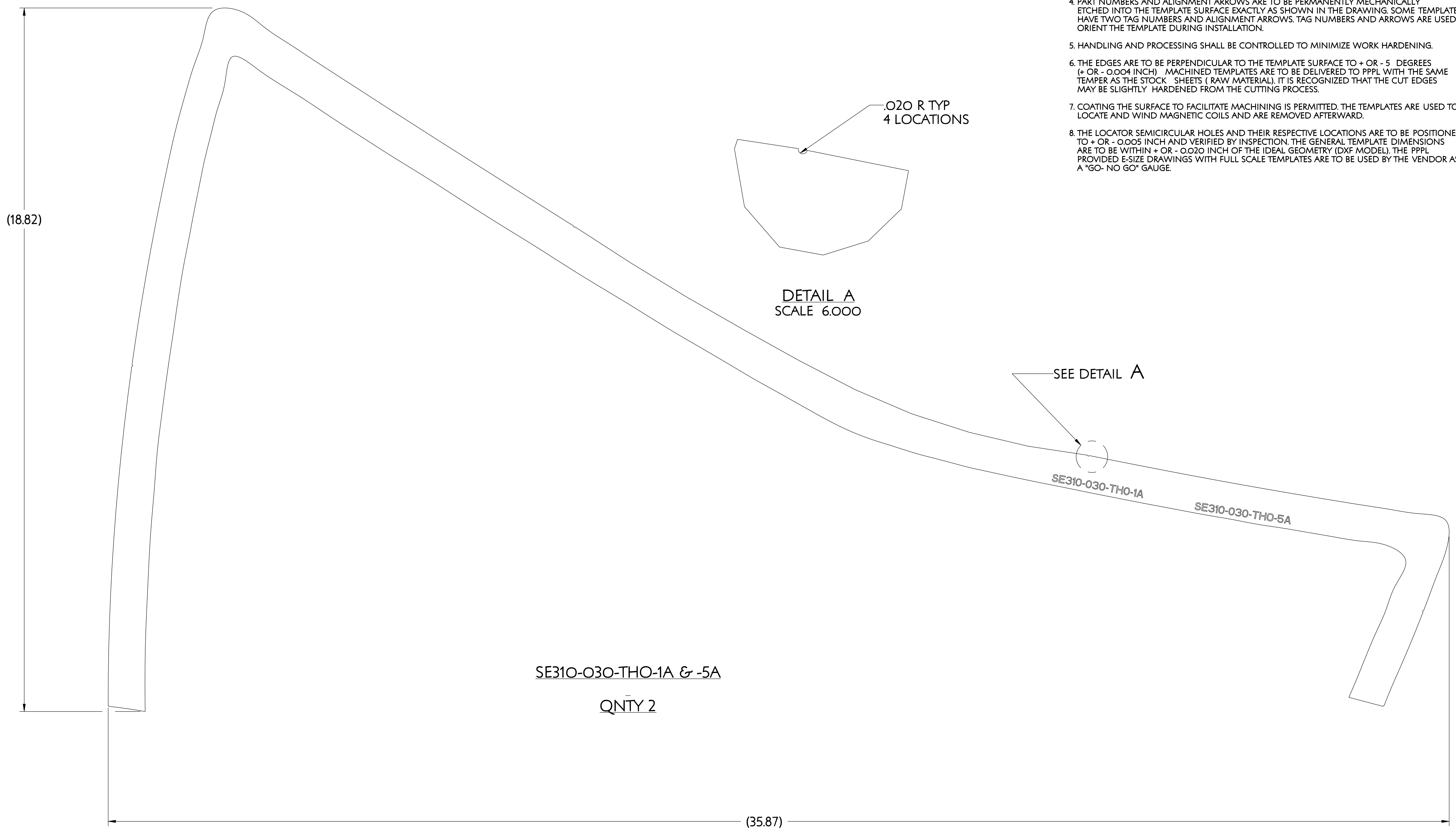


NO.	REVISION	BY	CH	SUP	APPROVED	DATE

NOTES:

- DRAWING DEPICTS FLAT PATTERN OF FORMED PARTS DEFINED BY PRO/ENGINEER FILES SE310-030-B*.PRT.
- THE MATERIAL USED SHALL BE COPPER ALLOY UNS C 11000, ANNEALED OR 1/8 HARD (H00-TEMPER) PER ASTM B370 OR ASTM B152
- MACHINED EDGES ARE TO BE DEBURRED AND SMOOTH TO PRECLUDE INJURY FROM HANDLING.
- 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.
- HANDLING AND PROCESSING SHALL BE CONTROLLED TO MINIMIZE WORK HARDENING.
- 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.
- COATING THE SURFACE TO FACILITATE MACHINING IS PERMITTED. THE TEMPLATES ARE USED TO LOCATE AND WIND MAGNETIC COILS AND ARE REMOVED AFTERWARD.
- 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.



SE310-030-TH0-1A & -5A
QNTY 2

(35.87)

(18.82)

DETAIL A
SCALE 6.000

.020 R TYP
4 LOCATIONS

SEE DETAIL A

SE310-030-TH0-1A

SE310-030-TH0-5A

RELEASE LEVEL:
DWG VERSION NO:

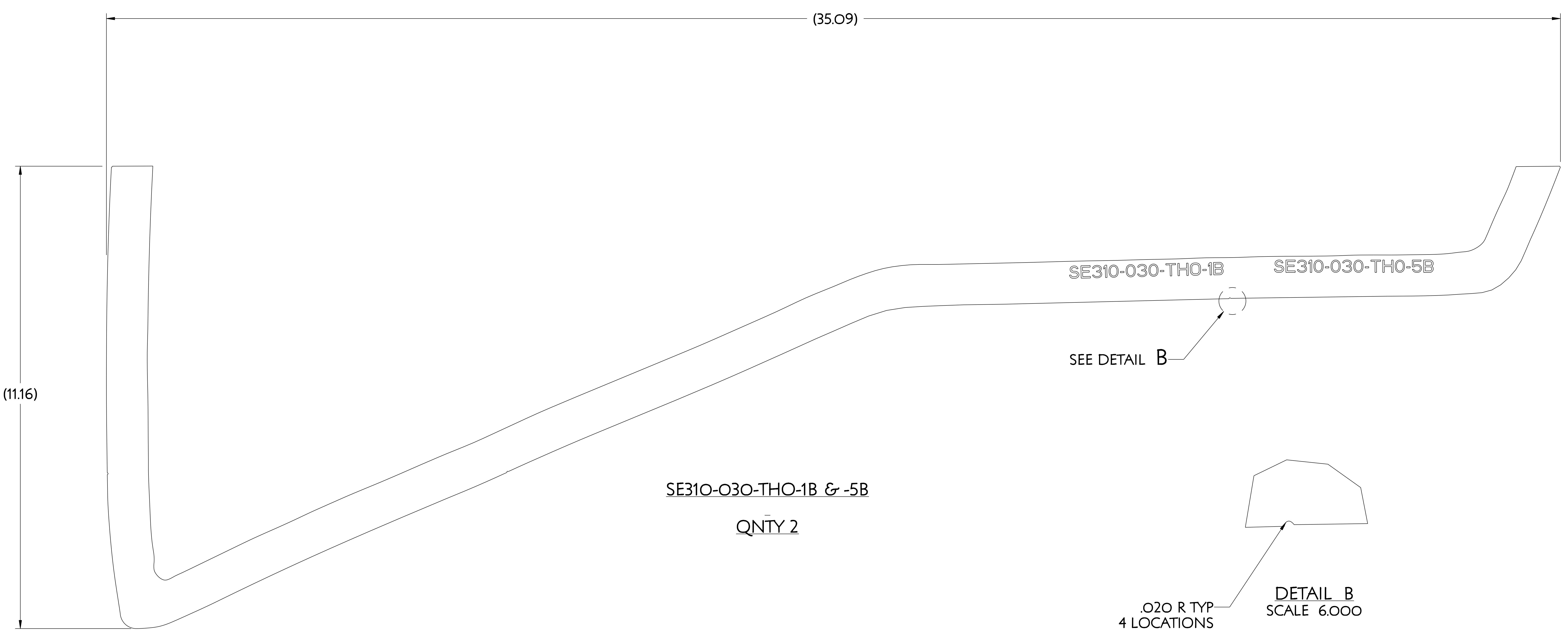
WEIGHT
0.0 lbs
MODEL NAME
SE310-030-TH0-1B
WELDING
ENGINEER

PART NO.	DRAWING NO	NOMENCLATURE OR DESCRIPTION	SEE NOTES	QTY REOD
PARTS LIST				
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	DIAGNOSTICS MAGNETIC DIAGNOSTICS MAGNETIC LOOPS SERIES TH0-1		
SCALE 1000	TOLERANCES NON-CUMULATIVE	DSN: J. RUSHINSKI	1/12/06	DRAWING NO:
NEXT ASSEMBLY	DECIMAL-INCH FRACTIONS	CHK: T. BROWN	1/12/06	SE310-030-TH0-1
	.X +/- .100 0°-12° +/- .124	ENGR: G. LABIK	1/12/06	
	.XX +/- .030 12°-12° +/- .118	SUPV: J. SIEGEL	1/12/06	SHEET 1 OF 2
	.XXX +/- .005 12°-120° +/- .114			REV 0
	ANGULAR +/- 0°-15° OVER 120° +/- .112			

C:\NCSX-SE310-030-TH0-1

NO.	REVISION	BY	CH	SUP	APPROVED	DATE

FOR NOTES SEE SHEET 1



RELEASE LEVEL: WIP
 DWG VERSION NO: 8

WEIGHT	0.0 lbs
MODEL NAME	SE310-030-THO-1B
WELDING ENGINEER	

PART NO.	DRAWING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY RECD
PARTS LIST				
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 BREAK SHARP EDGES .005/.020	DIAGNOSTICS MAGNETIC DIAGNOSTICS MAGNETIC LOOPS SERIES THO-1	
SCALE 1:000		TOLERANCES NON-CUMULATIVE	DSN: J. RUSHINSKI 1/12/06	DRAWING NO:
NEXT ASSEMBLY		DECIMAL-INCH FRACTIONS	CHK: T. BROWN 1/12/06	SE310-030-THO-1
		.XX +/- .000 0°-12° +/- .010	ENGR: G. LABIK 1/12/06	SHEET 2 OF 2
		.XXX +/- .005 12°-120° +/- .010	SUPV: J. SIEGEL 1/12/06	REV 0
		ANGULAR +/- .0°-15° OVER 120° +/- .120		

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