



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.

(6) ASSEMBLIES REQ'D

PART NO.	DRAWING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY	RECD
4	SE186-328-5	SUPPORT POST	ASTM A36	1	
3	SE186-328-3	MCWF SEGMENT TOP PLATE LARGE	ASTM A36	1	
2	SE186-328-2	MCWF SEGMENT SUPPORT LOCKING PLATE	ASTM A36	2	
1	SE186-328-1	MCWF SEGMENT SUPPORT GUSSET PLATE	ASTM A36	4	

PARTS LIST					
COMPUTER GENERATED DRAWING	CENTRAL FILES:	PRINCETON PLASMA PHYSICS LABORATORY			
MANUAL CHANGES NOT PERMITTED	UNLESS OTHERWISE SPECIFIED	NATIONAL COMPACT STELLARATOR EXPERIMENT			
DO NOT VERIFY INFORMATION BY SCALING DRAWING	DIMENSIONS ARE IN INCHES	STELLARATOR CORE			
	MACHINE SURFACES	TOOLING DESIGN & FABRICATION			
	BREAK SHARP EDGES .005/ .020	MCWF SUPPORT CART SUPPORT POST WELDMENT			
SCALE 0.625	TOLERANCES NON-CUMULATIVE	DSN: J. RUSHINSKI	8-2-2007	DRAWING NO:	
NEXT ASSEMBLY	DECIMAL-INCH FRACTIONS	CHK: M. COLE	8-2-2007	SE186-325	
	.XX +/- .030	ENGR: T. BROWN	8-2-2007		
	.XXX +/- .005	SUPV: J. SIEGEL	8-2-2007	SHEET 1 OF 1	REV 0
	ANGULAR +/- .015				

WEIGHT	93.0 lbs
MODEL NAME	SE186-325
WELDING ENGINEER	G. GETTELFINGER 8-2-2007

RELEASE LEVEL: WIP
DWG VERSION NO: 15

NCSX-SE186-325