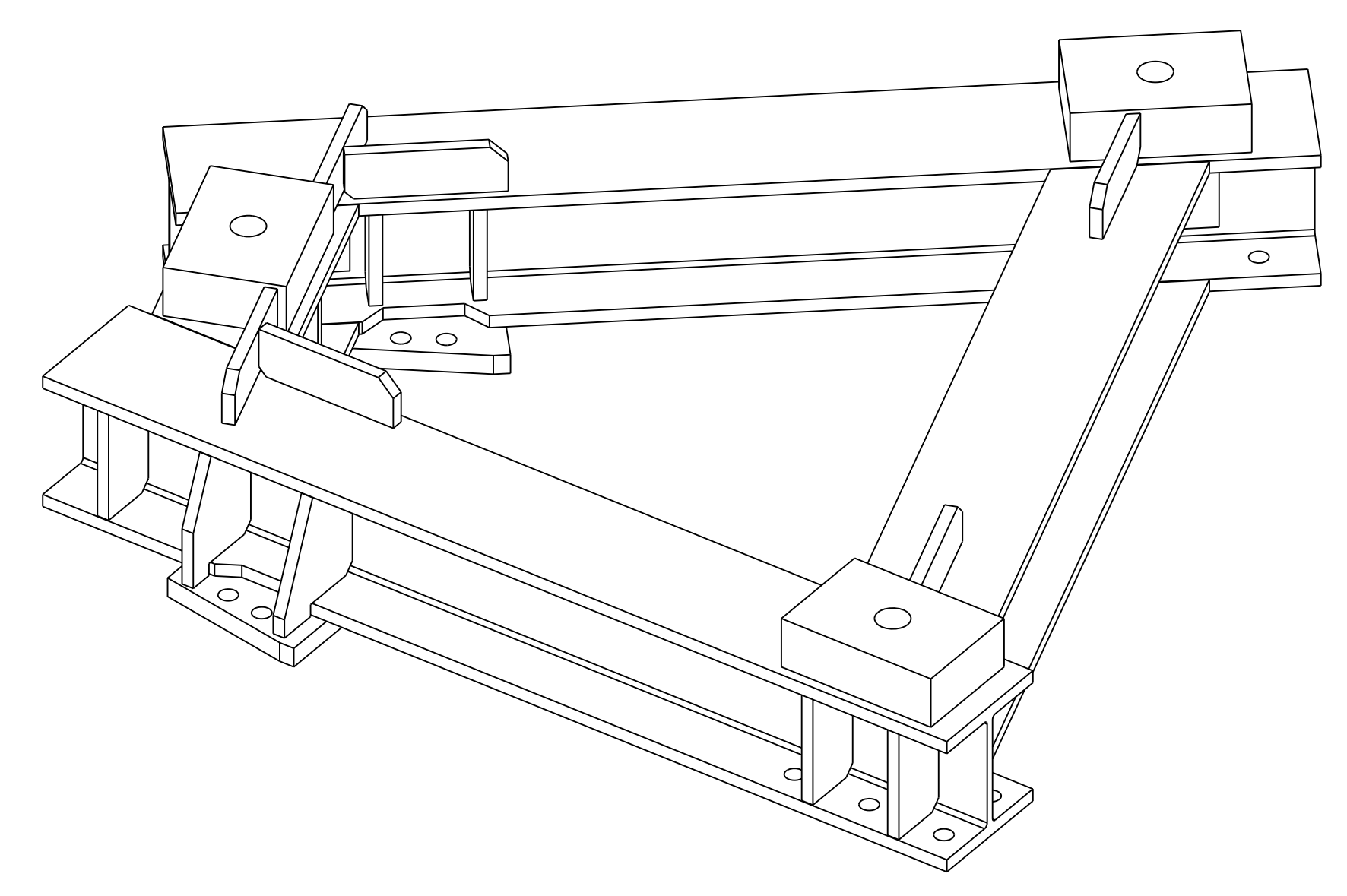
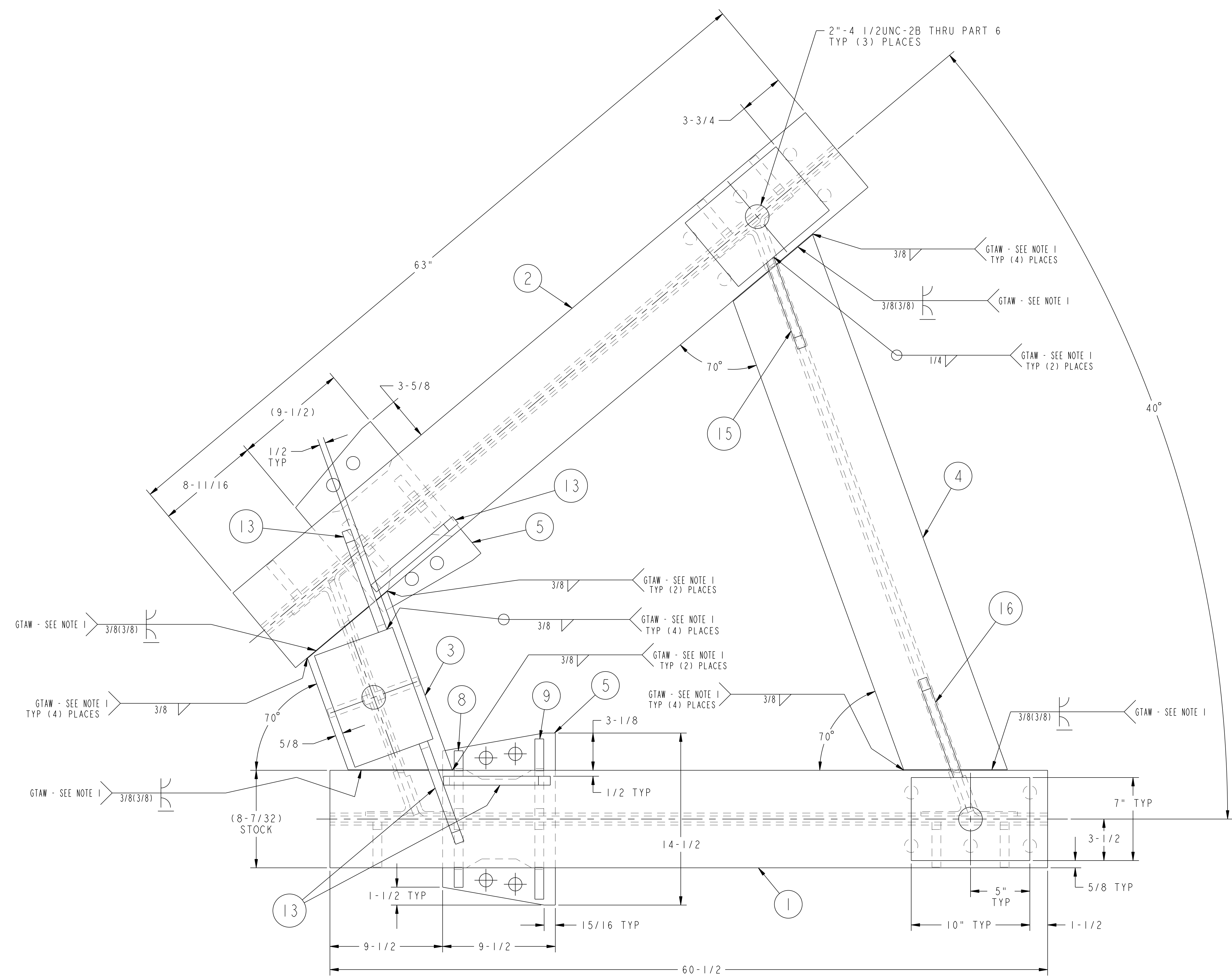


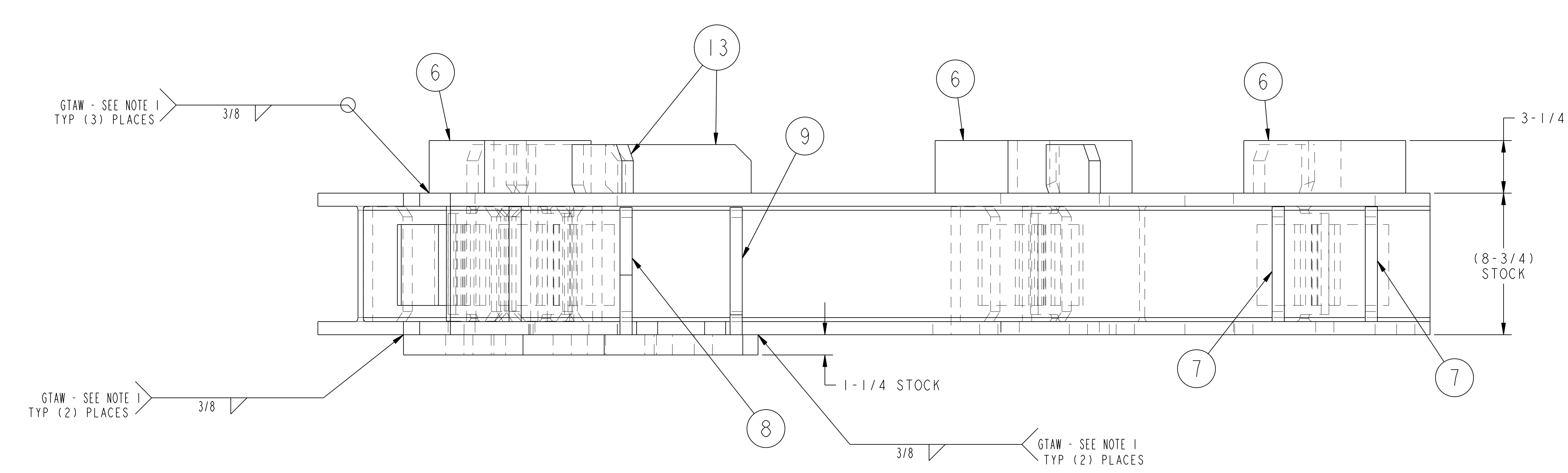
NO.	REVISION	BY	CH	SUP	APPROVED	DATE



REFERENCE ISOMETRIC
SCALE 0.125

NOTES

1. WELDING SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF AWS D1.1 OR PPPL PROCEDURE ENG-037. VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH THE ACCEPTANCE CRITERIA OF AWS D1.1 Section 6.



QTY	PART NO.	DRAWING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY REQD
1	16	THIS DWG	LIFTING BLOCK GUSSET - TYPE "C"	ASTM A36	
1	15	THIS DWG	LIFTING BLOCK GUSSET - TYPE "B"	ASTM A36	
4	14	THIS DWG	GUSSET - TYPE "D"	ASTM A36	
4	13	THIS DWG	LIFTING BLOCK GUSSET - TYPE "A"	ASTM A36	
2	12	THIS DWG	FORMED CLIP ANGLE - TYPE "C"	ASTM A36	
4	11	THIS DWG	FORMED CLIP ANGLE - TYPE "B"	ASTM A36	
2	10	THIS DWG	FORMED CLIP ANGLE - TYPE "A"	ASTM A36	
2	9	THIS DWG	GUSSET - TYPE "C"	ASTM A36	
2	8	THIS DWG	GUSSET - TYPE "B"	ASTM A36	
8	7	THIS DWG	GUSSET - TYPE "A"	ASTM A36	
3	6	THIS DWG	LIFTING EYE MOUNTING PLATE - 30000# CAP.	ASTM A36	
1	5	THIS DWG	LIFT MOUNT PLATE	ASTM A36	
1	4	THIS DWG	CONNECTING SUPPORT BEAM - LONG W8 x 58# WIDE FLANGE BEAM	ASTM A36	
1	3	THIS DWG	CONNECTING SUPPORT BEAM - SHORT W8 x 58# WIDE FLANGE BEAM	ASTM A36	
1	2	THIS DWG	LIFTING FRAME SUPPORT BEAM - TYPE "B" W8 x 58# WIDE FLANGE BEAM	ASTM A36	
1	1	THIS DWG	LIFTING FRAME SUPPORT BEAM - TYPE "A" W8 x 58# WIDE FLANGE BEAM	ASTM A36	
1		THIS DWG	LIFTING FIXTURE FRAME WELDMENT		

01	PART ASSY	DRAWING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY REQD
PARTS LIST					

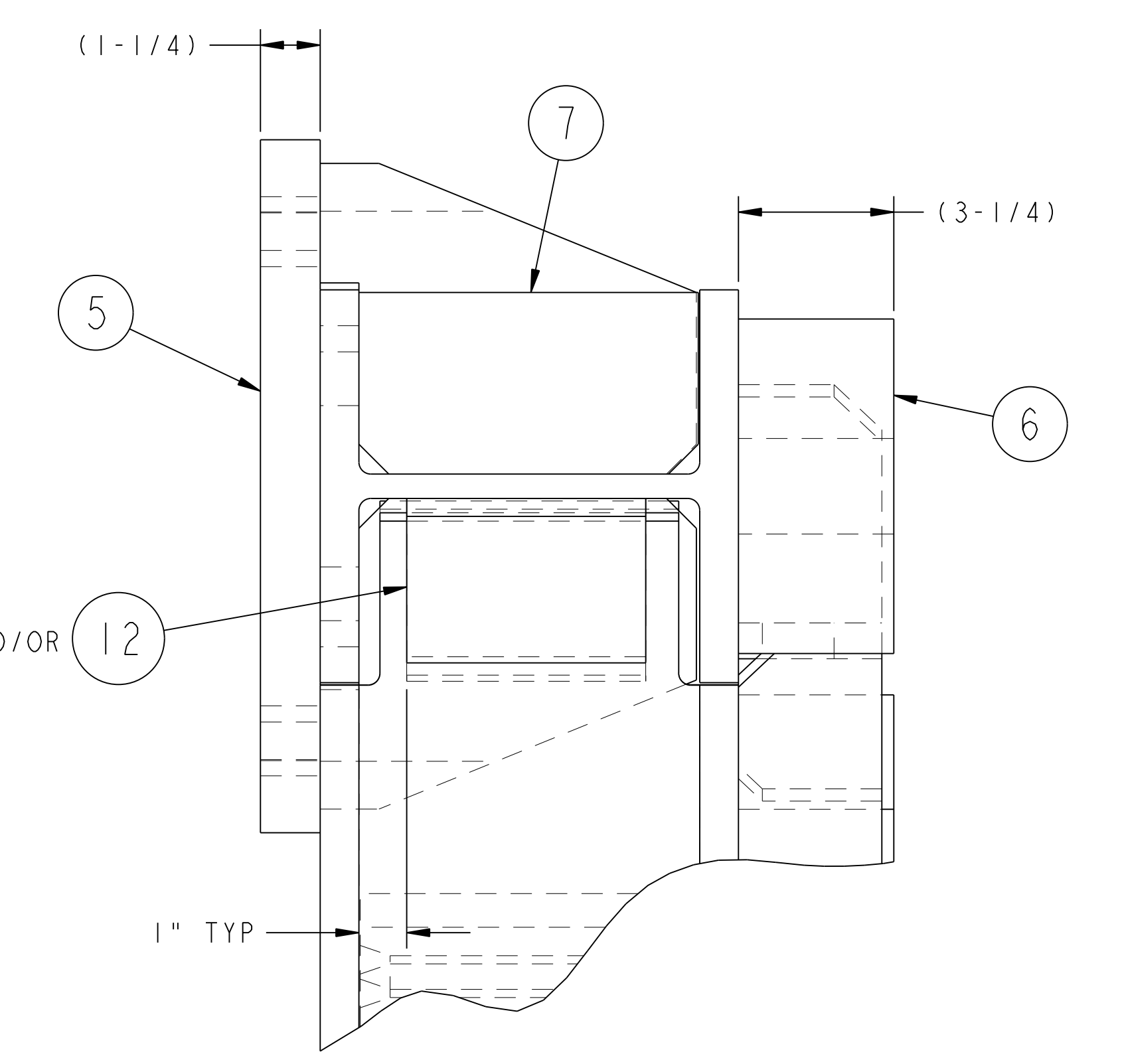
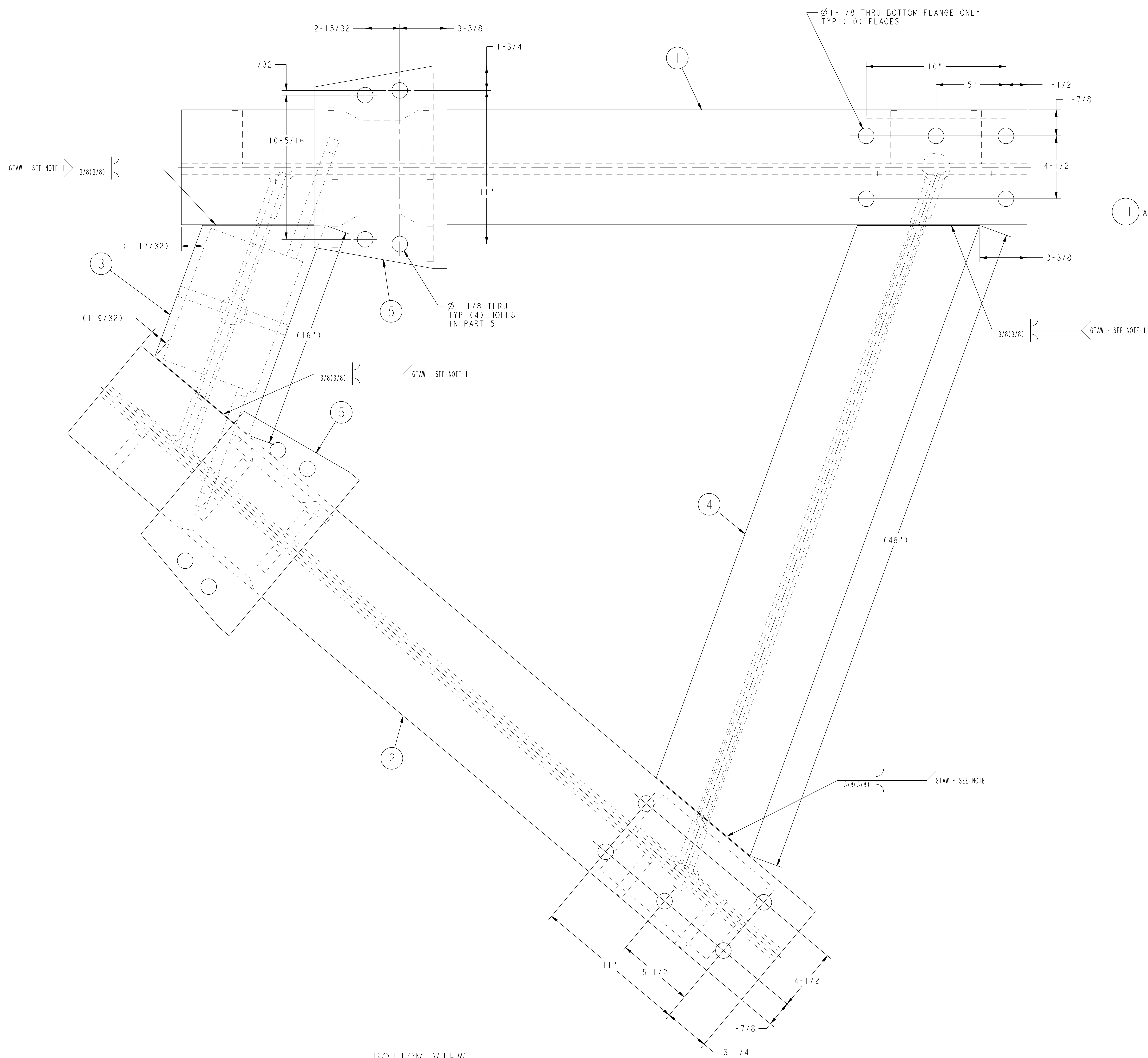
COMPUTER GENERATED DRAWING CHANGES NOT PERMITTED	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY			
Pro E	DIMENSIONS ARE IN INCHES MACHINE SURFACES	NATIONAL COMPACT STELLARATOR EXPERIMENT			
DO NOT VERIFY INFORMATION BY SCALING DRAWING	BREAK SHARP EDGES .005/.020	FIELD PERIOD ASSEMBLY FIXTURE			
WEIGHT 228.9 lbs	TOLERANCES NON-CUMULATIVE	MCWF HALF PERIOD LIFTING FIXTURE FRAME WELDMENT			
MODEL NAME SE185-316-2	DECIMAL-INCH FRACTIONS	DSN: L. MORRIS	11-19-07	DRAWING NO:	
WELDING ENGINEER L. DUDEK 11-14-07	XXX +/- .005 72"-120" +/- .124 ANGLER +/- .015	CHK: M. COLE	11-19-07	SE185-316	
		ENGR: T. BROWN	11-19-07	SHEET 1 OF 5	
		SUPV: J. SIEGEL	11-19-07	REV D, 12	

RELEASE LEVEL: WIP
DWG VERSION NO: 6

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NO.	REVISION	BY	CH	SUP	APPROVED	DATE



BOTTOM VIEW

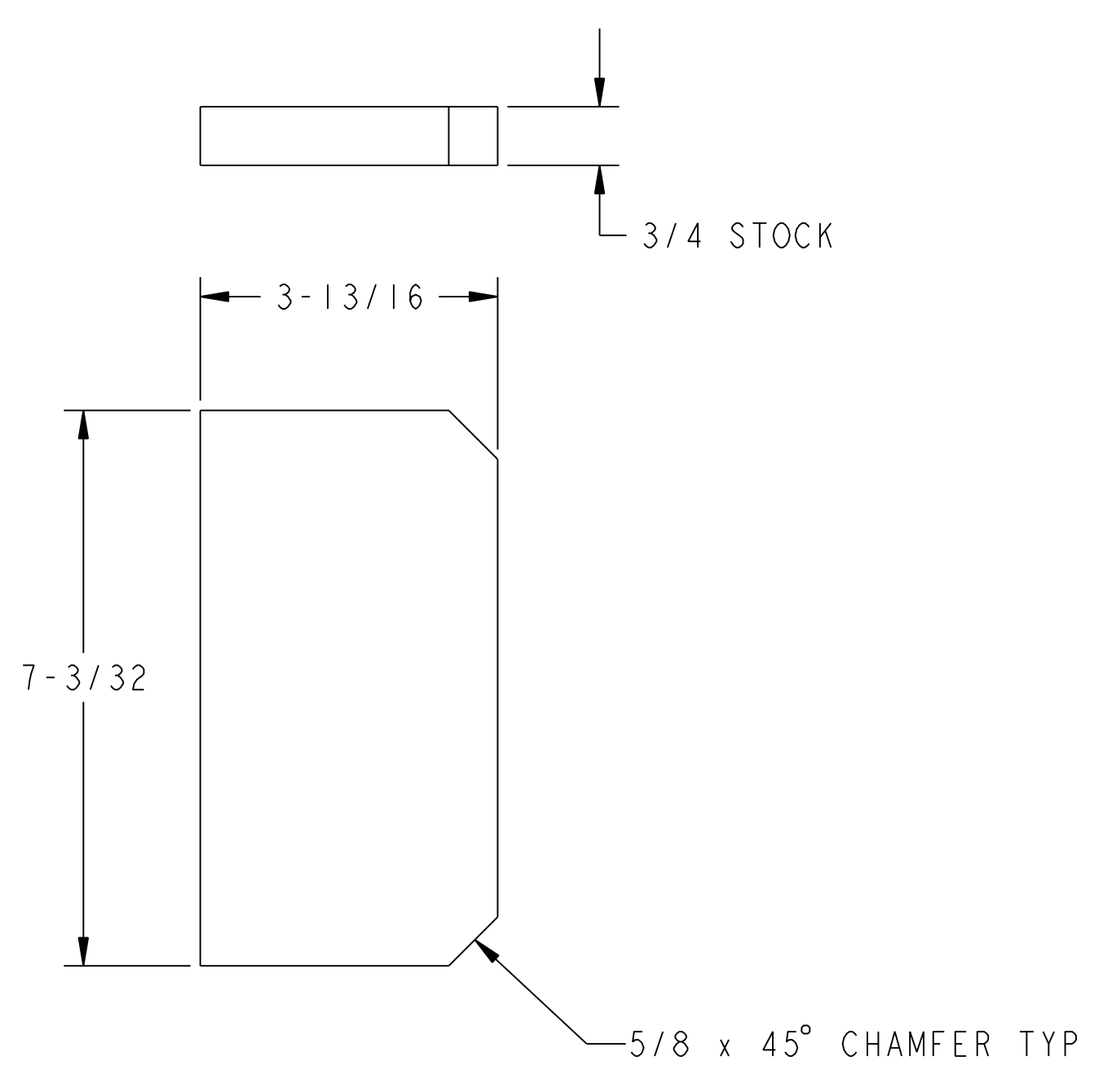
FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E DO NOT VERIFY INFORMATION BY SCALING DRAWING	CENTRAL FILES:	PRINCETON PLASMA PHYSICS LABORATORY	
	UNLESS OTHERWISE SPECIFIED	NATIONAL COMPACT STELLARATOR EXPERIMENT	
DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	TOLERANCES NON-CUMULATIVE	DSN: L. MORRIS	11-19-07
	DECIMAL-INCH FRACTIONS .X ±.100 0°-120° ±.100 .XX ±.030 12°-120° ±.100 .XXX ±.005 72°-120° ±.100 ANGULAR ±.0°-15° OVER 120° ±.100	CHK: M. COLE	11-19-07
NEXT ASSEMBLY	ENGR: T. BROWN	11-19-07	SE185-316
WELDING ENGINEER	SUPV: J. SIEGEL	11-19-07	SHEET 3 OF 5

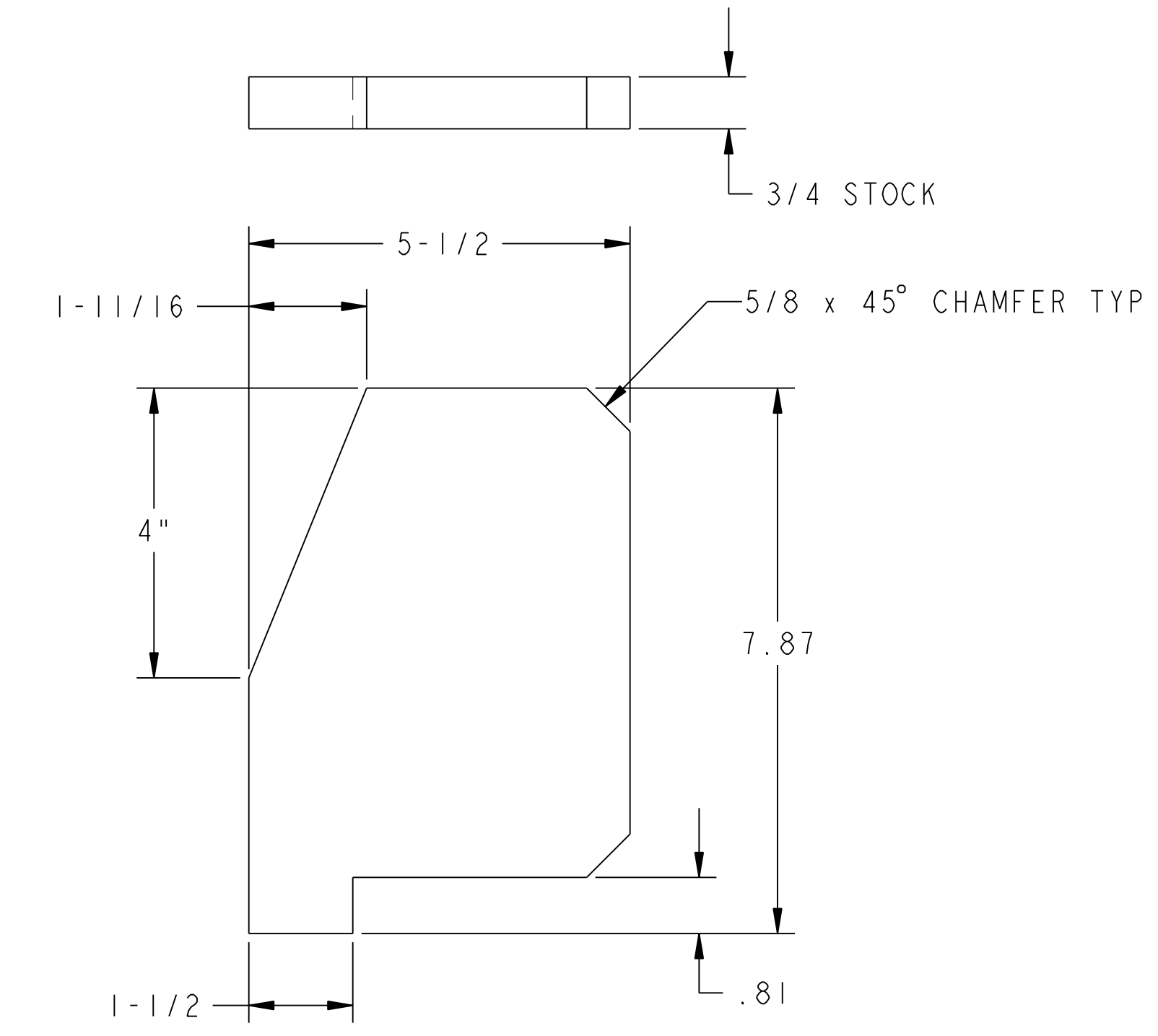
RELEASE LEVEL: WIP
DWG VERSION NO: 6

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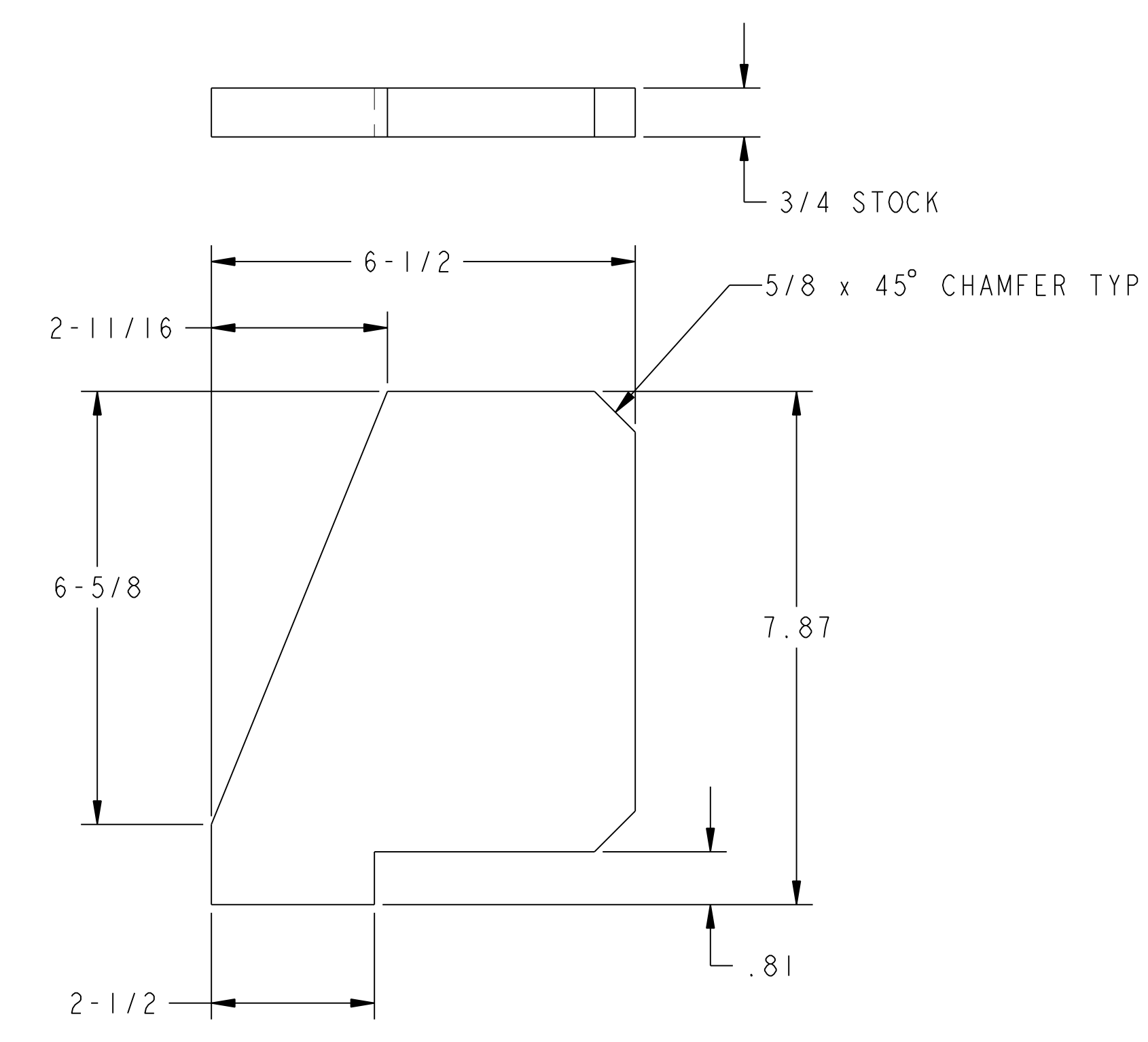
NO.	REVISION	BY	CH	SUP	APPROVED	DATE



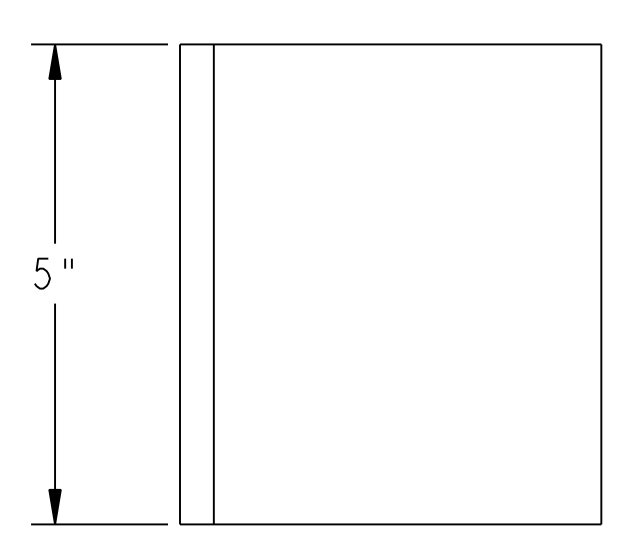
7 GUSSET - TYPE "A"



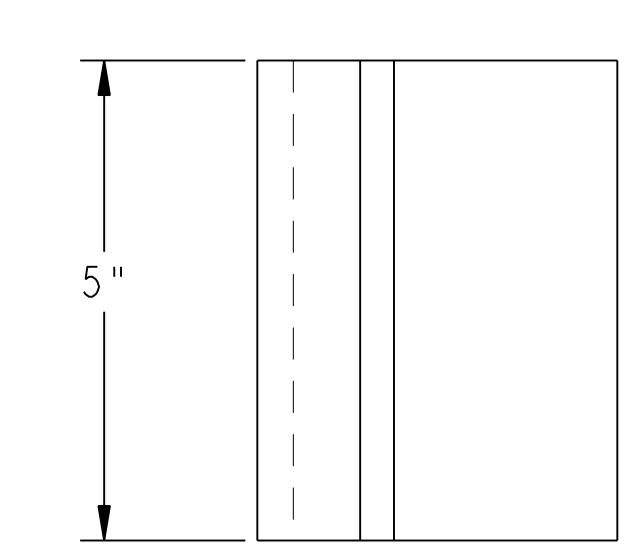
8 GUSSET - TYPE "B"



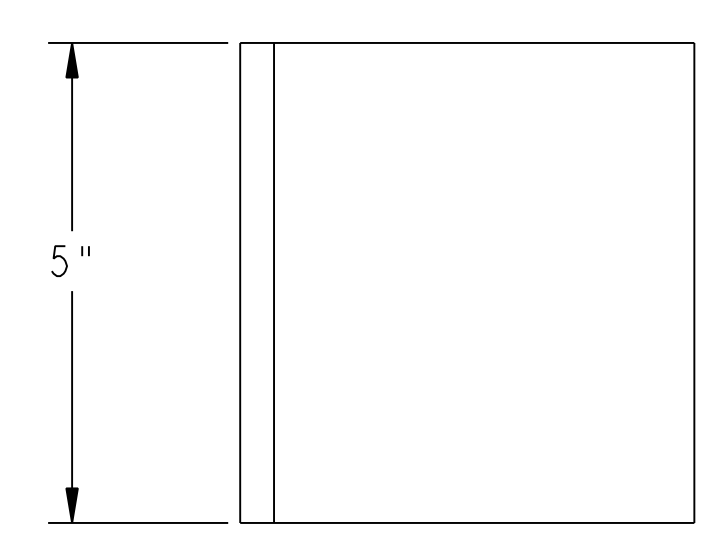
9 GUSSET - TYPE "C"



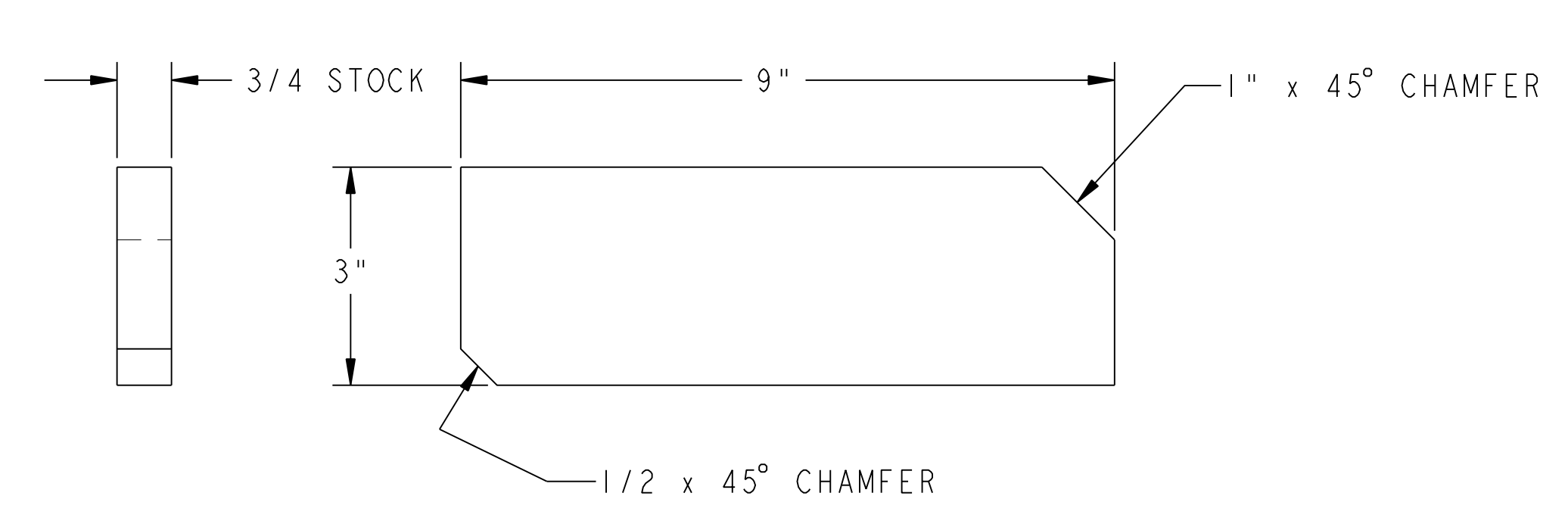
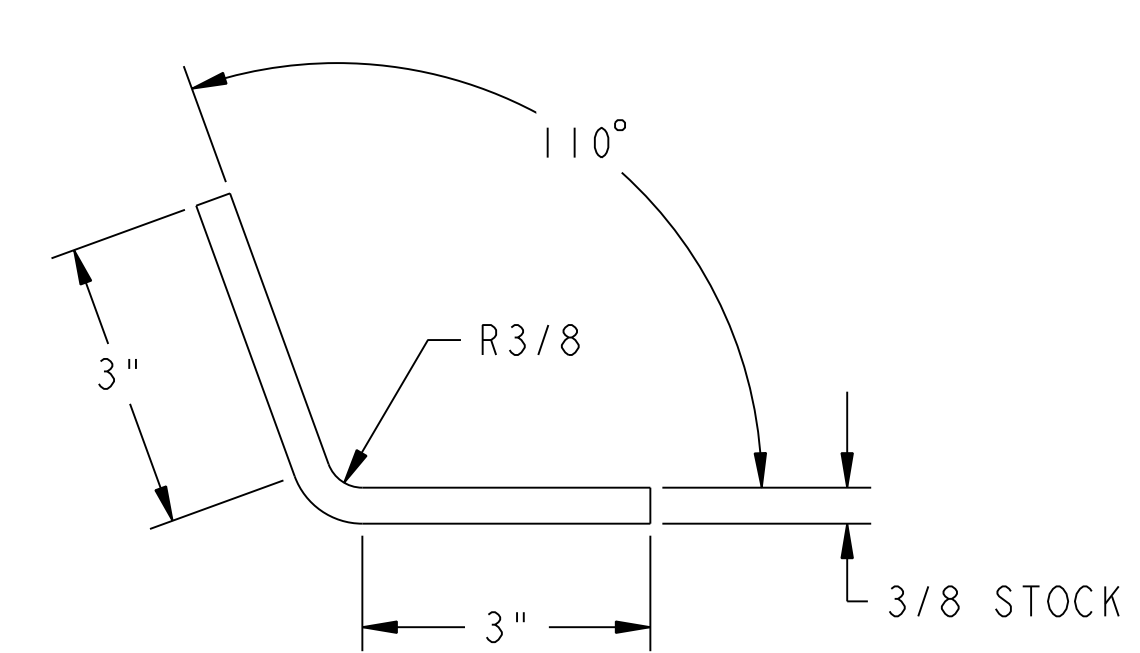
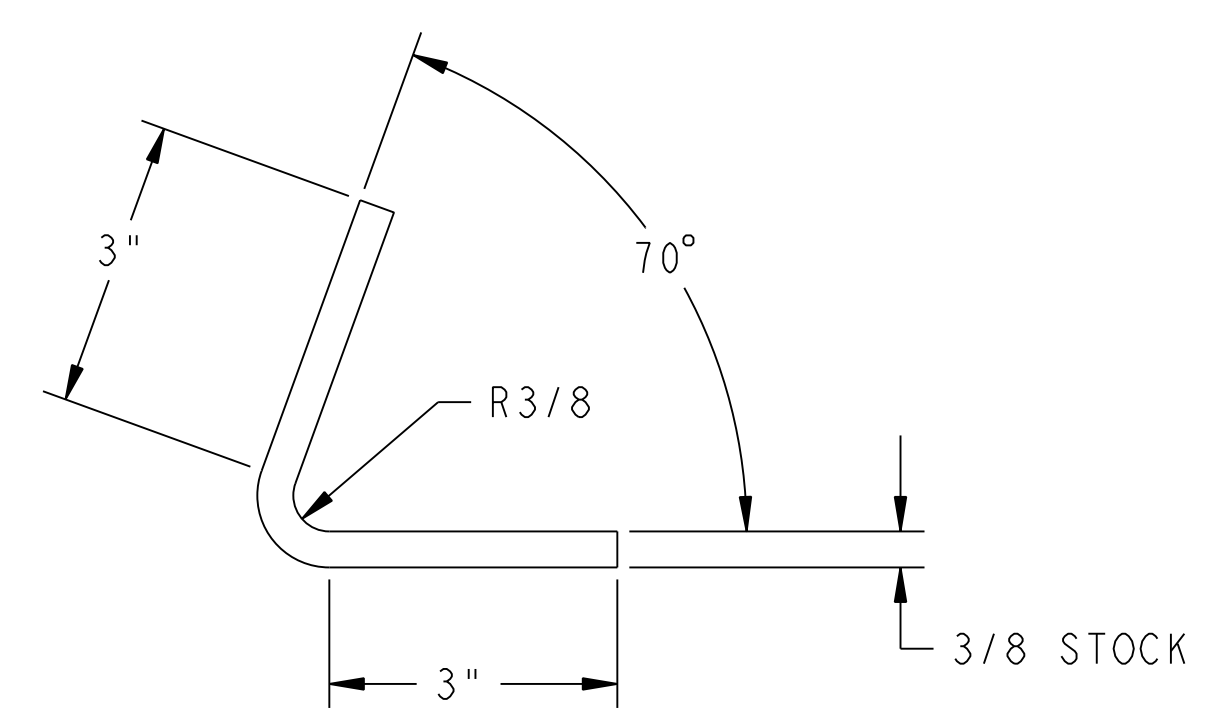
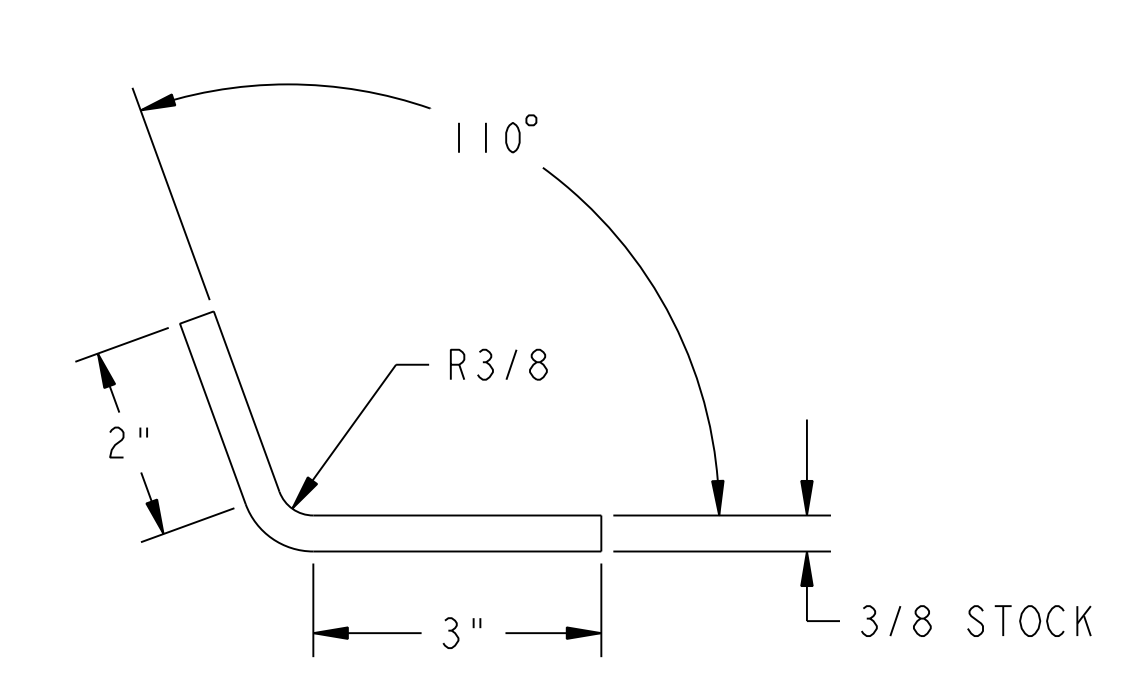
10 FORMED CLIP ANGLE - TYPE "A"



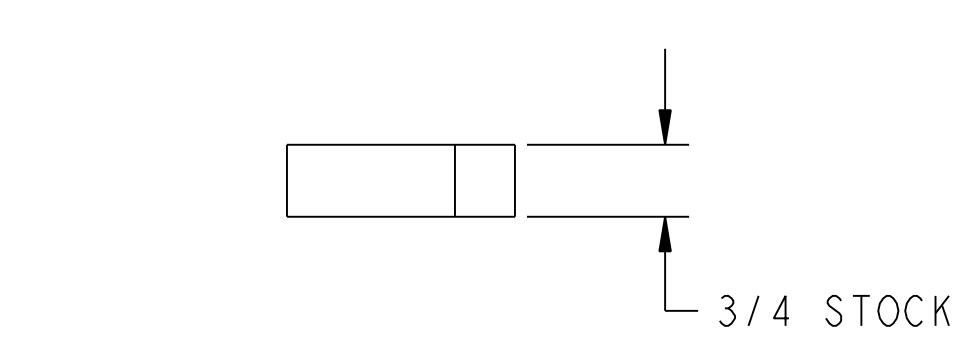
11 FORMED CLIP ANGLE - TYPE "B"



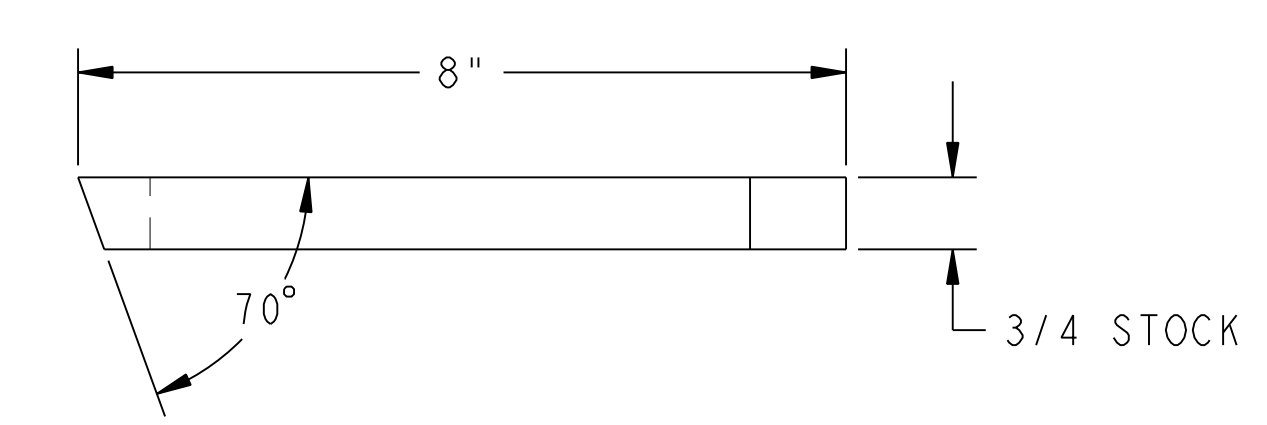
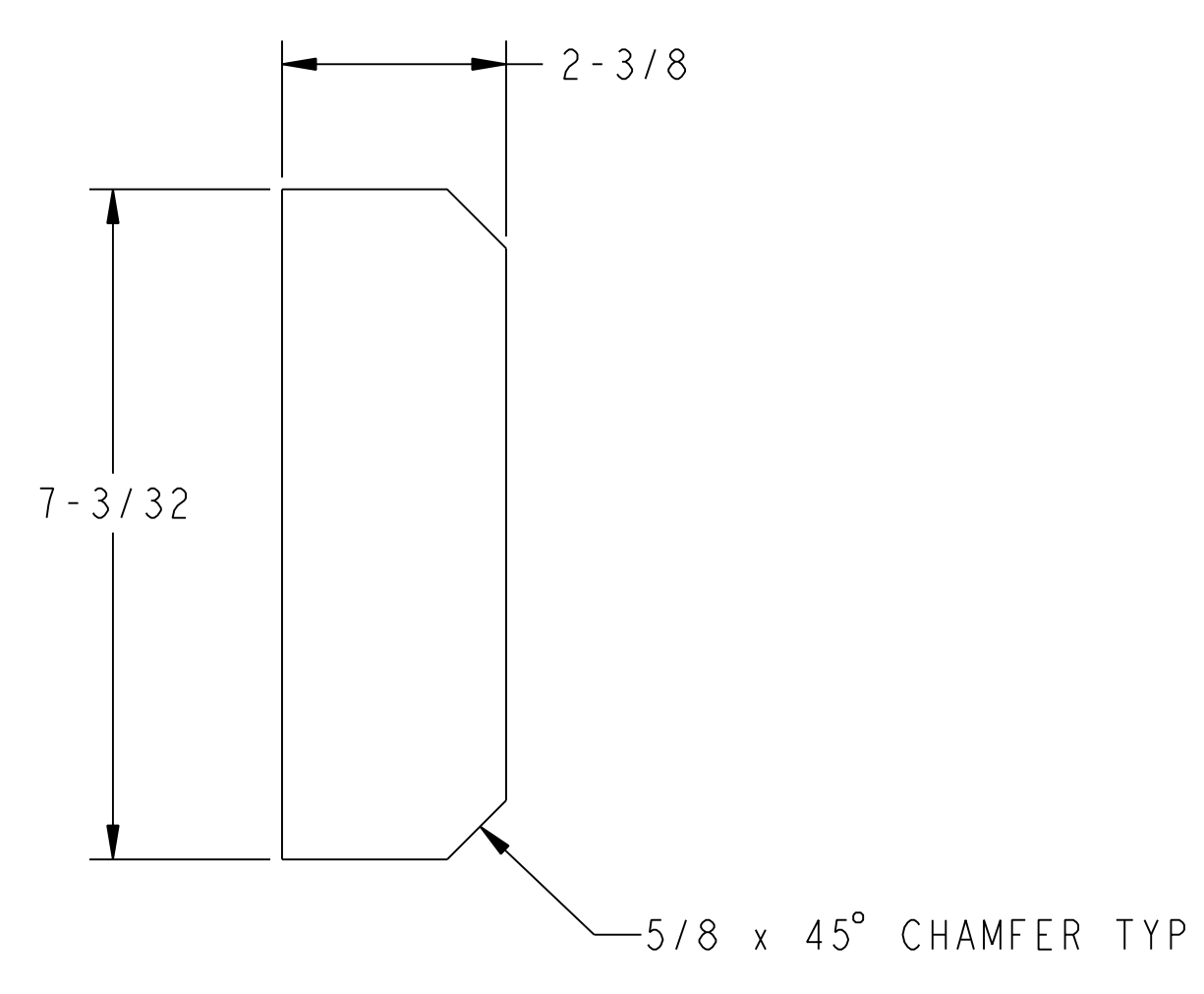
12 FORMED CLIP ANGLE - TYPE "C"



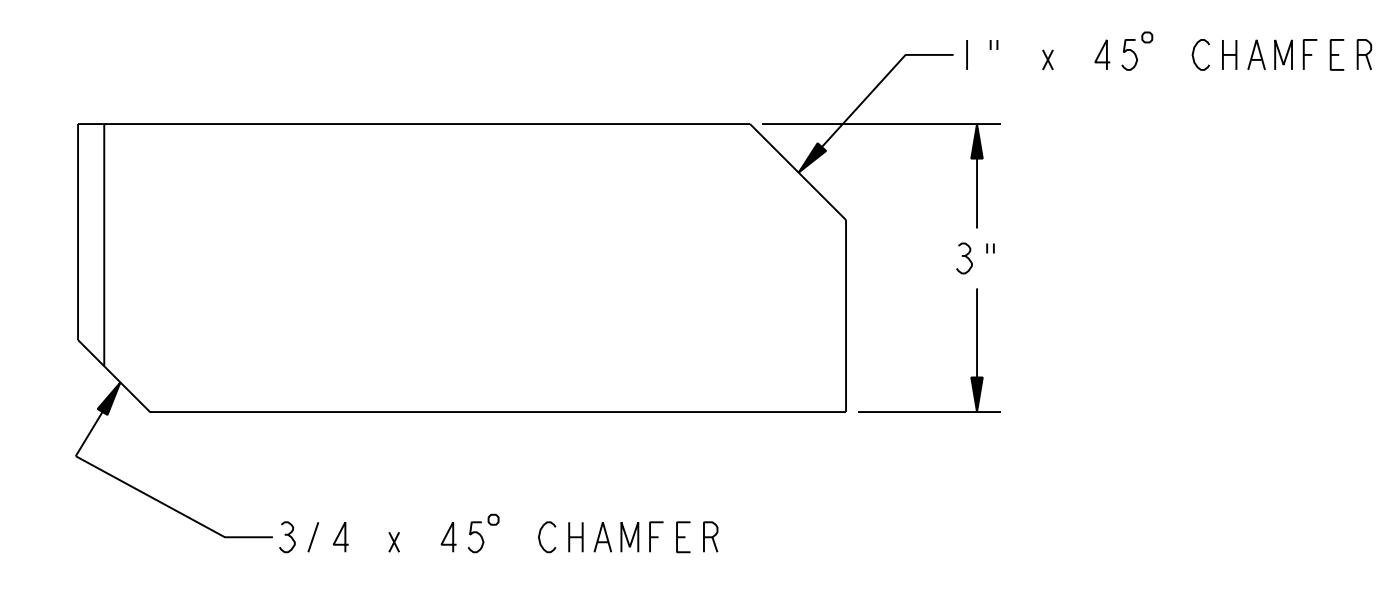
13 LIFTING BLOCK GUSSET - TYPE "A"



14 GUSSET - TYPE "D"



15 LIFTING BLOCK GUSSET - TYPE "B" - AS SHOWN



16 LIFTING BLOCK GUSSET - TYPE "C" - OPPOSITE

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

WEIGHT	2072.5 lbs
MODEL NAME	LM_SE185-314_JUNK
WELDING ENGINEER	

RELEASE LEVEL: WIP
DWG VERSION NO: 24

COMPUTER GENERATED DRAWING 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 FIELD PERIOD ASSEMBLY FIXTURE MCWF HALF PERIOD LIFTING FIXTURE FRAME WELDMENT
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° +/- .112	DSN: L. MORRIS 11-19-07 DRAWING NO: CHK: M. COLE 11-19-07 ENGR: T. BROWN 11-19-07 SUPV: J. SIEGEL 11-19-07
NEXT ASSEMBLY		SHEET 5 OF 5 REV D, 12

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