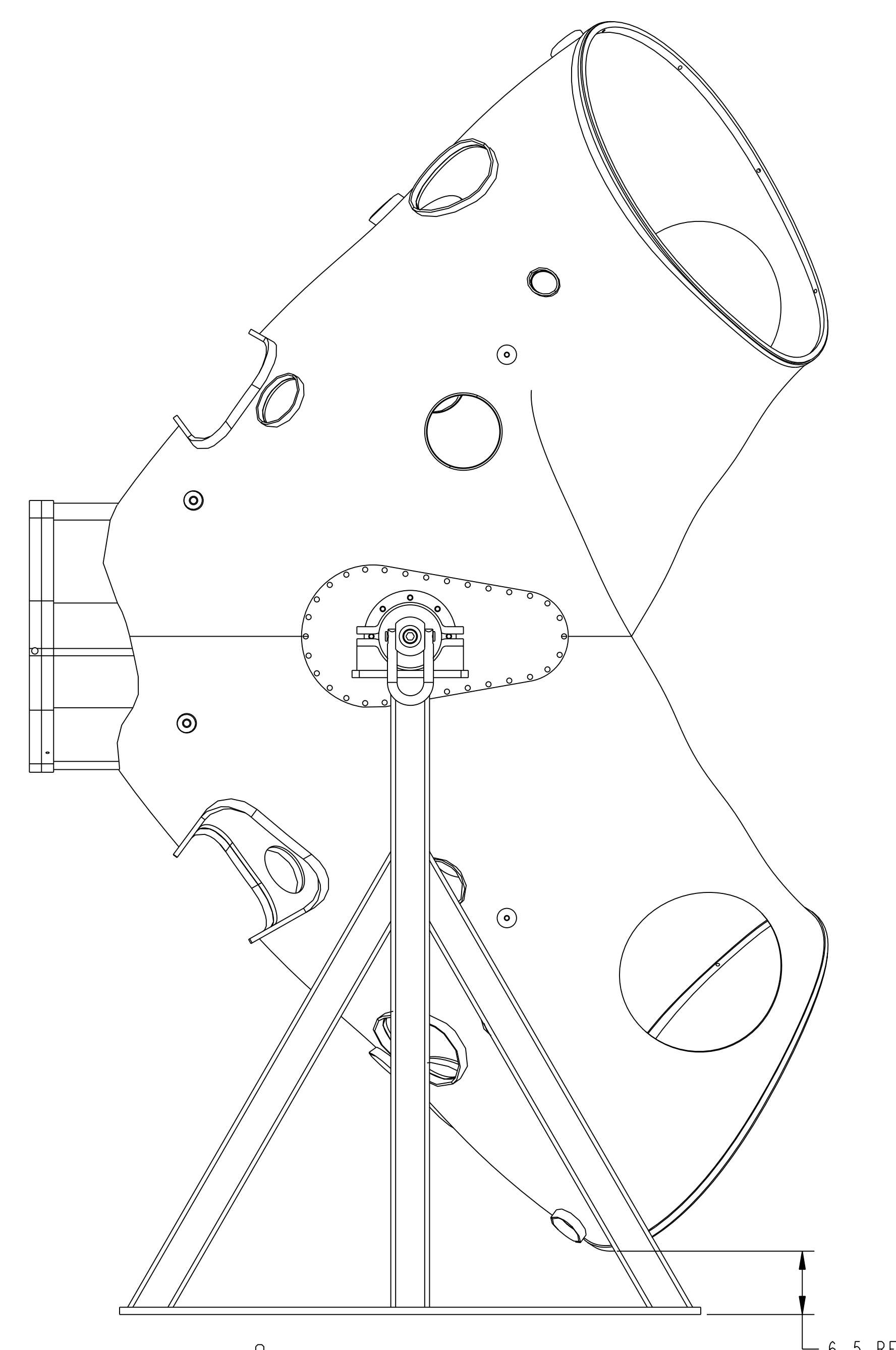
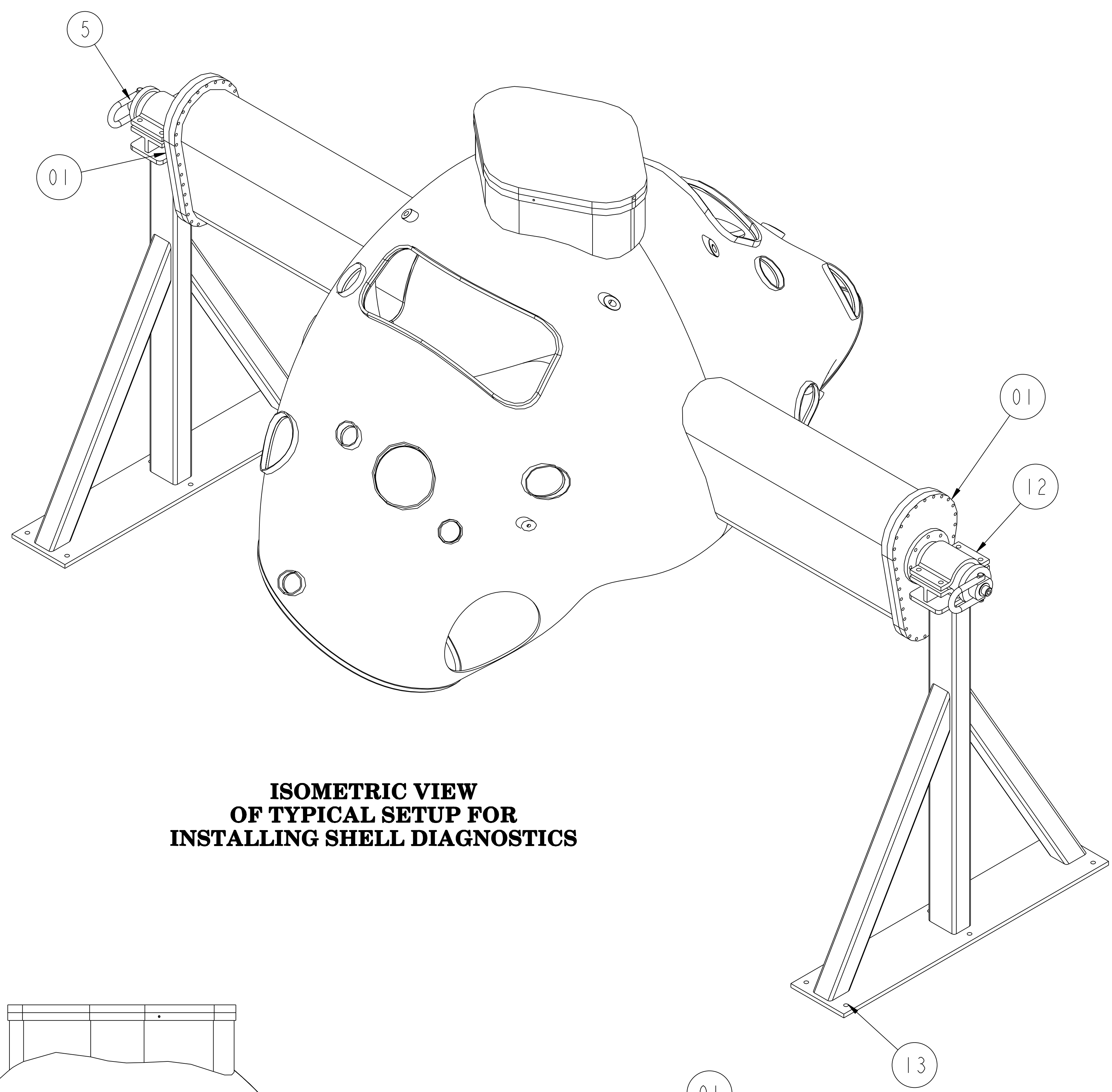


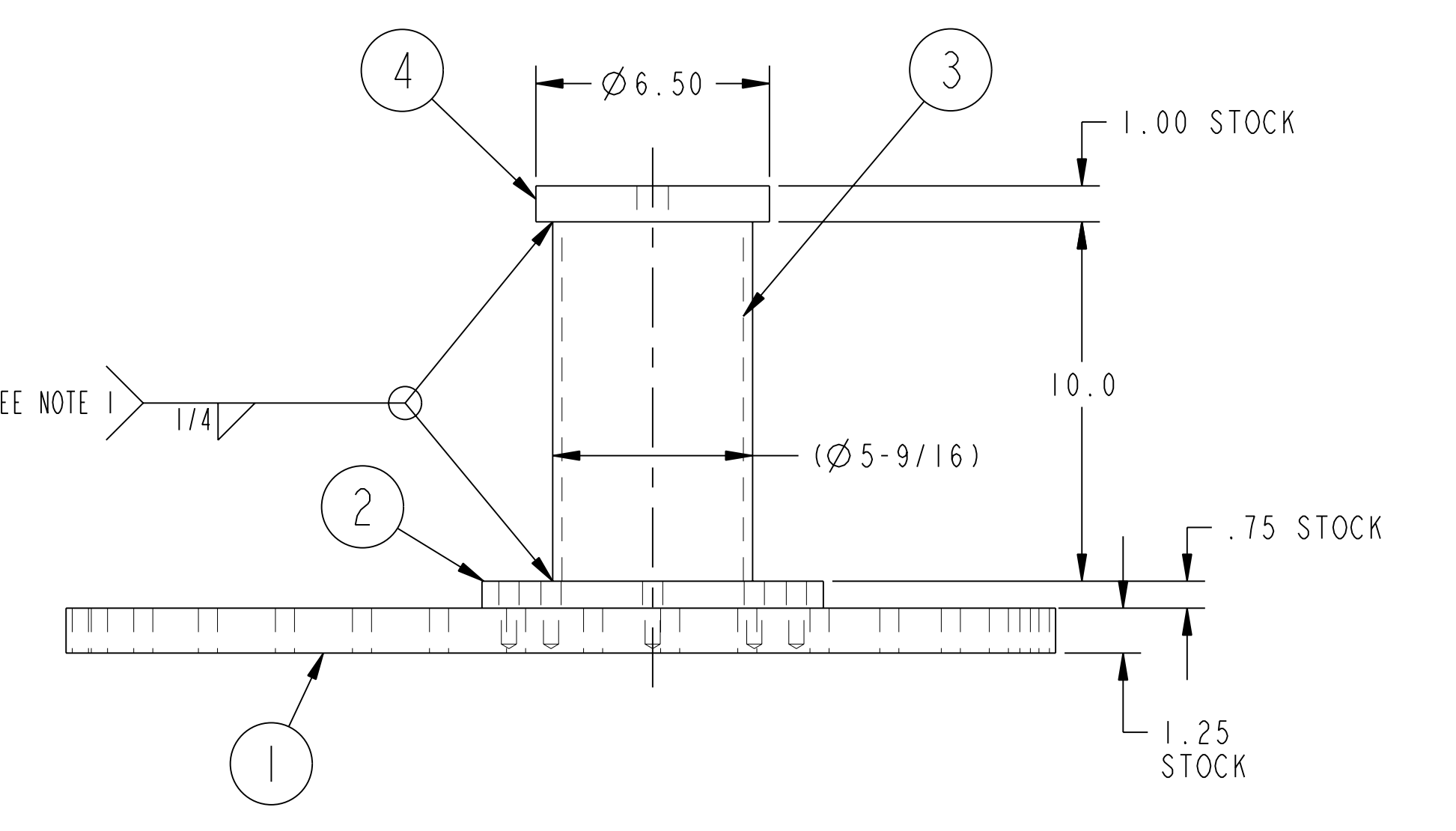
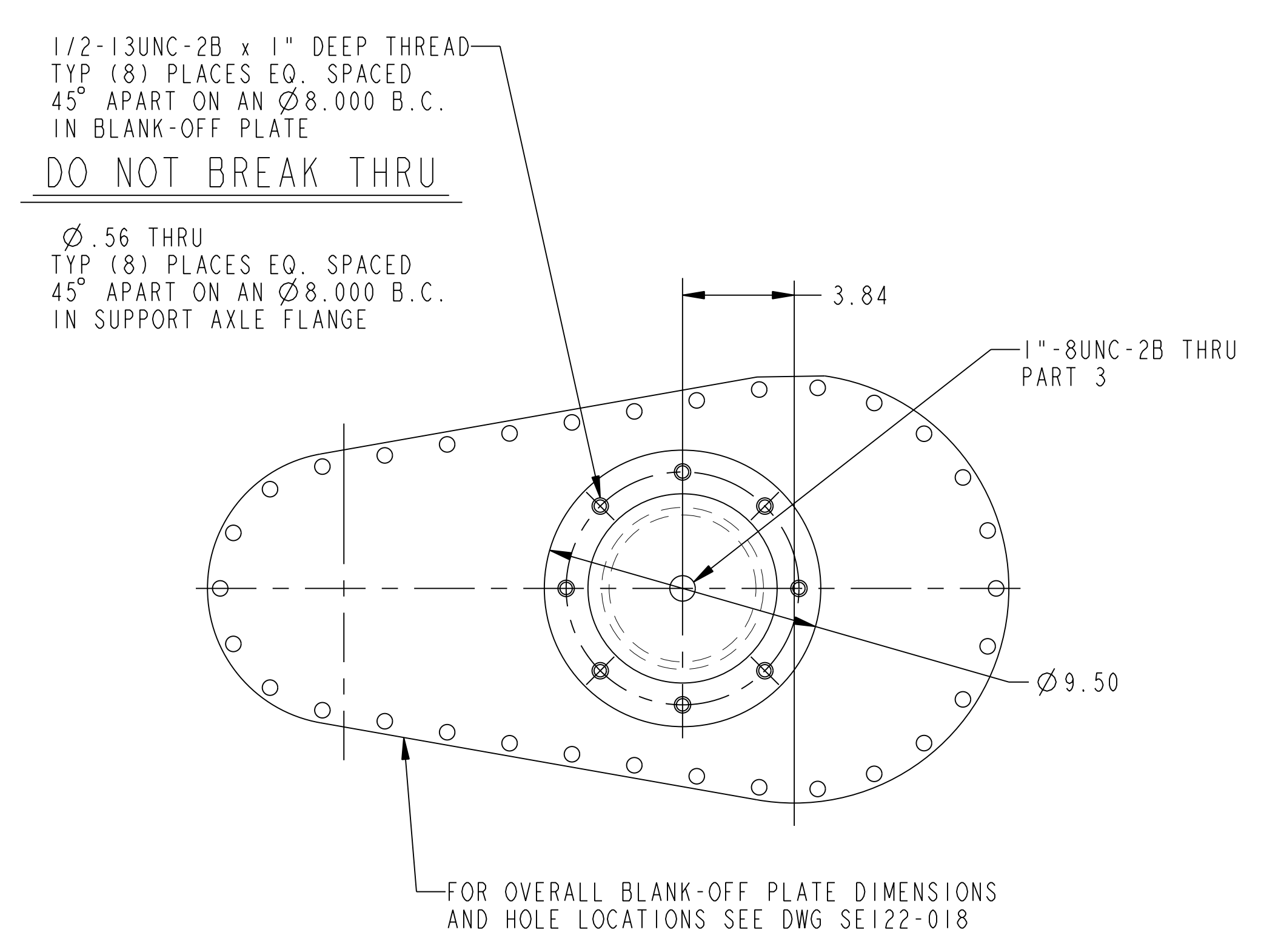
NO.	REVISION	BY	CH	SUP	APPROVED	DATE



90° ROTATED VESSEL VIEW
6.5 REF



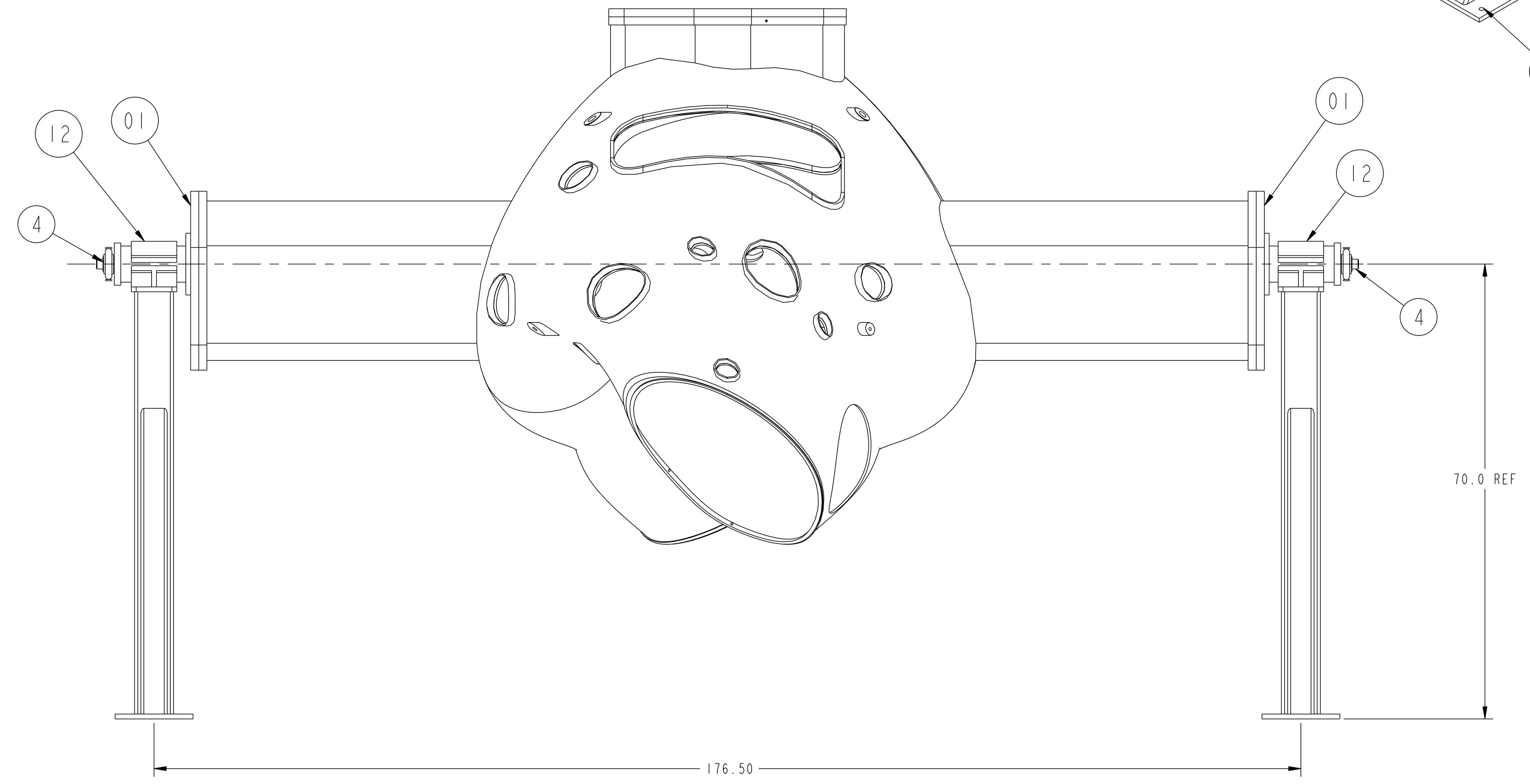
ISOMETRIC VIEW OF TYPICAL SETUP FOR INSTALLING SHELL DIAGNOSTICS



01 PORT #12 BLANK-OFF PLATE ASSEMBLY

NOTES

1. WELDS SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF AWS D1.6 AND PPPL PROCEDURE EM-002. VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH THE ACCEPTANCE CRITERIA OF AWS D1.6.
2. WELDS SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF AWS D1.1 AND PPPL PROCEDURE EM-002. VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH THE ACCEPTANCE CRITERIA OF AWS D1.1.
3. WELDS SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF AWS D1.3 AND PPPL PROCEDURE EM-002. VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH THE ACCEPTANCE CRITERIA OF AWS D1.3.



02 TYPICAL SETUP FOR INSTALLING SHELL DIAGNOSTICS

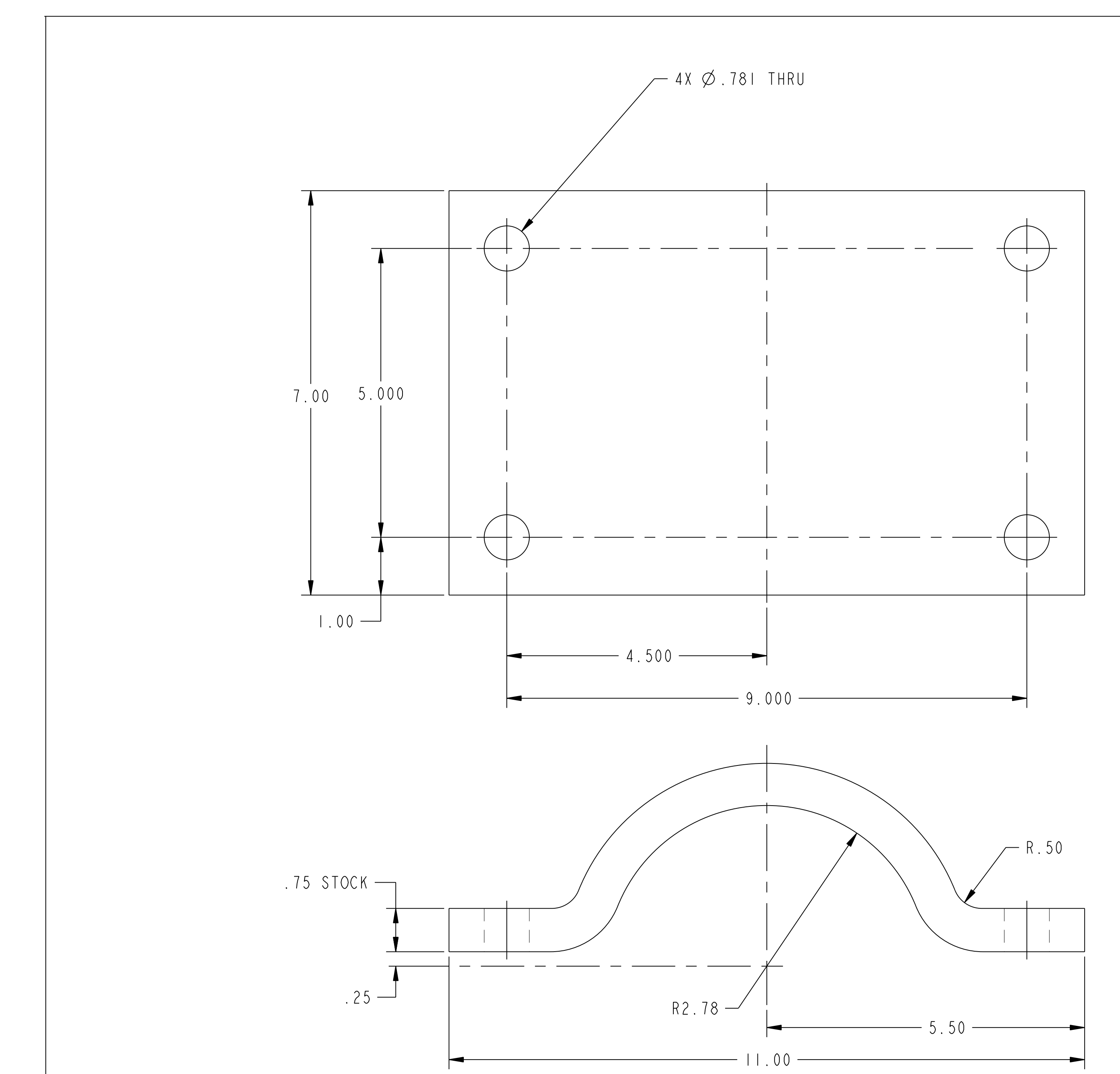
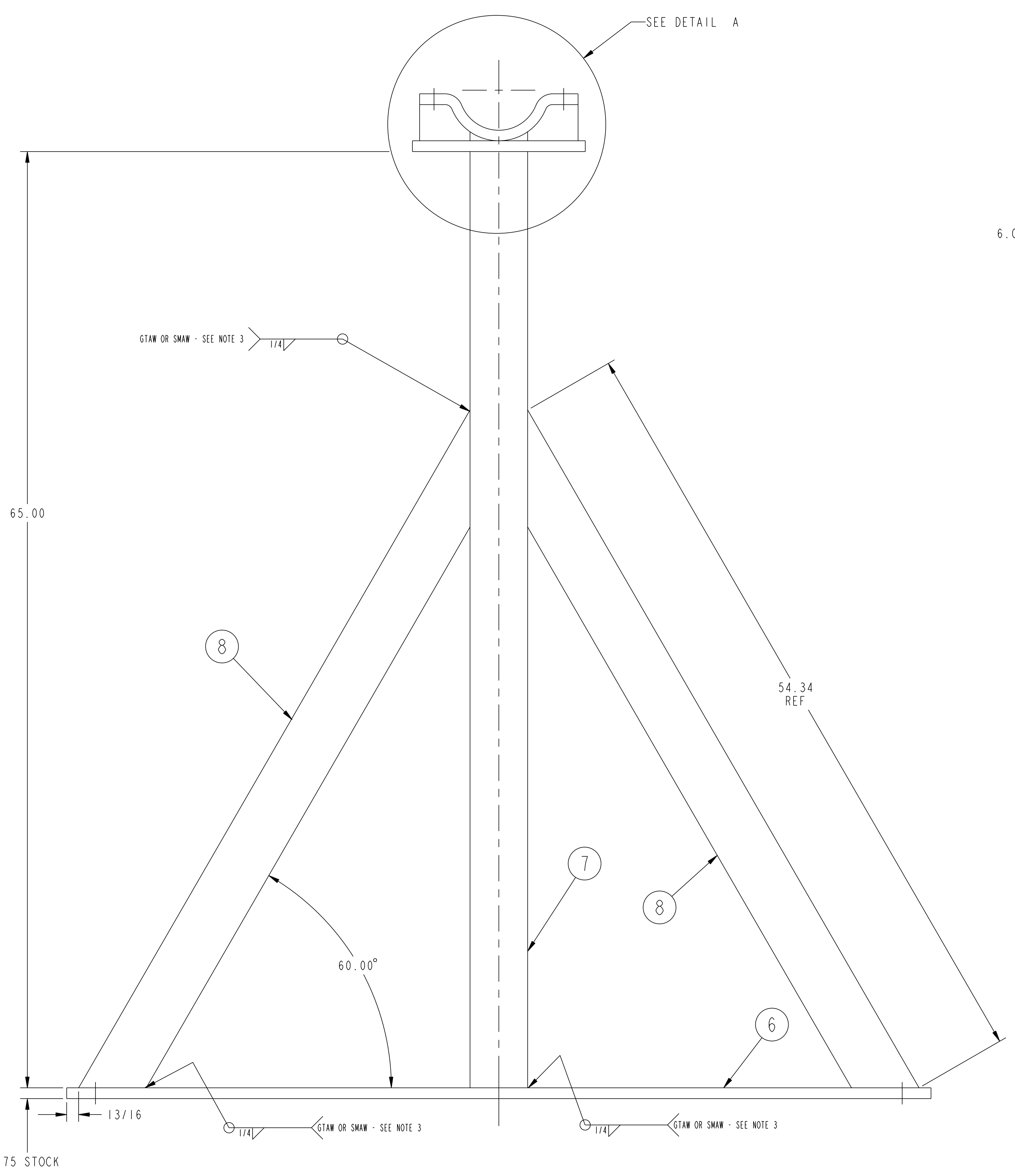
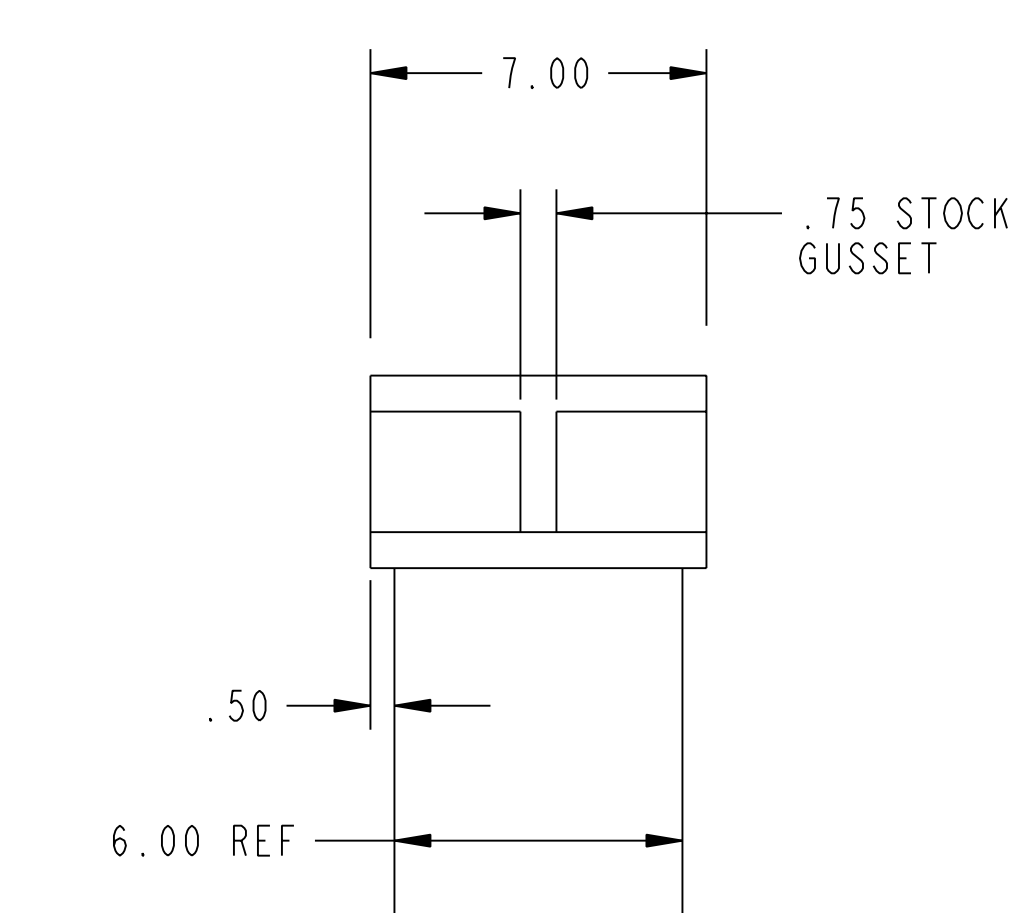
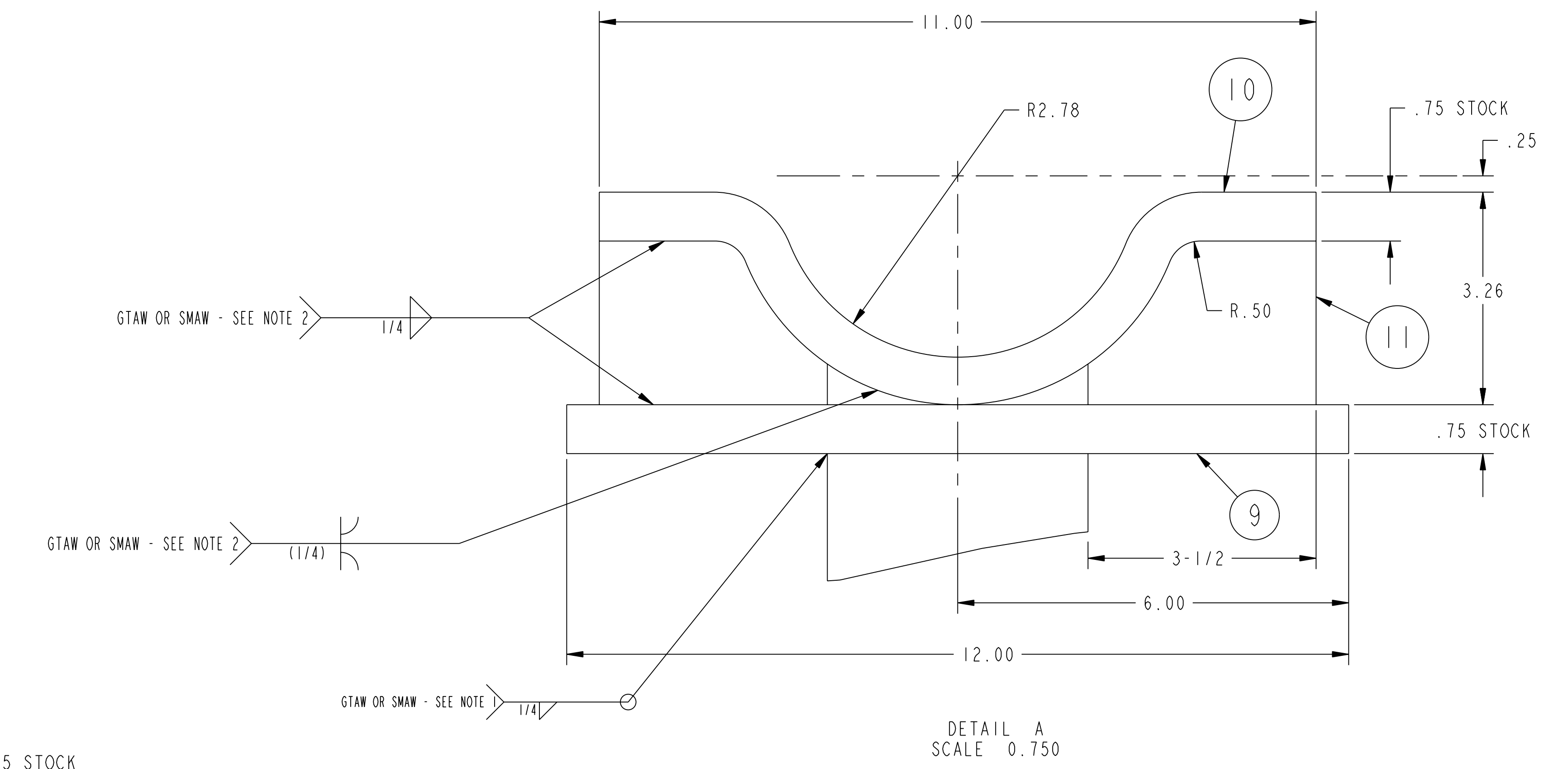
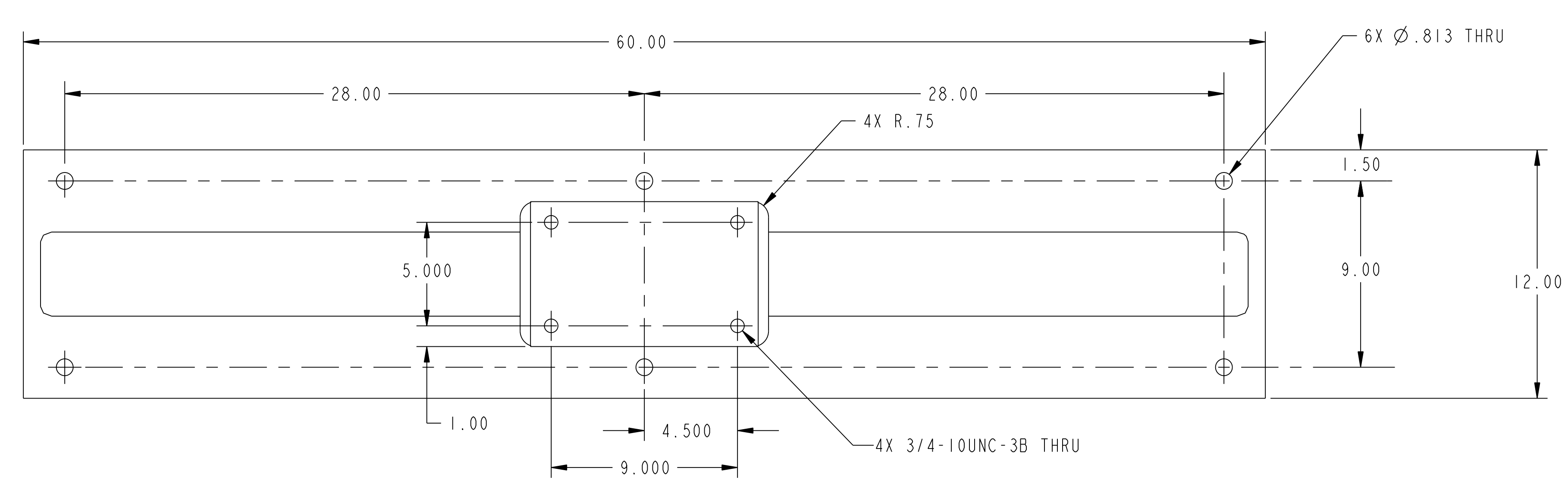
QTY	PART NO.	DRAWING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY REQ'D	
2	6	13	COMM 3/4" CONCRETE ANCHOR BOLT/NUT 5/12" LG	-----	12	
2	2	12	THIS DWG SHT 2 7" WIDE X .75 TH"K LG TO SUIT (SEE DETAIL)	A36	2	
2	11	12	THIS DWG SHT 2 .75 TH"K GUSSET (SEE DETAIL)	A36	4	
1	10	10	THIS DWG SHT 2 7" WIDE X .75 TH"K LG TO SUIT (SEE DETAIL)	A36	2	
1	9	9	THIS DWG SHT 2 7" X 12" X .75 TH"K PLATE	A36	2	
2	8	8	THIS DWG SHT 2 4" X 4" X .25 WALL TUBING (SEE DETAIL)	A36	4	
1	7	7	THIS DWG SHT 2 6" X 4" X .25 WALL TUBING (SEE DETAIL)	A36	2	
1	6	6	THIS DWG SHT 2 12" X 60" X .75 TH"K BASE PLATE	A36	2	
2	5	5	COMM HOIST RING McMaster-Carr NO 3145T34 OR EO.	-----	2	
1	4	4	THIS DWG SUPPORT AXLE END CAP	304 S/S	2	
1	3	3	THIS DWG SUPPORT AXLE - 5" PIPE SCHEDULE 40	304 S/S	2	
1	2	2	THIS DWG SUPPORT AXLE FLANGE	304 S/S	2	
1	1	1	THIS DWG PORT #12 BLANK-OFF PLATE	304 S/S	2	
---	---	---	THIS DWG VACUUM VESSEL SUPPORT STAND WELDMENT	---	2	
---	---	---	THIS DWG VACUUM VESSEL SHELL SUPPORT ASSEMBLY	---	1	
---	---	---	THIS DWG PORT #12 BLANK-OFF PLATE ASSEMBLY	---	2	
03	02	01	PART NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY REQ'D

WEIGHT 312.403[.1] lbs MODEL NAME SE184-001-03 WELDING ENGINEER	COMPUTER GENERATED DRAWING CHANGES NOT PERMITTED Pro E DO NOT VERIFY INFORMATION BY SCALING DRAWING NEXT ASSEMBLY	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020 TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS <table border="1"> <tr> <td>.XX</td> <td>±.000</td> <td>12"-12"</td> <td>±.010</td> </tr> <tr> <td>.XXX</td> <td>±.005</td> <td>12"-120"</td> <td>±.014</td> </tr> <tr> <td>ANGULAR</td> <td>±.05</td> <td>OVER 120"</td> <td>±.12</td> </tr> </table>	.XX	±.000	12"-12"	±.010	.XXX	±.005	12"-120"	±.014	ANGULAR	±.05	OVER 120"	±.12	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY NATIONAL COMPACT STELLATOR EXPERIMENT EXTERNAL FLUX LOOPS VACUUM VESSEL STAND ASSEMBLY WELDMENT AND DETAILS DSN: B. PAUL CHK: G. LABIK ENGR: G. LABIK SUPV: J. SIEGEL DRAWING NO: SE184-001 SHEET 1 OF 2 REV 0
.XX	±.000	12"-12"	±.010												
.XXX	±.005	12"-120"	±.014												
ANGULAR	±.05	OVER 120"	±.12												

RELEASE LEVEL: WIP
DWG VERSION NO: 3

NCSX-SE184-001

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



12 LOCKING CLAMP PLATE

FOR BILL OF MATERIAL AND NOTES SEE SHEET 1

03 VESSEL SHELL DIAGNOSTIC MOUNTING STAND

RELEASE LEVEL: WIP
DWG VERSION NO: 3

WEIGHT	312.403[.1] lbs
MODEL NAME	SE184-001-03
WELDING ENGINEER	

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 STELLATOR EXPERIMENT EXTERNAL FLUX LOOPS VACUUM VESSEL STAND ASSEMBLY WELDMENT AND DETAILS
DO NOT VERIFY INFORMATION BY SCALING DRAWING	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX ±.000 .XXX ±.005 ANGULAR ±.0°-15° OVER 120° ±.1°	DSN: B. PAUL CHK: ENGR: G. LABIK SUPV: J. SIEGEL
NEXT ASSEMBLY		DRAWING NO: SE184-001
		SHEET 2 OF 2 REV 0

NCSX-SE184-001