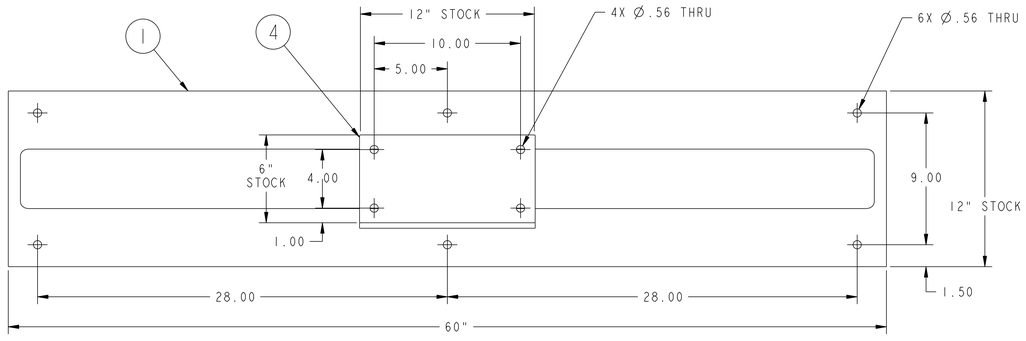
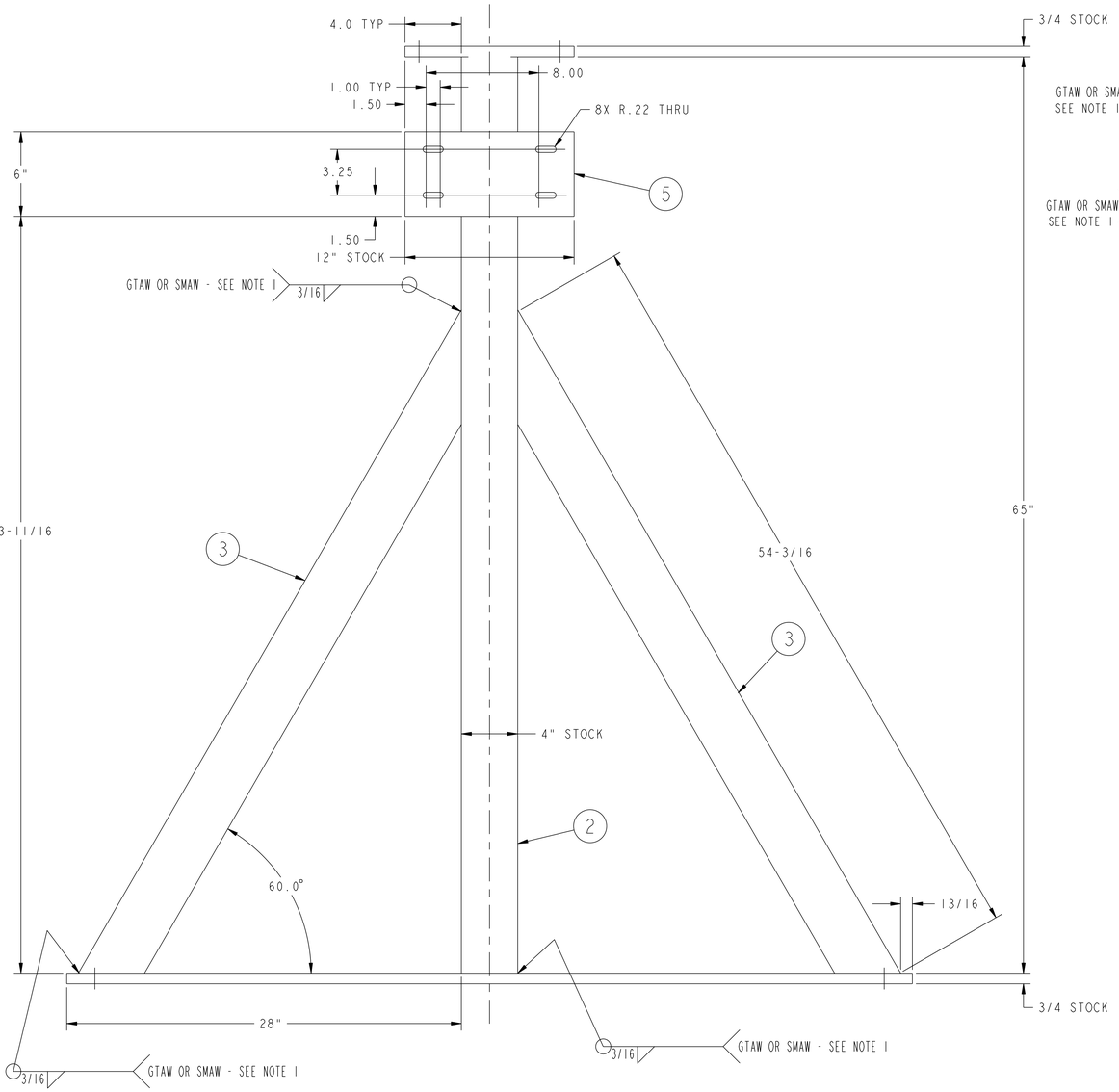
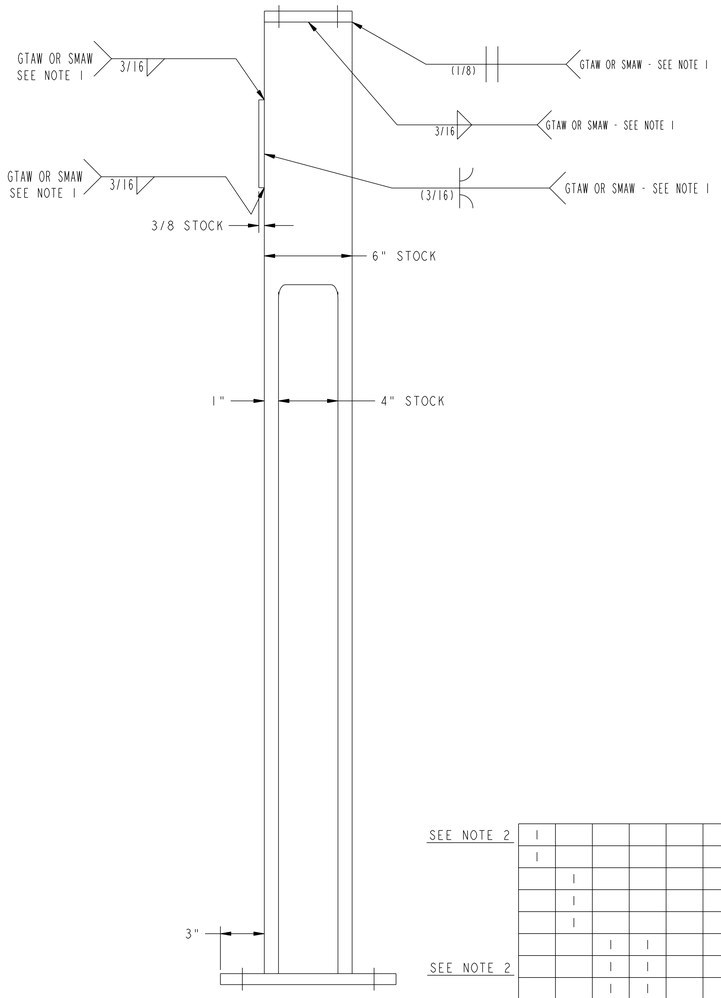
NO.	REVISION	BY	CH	SUP	APPROVED	DATE
1	REVISED PER ECN-5028	LM	TB	JS	T.BROWN	10-18-05
2	REVISED PER ECN-5077	LM	TB	JS	T.BROWN	2-16-06
3	REVISED PER ECN-	LM	TB	JS	T. BROWN	







NOTES

1. WELDING SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF AWS D1.1 AND AWS D1.3 AS APPLICABLE. WELDING PERFORMED BY PPPL SHALL ALSO MEET THE REQUIREMENTS OF 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.

01 ASSEMBLY SUPPORT STAND WELDMENT - WITH BRACKET

PARTS LIST

	06 ASSY	05 ASSY	04 ASSY	03 ASSY	02 ASSY	01 ASSY	PART NO.	DRAWING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY REQD
SEE NOTE 2	1						15	THIS DWG	WORM GEAR AXLE - Ø1 1/2 O.D. TUBE x 5/16 WALL	ASTM A513	
	1						14	THIS DWG	WORM GEAR AXLE BASE FLANGE	ASTM A36	
		1					13	THIS DWG	SUPPORT BRACKET GUSSET	ASTM A36	
		1					12	THIS DWG	SUPPORT BRACKET TOP PLATE	ASTM A36	
		1					11	THIS DWG	SUPPORT BRACKET SIDE PLATE	ASTM A36	
			1	1			10	THIS DWG	SUPPORT AXLE CAP	ASTM A36	
SEE NOTE 2			1	1			9	THIS DWG	SUPPORT AXLE - Ø5.50 O.D. TUBE x .1/2 WALL	ASTM A513	
			1	1			8	THIS DWG	SUPPORT AXLE BASE FLANGE	ASTM A36	
					1		7	THIS DWG	OUTRIGGER BASE PLATE	ASTM A36	
					1		6	THIS DWG	OUTRIGGER - 4" x 4" x 1/4" STRUCT TUBING	ASTM A36	
						1	5	THIS DWG	WORM SUPPORT BRACKET MOUNTING PLATE	ASTM A36	
					1	1	4	THIS DWG	SUPPORT STAND TOP PLATE	ASTM A36	
					2	2	3	THIS DWG	SUPPORT STAND BRACE - 4" x 4" x 1/4" STRUCT TUBING	ASTM A36	
					1	1	2	THIS DWG	SUPPORT STAND UPRIGHT - 6" x 4" X 1/4" STRUCT TUBING	ASTM A36	
					1	1	1	THIS DWG	SUPPORT STAND BASE PLATE	ASTM A36	
	X						—	THIS DWG	WORM GEAR AXLE WELDMENT	———	1
		X					—	THIS DWG	WORM SUPPORT BRACKET WELDMENT	———	1
			X				—	THIS DWG	SUPPORT AXLE WELDMENT - TYPE "B"	———	1
				X			—	THIS DWG	SUPPORT AXLE WELDMENT - TYPE "A"	———	1
					X		—	THIS DWG	SUPPORT STAND WELDMENT - WITH OUTRIGGER	———	1
						X	—	THIS DWG	SUPPORT STAND WELDMENT - WITH BRACKET	———	1

NCSX-SE184-002

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY NATIONAL COMPACT STELLARATOR EXPERIMENT	
Pro E	DIMENSIONS ARE IN INCHES MACHINE SURFACES 125	EXTERNAL FLUX LOOPS VACUUM VESSEL SUPPORT STAND FIXTURE ASSEMBLY WELDMENTS AND DETAILS	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	BREAK SHARP EDGES .005/.020		
	TOLERANCES NON-CUMULATIVE	DSN: L. MORRIS 9-28-05	DRAWING NO:
NEXT ASSEMBLY	DECIMAL-INCH FRACTIONS .X +/-.100 0°-12° +/-1/16 .XX +/-.030 12°-72° +/-1/8 .XXX +/-.005 72°-120° +/-1/4 ANGULAR +/-0°-15' OVER 120° +/-1/2	CHK: T. BROWN 9-28-05 ENGR: T. BROWN 9-28-05 SUPV: J. SIEGEL 9-28-05	SE184-002 SHEET 1 OF 3 REV 3
WEIGHT 295.2 lbs	MODEL NAME ~~SSE18844-000022-1012~~	WELDING ENGINEER L. DUDEK 10-18-05	
RELEASE LEVEL: WIP	DWG VERSION NO: 1		

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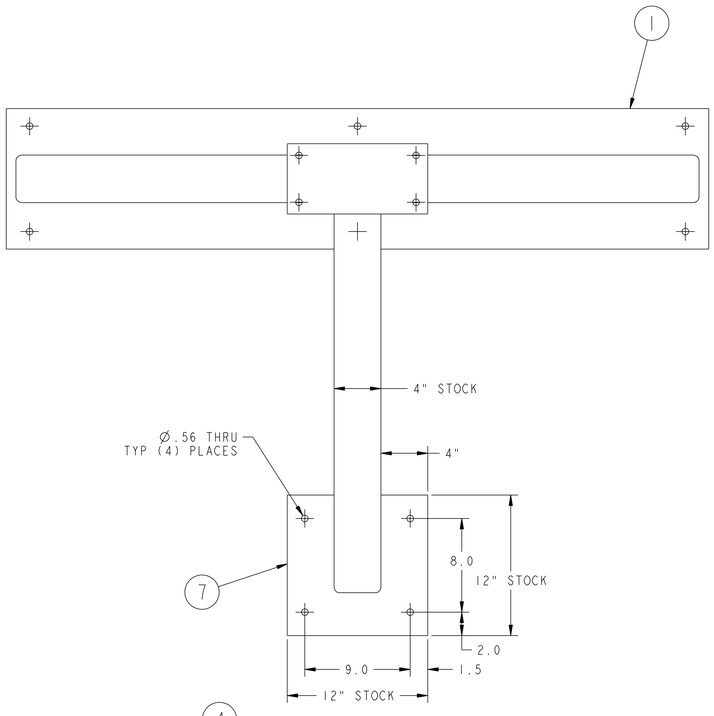
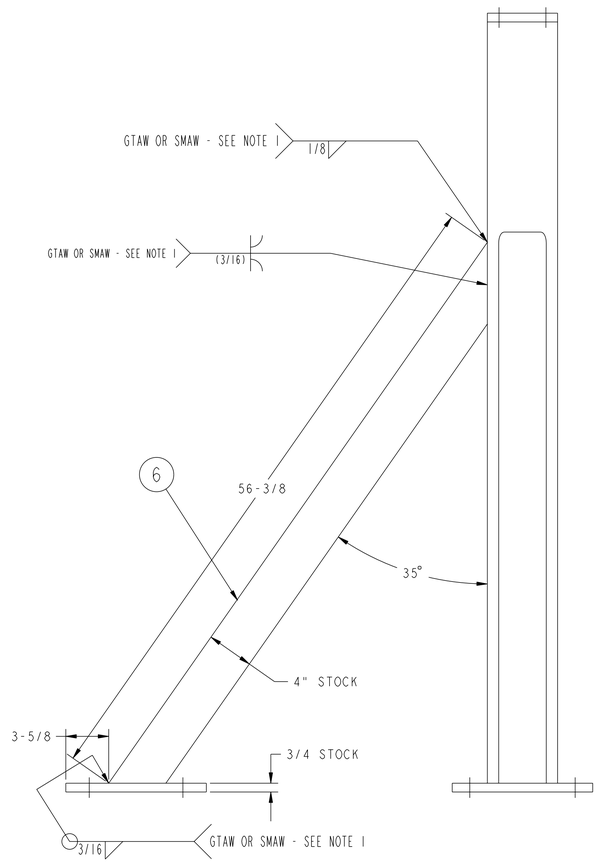
NO.	REVISION	BY	CH	SUP	APPROVED	DATE





02 ASSEMBLY SUPPORT STAND WELDMENT - WITH OUTRIGGER

REFER TO 01 ASSEMBLY FOR DIMENSIONS AND WELDMARKS NOT SHOWN HERE

FOR BILL OF MATERIAL AND NOTES SEE SHEET 1

RELEASE LEVEL: WIP
DWG VERSION NO: 1

WEIGHT	333.0 lbs
MODEL NAME	SE184-002-09
WELDING ENGINEER	L. DUDEK 10-18-05

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED

CENTRAL FILES: UNLESS OTHERWISE SPECIFIED

Pro E

DO NOT VERIFY INFORMATION BY SCALING DRAWING

DIMENSIONS ARE IN INCHES
MACHINE SURFACES 125

BREAK SHARP EDGES .005/.020

TOLERANCES NON-CUMULATIVE

NEXT ASSEMBLY

DECIMAL-INCH: .X +/-.100; .XX +/-.030; .XXX +/-.005; ANGULAR +/-0°-15'
FRACTIONS: 0°-12° +/-1/16; 12°-72° +/-1/8; 72°-120° +/-1/4; OVER 120° +/-1/2

PRINCETON PLASMA PHYSICS LABORATORY
PRINCETON UNIVERSITY
NATIONAL COMPACT STELLARATOR EXPERIMENT

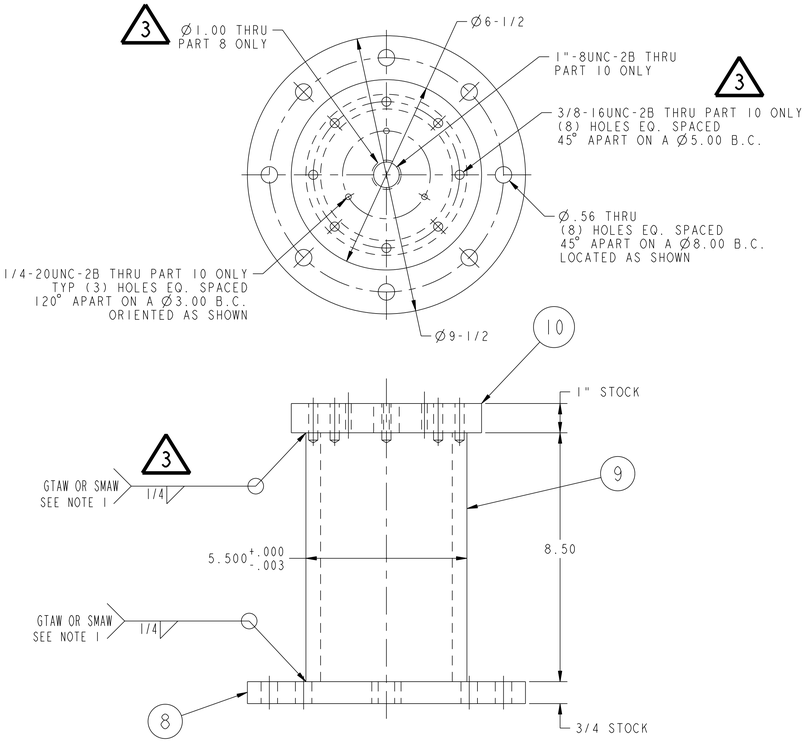
EXTERNAL FLUX LOOPS
VACUUM VESSEL SUPPORT STAND FIXTURE ASSEMBLY
WELDMENTS AND DETAILS

DSN: L. MORRIS	9-28-05	DRAWING NO: SE184-002
CHK: T. BROWN	9-28-05	
ENGR: T. BROWN	9-28-05	
SUPV: J. SIEGEL	9-28-05	SHEET 2 OF 3 REV 3

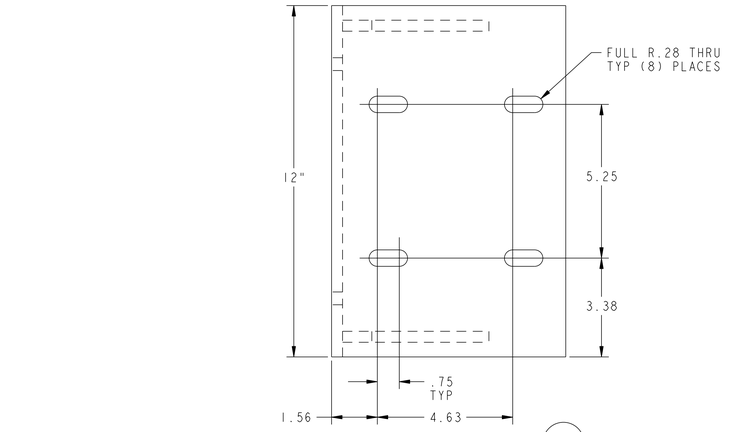
NCSX-SE184-002

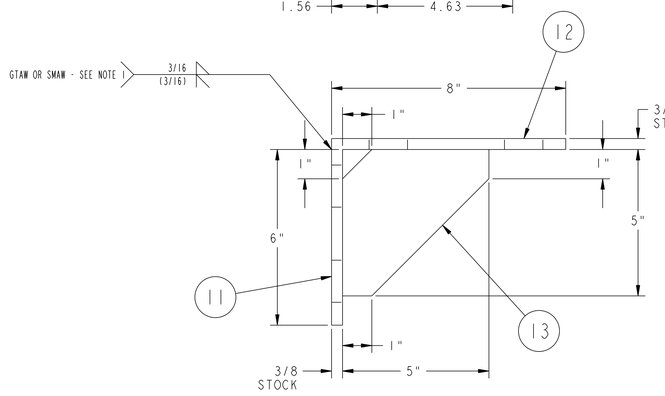
NCSX_ASSY_FORMAT_E

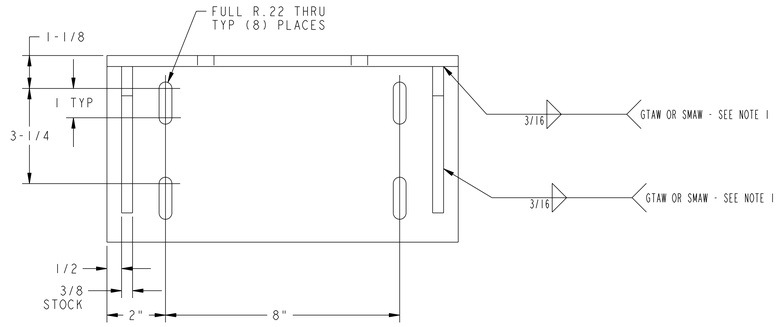
NO.	REVISION	BY	CH	SUP	APPROVED	DATE



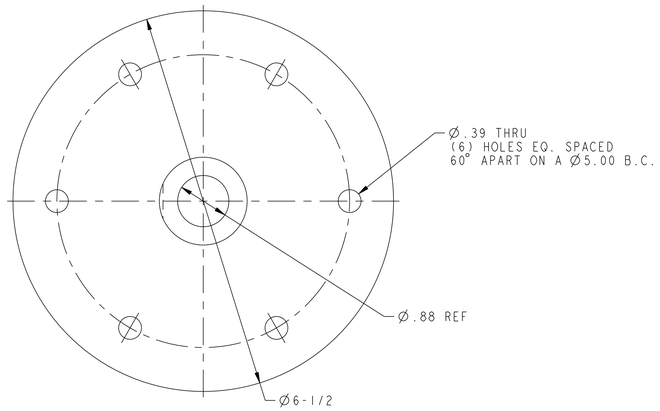
3 03 ASSEMBLY SUPPORT AXLE WELDMENT - TYPE "A"

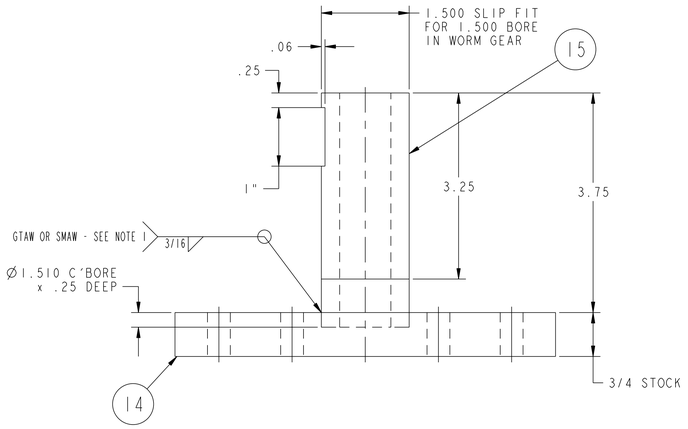




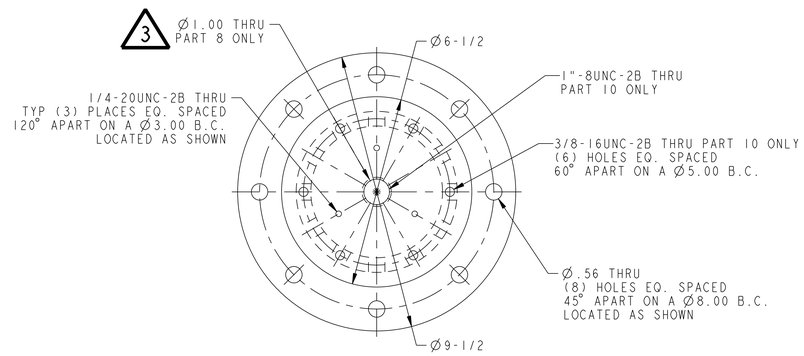


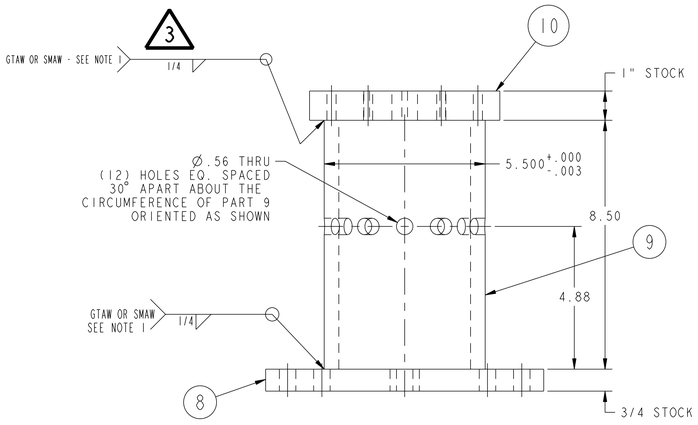
05 ASSEMBLY WORM SUPPORT BRACKET WELDMENT





06 ASSEMBLY WORM GEAR AXLE WELDMENT





3 04 ASSEMBLY SUPPORT AXLE WELDMENT - TYPE "B"

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

NCSX-SE184-002

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED	CENTRAL FILES:	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY	
	UNLESS OTHERWISE SPECIFIED	NATIONAL COMPACT STELLARATOR EXPERIMENT	
Pro E	DIMENSIONS ARE IN INCHES MACHINE SURFACES 125	EXTERNAL FLUX LOOPS VACUUM VESSEL SUPPORT STAND FIXTURE ASSEMBLY WELDMENTS AND DETAILS	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	BREAK SHARP EDGES .005/.020		
	TOLERANCES NON-CUMULATIVE	DSN: L. MORRIS	9-28-05
NEXT ASSEMBLY	DECIMAL-INCH / FRACTIONS	CHK: T. BROWN	9-28-05
	.X +/-.100 / 0°-12' +/-1/16	ENGR: T. BROWN	9-28-05
	.XX +/-.030 / 12'-72' +/-1/8	SUPV: J. SIEGEL	9-28-05
	.XXX +/-.005 / 72'-120' +/-1/4		
	ANGULAR +/-0°-15' / OVER 120' +/-1/2		

DRAWING NO: SE184-002

SHEET 3 OF 3 REV 3

WEIGHT	WELDING ENGINEER	L. DUDEK 10-18-05
*** lbs		
MODEL NAME		
SE184-002-02		

RELEASE LEVEL: WIP
DWG VERSION NO: 1

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