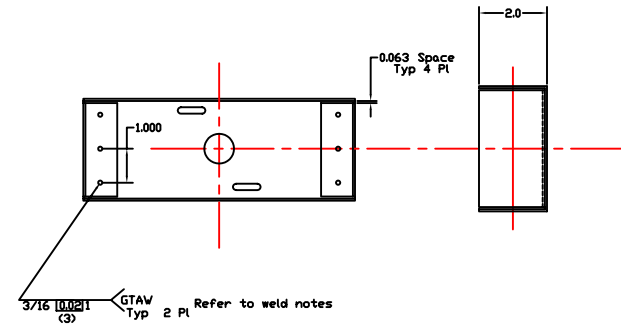
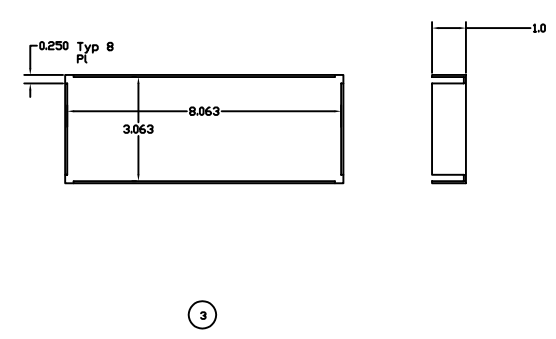
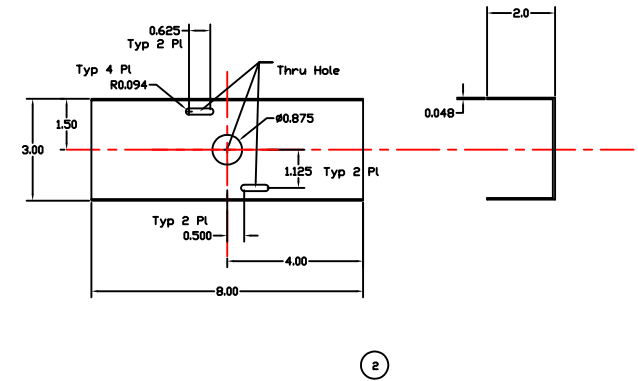
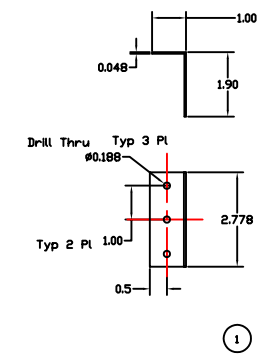


NO.	REVISION	BY	CH	SUP	APPROVED	DATE



ASSEMBLY



Weld Notes:

Welding shall be performed in accordance with the requirements of PPPL Procedure ENG 037.

Visual inspection shall be performed in accordance with the acceptance criteria of AWS D1.6

Use Inconel wire (ERNiCr-3 or ERNiCrMo-3) per PPPL Weld Procedure PPPL WPS # 107, to limit magnetic permeability

General Notes:

1. Use oversize washers to accommodate axial build of fillet weld at weld studs then standard 3/8 washer under hold down nut
2. Attach cover to base PN 3 to 2 using 0.005 inch 316 SS shim stock and spot weld

PART NO.	QUANTITY	NOMENCLATURE OR DESCRIPTION	DRAWING NO.	MATERIAL
1B 3		Cover_Plate 0.048 thick stock	This Drawing	316 SS
1B 2		Base_Plate_0.048 thick stock	This Drawing	316 SS
36 1		Base_SideAngle Plate_0.048 thick stock	This Drawing	316 SS
1B		ASSEMBLY/WELDMENT	This Drawing	

03	02	01	PART NO.	NOMENCLATURE OR DESCRIPTION	DRAWING NO.	MATERIAL
COMPUTER GENERATED DRAWING						
MANUAL CHANGES NOT PERMITTED						
AutoCAD2000						
DO NOT SCALE DIMENSIONS						
BREAK SHARP EDGES .000/.000						
TOLERANCES - NON-CUMULATIVE						
SCALE: NEXT ASSEMBLY						
DATE: 16 JAN 07						
DWN: G LABIK						
DWN: G LABIK						
CHK: M Kallish						
se 310- 033						
SHEET 1 OF 1 REV 0						

WELDING ENGINEER
 APPR: G Gettelfinger
 DATE: 16 JAN 07