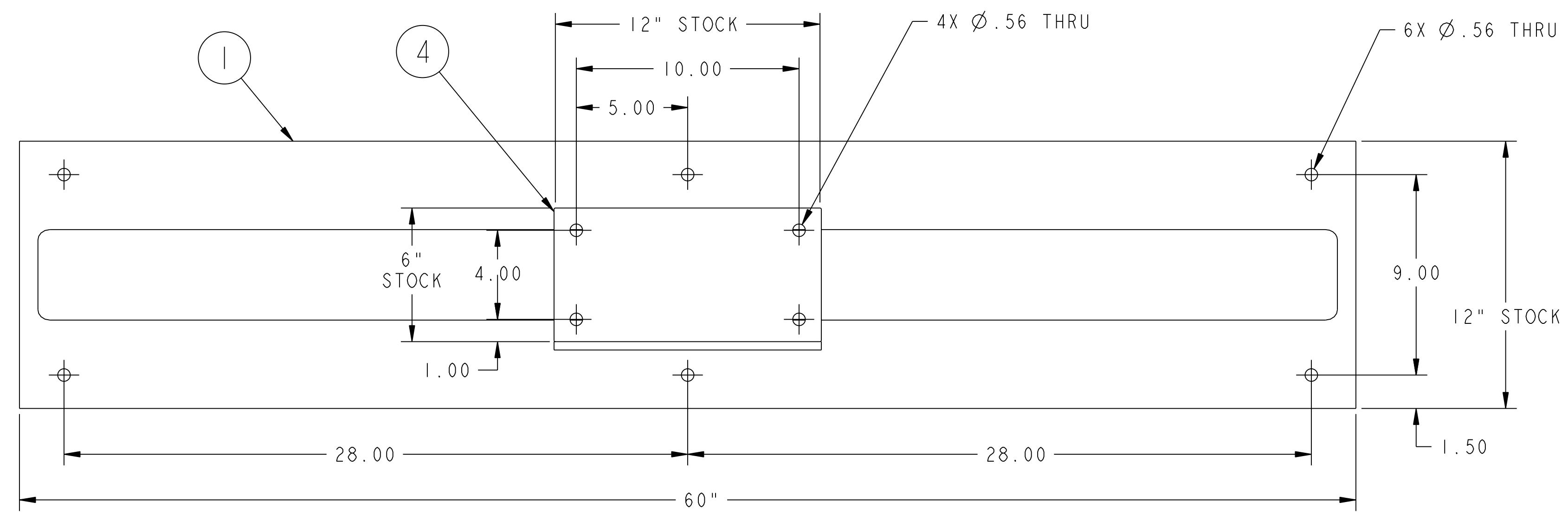
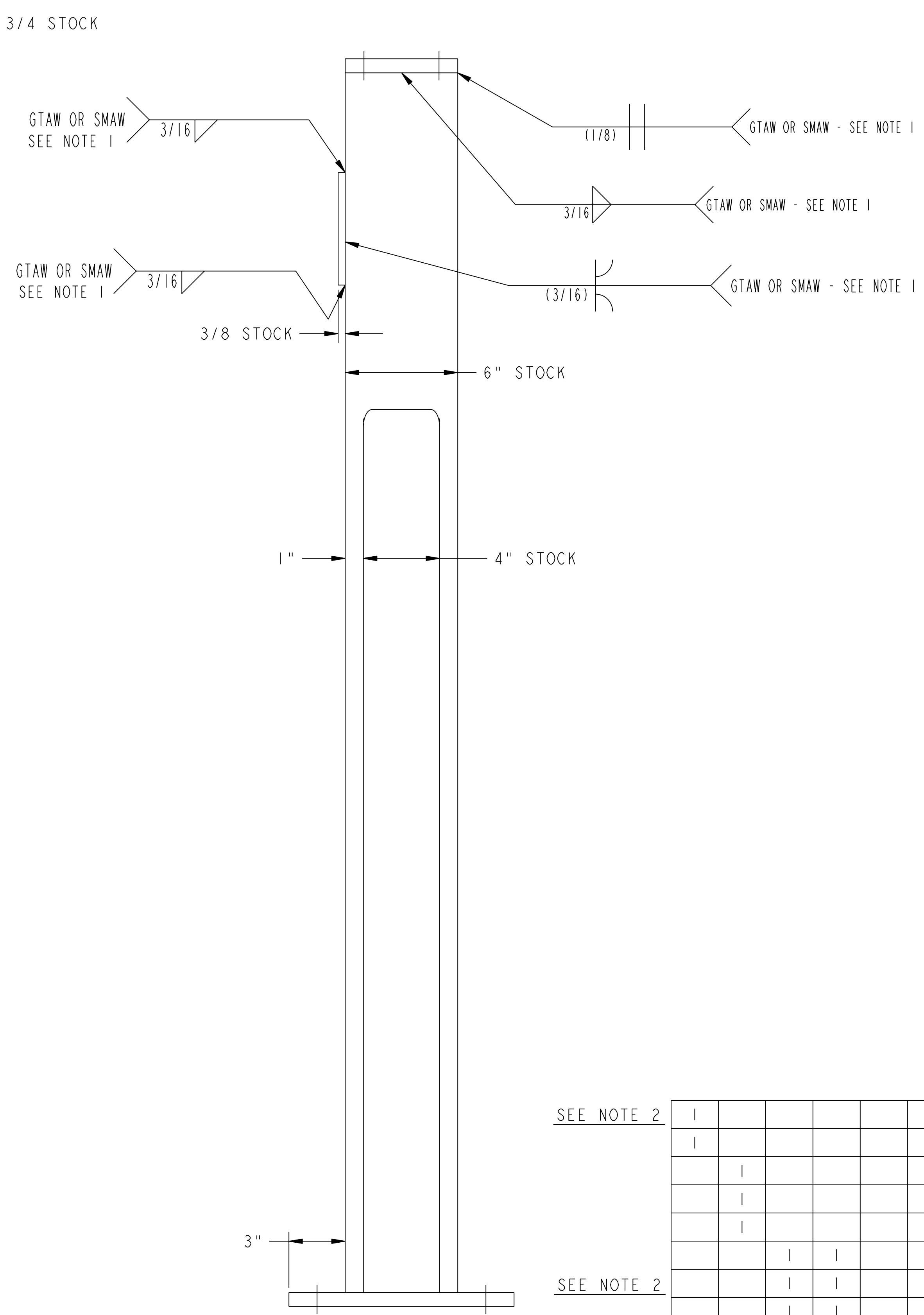
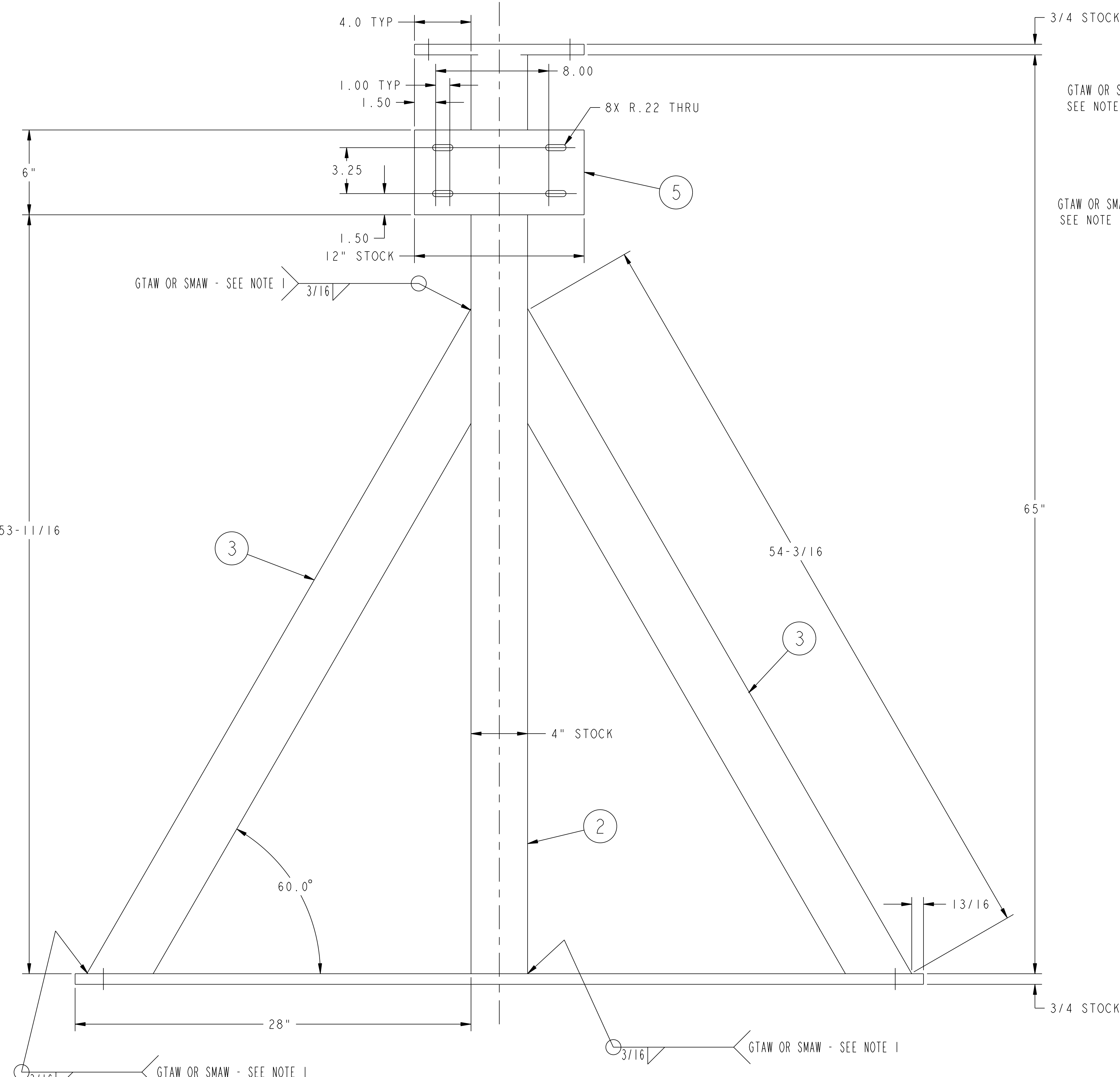


NO.	REVISION	BY	CH	SUP	APPROVED	DATE



**NOTES**

1. WELDS SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF THE APPLICABLE CODE AND PPPL PROCEDURE ENG-037. VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH THE ACCEPTANCE CRITERIA OF AWS D1.1 Section 6 AND AWS D1.3 AS APPLICABLE.
2. ASTM A513 TUBING SHALL BE CARBON STEEL GRADE 1010-1020.



**RELEASED FOR  
FABRICATION / INSTALLATION**  
PPPL Drafting:

SEE NOTE 2	REV	DATE	DESCRIPTION	QTY
15			THIS DWG WORM GEAR AXLE - Ø1 1/2 O.D. TUBE x 5/16 WALL	ASTM A513
14			THIS DWG WORM GEAR AXLE BASE FLANGE	ASTM A36
13			THIS DWG SUPPORT BRACKET GUSSET	ASTM A36
12			THIS DWG SUPPORT BRACKET TOP PLATE	ASTM A36
11			THIS DWG SUPPORT BRACKET SIDE PLATE	ASTM A36
10			THIS DWG SUPPORT AXLE CAP	ASTM A36
9			THIS DWG SUPPORT AXLE - Ø5.50 O.D. TUBE x .1/2 WALL	ASTM A513
8			THIS DWG SUPPORT AXLE BASE FLANGE	ASTM A36
7			THIS DWG OUTRIGGER BASE PLATE	ASTM A36
6			THIS DWG OUTRIGGER - 4" x 4" x 1/4" STRUCT TUBING	ASTM A36
5			THIS DWG WORM SUPPORT BRACKET MOUNTING PLATE	ASTM A36
4			THIS DWG SUPPORT STAND TOP PLATE	ASTM A36
3			THIS DWG SUPPORT STAND BRACE - 4" x 4" x 1/4" STRUCT TUBING	ASTM A36
2			THIS DWG SUPPORT STAND UPRIGHT - 6" x 4" x 1/4" STRUCT TUBING	ASTM A36
1			THIS DWG SUPPORT STAND BASE PLATE	ASTM A36
			THIS DWG WORM GEAR AXLE WELDMNT	---
			THIS DWG WORM SUPPORT BRACKET WELDMNT	---
			THIS DWG SUPPORT AXLE WELDMNT - TYPE "B"	---
			THIS DWG SUPPORT AXLE WELDMNT - TYPE "A"	---
			THIS DWG SUPPORT STAND WELDMNT - WITH OUTRIGGER	---
			THIS DWG SUPPORT STAND WELDMNT - WITH BRACKET	---

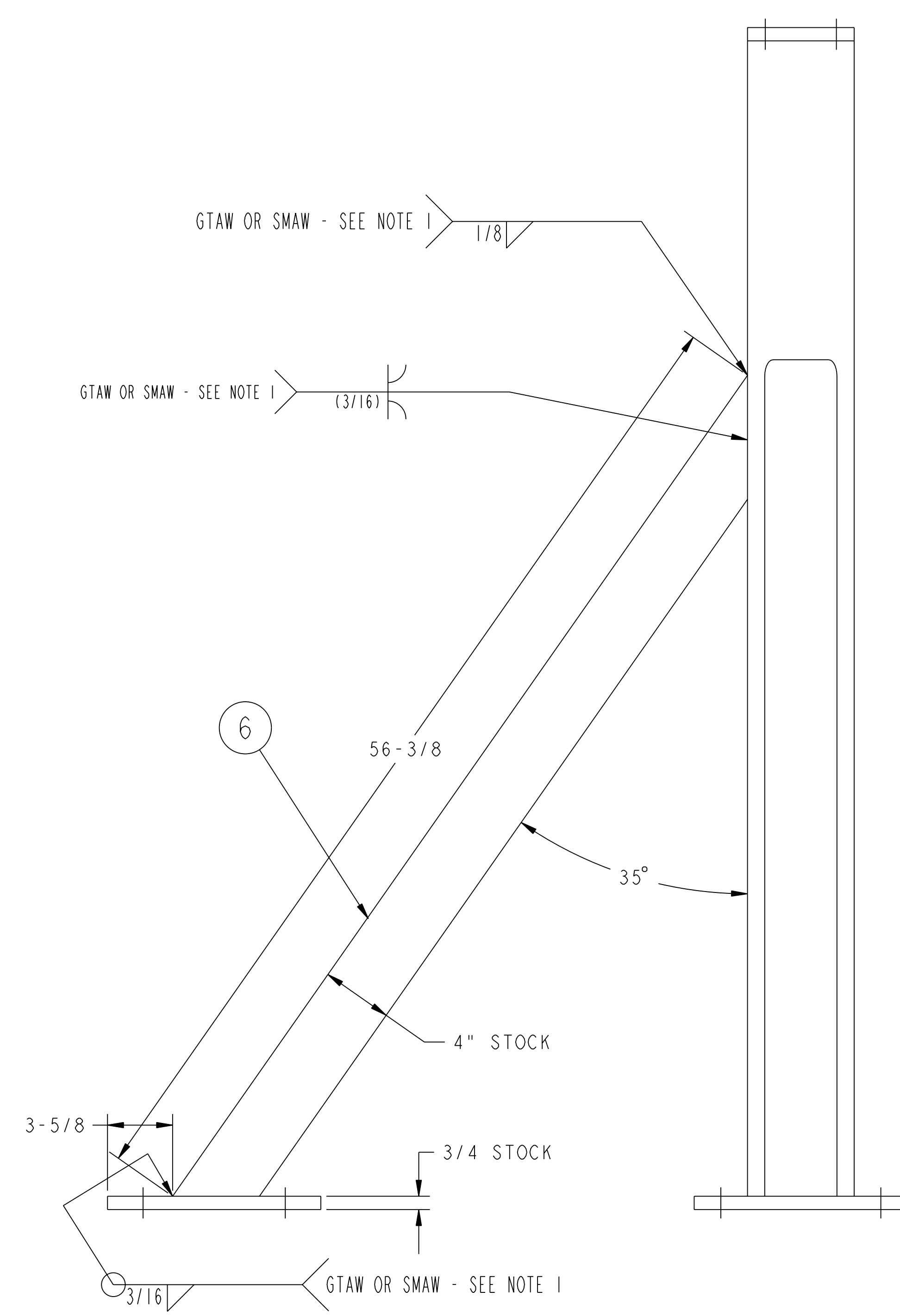
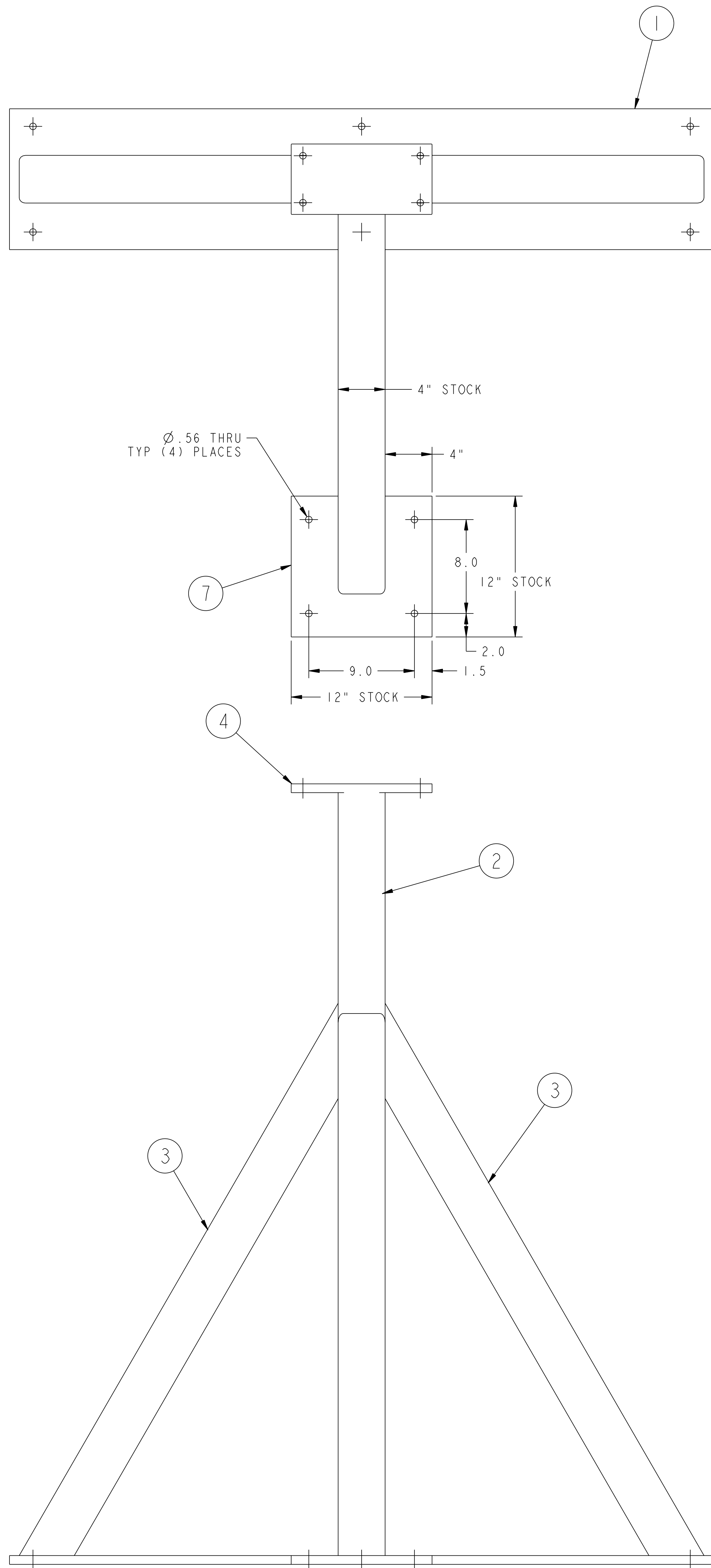
01 ASSEMBLY SUPPORT STAND WELDMNT - WITH BRACKET

**RELEASE LEVEL: Fabrication**  
**DWG VERSION NO: 6**

WEIGHT 295.2 lbs	COMPUTER GENERATED DRAWING CHANGES NOT PERMITTED Pro E	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY
MODEL NAME SEE 1884-0002-002	DO NOT VERIFY INFORMATION BY SCALING DRAWING	DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	<b>NATIONAL COMPACT STELLARATOR EXPERIMENT</b>
WELDING ENGINEER R. KEILBACH 9-28-05	NEXT ASSEMBLY	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX ±.000 .XXX ±.005 ANGULAR ±.0°-15'	EXTERNAL FLUX LOOPS VACUUM VESSEL SUPPORT STAND FIXTURE ASSEMBLY WELDMENTS AND DETAILS
		DSN: L. MORRIS 9-28-05 CHK: T. BROWN 9-28-05 ENGR: T. BROWN 9-28-05 SUPV: J. SIEGEL 9-28-05	DRAWING NO: <b>SE184-002</b> SHEET 1 OF 3 REV 0

NCSX-SE184-002

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



02 ASSEMBLY SUPPORT STAND WELDMENT - WITH OUTRIGGER  
REFER TO 01 ASSEMBLY FOR DIMENSIONS AND WELDMARKS NOT SHOWN HERE

**RELEASED FOR  
FABRICATION / INSTALLATION**  
PPPL Drafting:

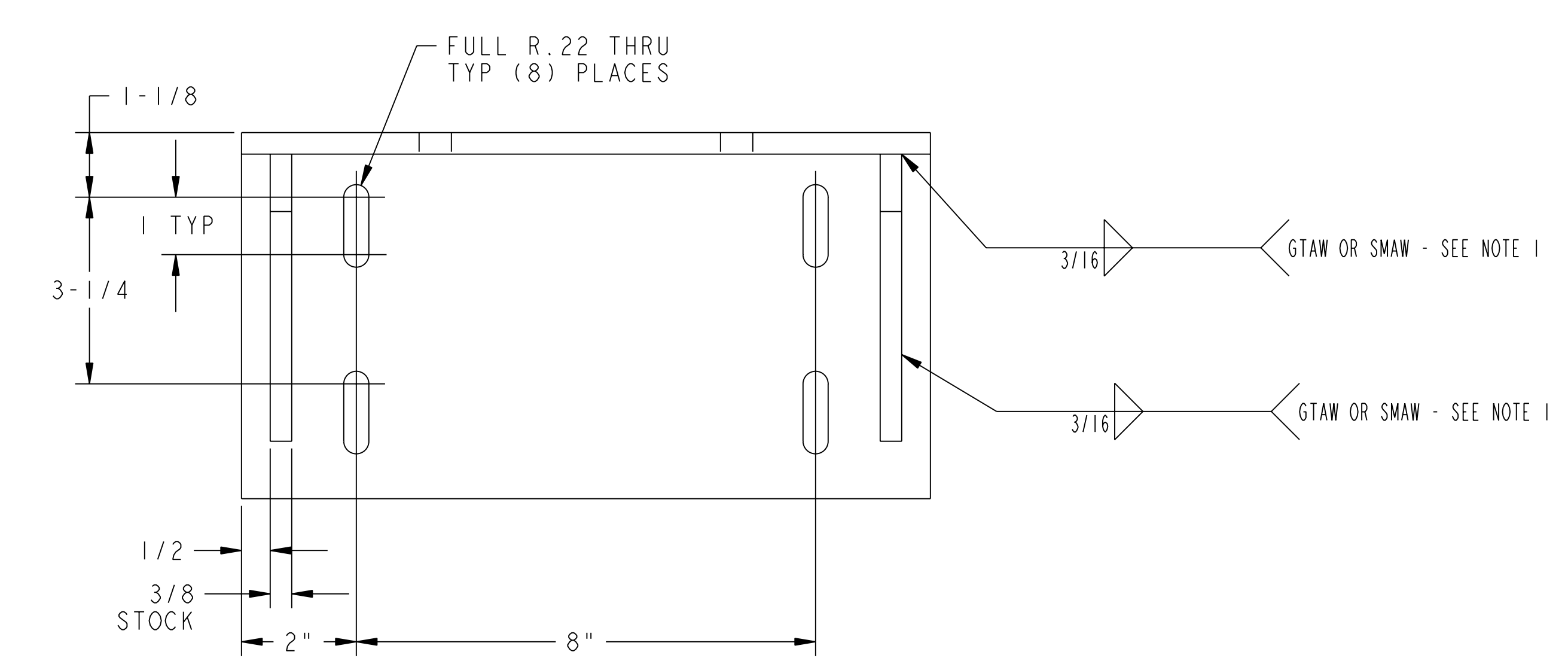
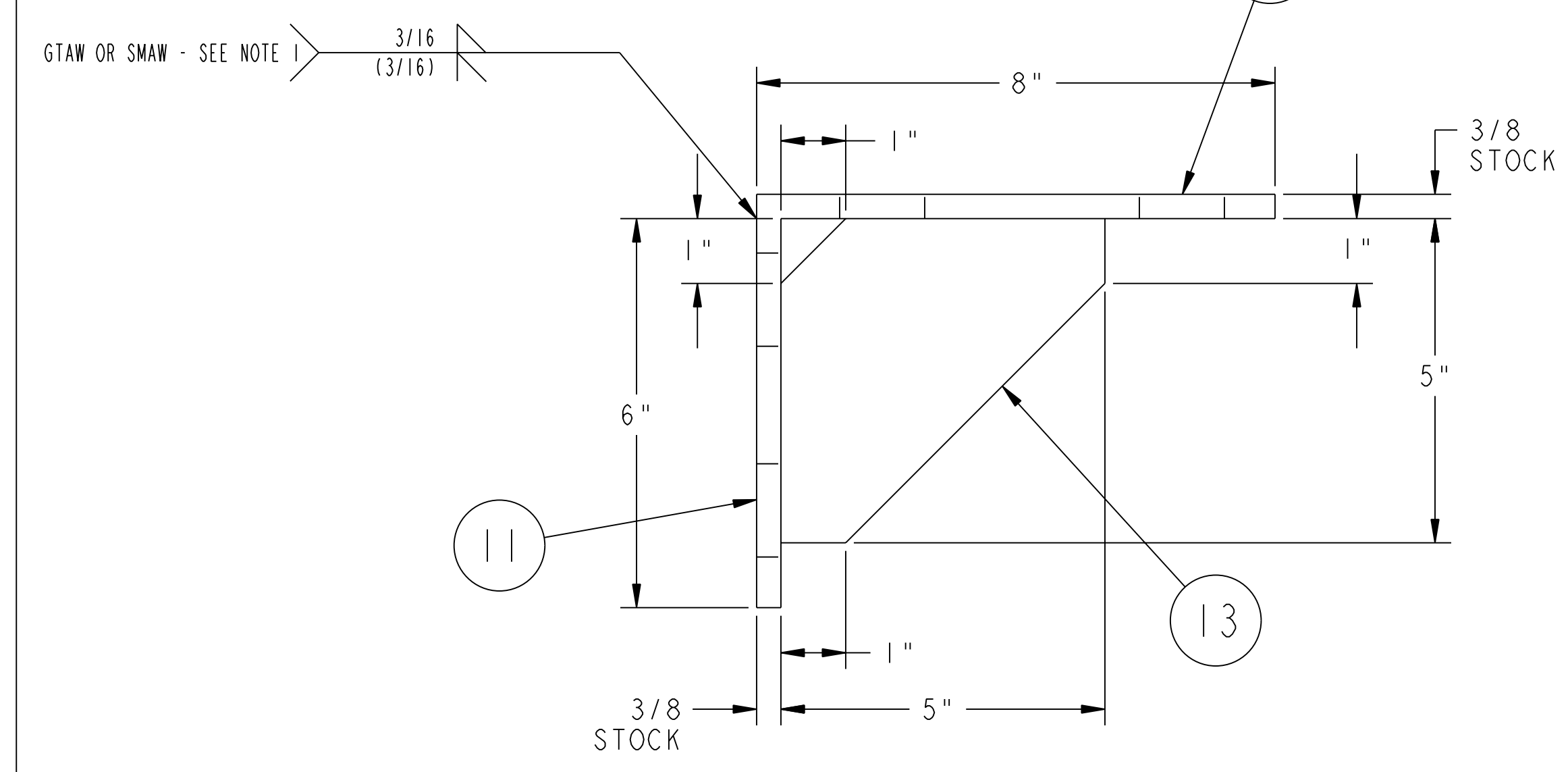
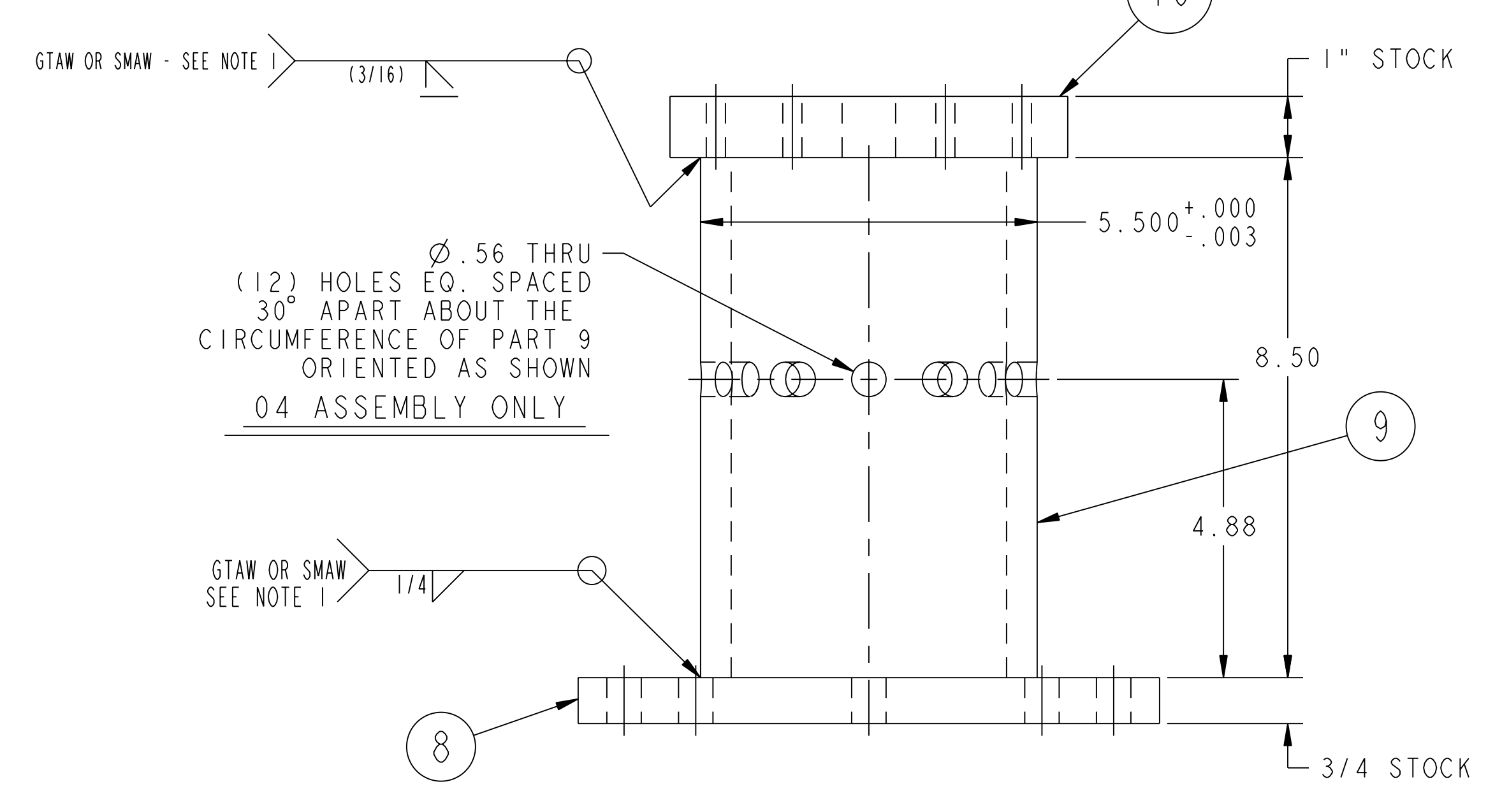
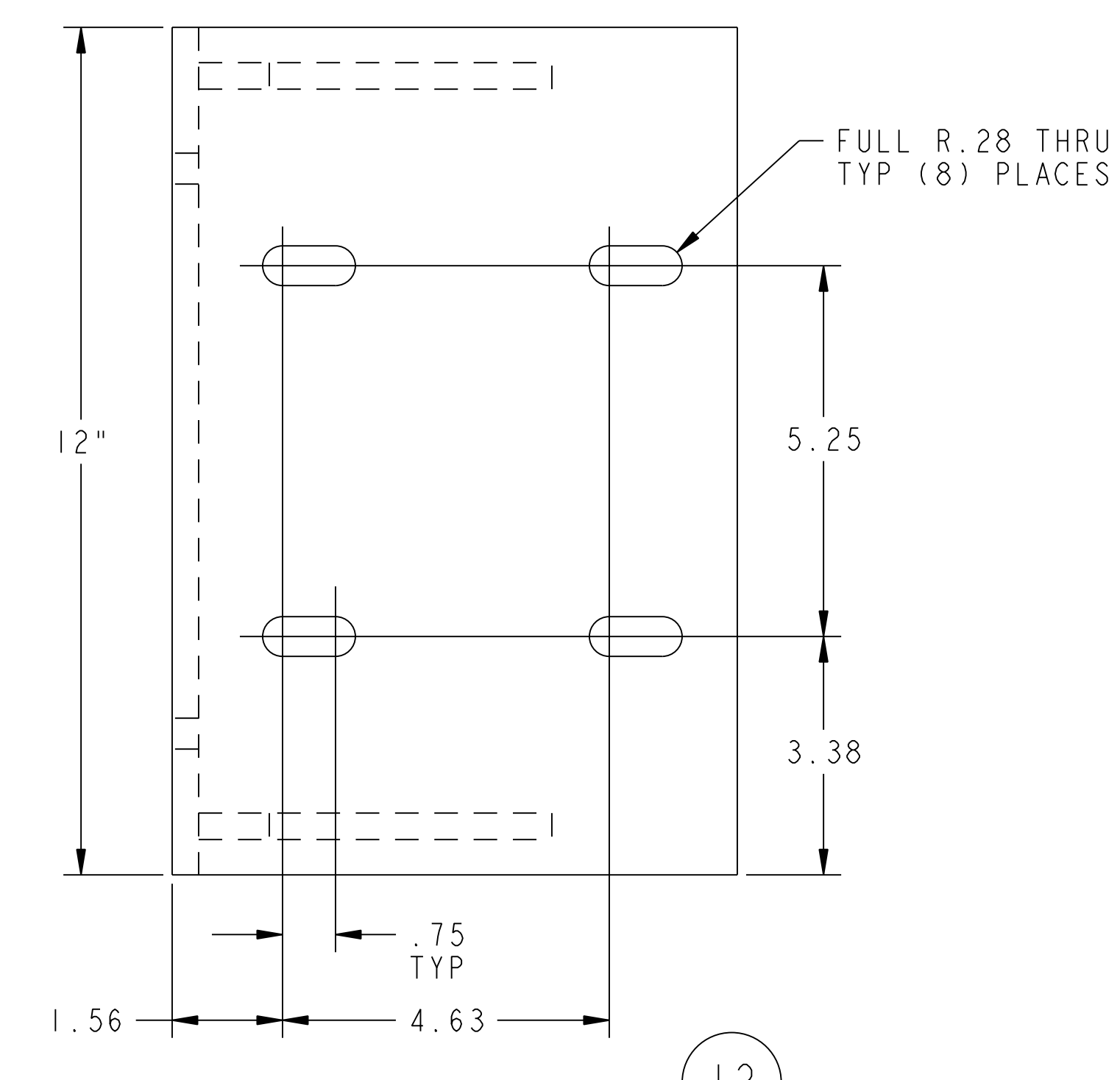
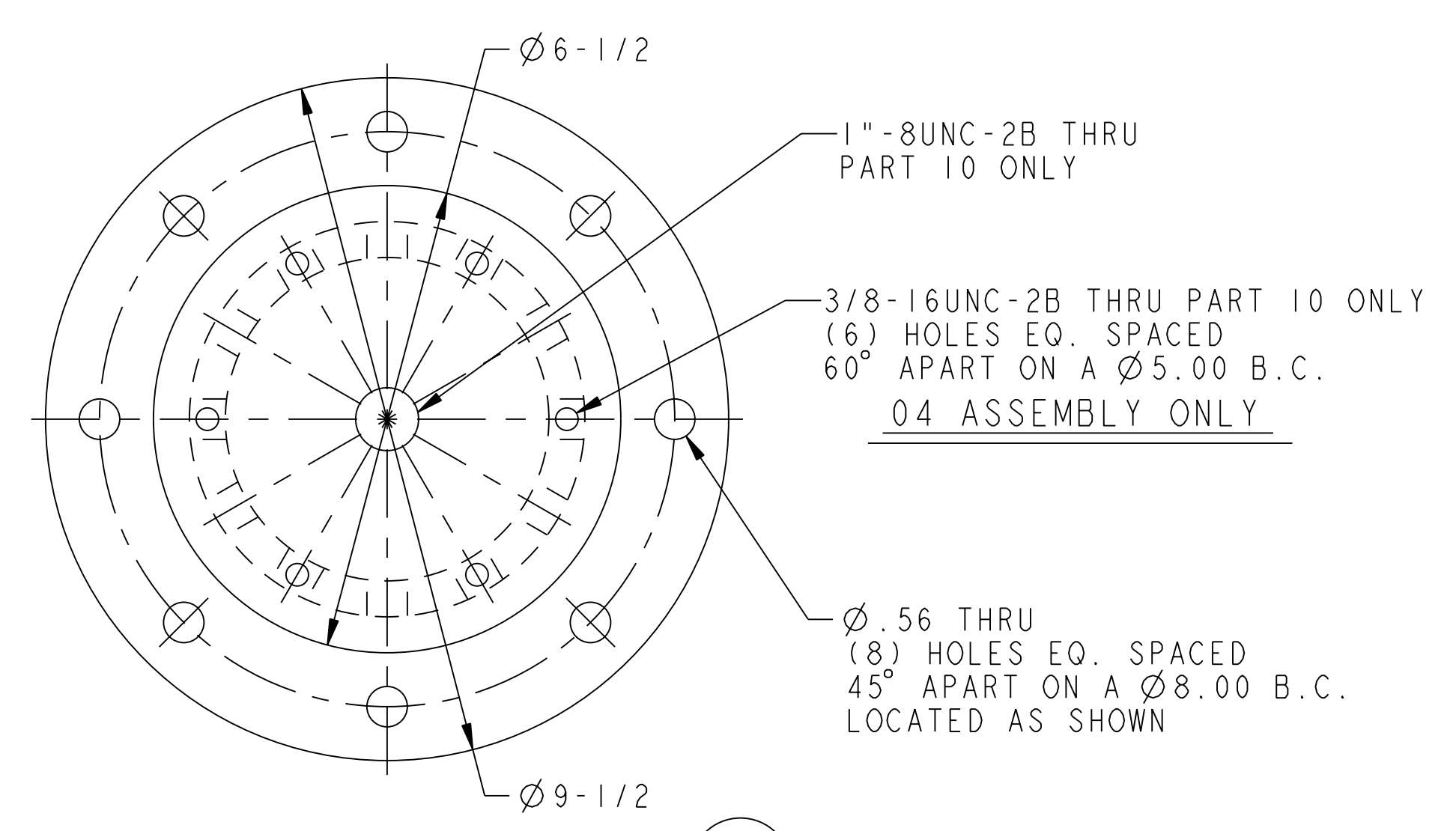
FOR BILL OF MATERIAL AND NOTES SEE SHEET 1

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES:	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY			
	UNLESS OTHERWISE SPECIFIED	<b>NATIONAL COMPACT STELLARATOR EXPERIMENT</b>			
DO NOT VERIFY INFORMATION BY SCALING DRAWING	DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	EXTERNAL FLUX LOOPS VACUUM VESSEL SUPPORT STAND FIXTURE ASSEMBLY WELDMENTS AND DETAILS			
NEXT ASSEMBLY	TOLERANCES NON-CUMULATIVE	DSN: L. MORRIS	9-28-05	DRAWING NO:	
	DECIMAL-INCH FRACTIONS	CHK: T. BROWN	9-28-05	<b>SE184-002</b>	
	.XX +/- .000 0°-12° +/- .010 .XX +/- .005 12°-120° +/- .010 ANGULAR +/- 0°-15° OVER 120° +/- .100	ENGR: T. BROWN	9-28-05		
WEIGHT 333.0 lbs	MODEL NAME SE184-002-09	SUPV: J. SIEGEL	9-28-05	SHEET 2 OF 3	REV 0
WELDING ENGINEER R. KEILBACH 9-28-05	RELEASE LEVEL: Fabrication DWG VERSION NO: 6				

NCSX-SE184-002

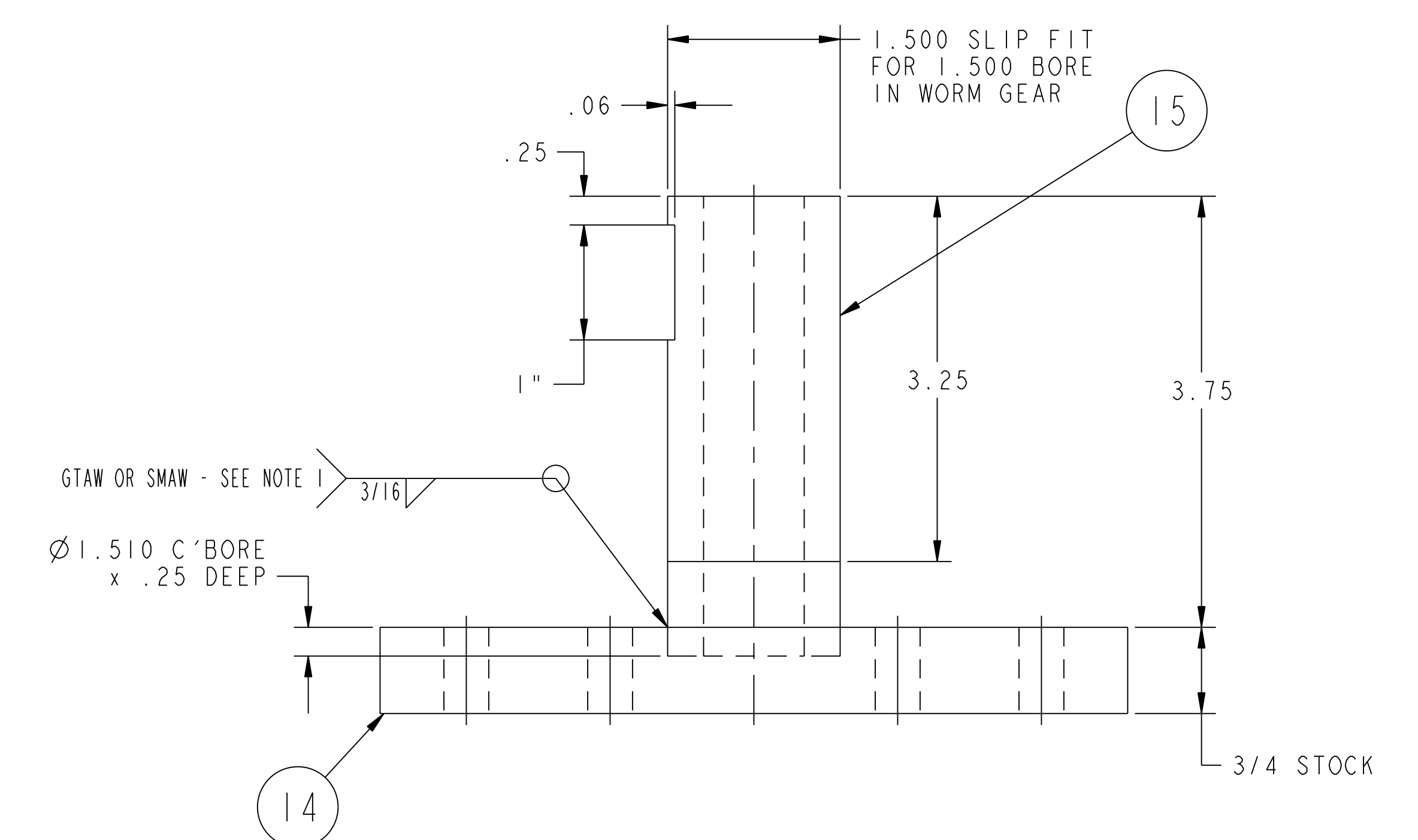
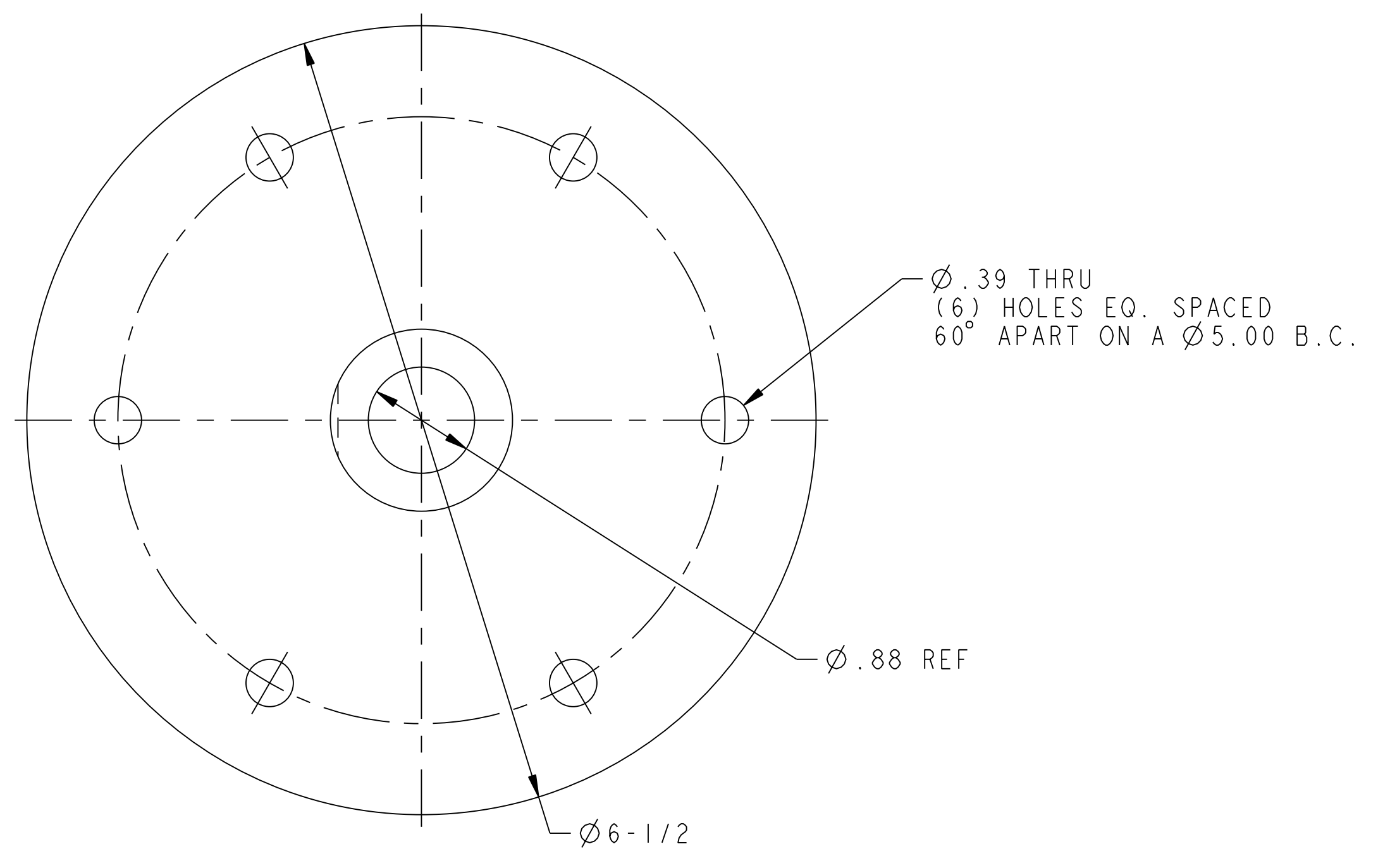


NO.	REVISION	BY	CH	SUP	APPROVED	DATE
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03 ASSEMBLY SUPPORT AXLE WELDMENT - TYPE "A"  
 04 ASSEMBLY SUPPORT AXLE WELDMENT - TYPE "B"

05 ASSEMBLY WORM SUPPORT BRACKET WELDMENT



06 ASSEMBLY WORM GEAR AXLE WELDMENT

**RELEASED FOR FABRICATION / INSTALLATION**  
 PPPL Drafting:

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

RELEASE LEVEL: Fabrication  
 DWG VERSION NO: 6

WEIGHT	*** lbs
MODEL NAME	SE184-002-02
WELDING ENGINEER	R. KEILBACH 9-28-05

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 <b>NATIONAL COMPACT STELLATOR EXPERIMENT</b> EXTERNAL FLUX LOOPS VACUUM VESSEL SUPPORT STAND FIXTURE ASSEMBLY WELDMENTS AND DETAILS
DO NOT VERIFY INFORMATION BY SCALING DRAWING	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX $\pm .000$ 0°-120° $\pm .000$ .XX $\pm .005$ 120°-120° $\pm .005$ ANGULAR $\pm .05$ OVER 120° $\pm .125$	DSN: L. MORRIS 9-28-05 DRAWING NO: CHK: T. BROWN 9-28-05 ENGR: T. BROWN 9-28-05 SUPV: J. SIEGEL 9-28-05
NEXT ASSEMBLY		9-28-05 9-28-05 9-28-05
		SHEET 3 OF 3 REV 0