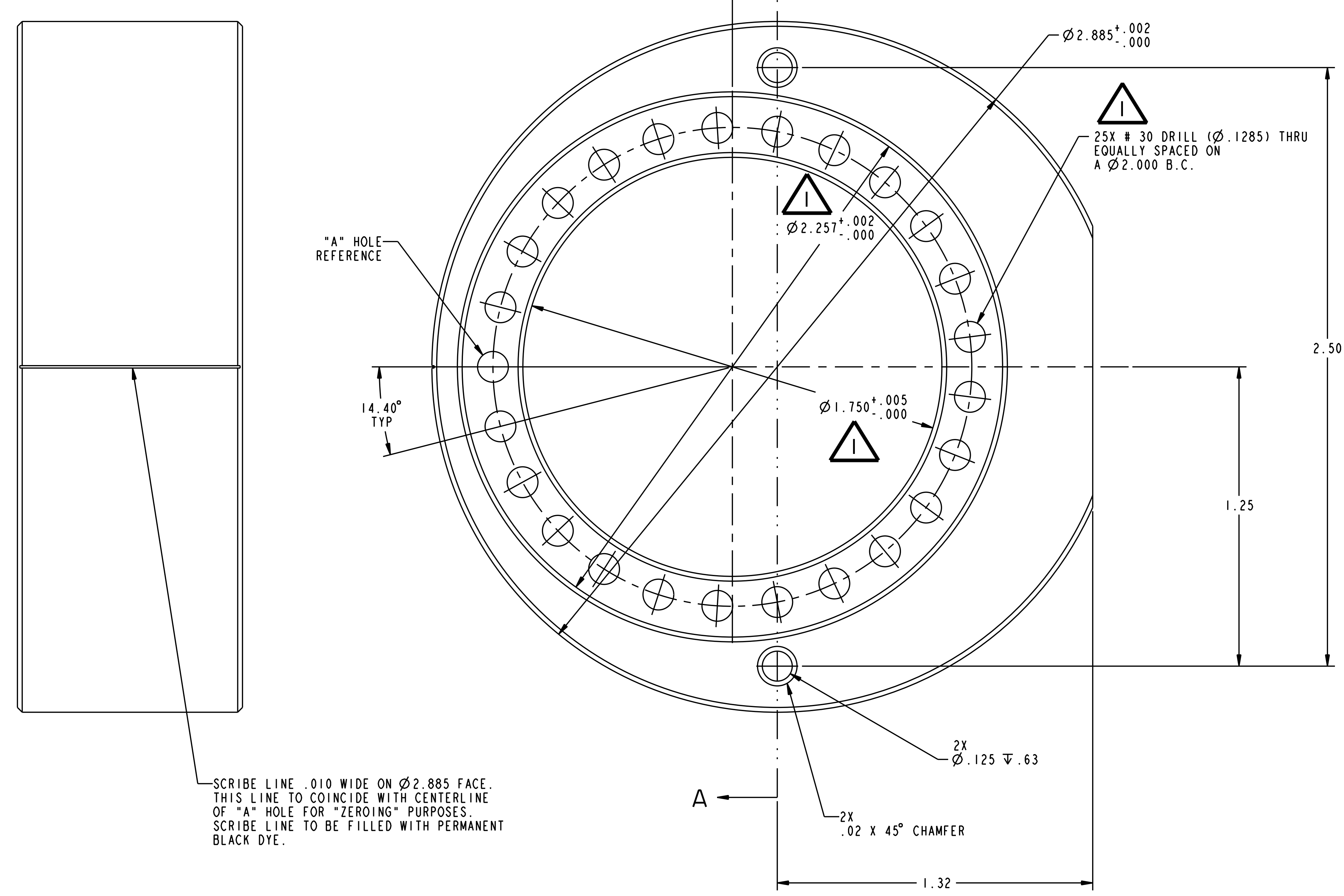
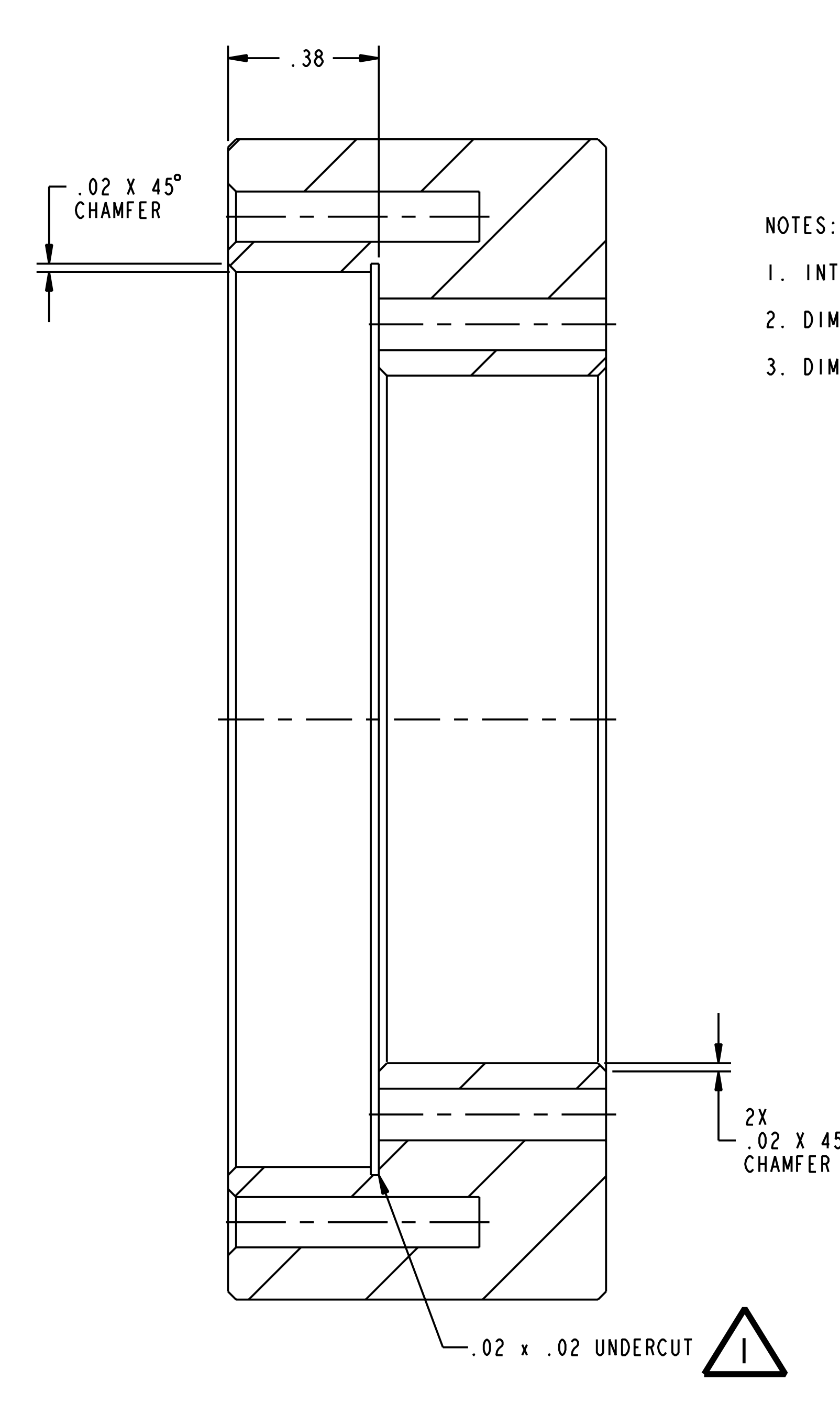


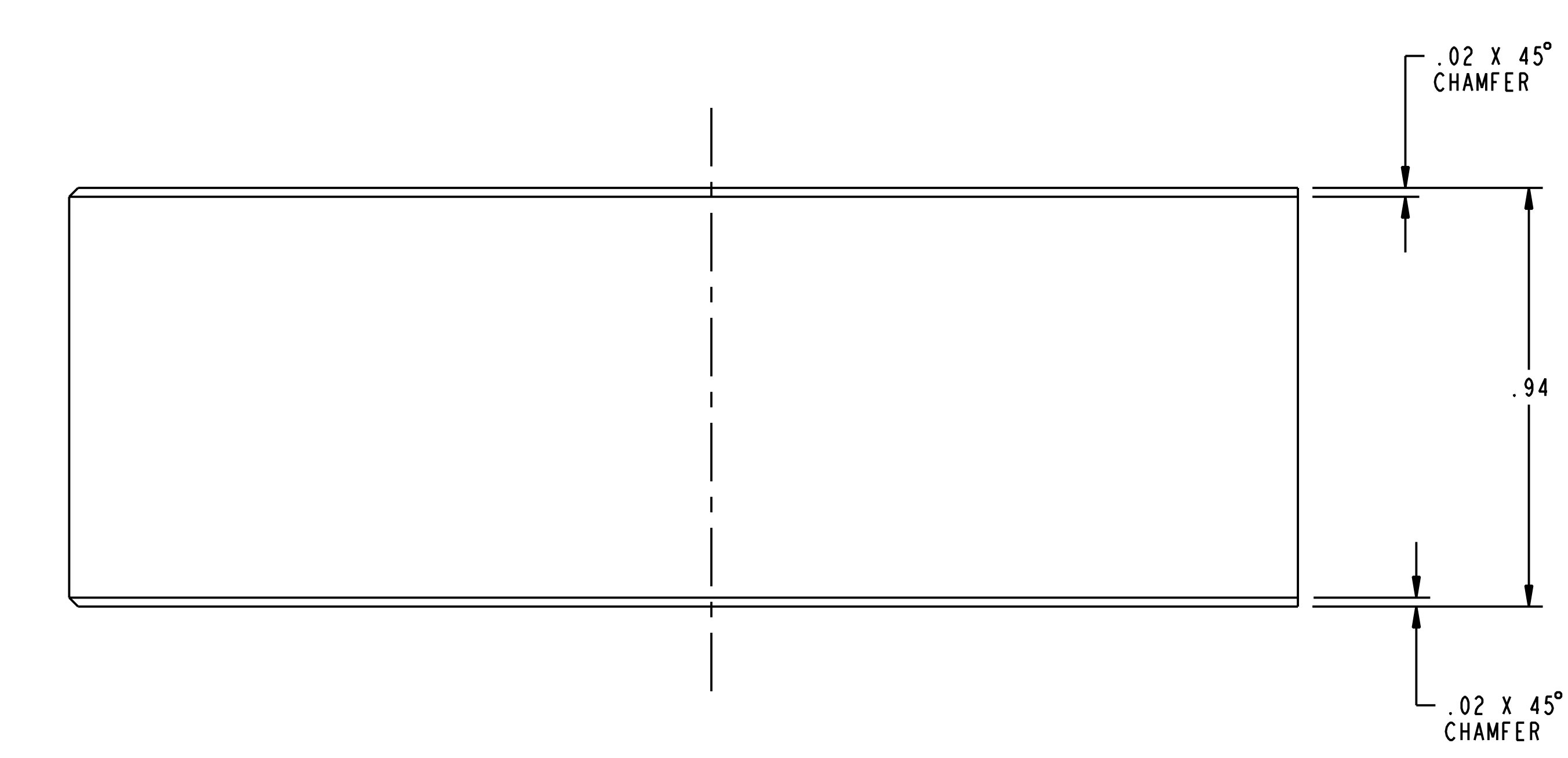
NO.	REVISION	BY	CH	SUP	APPROVED	DATE
1	REVISED PER ECN-5008	LM	TB	JS	T. BROWN	7-19-05



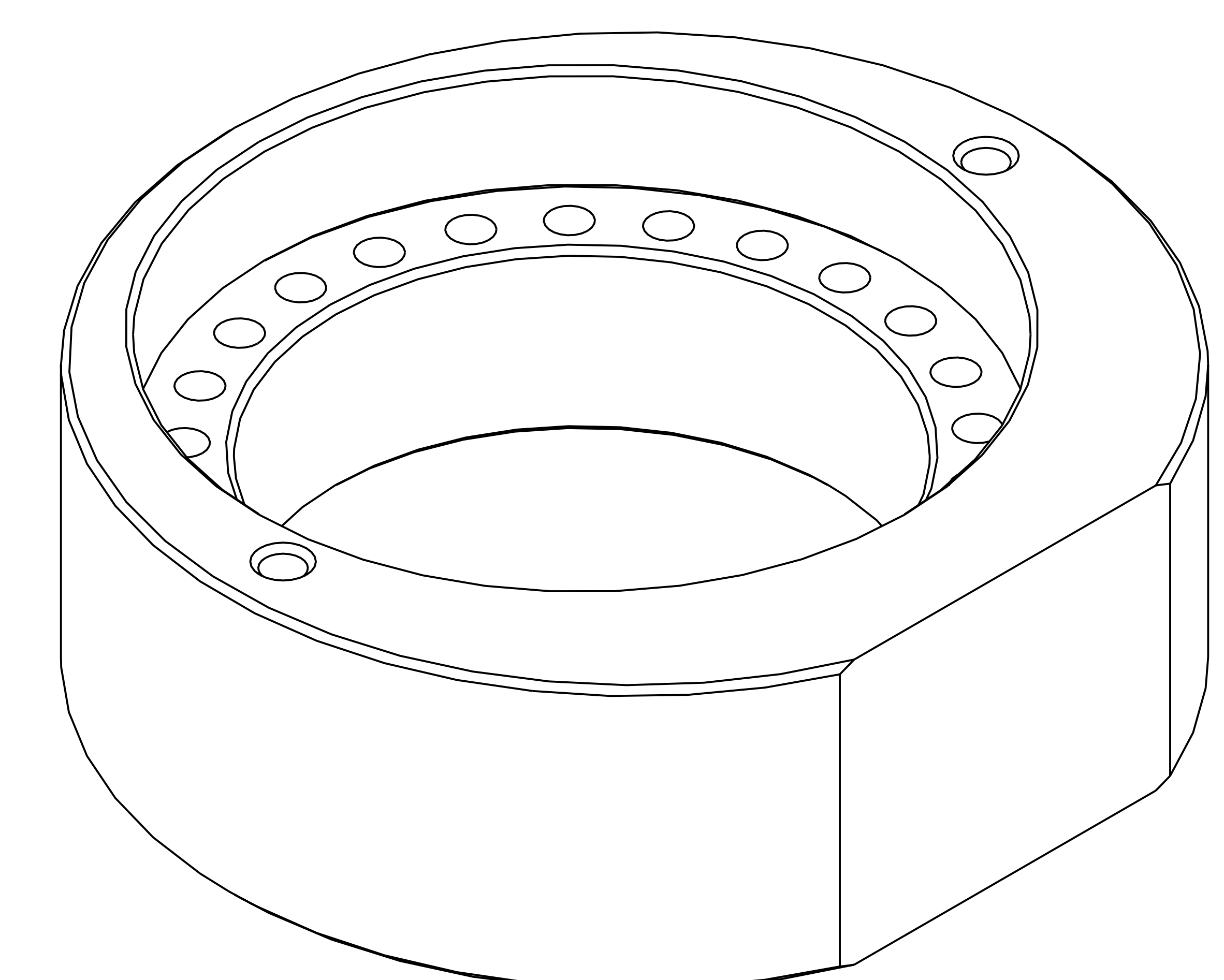
SCRIBE LINE .010 WIDE ON $\phi 2.885$ FACE. THIS LINE TO COINCIDE WITH CENTERLINE OF "A" HOLE FOR "ZEROING" PURPOSES. SCRIBE LINE TO BE FILLED WITH PERMANENT BLACK DYE.



- NOTES:
1. INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M
 2. DIMENSIONS ARE IN INCHES
 3. DIMENSIONS APPLY AT ROOM TEMPERATURE.



SCALE 4 : 1



PART NO.	DRAWING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY RECD
1	SE1851-173	OUTER ALIGNMENT WASHER	304 S/S	3

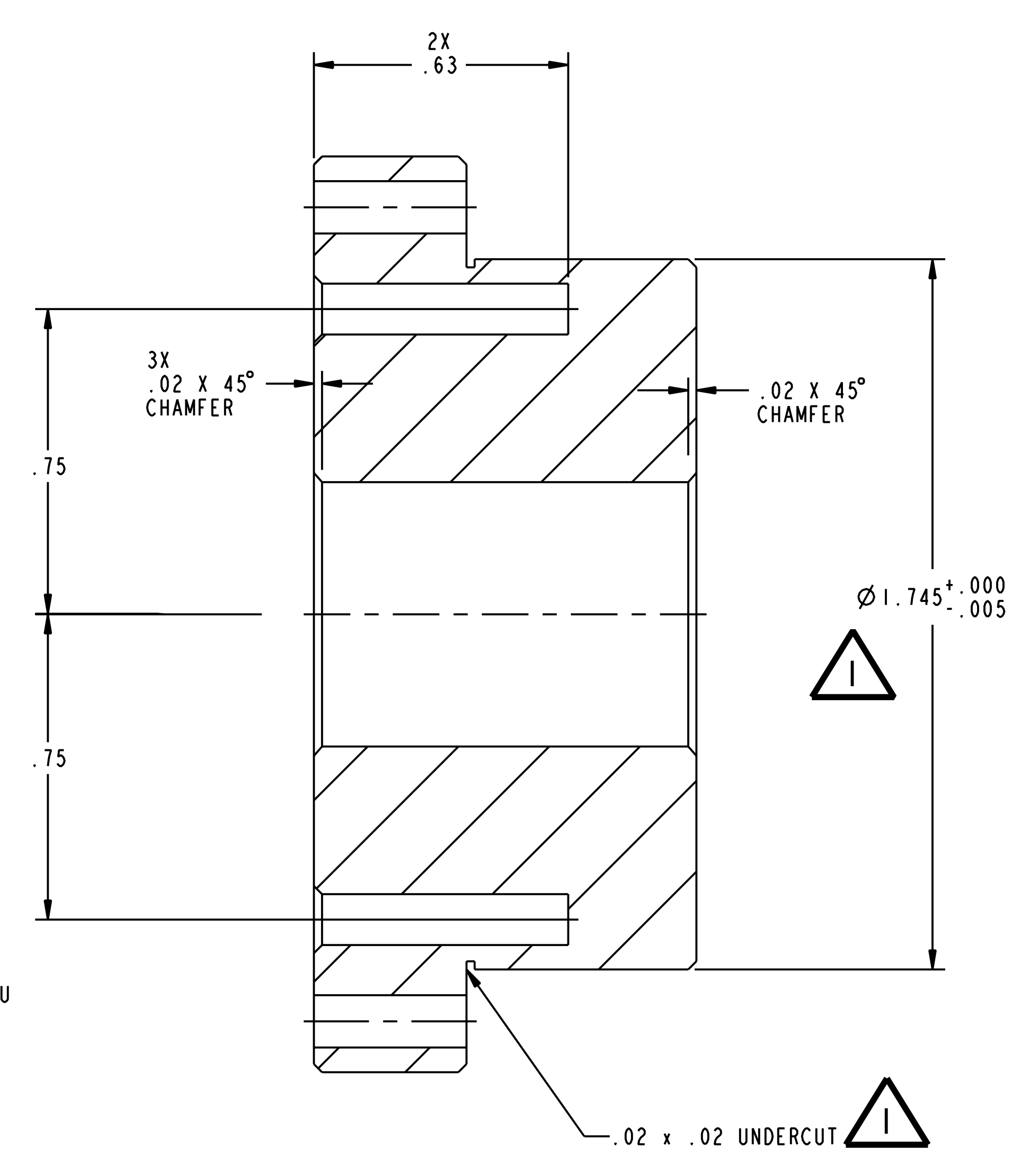
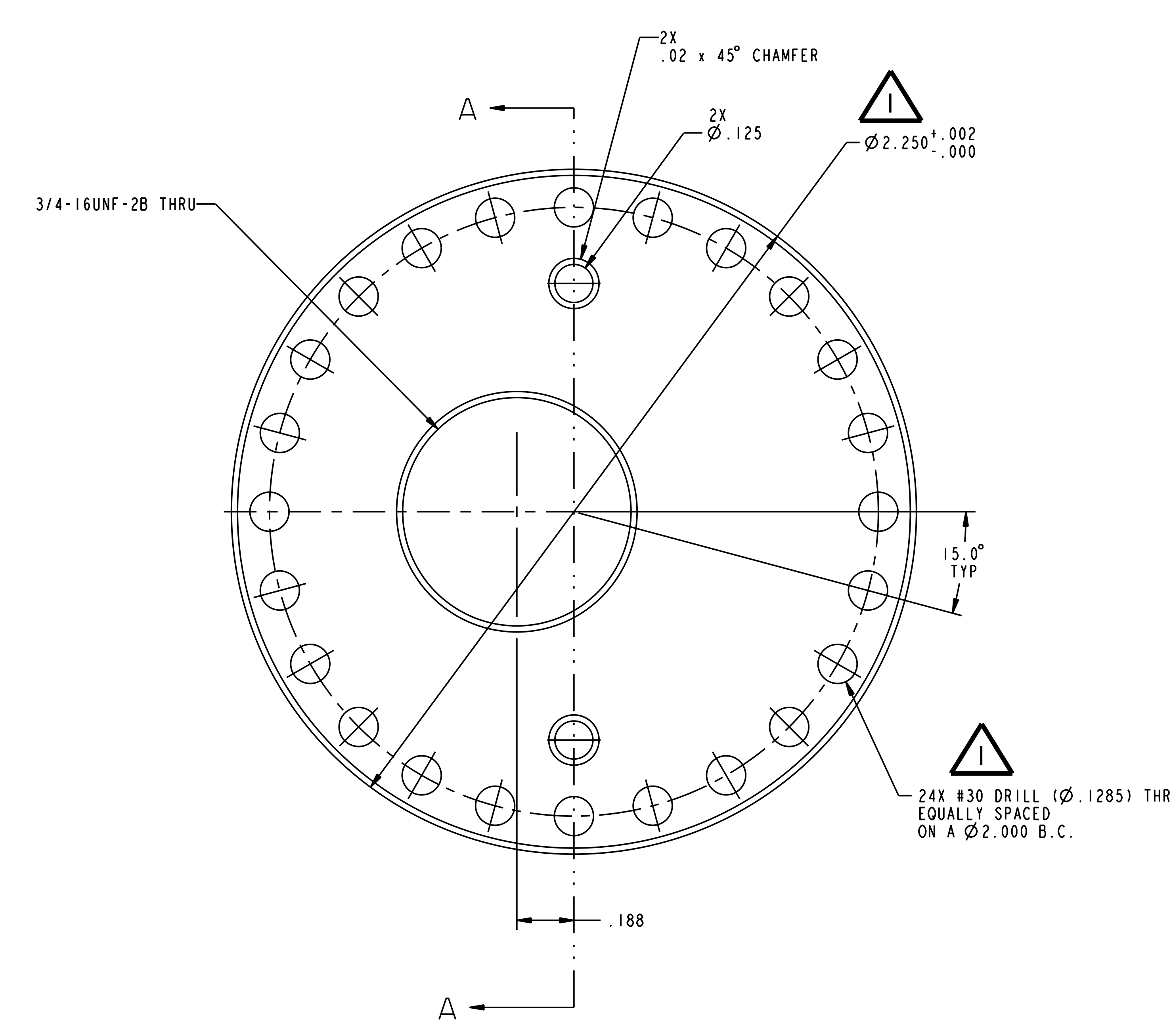
PARTS LIST

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES MACHINE SURFACES UNLESS OTHERWISE SPECIFIED BREAK SHARP EDGES .005/.020	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY NATIONAL COMPACT STELLARATOR EXPERIMENT		
DO NOT VERIFY INFORMATION BY SCALING DRAWING	TOLERANCES NON-CUMULATIVE	DSN: L. MORRIS	7-6-05	DRAWING NO:
WEIGHT 0.8 lbs	DECIMAL-INCH FRACTIONS	CHK: M. COLE	7-6-05	SE1851-173
MODEL NAME SE1851-173	NEXT ASSEMBLY	ENGR: T. BROWN	7-6-05	
WELDING ENGINEER	ANGULAR: $\pm 15^\circ$ OVER: $120^\circ \pm 1/2^\circ$	SUPV: J. SIEGEL	7-6-05	SHEET 1 OF 1 REV 1

RELEASE LEVEL: WIP
DWG VERSION NO: 2

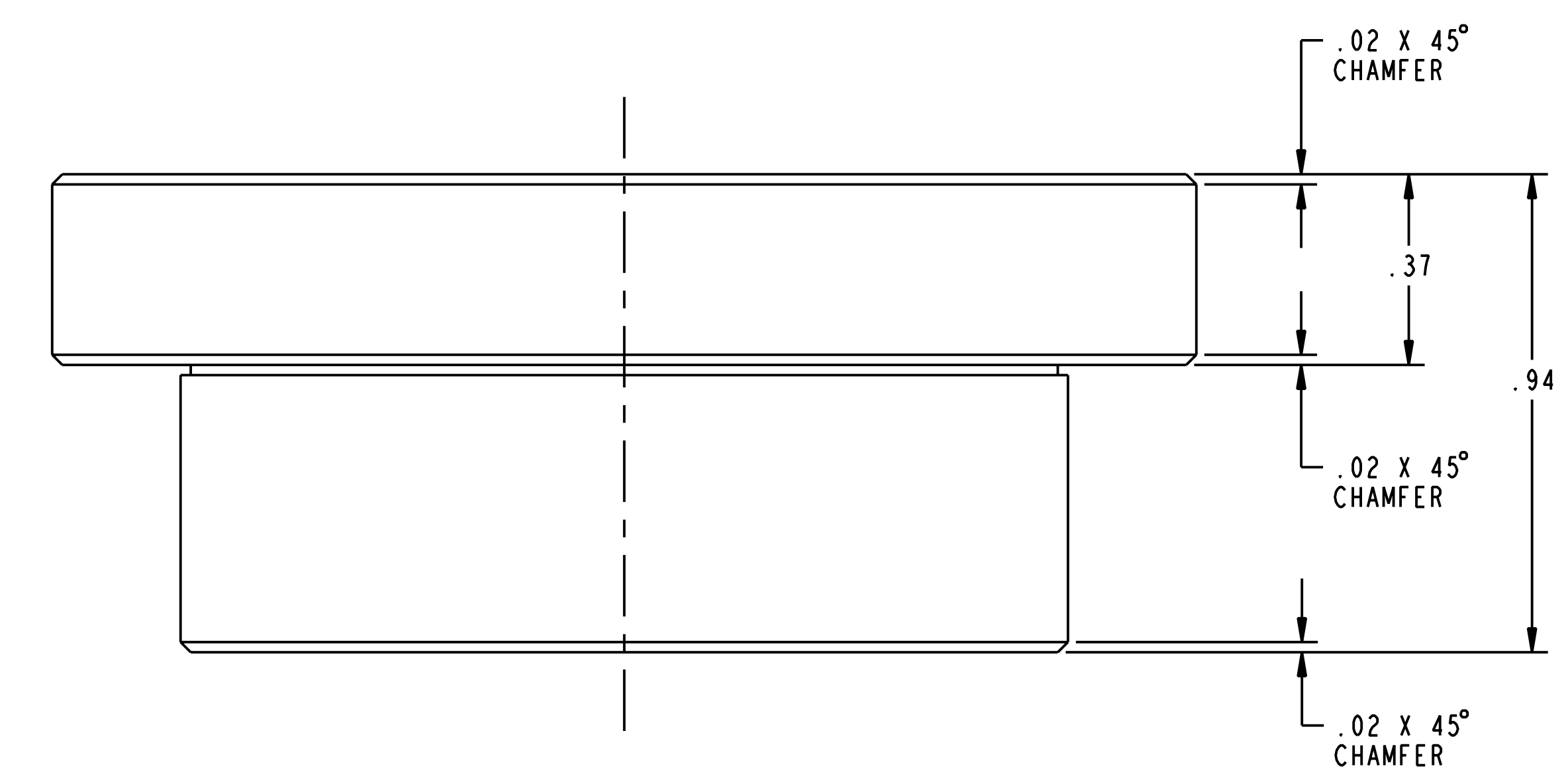
NCSX-SE1851-173

NO.	REVISION	BY	CH	SUP	APPROVED	DATE
1	REVISED PER ECN-5008	LM	TB	JS	T. BROWN	7-19-05

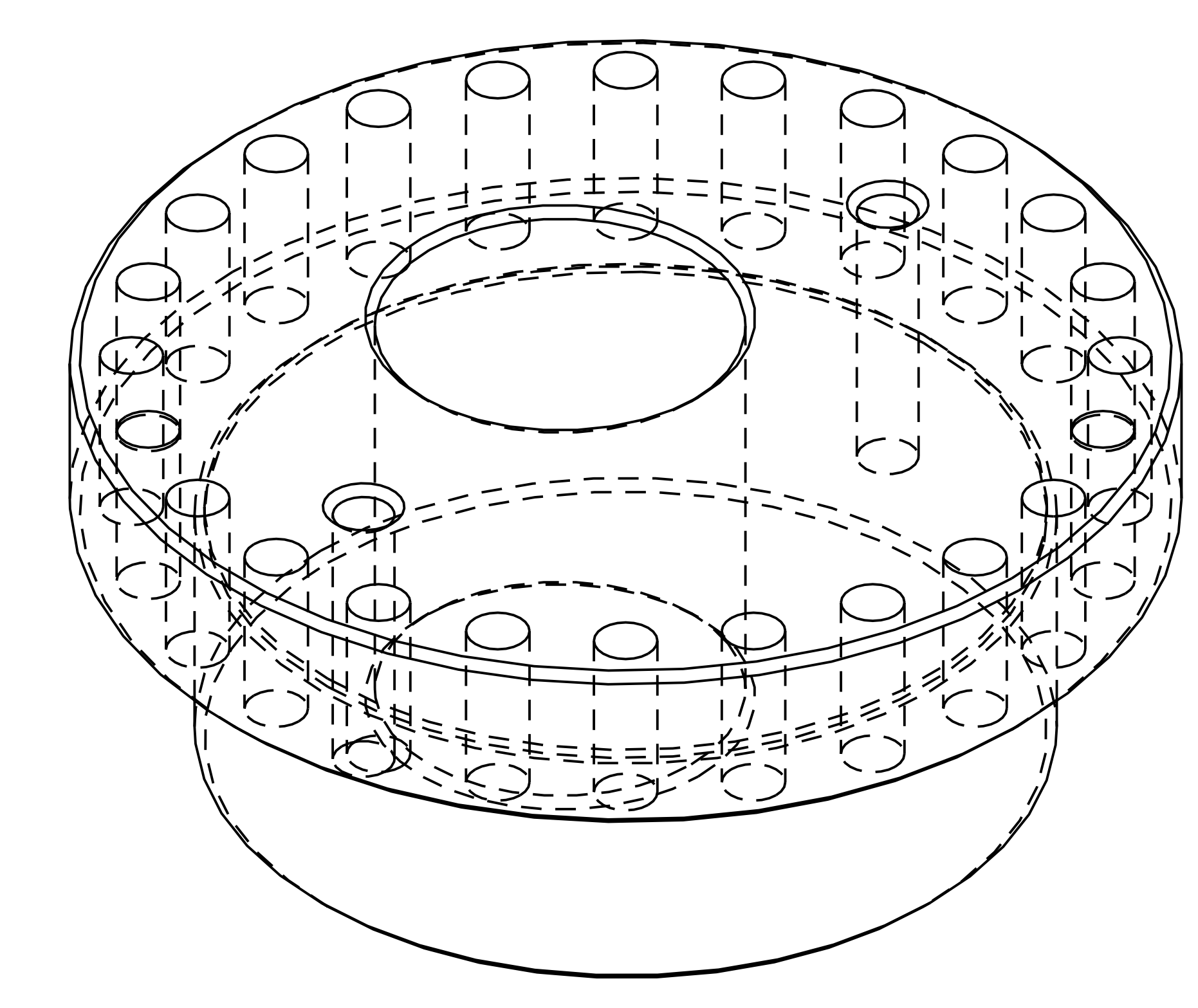


SECTION A-A

- NOTES:
1. INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M
 2. DIMENSIONS ARE IN INCHES
 3. DIMENSIONS APPLY AT ROOM TEMPERATURE.



SCALE 4 : 1



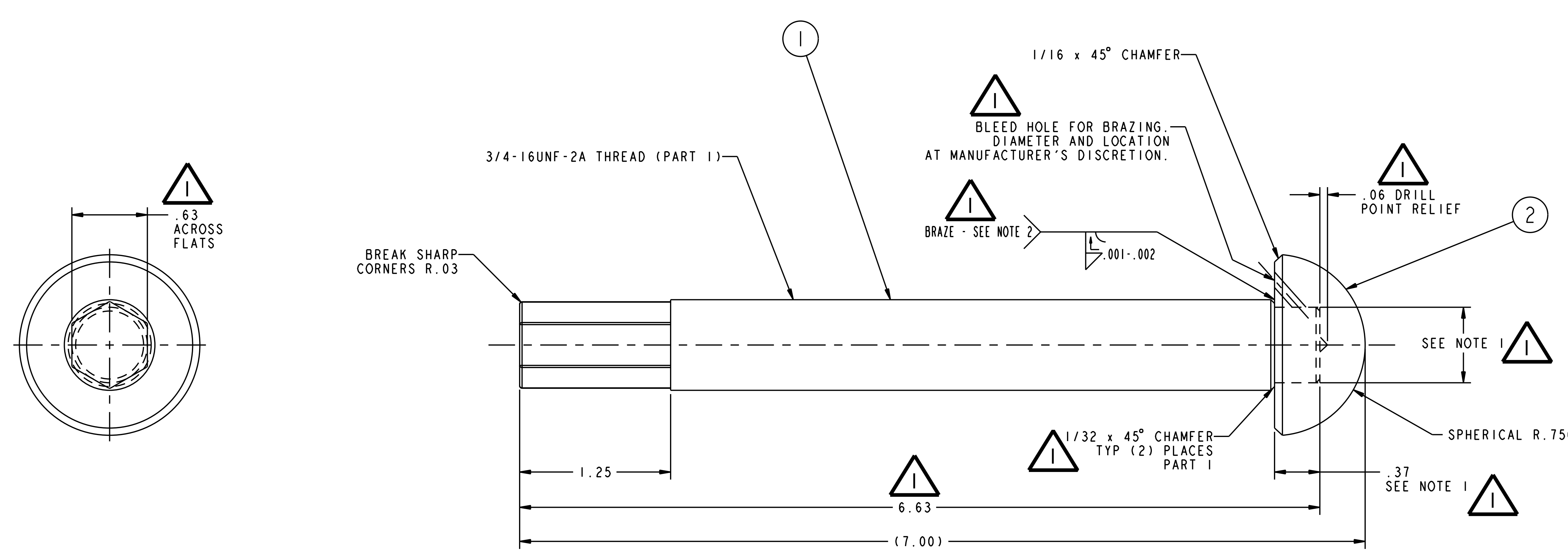
SCALE 4.000

PART NO.	SEI851-174	INNER ALIGNMENT WASHER	304 S/S	3
	DRAWING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY RECD
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	MODULAR COILS BALL ALIGNMENT ASSEMBLY INNER ALIGNMENT WASHER		
WEIGHT 0.6 lbs	MODEL NAME SEI851-174	TOLERANCES NON-CUMULATIVE	DSN: L. MORRIS	7-6-05
		DECIMAL-INCH FRACTIONS	CHK: M. COLE	7-6-05
		.XX ±.030	ENGR: T. BROWN	7-6-05
		.XXX ±.005	SUPV: J. SIEGEL	7-6-05
		ANGULAR ±.0°-15°		
		OVER 120° ±.1°-1.2°		
			DRAWING NO:	
				SEI851-174
			SHEET 1 OF 1	REV 1

RELEASE LEVEL: WIP
DWG VERSION NO: 3

NCSX-SEI851-174

NO.	REVISION	BY	CH	SUP	APPROVED	DATE
1	REVISED PER ECN-5008	LM	TB	JS	T. BROWN	7-18-05



- NOTES**
1. UNDERCUT THREADED DIAMETER, PART 1, TO ROOT DEPTH OF THREAD TO LENGTH INDICATED. HOLE DIAMETER IN BALL, PART 2, TO PROVIDE A LIGHT PRESS FIT. PROVIDE BOTTOM RELIEF IN PART 2 AS INDICATED.
 2. BRAZING SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF AWS C3.4 (TORCH BRAZING) AND PPPL PROCEDURE EM-002.

1	2	THIS DWG	POSITIONER BALL	316 S/S	
1	1	THIS DWG	POSITIONER STUD	316 S/S	
1	1	THIS DWG	BALL AND STUD ASSEMBLY		3
QTY	PART	DRAWING NO.	INSTRUCTIONS OR DESCRIPTION	WATERIAL	QTY REQD

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED		CENTRAL FILES: UNLESS OTHERWISE SPECIFIED		PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY	
DO NOT VERIFY INFORMATION BY SCALING DRAWING		DIMENSIONS ARE IN INCHES MACHINE SURFACES UNLESS OTHERWISE SPECIFIED		MODULAR COILS BALL ALIGNMENT ASSEMBLY BALL AND STUD ASSEMBLY	
WEIGHT 1.0 lbs		TOLERANCES NON-CUMULATIVE		DSN: L. MORRIS 7-6-05 DRAWING NO:	
MODEL NAME SE1851-175		DECIMAL-INCH FRACTIONS		CHK: M. COLE 7-6-05	
RELEASE LEVEL: WIP DWG VERSION NO: 0		NEXT ASSEMBLY		ENGR: T. BROWN 7-6-05	
WELDING ENGINEER		ANGULAR: 15° OVER 120°		SUPV: J. SIEGEL 7-6-05	
				7-6-05 SHEET 1 OF 1 REV 1	

NCSX-SE1851-175