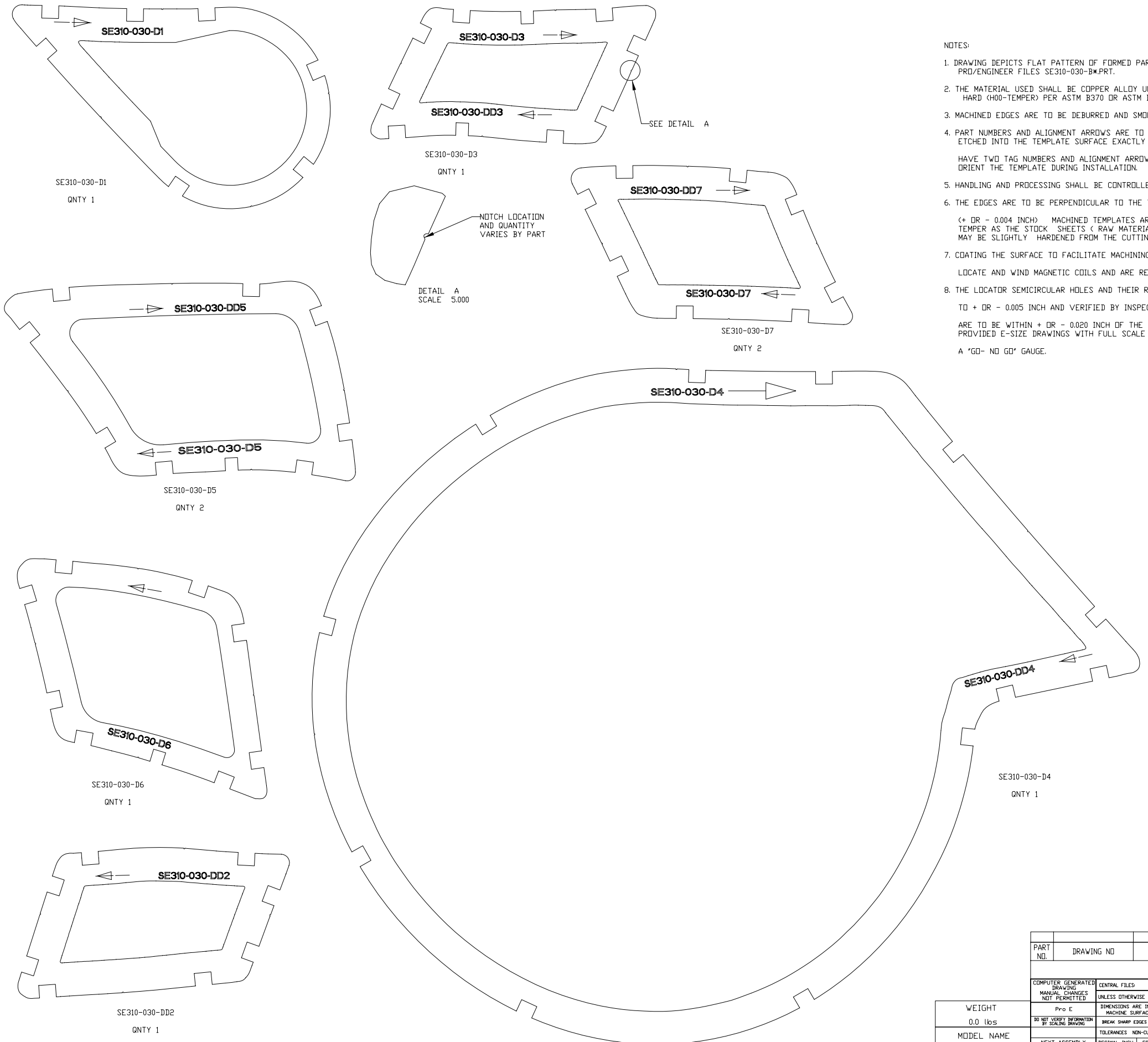
NO.	REVISION	BY	CH	SUP	APPROVED	DATE



NOTES:

1. DRAWING DEPICTS FLAT PATTERN OF FORMED PARTS DEFINED BY PRO/ENGINEER FILES SE310-030-B*.PRT.
2. THE MATERIAL USED SHALL BE COPPER ALLOY UNS C 11000, ANNEALED OR 1/8 HARD (H00-TEMPER) PER ASTM B370 OR ASTM B152
3. MACHINED EDGES ARE TO BE DEBURRED AND SMOOTH TO PRECLUDE INJURY FROM HANDLING.
4. PART NUMBERS AND ALIGNMENT ARROWS ARE TO BE PERMANENTLY MECHANICALLY ETCHED INTO THE TEMPLATE SURFACE EXACTLY AS SHOWN IN THE DRAWING. SOME TEMPLATES HAVE TWO TAG NUMBERS AND ALIGNMENT ARROWS. TAG NUMBERS AND ARROWS ARE USED TO ORIENT THE TEMPLATE DURING INSTALLATION.
5. HANDLING AND PROCESSING SHALL BE CONTROLLED TO MINIMIZE WORK HARDENING.
6. THE EDGES ARE TO BE PERPENDICULAR TO THE TEMPLATE SURFACE TO + OR - 5 DEGREES (+ OR - 0.004 INCH) MACHINED TEMPLATES ARE TO BE DELIVERED TO PPPL WITH THE SAME TEMPER AS THE STOCK SHEETS (RAW MATERIAL). IT IS RECOGNIZED THAT THE CUT EDGES MAY BE SLIGHTLY HARDENED FROM THE CUTTING PROCESS.
7. COATING THE SURFACE TO FACILITATE MACHINING IS PERMITTED. THE TEMPLATES ARE USED TO LOCATE AND WIND MAGNETIC COILS AND ARE REMOVED AFTERWARD.
8. THE LOCATOR SEMICIRCULAR HOLES AND THEIR RESPECTIVE LOCATIONS ARE TO BE POSITIONED TO + OR - 0.005 INCH AND VERIFIED BY INSPECTION. THE GENERAL TEMPLATE DIMENSIONS ARE TO BE WITHIN + OR - 0.020 INCH OF THE IDEAL GEOMETRY (DXF MODEL). THE PPPL PROVIDED E-SIZE DRAWINGS WITH FULL SCALE TEMPLATES ARE TO BE USED BY THE VENDOR AS A "GO- NO GO" GAUGE.

PART NO.	DRAWING NO	NOMENCLATURE OR DESCRIPTION	SEE NOTES MATERIAL	QTY REQD

PARTS LIST

COMPUTER GENERATED DRAWING
MANUAL CHANGES NOT PERMITTED

CENTRAL FILES
UNLESS OTHERWISE SPECIFIED
Pro E
DIMENSIONS ARE IN INCHES
MACHINE SURFACES 125
BREAK SHARP EDGES .005/.020
DO NOT VERIFY INFORMATION BY SCALING DRAWING

PRINCETON PLASMA PHYSICS LABORATORY
PRINCETON UNIVERSITY
NATIONAL COMPACT STELLARATOR EXPERIMENT

DIAGNOSTICS
MAGNETIC DIAGNOSTICS TEMPLATES W/ INDENTS
MAGNETIC LOOPS SERIES "D"

TOLERANCES NON-CUMULATIVE

DECIMAL-INCH		FRACTIONS	
.X	+/-.100	0"-12"	+/-1/64
.XX	+/-.030	12"-72"	+/-1/8
.XXX	+/-.005	72"-120"	+/-1/4
ANGULAR	+/-0°-15'	OVER 120"	+/-1/2

NEXT ASSEMBLY

DSN: T. BROWN	1/12/06	DRAWING NO:
CHK: J. RUSHINSKI	1/12/06	SE310-030-A_Q
ENGR: G. LABIK	1/12/06	
SUPV: J. SEIGEL	1/12/06	SHEET 2 OF 15 REV 0

WEIGHT
0.0 lbs

MODEL NAME
SE310-030-HH7

WELDING ENGINEER

RELEASE LEVEL:
DWG VERSION NO:

NCSX_PART_FORMAT_E

NCSX-SE310-030-A_Q