

IDENTIFIER FOR O1 ASSEMBLY AS SHOWN.
IDENTIFIER FOR O2 ASSEMBLY TO BE ON OPPOSITE SIDE.
SEE NOTES.

NOTE

- WELDING SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF AWS D1.1 OR PPPL PROCEDURE NO. ENG-37.
- VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH THE ACCEPTANCE CRITERIA OF AWS D1.1 Section 6.
- NOTE ORIENTATION OF ALL PARTS PRIOR TO WELDING.
- BRACKET ASSEMBLY IS TO BE STAMPED OR PERMANENTLY MARKED WITH IDENTIFIER AS INDICATED.
- SAND BLAST AND APPLY 2 COATS "SAFETY YELLOW" PAINT.

O1 ASSEMBLY - AS SHOWN- (1) REQ'D
O2 ASSEMBLY - OPPOSITE - (1) REQ'D

| PART NO. | DRAWING NO | NOMENCLATURE OR DESCRIPTION | MATERIAL | QTY REQD |
|----------|-------------|---|--------------|----------|
| 4 | SE186-307-4 | GUSSET SEGMENT "C" MCWF BRACKET | ASTM A36 | 2 |
| 3 | SE186-307-3 | SIDE PLATE MCWF SEGMENT "C" SUPPORT BRACKET TYPE #1 | CARBON STEEL | 2 |
| 2 | SE186-307-2 | TOP PLATE MCWF SEGMENT "C" SUPPORT BRACKET TYPE #1 | CARBON STEEL | 1 |
| 1 | SE186-307-1 | BOTTOM PLATE MCWF SEGMENT "C" SUPPORT BRACKET TYPE #1 | CARBON STEEL | 1 |

PARTS LIST

| | | | |
|--|--|---|----------------------|
| COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED | CENTRAL FILES: UNLESS OTHERWISE SPECIFIED | PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY | |
| Pro E | DIMENSIONS ARE IN INCHES MACHINE SURFACES | NATIONAL COMPACT STELLARATOR EXPERIMENT | |
| DO NOT VERIFY INFORMATION BY SCALING DRAWING | BREAK SHARP EDGES .005/.020 | STELLARATOR CORE TOOLING DESIGN & FABRICATION | |
| SCALE 0.750 | TOLERANCES NON-CUMULATIVE | DSN: J. RUSHINSKI | 8-2-2007 DRAWING NO: |
| NEXT ASSEMBLY | DECIMAL-INCH FRACTIONS | CHK: M. COLE | 8-2-2007 |
| WEIGHT | .XX +/- .030 | ENGR: T. BROWN | 8-2-2007 |
| 88.8 lbs | .XXX +/- .005 | SUPV: J. SIEGEL | 8-2-2007 |
| MODEL NAME | ANGULAR +/- 0°-15° | | |
| SE186-307-01 | OVER 120° +/- 1/2° | | |
| WELDING ENGINEER | | | |
| G. GETTELFINGER 8-2-2007 | | | |

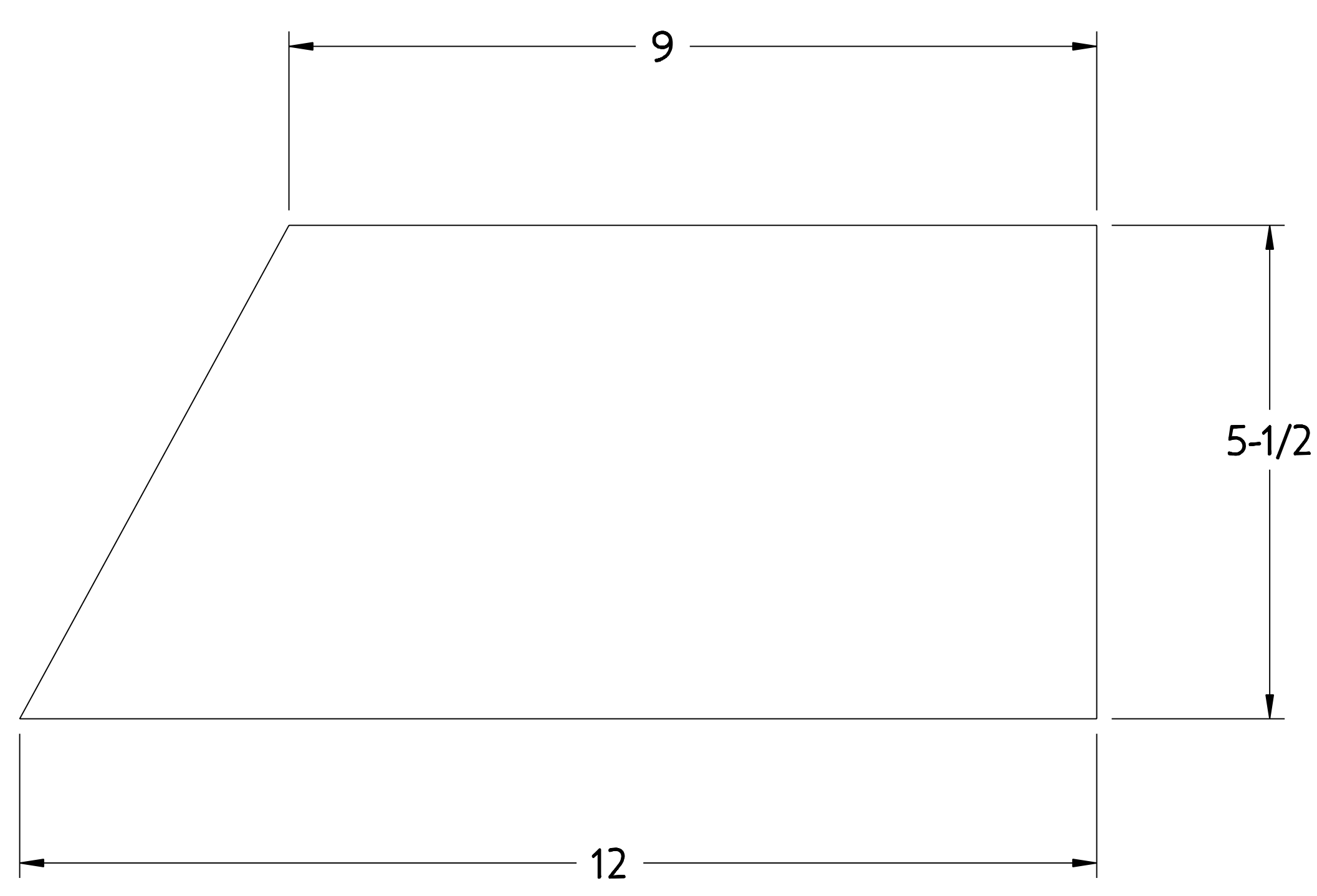
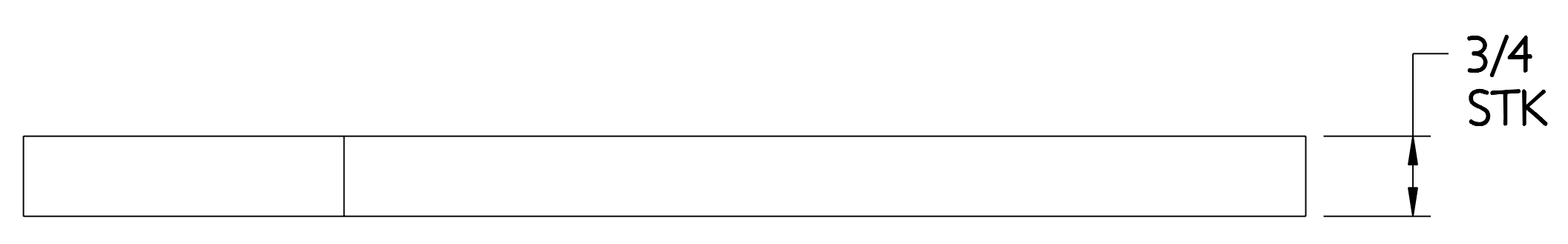
SE186-307

SHEET 1 OF 2 REV 0

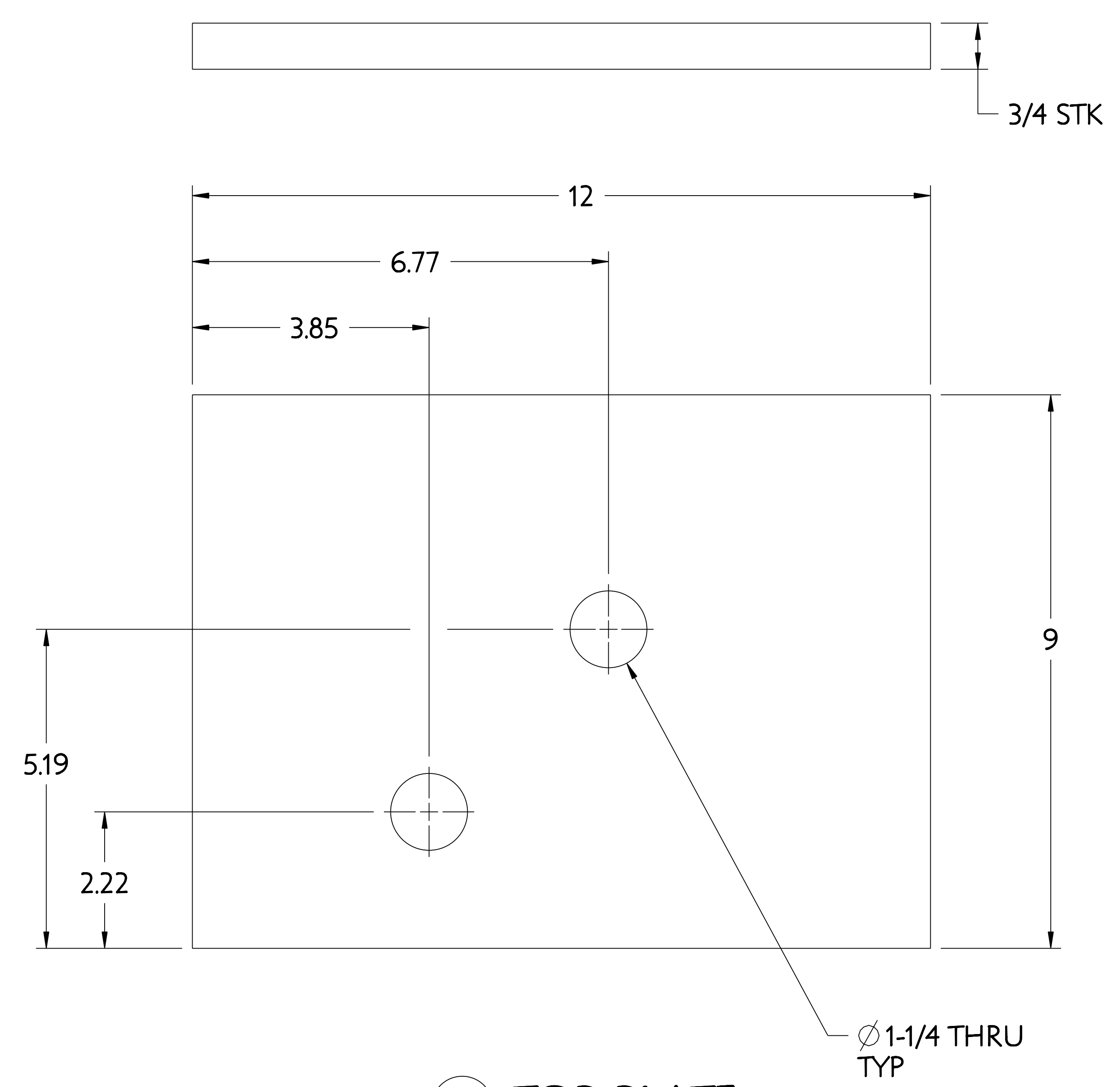
RELEASE LEVEL: ***
DWG VERSION NO: 6

NCSX-SE186-307

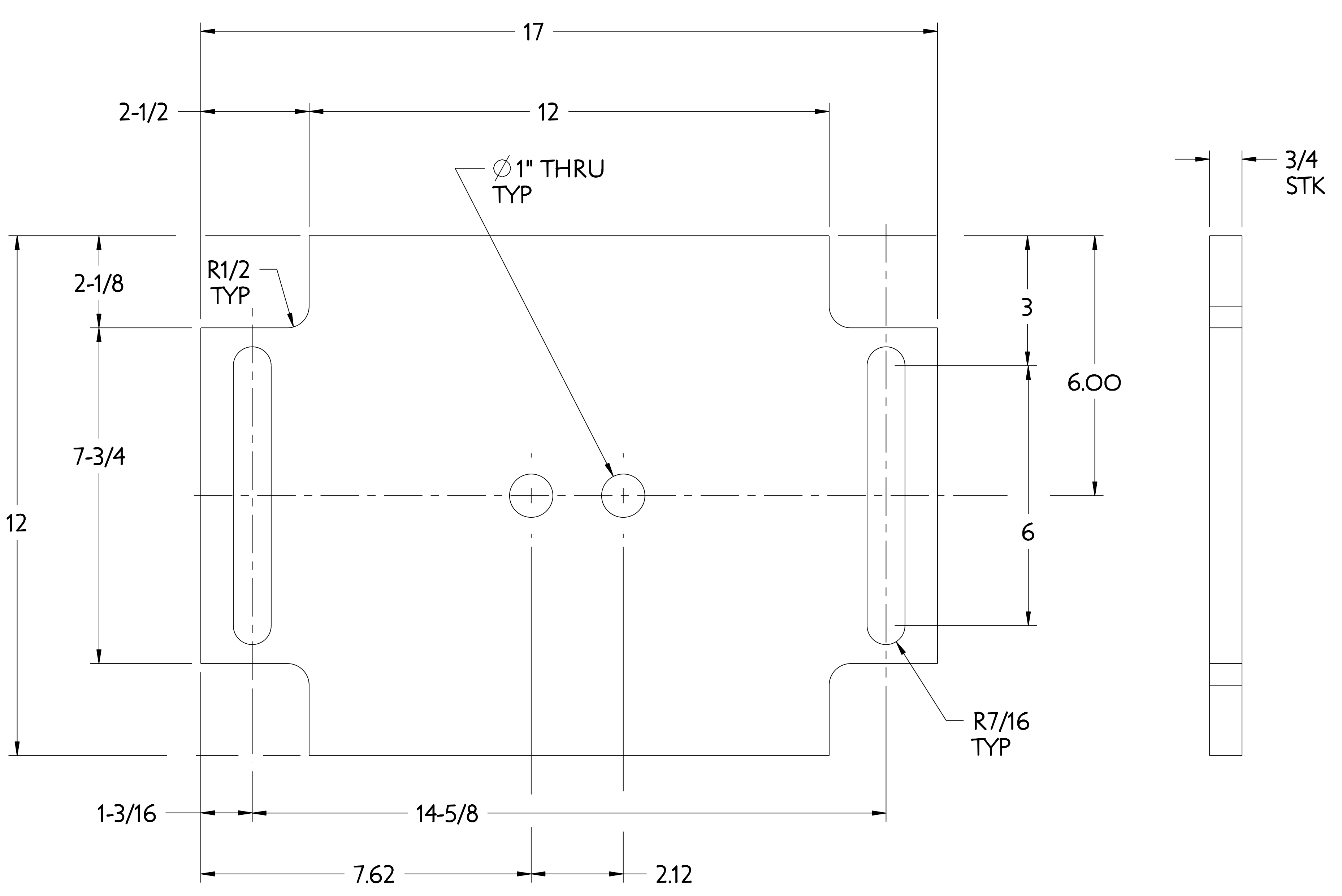
| NO. | REVISION | BY | CH | SUP | APPROVED | DATE |
|-----|----------|----|----|-----|----------|------|
| | | | | | | |



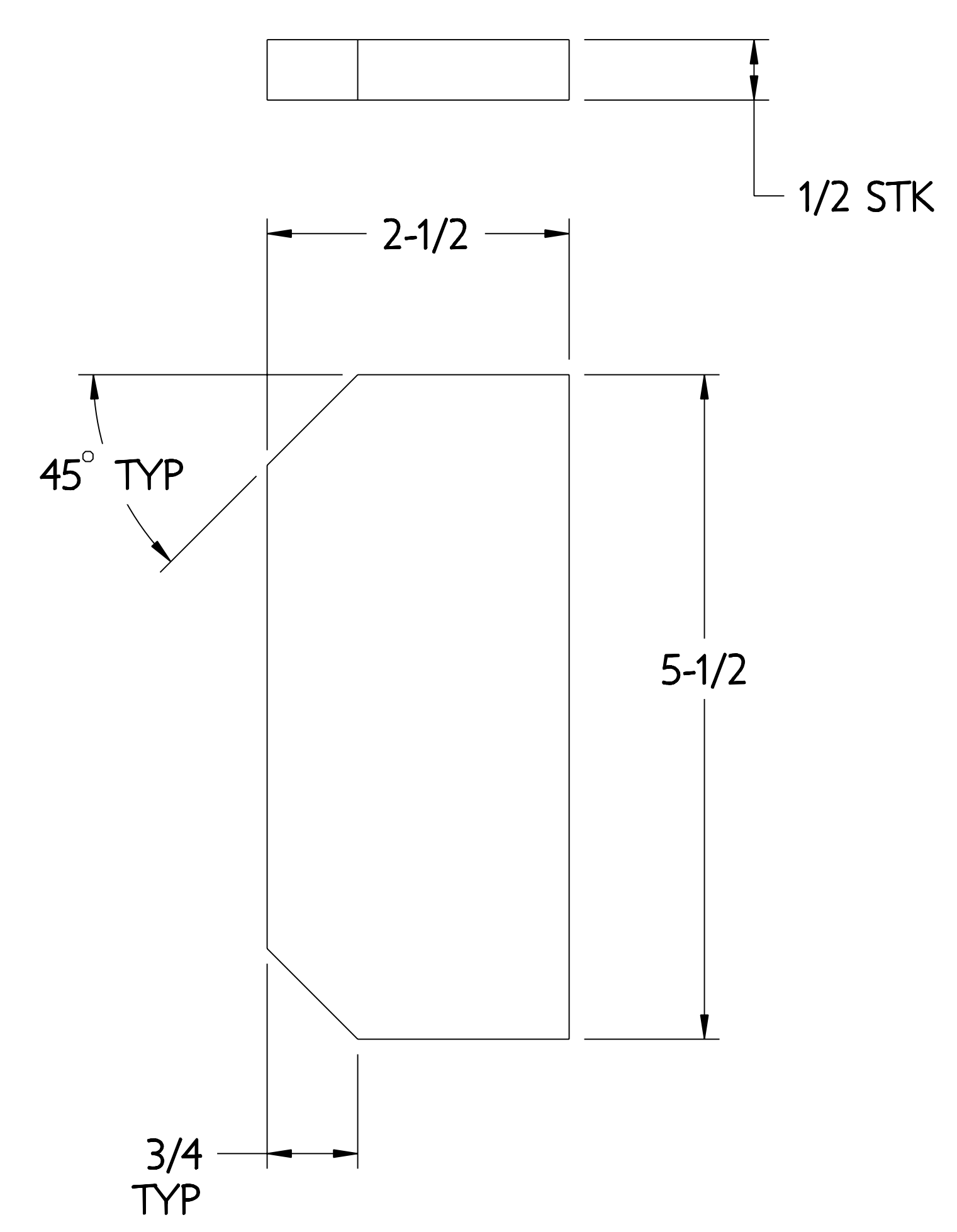
3 SIDE PLATE



2 TOP PLATE



1 BOTTOM PLATE



4 GUSSET

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

| | |
|------------------|--------------|
| WEIGHT | 88.8 lbs |
| MODEL NAME | SE186-307-01 |
| WELDING ENGINEER | |

RELEASE LEVEL: ***
DWG VERSION NO: 6

| | | |
|---|--|--|
| COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E | CENTRAL FILES: UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020 | PRINCETON PLASMA PHYSICS LABORATORY NATIONAL COMPACT STELLARATOR EXPERIMENT STELLARATOR CORE TOOLING DESIGN & FABRICATION MCWF SEGMENT "C" SUPPORT BRACKET TYPE #1 WELDMENTS |
| DO NOT VERIFY INFORMATION BY SCALING DRAWING | TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX +/- .000 0°-12° +/- .010 .XXX +/- .005 12°-120° +/- .010 ANGULAR +/- .0°-15° OVER 120° +/- .125 | DSN: J. RUSHINSKI 8-2-2007 CHK: M. COLE 8-2-2007 ENGR: T. BROWN 8-2-2007 SUPV: J. SIEGEL 8-2-2007 |
| NEXT ASSEMBLY | | DRAWING NO: SE186-307 SHEET 2 OF 2 REV 0.6 |

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