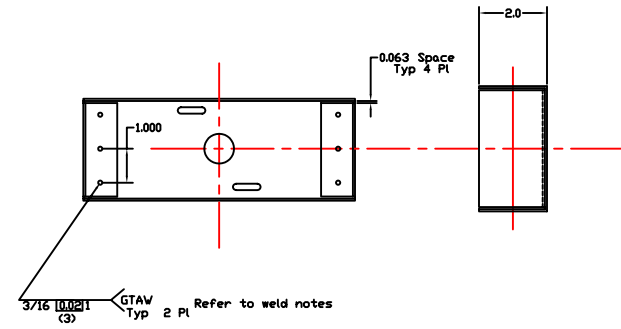
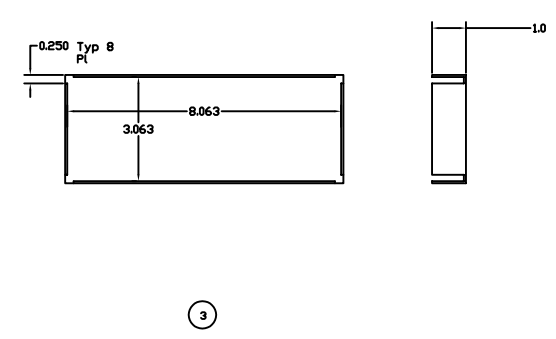
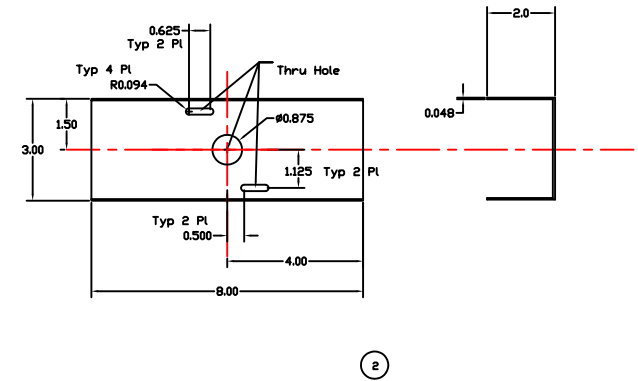
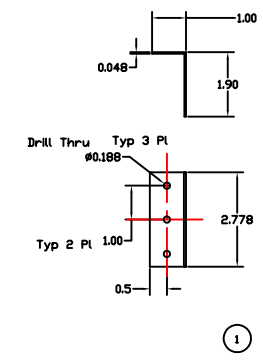


NO.	REVISION	BY	CH	SUP	APPROVED	DATE



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

**RELEASED FOR
FABRICATION / INSTALLATION**
PPPL Drafting:

REV	NO.	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			CENTRAL FILES			
MANUAL CHANGES NOT PERMITTED			UNLESS OTHERWISE SPECIFIED			
AutoCAD2000			DIMENSIONS ARE IN INCHES			
DO NOT SCALE DIMENSIONS			MACHINE SURFACES UNLESS NOTED OTHERWISE			
BREAK SHARP EDGES .000/.000			TOLERANCES NON-CUMULATIVE			
SCALE:			NEXT ASSEMBLY:		DATE: 16 JAN 07	
WELDING ENGINEER: G. LABIK			DRAWN: G. LABIK		APPROVED: G. LABIK	
DATE: 16 JAN 07			CHK: SUPP		se 310- 033	
G. Gettelfinger			CHK: M. Kalish		SHEET 1 OF 1 REV 0	

WELDING ENGINEER: G. LABIK
DATE: 16 JAN 07
G. Gettelfinger