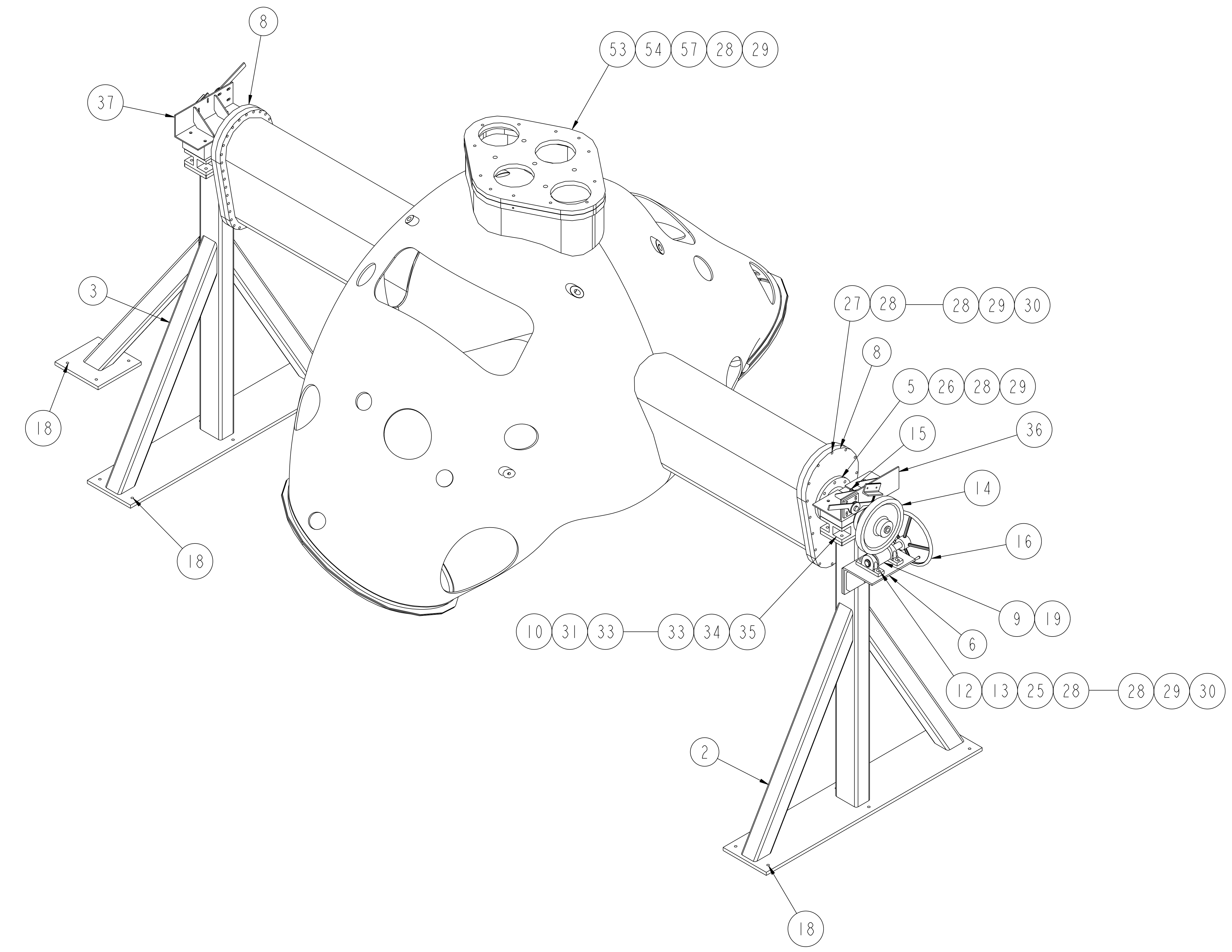


NO.	REVISION	BY	CH	SUP	APPROVED	DATE
1	REVISED PER ECN-5077	LM	TB	JS	T. BROWN	2-16-05
2	REVISED PER ECN-5099	LM	TB	JS	T. BROWN	3-29-06
3	REVISED PER ECN-5120	LM	TB	JS	T. BROWN	5-11-06

NOTES
 1. USE THIS DRAWING IN CONJUNCTION WITH DRAWING SE184-007 FOR POSITIONING AND ALIGNMENT OF ASSEMBLY FIXTURE.



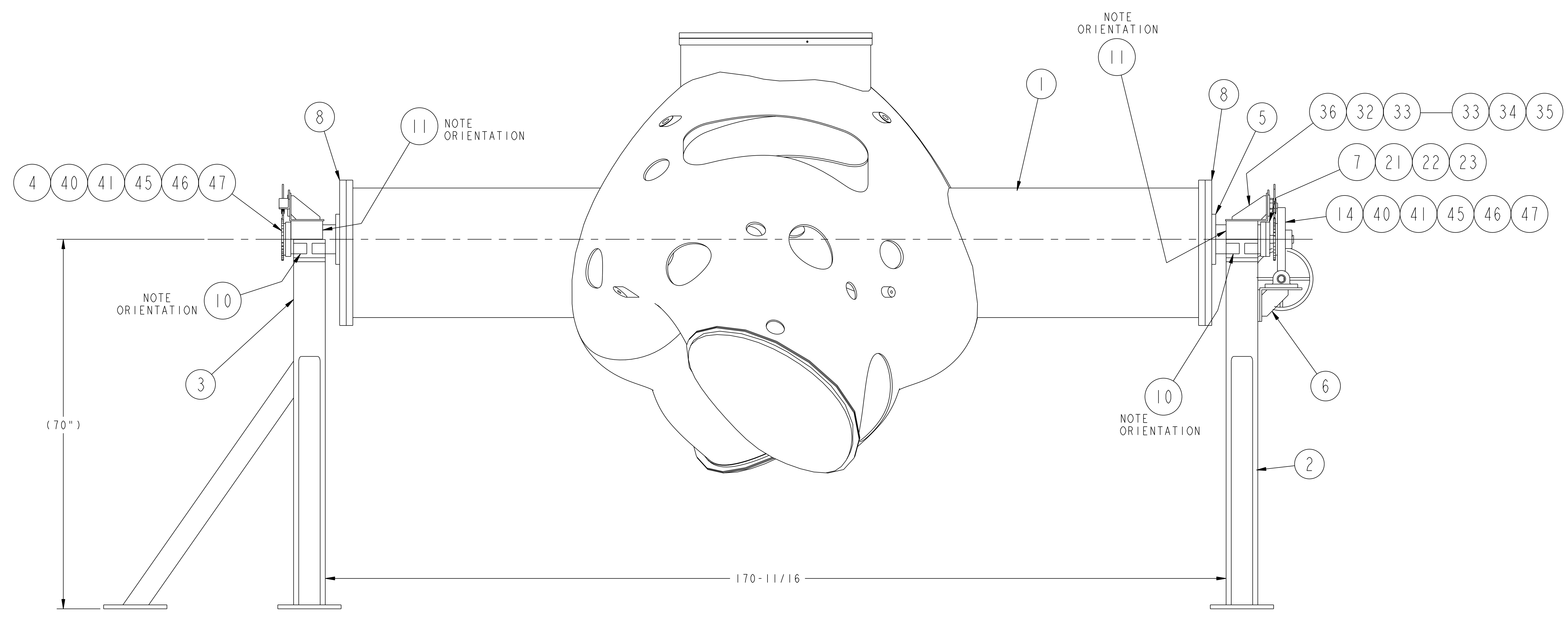
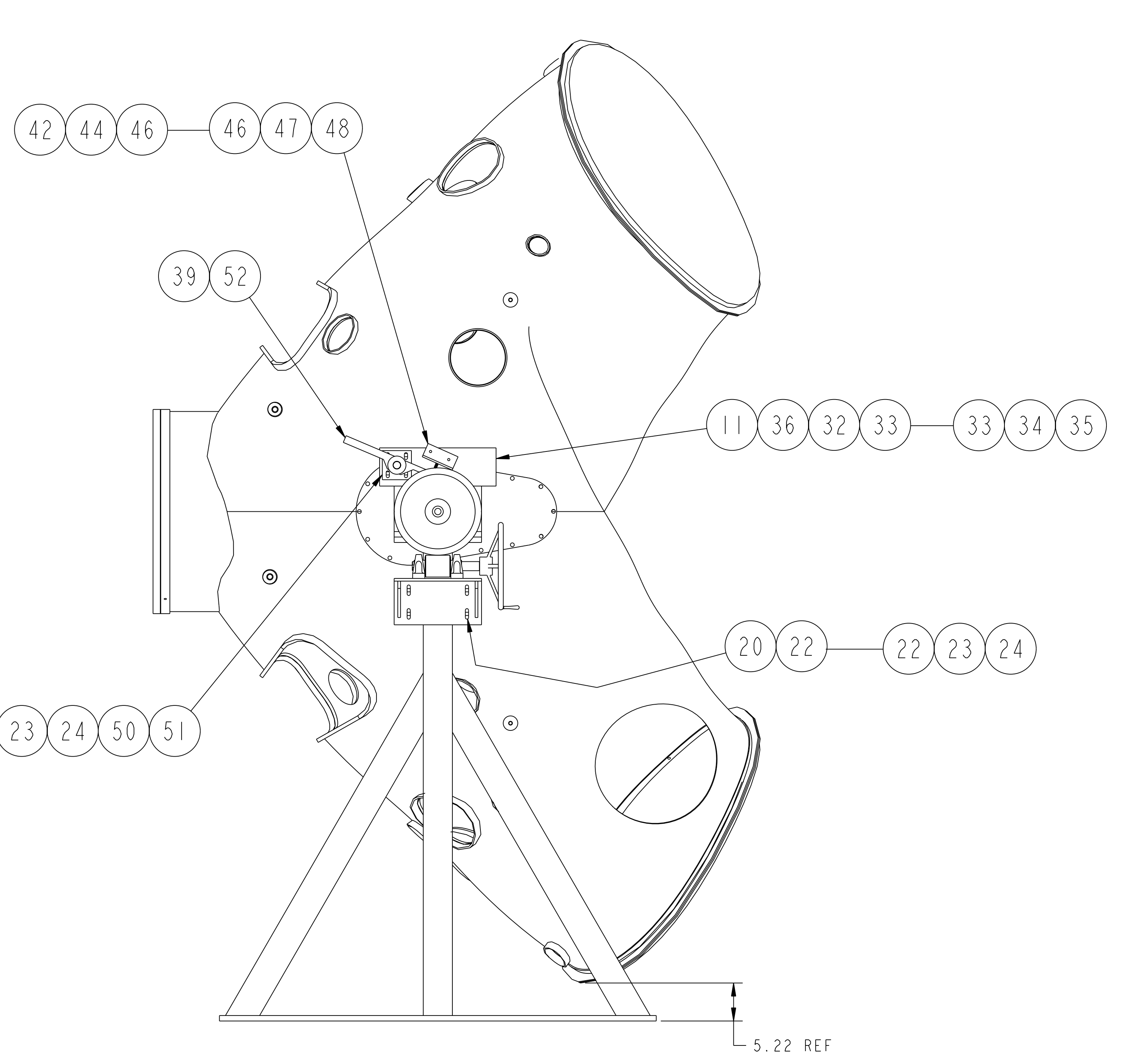
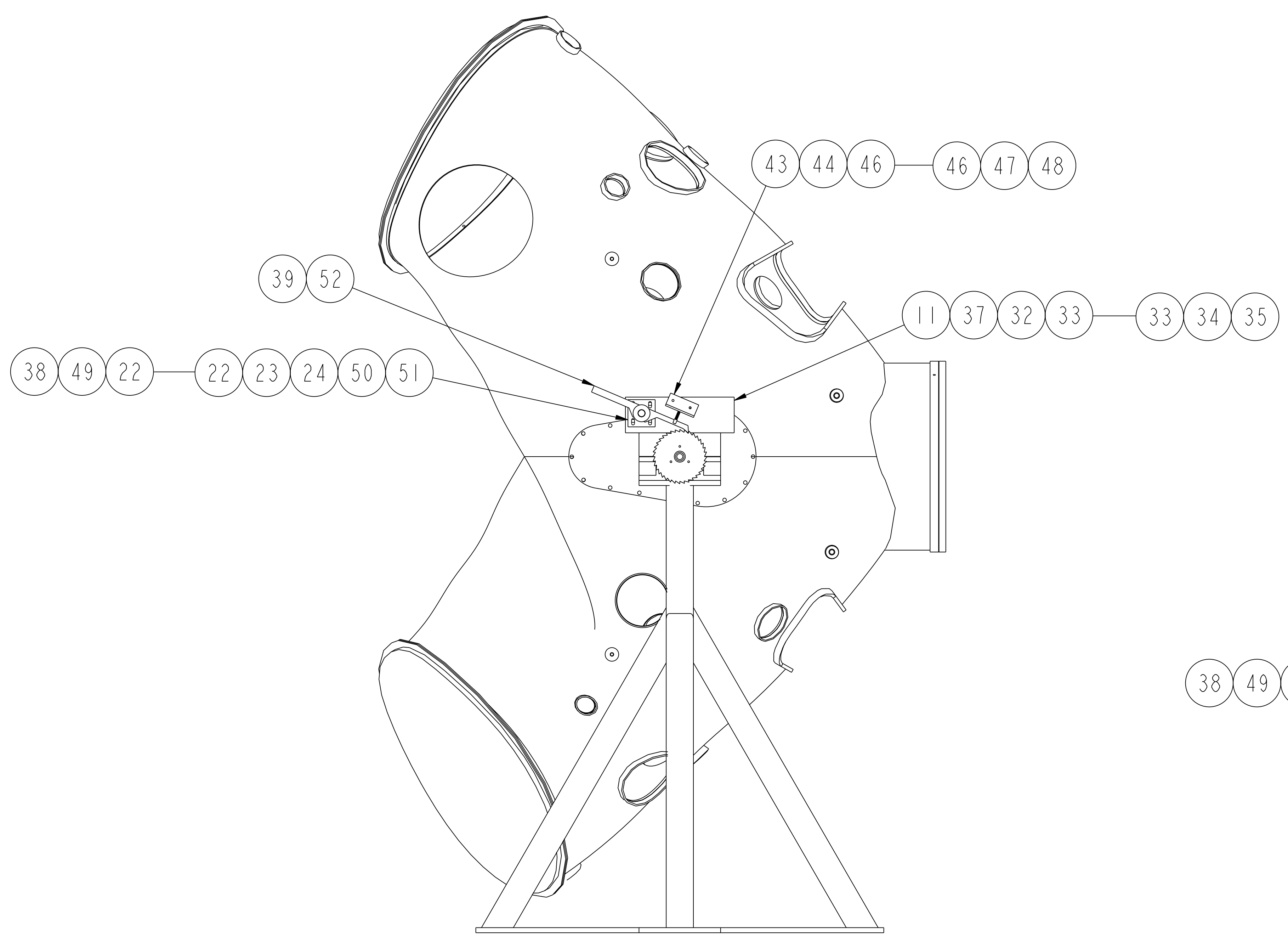
12	57	COMM	1/2-13UNC-2A x 3" LG HEX HD CAP SCR	C'STL - ZN PLT
8	56	COMM	3/8-16UNC-2A x 2" LG HEX HD CAP SCR	C'STL - ZN PLT
1	55	SE184-008	HOIST RING MOUNT LIFTING ASSEMBLY W/ LASER POINTER	SEE DWG
1	54	SE184-055	N.B. PORT TEMPORARY COVER SPACER	SEE DWG
1	53	SE184-054	N.B. PORT TEMPORARY COVER WELDMENT	SEE DWG
2	52	COMM	COMPRESSION SPRING - 3/8" O.D., .035 WIRE, 1 1/4 LG McMASTER-CARR #9657K155 OR EQUIV.	C'STL - ZN PLT TEMPERED
4	51	COMM	Ø1/8" x 1 1/2 LG COTTER PIN	C'STL - ZN PLT
4	50	COMM	1" (NOM) FLAT WASHER	C'STL - ZN PLT
8	49	COMM	3/8-16UNC-2A x 1 1/2 LG HEX HD CAP SCR	C'STL - ZN PLT
4	48	COMM	1/4-20UNC-2B HEX NUT	C'STL - ZN PLT
10	47	COMM	1/4" SPLIT LOCK WASHER	C'STL - ZN PLT
14	46	COMM	1/4" (NOM) FLAT WASHER	C'STL - ZN PLT
6	45	COMM	1/4-20UNC-2A x 1 1/2 LG HEX HD CAP SCR	C'STL - ZN PLT
4	44	COMM	1/4-20UNC-2A x 1 1/4 LG HEX HD CAP SCR	C'STL - ZN PLT
1	43	SE184-006-7	CLIP ANGLE - TYPE "B"	SEE DWG
1	42	SE184-006-6	CLIP ANGLE - TYPE "A"	SEE DWG
2	41	SE184-006-3	RATCHET SPACER	SEE DWG
2	40	SE184-006-2	RATCHET	SEE DWG
2	39	SE184-005-04	PAWL WELDMENT	SEE DWG
2	38	SE184-005-03	PAWL AXLE MOUNTING PLATE WELDMENT	SEE DWG
1	37	SE184-005-02	PAWL SUPPORT BRACKET WELDMENT - TYPE "B"	SEE DWG
1	36	SE184-005-01	PAWL SUPPORT BRACKET WELDMENT - TYPE "A"	SEE DWG
8	35	COMM	3/4-10UNC-2B HEX NUT	C'STL - ZN PLT
16	34	COMM	3/4" SPLIT LOCK WASHER	C'STL - ZN PLT
24	33	COMM	3/4" (NOM) FLAT WASHER	C'STL - ZN PLT
8	32	COMM	3/4-10UNC-2A x 5 1/2" LG HEX HD CAP SCR	C'STL - ZN PLT
16	31	COMM	3/4-10UNC-2A x 2 1/2" LG HEX HD CAP SCR	C'STL - ZN PLT
64	30	COMM	1/2-13UNC-2B HEX NUT	C'STL - ZN PLT
84	29	COMM	1/2" SPLIT LOCK WASHER	C'STL - ZN PLT
156	28	COMM	1/2" (NOM) FLAT WASHER	C'STL - ZN PLT
64	27	COMM	1/2-13UNC-2A x 3 1/4" LG HEX HD CAP SCR	C'STL - ZN PLT
16	26	COMM	1/2-13UNC-2A x 2" LG HEX HD CAP SCR	C'STL - ZN PLT
4	25	COMM	1/2-13UNC-2A x 1 3/4" LG HEX HD CAP SCR	C'STL - ZN PLT
12	24	COMM	3/8-16UNC-2B HEX NUT	C'STL - ZN PLT
26	23	COMM	3/8" SPLIT LOCK WASHER	C'STL - ZN PLT
38	22	COMM	3/8" (NOM) FLAT WASHER	C'STL - ZN PLT
6	21	COMM	3/8-16UNC-2A x 1 3/4" LG HEX HD CAP SCR	C'STL - ZN PLT
4	20	COMM	3/8-16UNC-2A x 1 1/2" LG HEX HD CAP SCR	C'STL - ZN PLT
1	19	COMM	5/16" NOM SQ. KEY x 4" LG	C'STL
16	18	COMM	1/2" CONCRETE ANCHOR BOLT/NUT 5 1/2" LG	STEEL
1	17	COMM	HOIST RING - 10,000# CAP. McMASTER-CARR #3145T34 OR EQUIV.	STEEL
1	16	COMM	HANDWHEEL WITH HANDLE - 5/8" BORE x 12" O.D. McMASTER-CARR #6026K159 OR EQUIV.	CAST IRON
1	15	COMM	QUICK RELEASE PIN - Ø1/2" x 1.5" LG GRIP McMASTER-CARR #98320A495 OR EQUIV.	ZN PLT ST'L
1	14	SE184-006-1	WORM GEAR - 4 PITCH 48 TEETH 12,000 P.D BOSTON GEAR CAT. #G1104 ITEM #13244 MODIFIED PER DRAWING	SEE DWG
1	13	COMM	WORM - 3" P.D. RIGHT HAND BOSTON GEAR CAT. #H1106 ITEM #12976	STEEL
2	12	COMM	Ø1.250 PILLOW BLOCK WITH BEARING McMASTER-CARR #6244K73 OR EQUIV.	CAST IRON
2	11	SE184-004-2	SUPPORT AXLE CRADLE TOP	SEE DWG
2	10	SE184-004-1	SUPPORT AXLE CRADLE BASE	SEE DWG
1	9	SE184-003-2	WORM AXLE	SEE DWG
2	8	SE184-003-1	PORT 12 BLANK-OFF COVER	SEE DWG
1	7	SE184-002-06	WORM GEAR AXLE WELDMENT	SEE DWG
1	6	SE184-002-05	WORM SUPPORT BRACKET WELDMENT	SEE DWG
1	5	SE184-002-04	SUPPORT AXLE WELDMENT - TYPE "B"	SEE DWG
1	4	SE184-002-03	SUPPORT AXLE WELDMENT - TYPE "A"	SEE DWG
1	3	SE184-002-02	SUPPORT STAND WELDMENT - WITH OUTRIGGER	SEE DWG
1	2	SE184-002-01	SUPPORT STAND WELDMENT - WITH BRACKET	SEE DWG
1	1	SE120-002	120" VACUUM VESSEL SEGMENT	SEE DWG
1	—	—	THIS DWG	—
1	—	—	FIXTURE ASSEMBLY	—

01 PART ASSY	PART NO.	DRAWING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY REQD
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COMPUTER GENERATED DRAWING CHANGES NOT PERMITTED	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY NATIONAL COMPACT STELLATORATOR EXPERIMENT			
DO NOT VERIFY INFORMATION BY SCALING DRAWING	DIMENSIONS ARE IN INCHES MACHINE SURFACES UNLESS SHOWN OTHERWISE BREAK SHARP EDGES .005/.020	EXTERNAL FLUX LOOPS VACUUM VESSEL SUPPORT STAND FIXTURE ASSEMBLY			
WEIGHT 16398.6 lbs	MODEL NAME SE184-001-01	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX ±.000 .XXX ±.005 ANGULAR ±.015°	DSN: L. MORRIS CHK: T. BROWN ENGR: T. BROWN SUPV: J. SIEGEL	9-28-05 9-28-05 9-28-05 9-28-05	DRAWING NO: SE184-001 SHEET 1 OF 4 REV 3
RELEASE LEVEL: WIP DWG VERSION NO: 1	WELDING ENGINEER				

NCSX-SE184-001

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

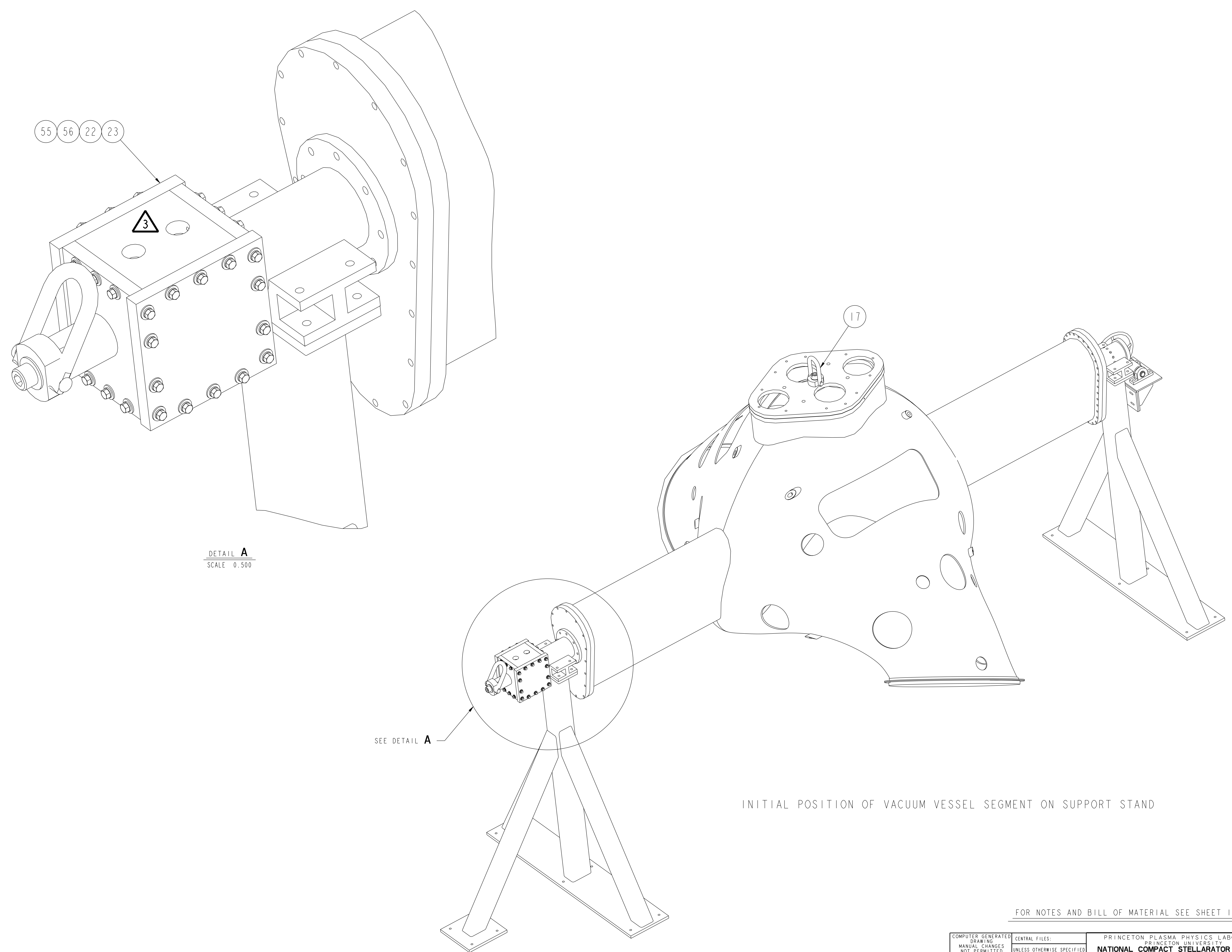
RELEASE LEVEL: WIP
DWG VERSION NO: 1

WEIGHT	16398.6 lbs
MODEL NAME	SE184-001-01
WELDING ENGINEER	

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	EXTERNAL FLUX LOOPS VACUUM VESSEL SUPPORT STAND FIXTURE ASSEMBLY			
NEXT ASSEMBLY	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS	DSN: L. MORRIS	2-16-05	DRAWING NO:	
	.X +/- .100 0°-120° +/- 1.0° .XX +/- .030 12°-12° +/- 1.0° .XXX +/- .005 72°-120° +/- 1.0° ANGULAR +/- 0°-15° OVER 120° +/- 1.0°	CHK: T. BROWN	2-16-05	SE184-001	
		ENGR: T. BROWN	2-16-05	SHEET 2 OF 4	
		SUPV: J. SIEGEL	2-16-05	REV 2	

NCSX-SE184-001

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



DETAIL A
SCALE 0.500

SEE DETAIL A

INITIAL POSITION OF VACUUM VESSEL SEGMENT ON SUPPORT STAND

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

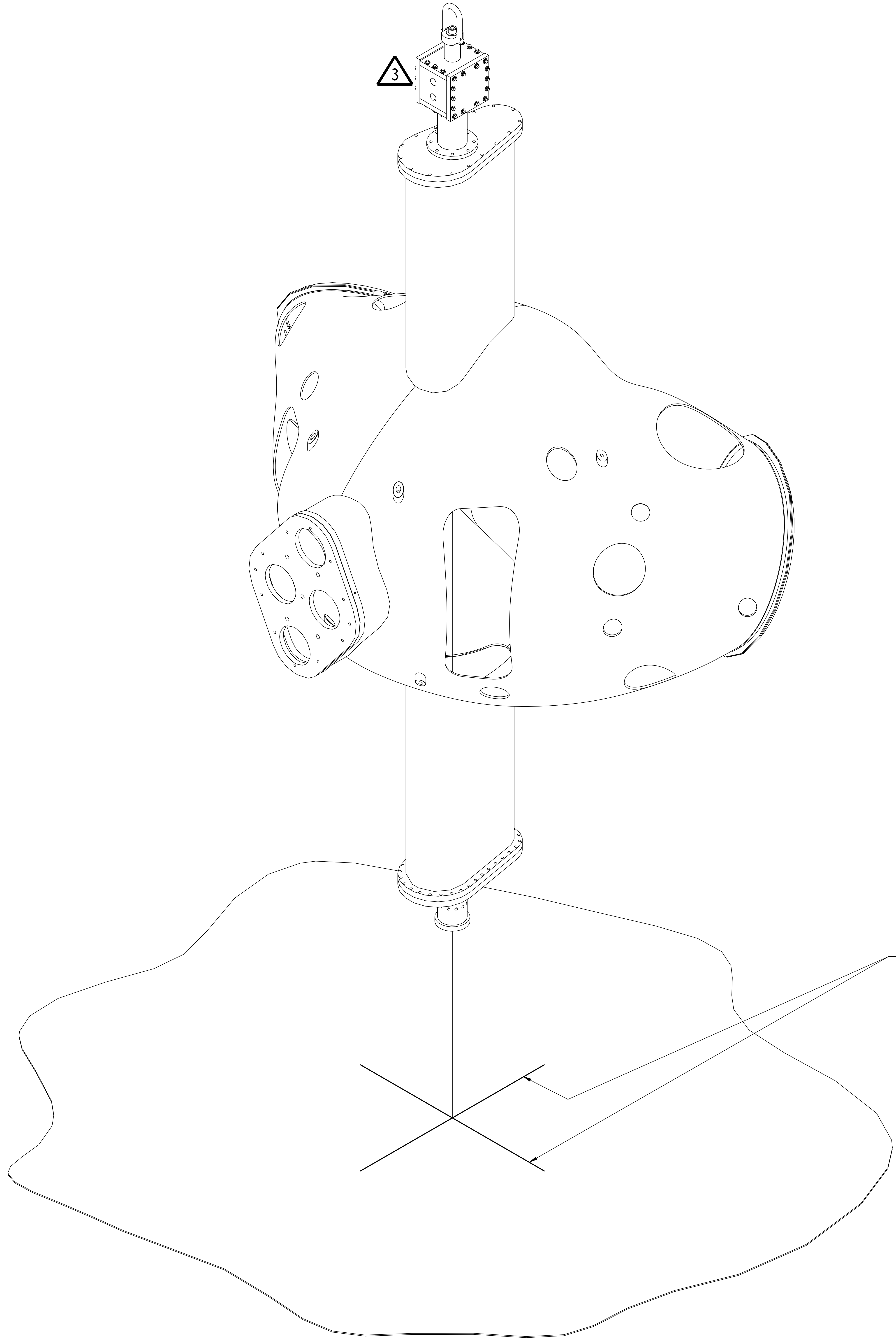
RELEASE LEVEL: WIP
DWG VERSION NO: 0

WEIGHT	16398.6 lbs
MODEL NAME	SE184-001-01
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	EXTERNAL FLUX LOOPS VACUUM VESSEL SUPPORT STAND FIXTURE ASSEMBLY	
NEXT ASSEMBLY	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX +/- .030 .XXX +/- .005 ANGULAR +/- .0°-15°	DSN: L. MORRIS CHK: ENGR: T. BROWN SUPV:	DRAWING NO: SE184-001 SHEET 3 OF 4 REV 3.1

NCSX-SE184-001

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



TARGET CROSSHAIRS ON FLOOR FOR VERTICAL ALIGNMENT OF VACUUM VESSEL SEGMENT CENTER OF GRAVITY

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

RELEASE LEVEL: WIP
 DWG VERSION NO: 0

WEIGHT
 16398.6 lbs
 MODEL NAME
 SE184-001-01
 WELDING ENGINEER

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	EXTERNAL FLUX LOOPS VACUUM VESSEL SUPPORT STAND FIXTURE ASSEMBLY	
NEXT ASSEMBLY	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .X +/- .000 0°-120° +/- .010 .XX +/- .005 120°-120° +/- .010 .XXX +/- .005 OVER 120° +/- .010	DSN: L. MORRIS CHK: ENGR: T. BROWN SUPV:	DRAWING NO: SE184-001 SHEET 4 OF 4 REV 3.1

NCSX-SE184-001