



NOTE: McMASTER-CARR TOOLING BALL 8481A27 IS SHOWN

MEASUREMENT POINTS (FROM CSI ON PART -093)

ID	Pt #	X	Y	Z
TOOLING BALLS	1	3.387	6.059	4.195
	2	3.536	14.538	3.607
	3	25.567	17.450	4.175
	4	25.314	2.488	5.212
SPHERICAL SEAT	1	27.370	2.343	3.639
	2	27.632	17.305	2.602
	3	2.020	10.206	2.202

ON PART -093, CS2 LOCATED FROM CSI AT A VALUE OF:
17.250 X, 10.000 Y, 0.0 Z, 0.0 RX, 0.0 RY, 0.0RZ
ON PART -176, CSI LOCATED FROM CS0 AT A VALUE OF:
17.25 X, 0.005 Y, 0.0 Z, 4.000 RX, 2.000 RY, 1.000 RZ

ARRANGEMENT FOR TEST SET-UP 1

WEIGHT 355.3 lbs MODEL NAME SE1851-180 WELDING ENGINEER	COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E DO NOT VERIFY INFORMATION BY SCALING DRAWING	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	PRINCETON PLASMA PHYSICS LABORATORY NATIONAL COMPACT STELLARATOR EXPERIMENT MODULAR COILS BALL ALIGNMENT ASSEMBLY TEST ASSEMBLY FIXTURE
	RELEASE LEVEL: DWG VERSION NO: 0	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX +/- .030 0°-120° +/- .010 .XXX +/- .005 120°-120° +/- .010 ANGULAR +/- .0°-15° OVER 120° +/- .010	DSN: L. MORRIS CHK: ENGR. T. BROWN SUPV:

NCSX-SE1851-180