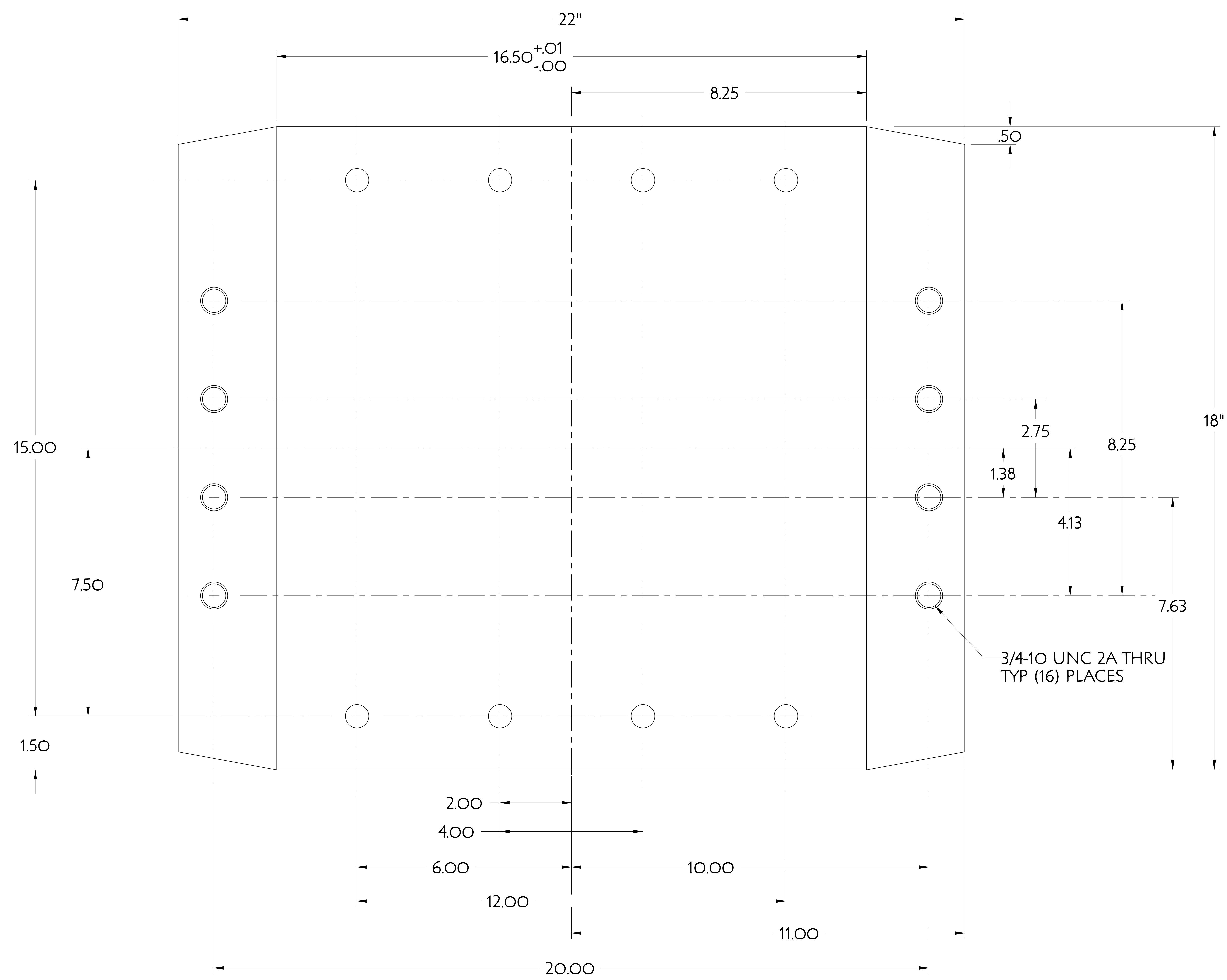
RELEASE LEVEL: WIP
DWG VERSION NO: 6

WEIGHT	315.1 lbs
MODEL NAME	SE172-240-3
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 OUTER SUPPORT COLUMN WELDMENT - C TO C JOINT	
NEXT ASSEMBLY	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .X +/- .000 .XX +/- .005 ANGULAR +/- .05	DSN: T. CRUICKSHANK CHK: ENGR: F. DAHLGREN SUPV:	DRAWING NO: SE172-240
			SHEET 3 OF 4 REV 0.6

NCSX-SE172-240

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6 REQUIRED

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

3 SUPPORT COLUMN TOP PLATE

COMPUTER GENERATED DRAWING CHANGES NOT PERMITTED Pro E DO NOT VERIFY INFORMATION BY SCALING DRAWING	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 OUTER SUPPORT COLUMN WELDMENT - C TO C JOINT
WEIGHT 147.4 lbs	MODEL NAME SEI72-240-3	DSN: T. CRUCKSHANK CHK: F. DAHLGREN ENGR: F. DAHLGREN SUPV: DRAWING NO: SEI72-240
RELEASE LEVEL: WIP DWG VERSION NO: 8	WELDING ENGINEER	SHEET 4 OF 4 REV 0.6

NCSX-SEI72-240