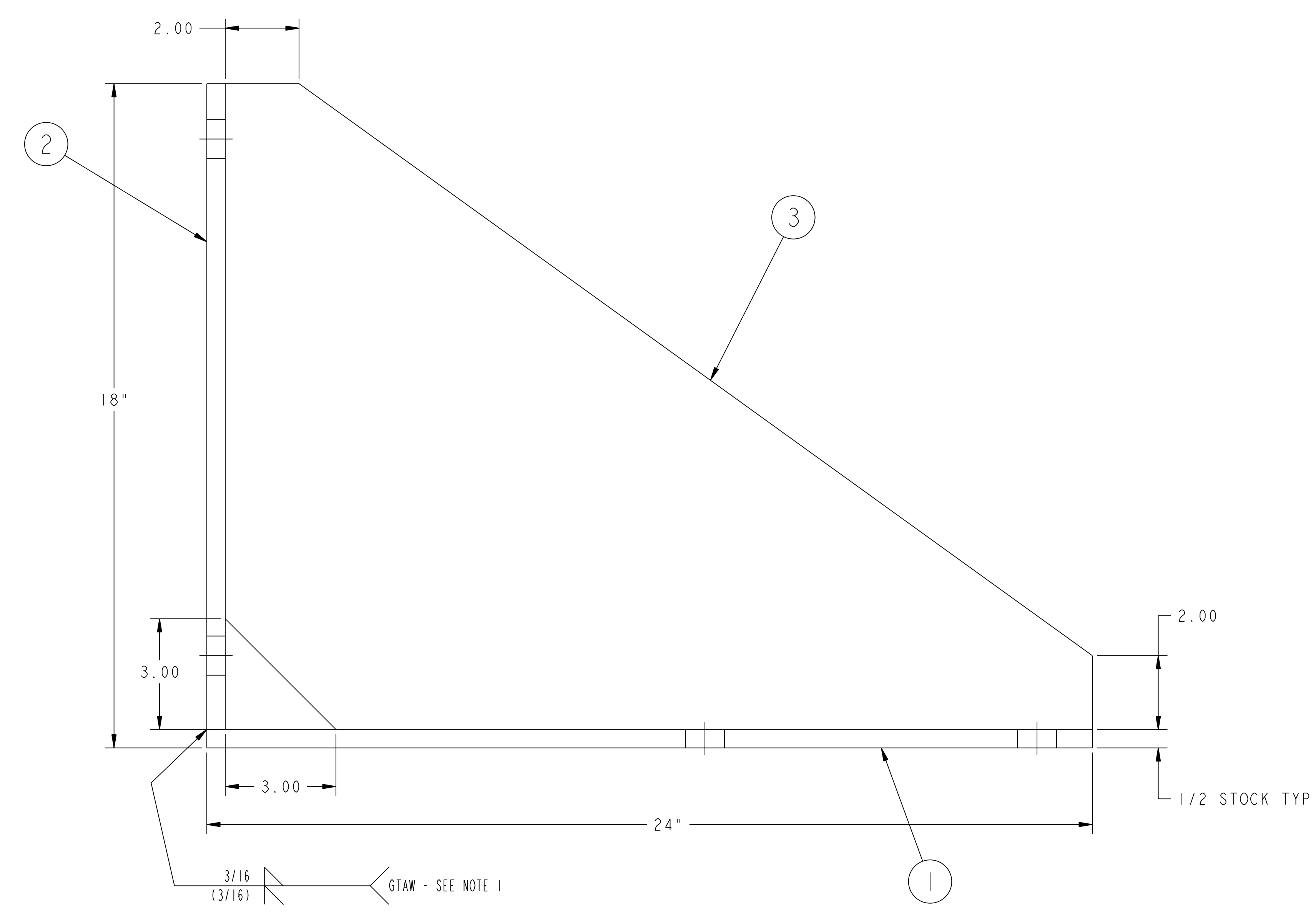
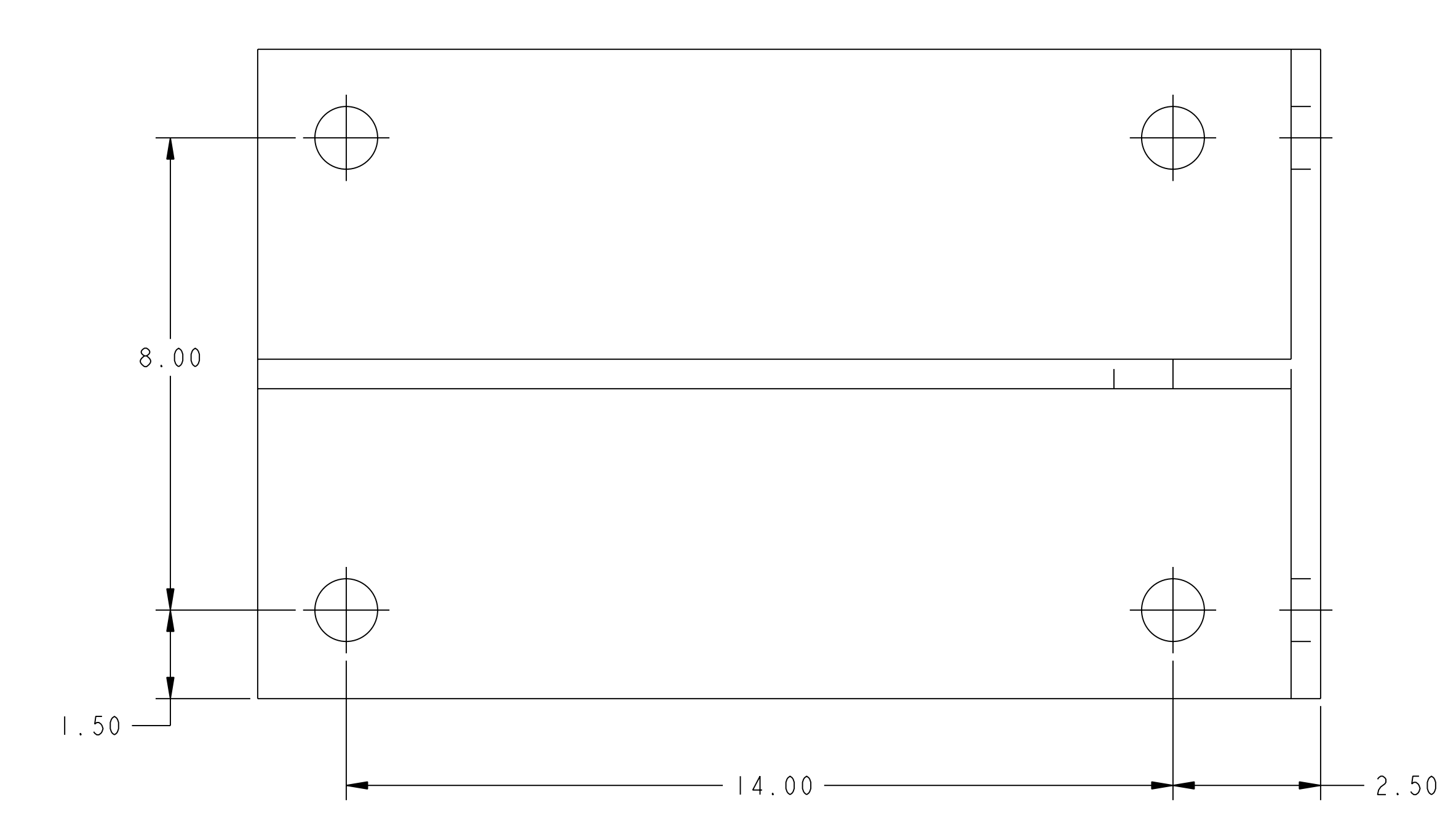
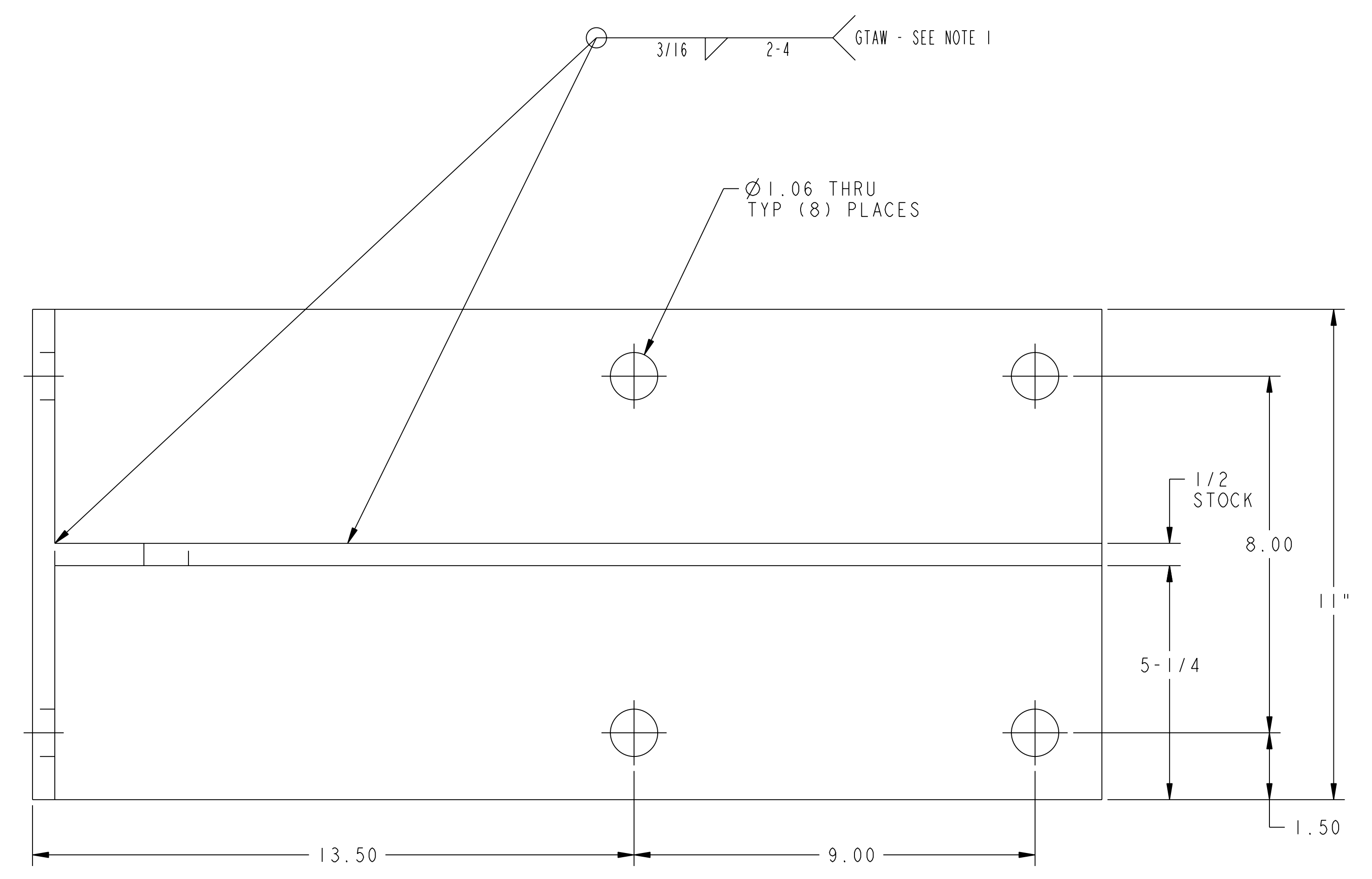


NO.	REVISION	BY	CH	SUP	APPROVED	DATE



**01 ASSEMBLY**  
(1) REQ'D

**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.
2. ALL HOLES TO BE MACHINED AFTER ALL WELDS ARE COMPLETE.

**RFD-18-001 permitted either GTAW or GMAW welds. See RFD-18-001 for details)**

**RELEASED FOR FABRICATION / INSTALLATION**  
PPPL Drafting

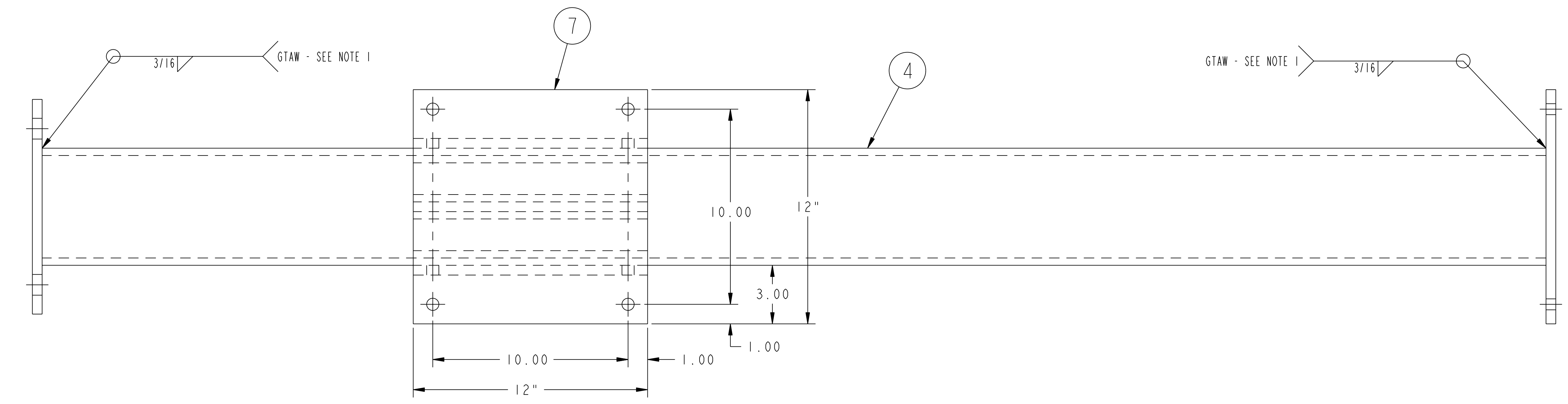
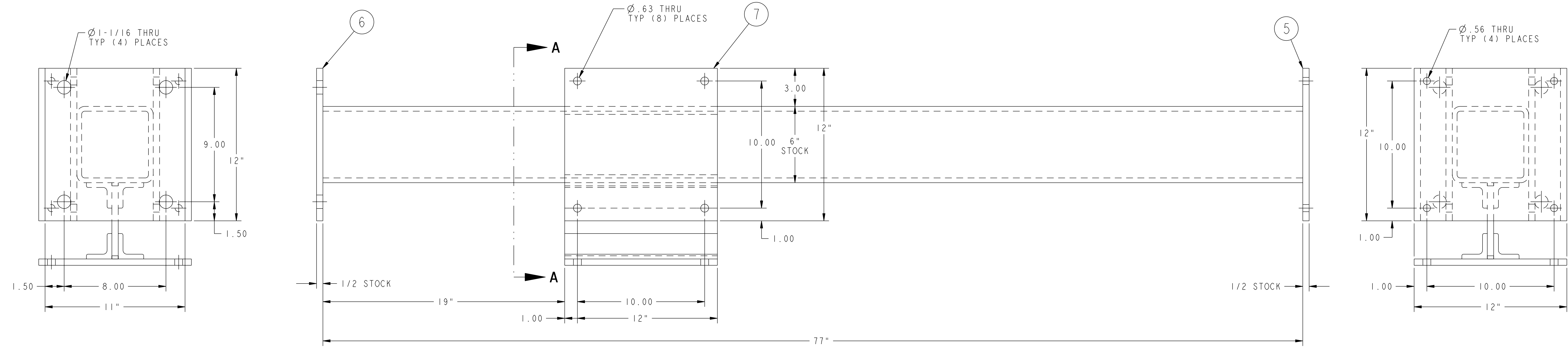
QTY	ASSY	PART NO.	DRAWING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY RECD
1		12	THIS DWG	OUTRIGGER TIE PLATE	ASTM A36	
1		11	THIS DWG	FOOT PLATE	ASTM A36	
1		10	THIS DWG	OUTRIGGER TUBE - 6" x 6" x 3/8 STRUCT TUBE	ASTM A36	
4		9	THIS DWG	MOUNTING CLIP ANGLE - 2 x 2 x 3/8 STRUCT ANGLE	ASTM A36	
1		8	THIS DWG	SANDWICH PLATE	ASTM A36	
2		7	THIS DWG	TIE PLATE	ASTM A36	
1		6	THIS DWG	TOP PLATE	ASTM A36	
1		5	THIS DWG	BASE PLATE	ASTM A36	
1		4	THIS DWG	VERTICAL TUBE - 6" x 6" x 3/8 STRUCT TUBE	ASTM A36	
	1	3	THIS DWG	GUSSET	ASTM A36	
	1	2	THIS DWG	VERTICAL PLATE	ASTM A36	
	1	1	THIS DWG	BASE PLATE	ASTM A36	
			THIS DWG	OUTRIGGER WELDMENT		3
			THIS DWG	VERTICAL SUPPORT WELDMENT		1
			THIS DWG	SUPPORT BRACKET WELDMENT		1

COMPUTER GENERATED DRAWING		CENTRAL FILES:		PRINCETON PLASMA PHYSICS LABORATORY	
MANUAL CHANGES NOT PERMITTED	PRO E	UNLESS OTHERWISE SPECIFIED		NATIONAL COMPACT STELLARATOR EXPERIMENT	
DO NOT VERIFY INFORMATION BY SCALING DRAWING		DIMENSIONS ARE IN INCHES		FIELD PERIOD ASSEMBLY	
		BREAK SHARP EDGES .005/.020		VACUUM VESSEL SUPPORT ASSEMBLY	
		TOLERANCES NON-CUMULATIVE		VERTICAL SUPPORT WELDMENTS	
		DECIMAL-INCH FRACTIONS	DSN: L. MORRIS	8-2-2007	DRAWING NO:
		NEXT ASSEMBLY	CHK: M. COLE	8-2-2007	<b>SE184-056</b>
		WELDING ENGINEER	ENGR: T. BROWN	8-2-2007	
		G. GETTELFINGER 8-2-2007	SUPV: J. SIEGEL	8-2-2007	SHEET 1 OF 3
					REV 0

**RELEASE LEVEL: Fabrication**  
**DWG VERSION NO: 3**

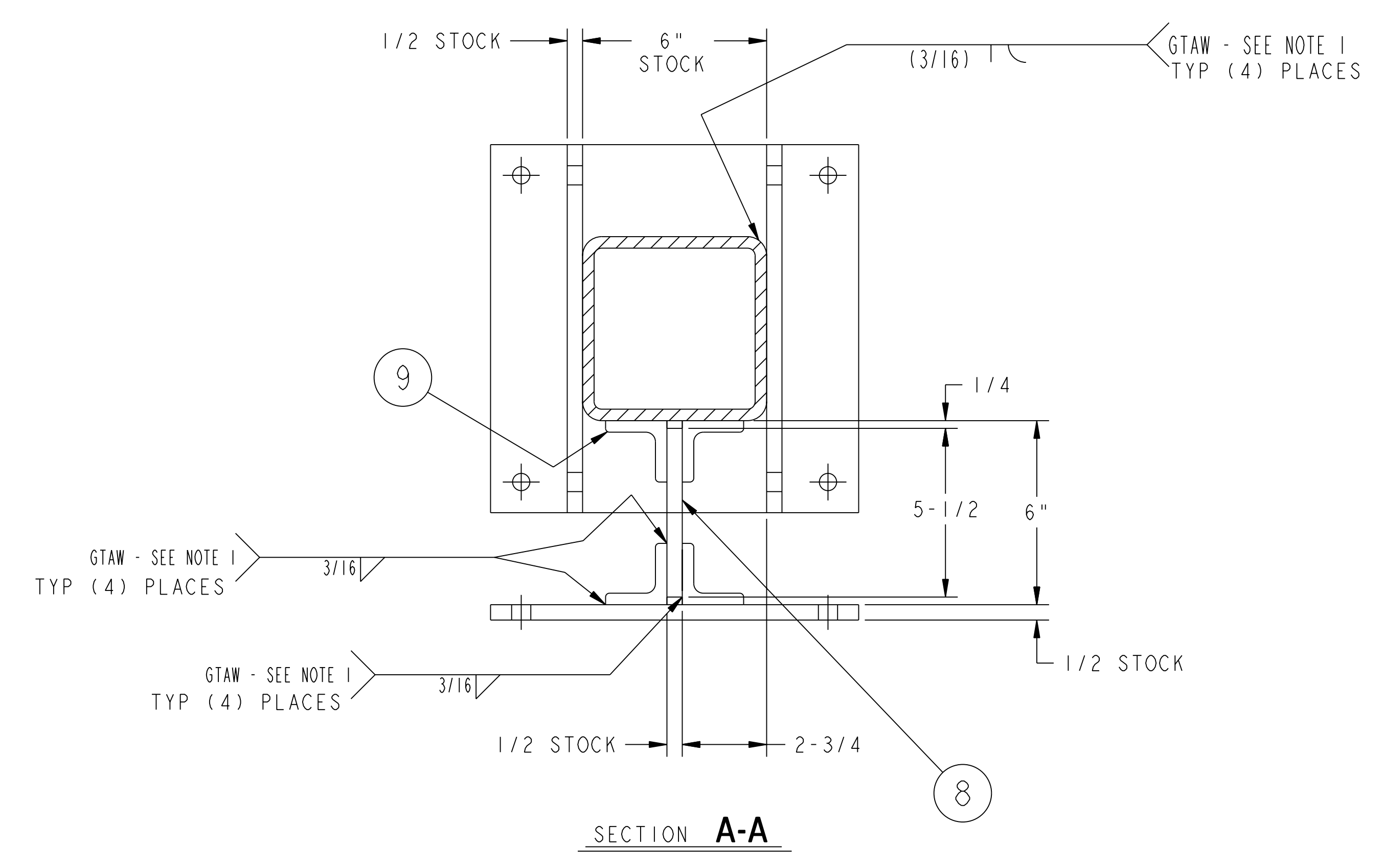
NCSX-SE184-056

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



**02 ASSEMBLY**

(1) REQ'D



**RELEASED FOR FABRICATION / INSTALLATION**  
 PPPL Drafting

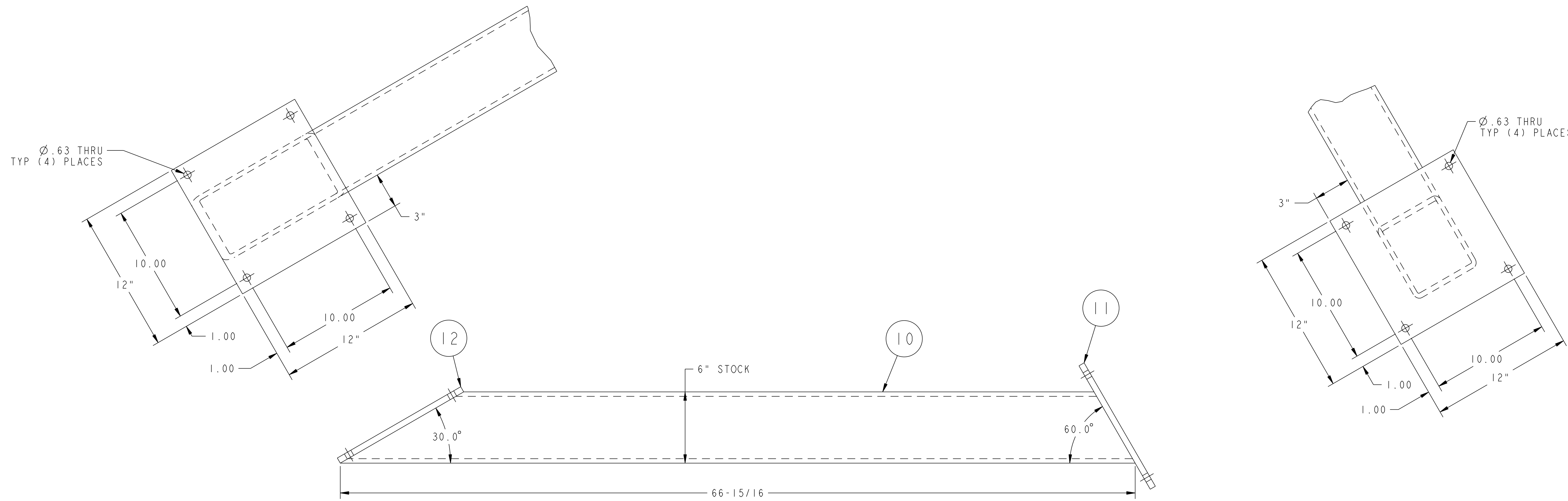
FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

COMPUTER GENERATED DRAWING 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	FIELD PERIOD ASSEMBLY VACUUM VESSEL SUPPORT ASSEMBLY VERTICAL SUPPORT WELDMENTS		DRAWING NO:
TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX ±.000 0°-120° ±.125 .XXX ±.005 120°-120° ±.125 ANGULAR ±.0°-15° OVER 120° ±.125	DSN: L. MORRIS 8-2-2007 CHK: M. COLE 8-2-2007 ENGR: T. BROWN 8-2-2007 SUPV: J. SIEGEL 8-2-2007	<b>SE184-056</b> SHEET 2 OF 3 REV D, 2	

RELEASE LEVEL: Fabrication  
 DWG VERSION NO: 3

WELDING ENGINEER  
 G. GETTELFINGER 8-2-2007

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



**03 ASSEMBLY**  
(3) REQ'D

**RELEASED FOR  
FABRICATION / INSTALLATION**  
PPPL Drafting

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES:	PRINCETON PLASMA PHYSICS LABORATORY NATIONAL COMPACT STELLARATOR EXPERIMENT	
	UNLESS OTHERWISE SPECIFIED	FIELD PERIOD ASSEMBLY	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	VACUUM VESSEL SUPPORT ASSEMBLY VERTICAL SUPPORT WELDMENTS	
TOLERANCES NON-CUMULATIVE	DECIMAL-INCH FRACTIONS	DSN: L. MORRIS	8-2-2007 DRAWING NO:
NEXT ASSEMBLY	.XX +/- .000 .XXX +/- .005 ANGULAR +/- 0°-15'	CHK: M. COLE	8-2-2007
WELDING ENGINEER: G. GETTELFINGER 8-2-2007		ENGR: T. BROWN	8-2-2007
		SUPV: J. SIEGEL	8-2-2007
			SHEET 3 OF 3
			REV D, 2

RELEASE LEVEL: Fabrication  
DWG VERSION NO: 6

WEIGHT  
312.3 lbs  
MODEL NAME  
SE184-056-02

NCSX-SE184-056