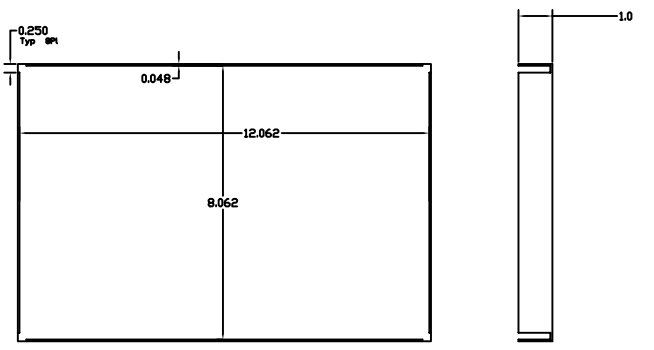
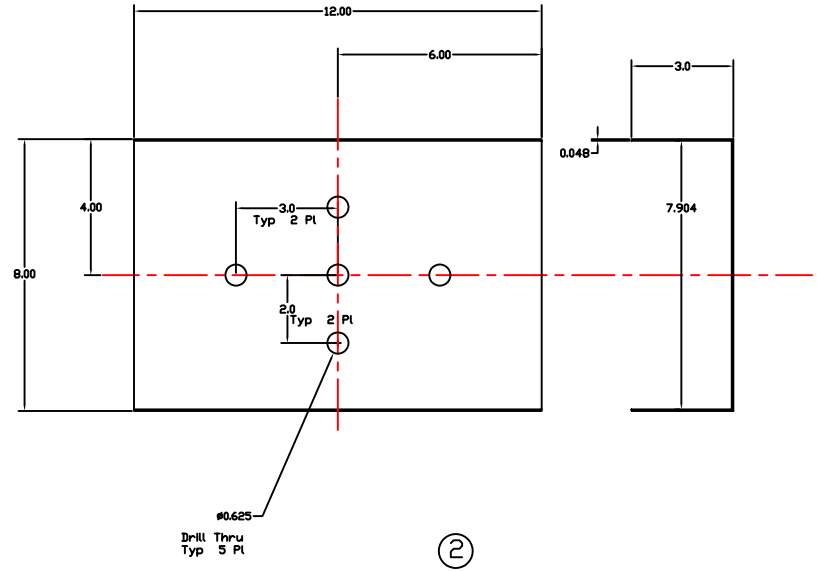
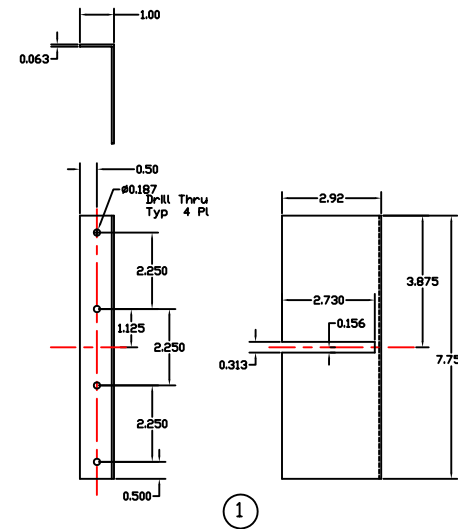


Secure base to Modular Coil using two or three 3/8 weld studs. Transfer hole pattern to Modular coil. Orient to line up one slot with sensing cables of Modular Coil.

Refer to weld notes



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 (ERN1Cr-3 or ERN1CrMo-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

RELEASED FOR FABRICATION / INSTALLATION
PPPL Drafting:

REV	NO.	DESCRIPTION	DATE	BY	CHKD	APPD
1B	3	Cover, Plate 0.048 thick stock				
1B	2	Base, Plate 0.048 thick stock				
3C	1	Base, Sideangle Plate 0.048 thick stock				
1B		ASSEMBLY/WELDMENT				

REV	NO.	DESCRIPTION	DATE	BY	CHKD	APPD
03	02	01				

COMPUTER GENERATED DRAWING	UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY
MANUAL CHANGES NOT PERMITTED	DIMENSIONS ARE IN INCHES	NATIONAL COMPACT STELLARATOR EXPERIMENT
AutoCAD2000	MACHINE SURFACES \sqrt{R}	MAGNETIC DIAGNOSTICS
DO NOT VERIFY DIMENSIONS BY SCALAR DRAWING	BREAK SHARP EDGES .000/.000	CO WOUND LOOPS - MODULAR COIL
		SENSING CABLE PROTECTIVE BOX

SCALE:	TOLERANCES - NON-CUMULATIVE	DWG: FOM	DATE: 17 JAN 07	CHG FILE:
APPV: G Gettelfinger	DATE:	APPROVED: G LABIK		se 310-032
		DWG: G LABIK		
		CHK: M Cole		SHEET 1 OF 1 REV 0

WELDING ENGINEER
 APPV: G Gettelfinger
 DATE:

APPROVED: G LABIK
 DATE:

PRINCETON PLASMA PHYSICS LABORATORY
 NATIONAL COMPACT STELLARATOR EXPERIMENT
 MAGNETIC DIAGNOSTICS
 CO WOUND LOOPS - MODULAR COIL
 SENSING CABLE PROTECTIVE BOX