

IDENTIFIER FOR O2 ASSEMBLY AS SHOWN.  
IDENTIFIER FOR O1 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

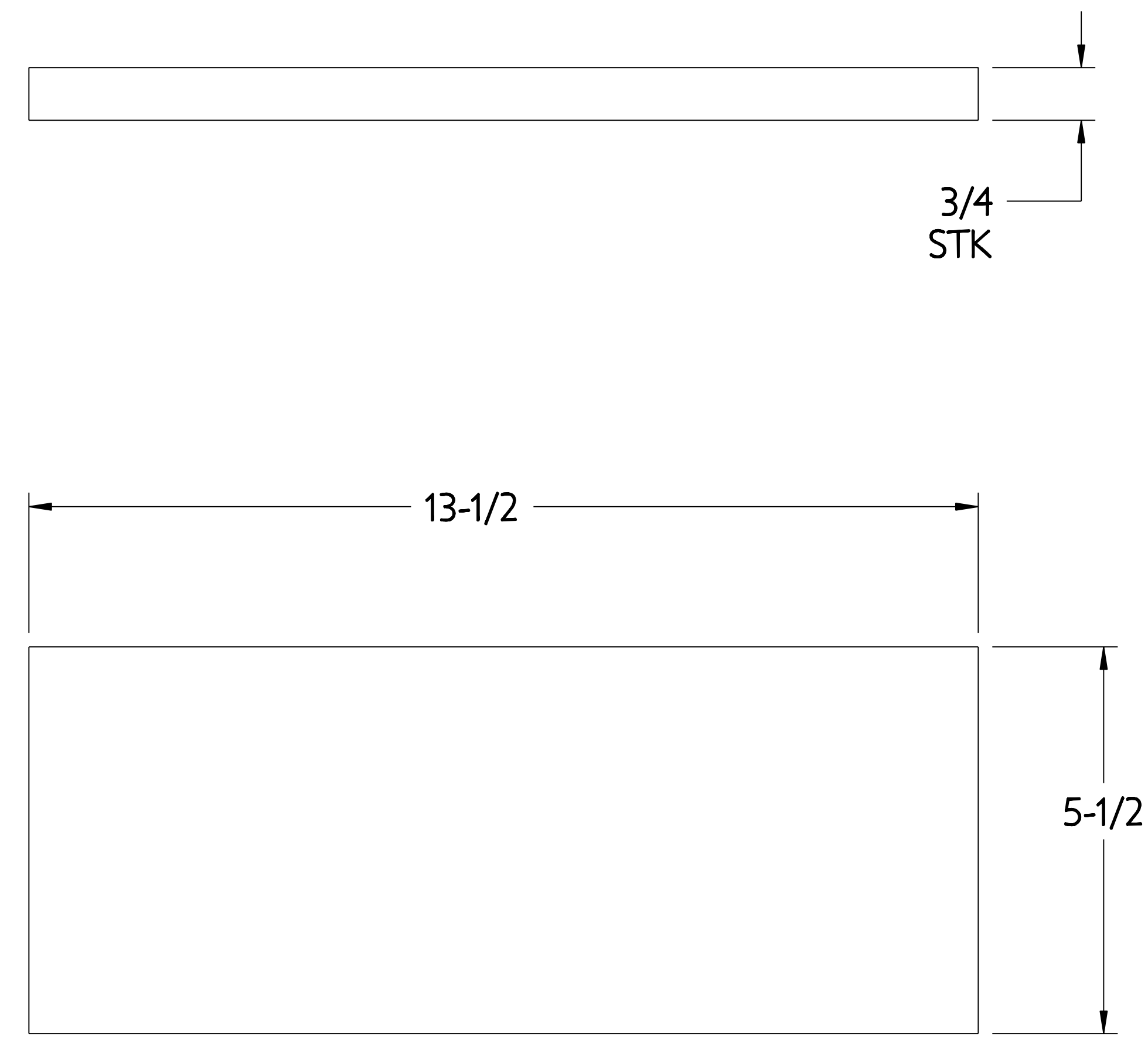
PART NO.	DRAWING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY REQD
4	SE186-308-3	BOTTOM PLATE MCWF SEGMENT "C" SUPPORT BRACKET TYPE #2	CARBON STEEL	1
3	SE186-308-2	TOP PLATE MCWF SEGMENT "C" SUPPORT BRACKET TYPE #2	CARBON STEEL	1
2	SE186-308-1	SIDE PLATE MCWF SEGMENT "C" SUPPORT BRACKET TYPE #2	CARBON STEEL	2
1	SE186-307-4	GUSSET SEGMENT "C" MCWF BRACKET	ASTM A36	2

**PARTS LIST**

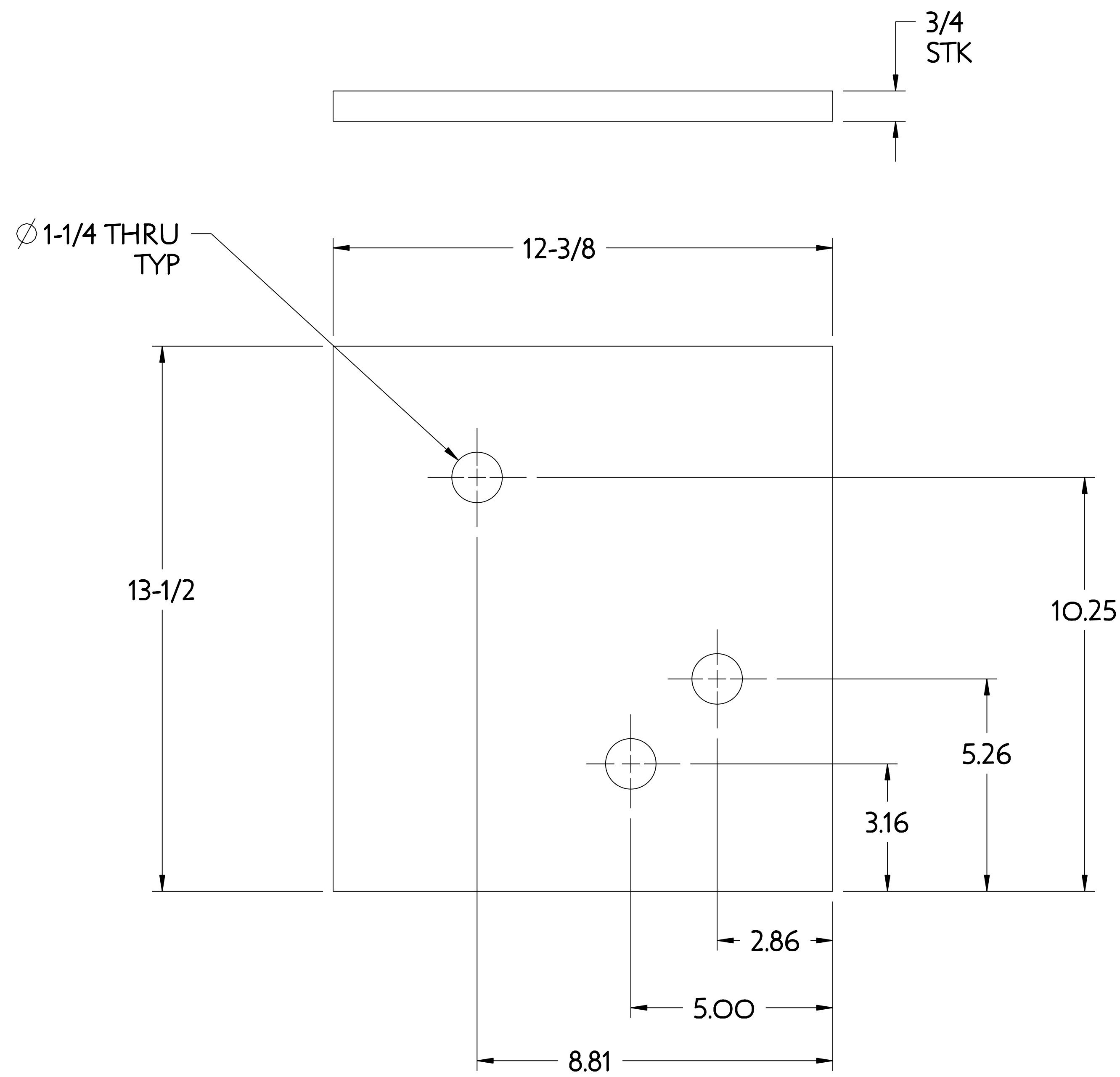
COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY NATIONAL COMPACT STELLARATOR EXPERIMENT	
Pro E	DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	STELLARATOR CORE TOOLING DESIGN & FABRICATION MCWF SEGMENT "C" SUPPORT BRACKET TYPE #2 WELDMENTS	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	SCALE 0.750	TOLERANCES NON-CUMULATIVE	DSN: J. RUSHINSKI 8-2-2007 DRAWING NO:
WEIGHT 112.1 lbs	MODEL NAME SE186-308-01	DECIMAL-INCH FRACTIONS	CHK: M. COLE 8-2-2007
RELEASE LEVEL: ***	WELDING ENGINEER: G. GETTELFINGER 8-2-2007	NEXT ASSEMBLY	ENGR: T. BROWN 8-2-2007
DWG VERSION NO: 4		ANGULAR: ±0°-15' OVER: 120°-112'	SUPV: J. SIEGEL 8-2-2007
			REV 0

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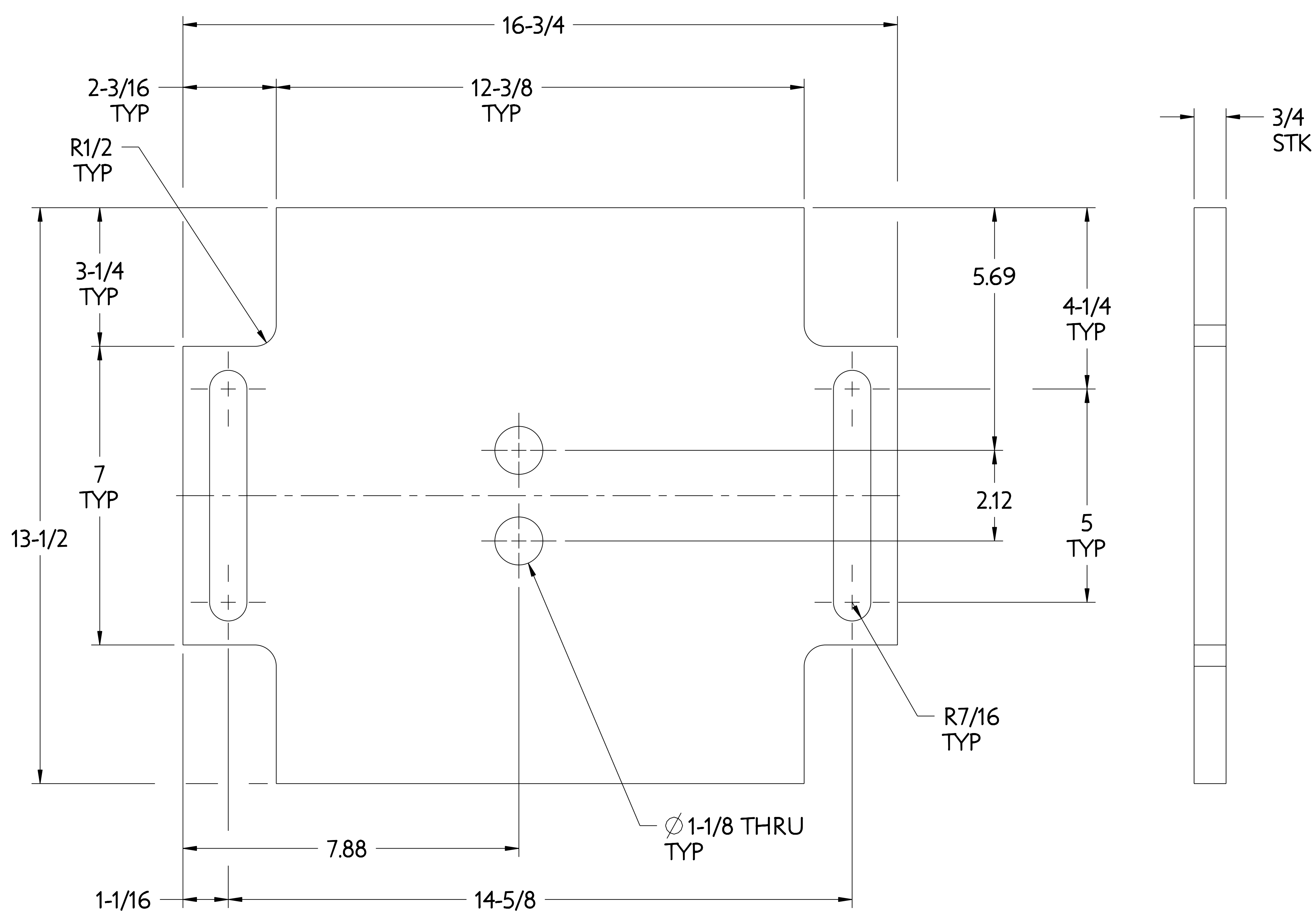
NO.	REVISION	BY	CH	SUP	APPROVED	DATE



1 SIDE PLATE



2 TOP PLATE



3 BOTTOM PLATE

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

WEIGHT	112.1 lbs
MODEL NAME	SE186-308-01
WELDING ENGINEER	

RELEASE LEVEL: \*\*\*  
DWG VERSION NO: 4

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	STELLARATOR CORE TOOLING DESIGN & FABRICATION MCWF SEGMENT "C" SUPPORT BRACKET TYPE #2 WELDMENTS
NEXT ASSEMBLY	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
		DRAWING NO: <b>SE186-308</b> SHEET 2 OF 2 REV ***

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