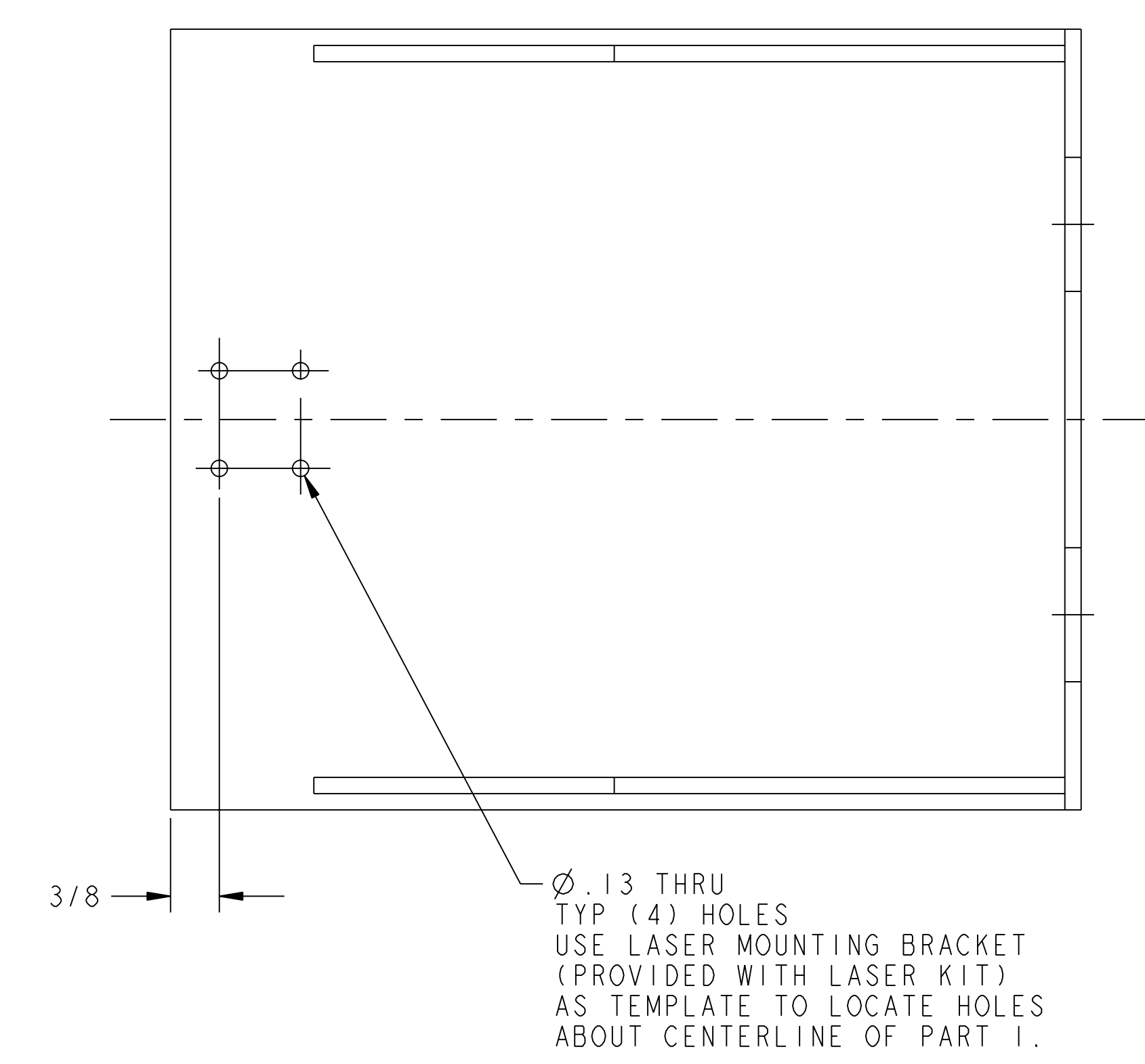
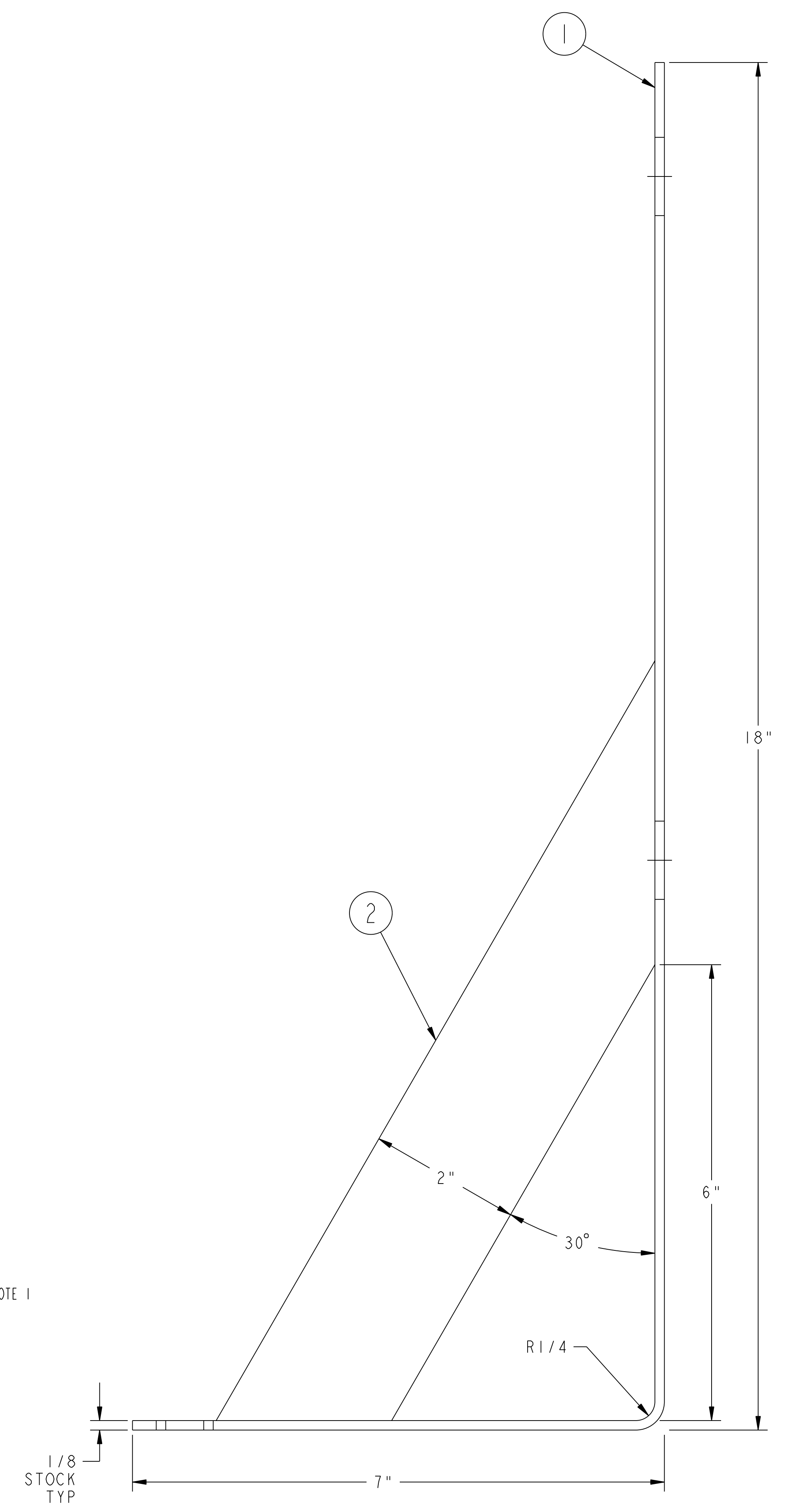
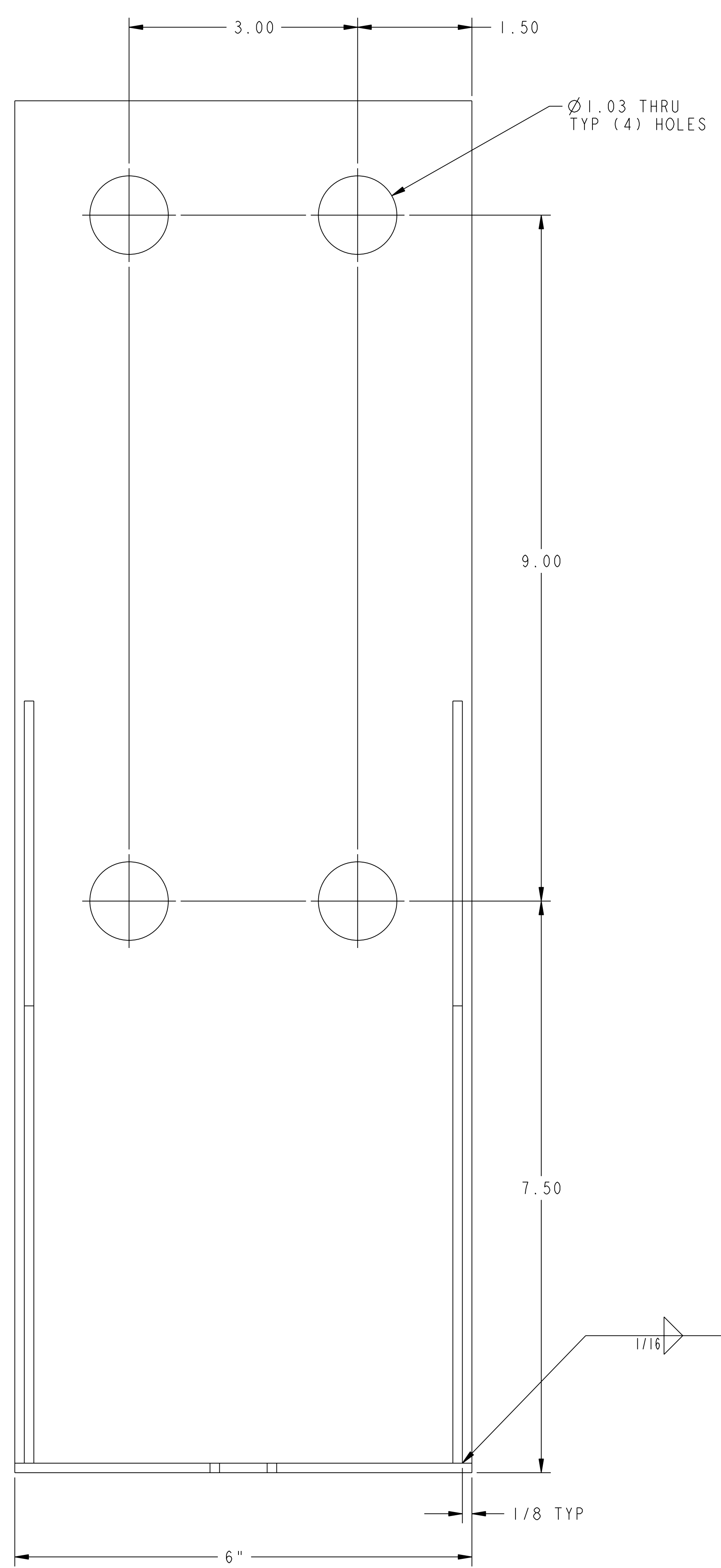


NO.	REVISION	BY	CH	SUP	APPROVED	DATE



**NOTES**

1. WELDING SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF 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.



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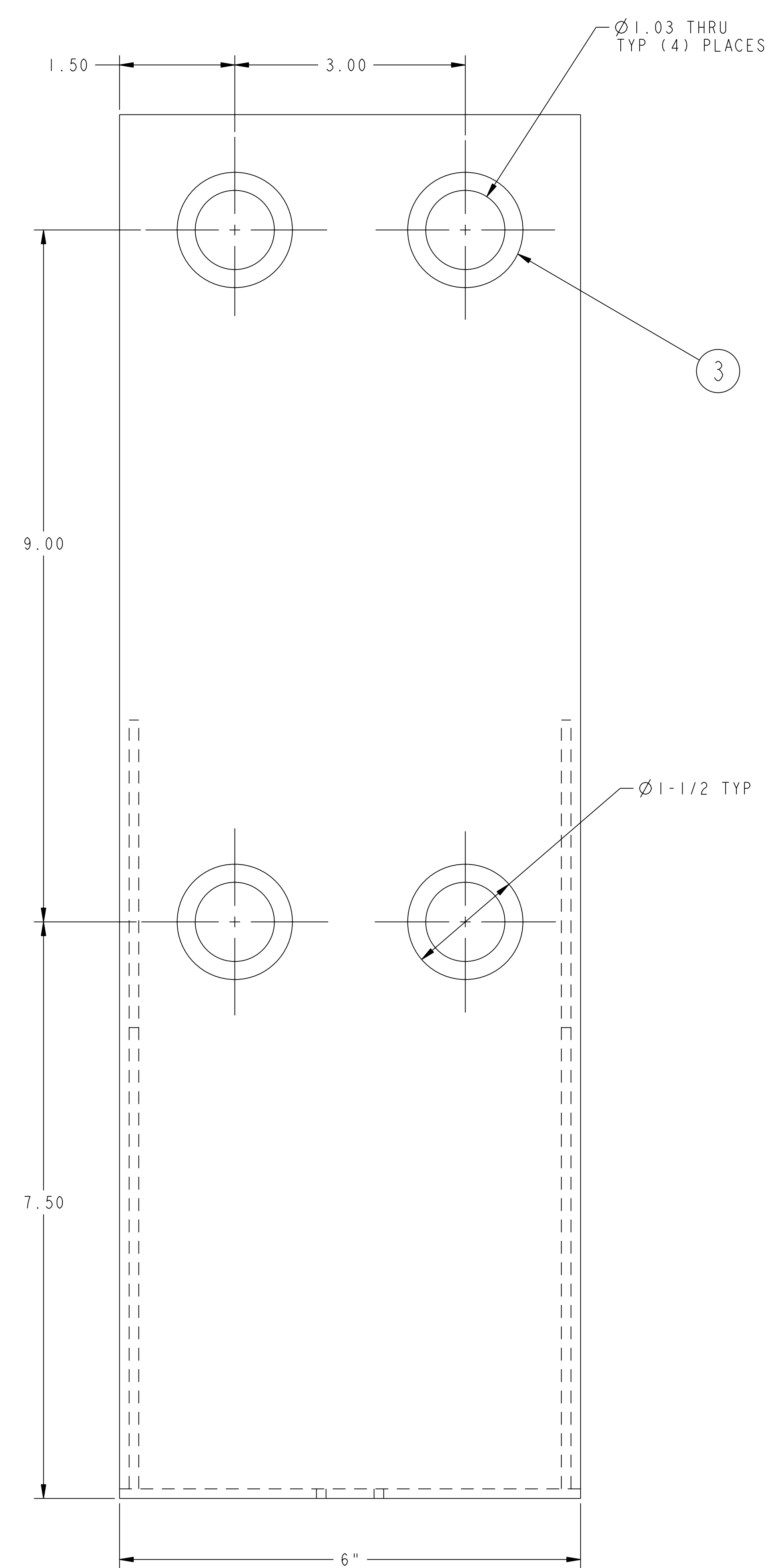
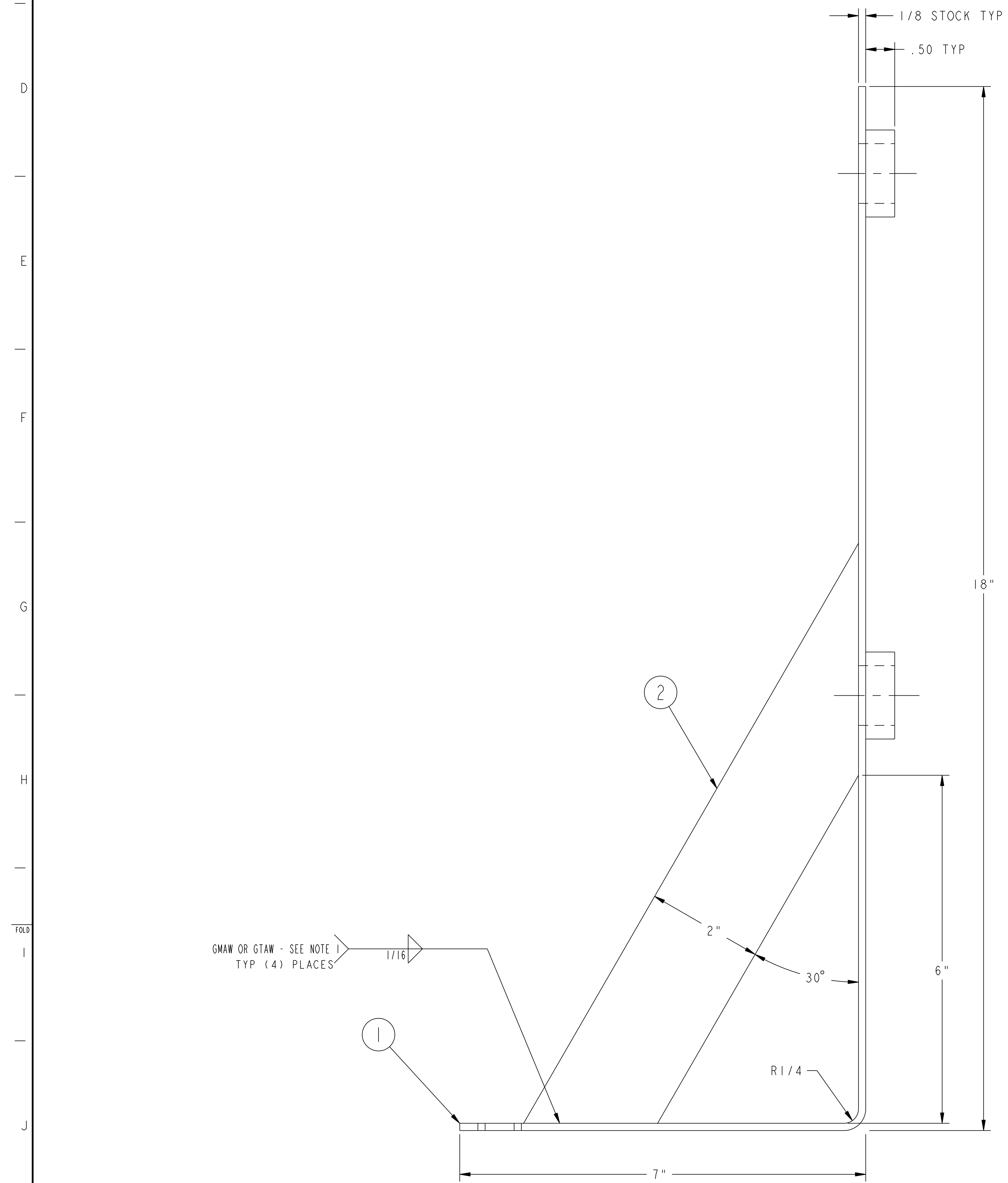
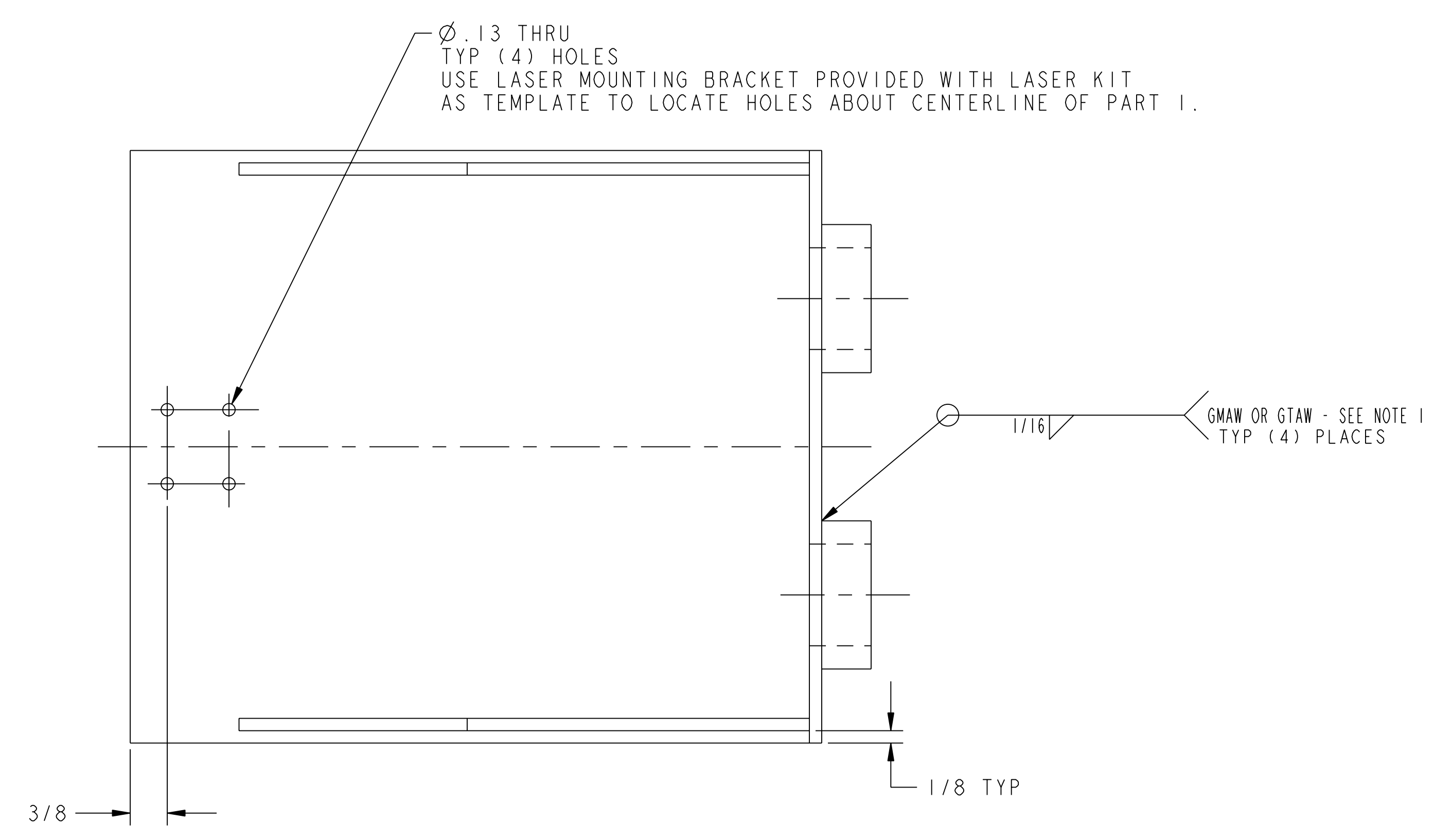
ASSY NO.	ASSY NAME	PART NO.	DRAWING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY REQD
8	THIS DWG			VERTICAL LASER PEN SUPPORT BRACKET BRACE	ASTM A36	1
7				MOUNTING BRACKET STRONGBACK	ASTM A36	1
6				MOUNTING BRACKET SUPPORT PLATE	ASTM A36	1
5				VERTICAL MOUNTING BRACKET GUSSET PLATE	ASTM A36	1
4				VERTICAL MOUNTING BRACKET BASE	ASTM A36	1
3				MOUNTING BRACKET STANDOFF	ASTM A36	1
2				MOUNTING BRACKET GUSSET	ASTM A36	1
1				MOUNTING BRACKET BASE	ASTM A36	1
				VERTICAL LASER PEN MOUNTING BRACKET SUPPORT PLATE WELDMENT		1
				VERTICAL LASER PEN MOUNTING BRACKET WELDMENT		1
				REAR LASER PEN MOUNTING BRACKET WELDMENT		1
				FRONT LASER PEN MOUNTING BRACKET WELDMENT		1

01 ASSEMBLY - FRONT LASER PEN MOUNTING BRACKET WELDMENT  
SCALE 1.000

RELEASE LEVEL: Fabrication  
DWG VERSION NO: 8

WEIGHT 6.6 lbs	MODEL NAME SE185-311-01	WELDING ENGINEER L. DUDEK 11-26-07	COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES MACHINE SURFACES UNLESS OTHERWISE SPECIFIED BREAK SHARP EDGES .005/.020	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY NATIONAL COMPACT STELLARATOR EXPERIMENT FIELD PERIOD ASSEMBLY FIELD PERIOD ASSEMBLY FIXTURE LASER PEN MOUNTING BRACKET WELDMENTS AND DETAILS
			DO NOT VERIFY INFORMATION BY SCALING DRAWING	TOLERANCES NON-CUMULATIVE	DSN: L. MORRIS 11-26-07 DRAWING NO:
				DECIMAL-INCH FRACTIONS	CHK: M. COLE 11-26-07
				ANGULAR ±.05° OVER	ENGR: T. BROWN 11-26-07
					SUPV: J. SIEGEL 11-26-07

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



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FOR NOTES AND B/M SEE SHEET 1

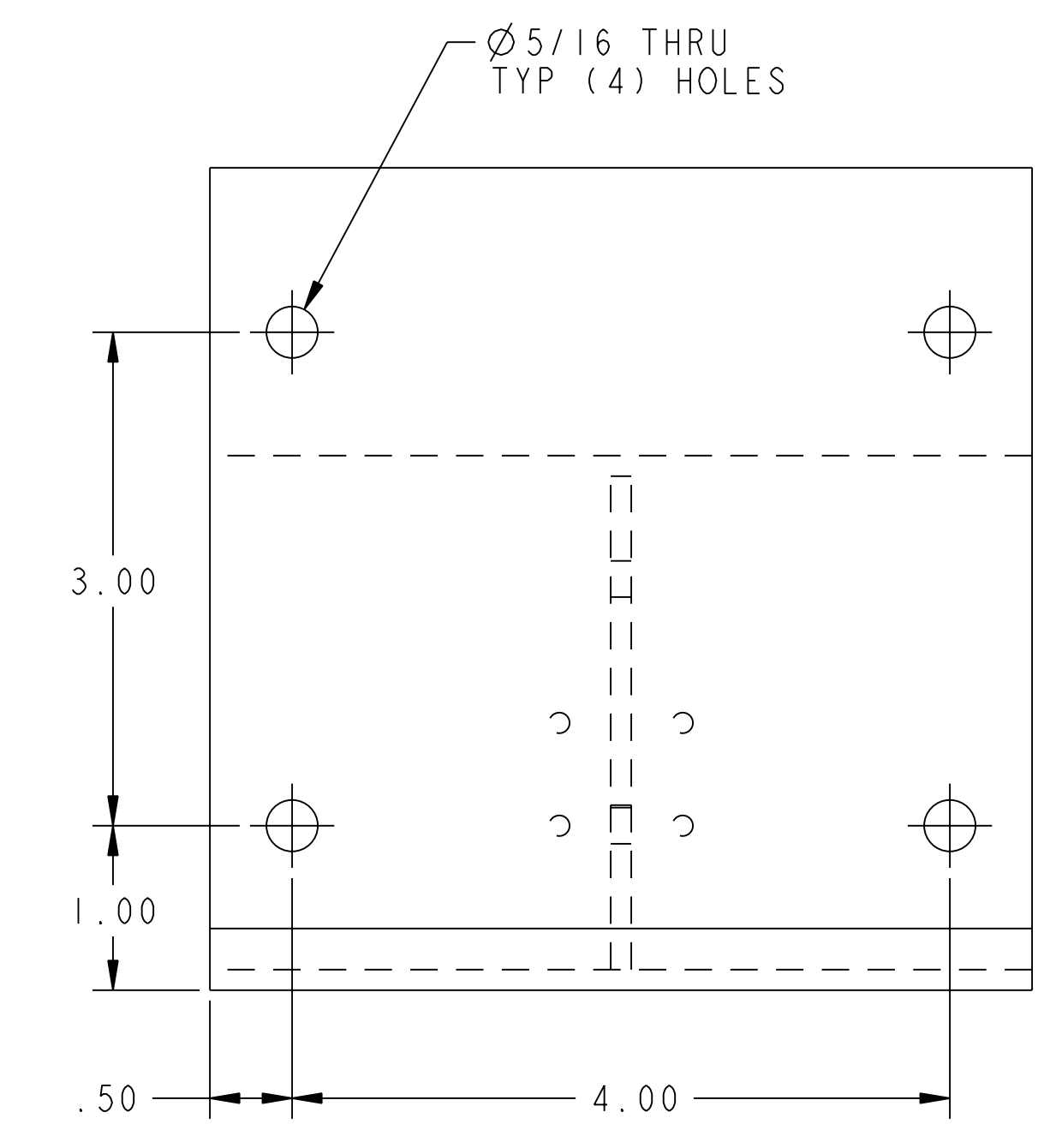
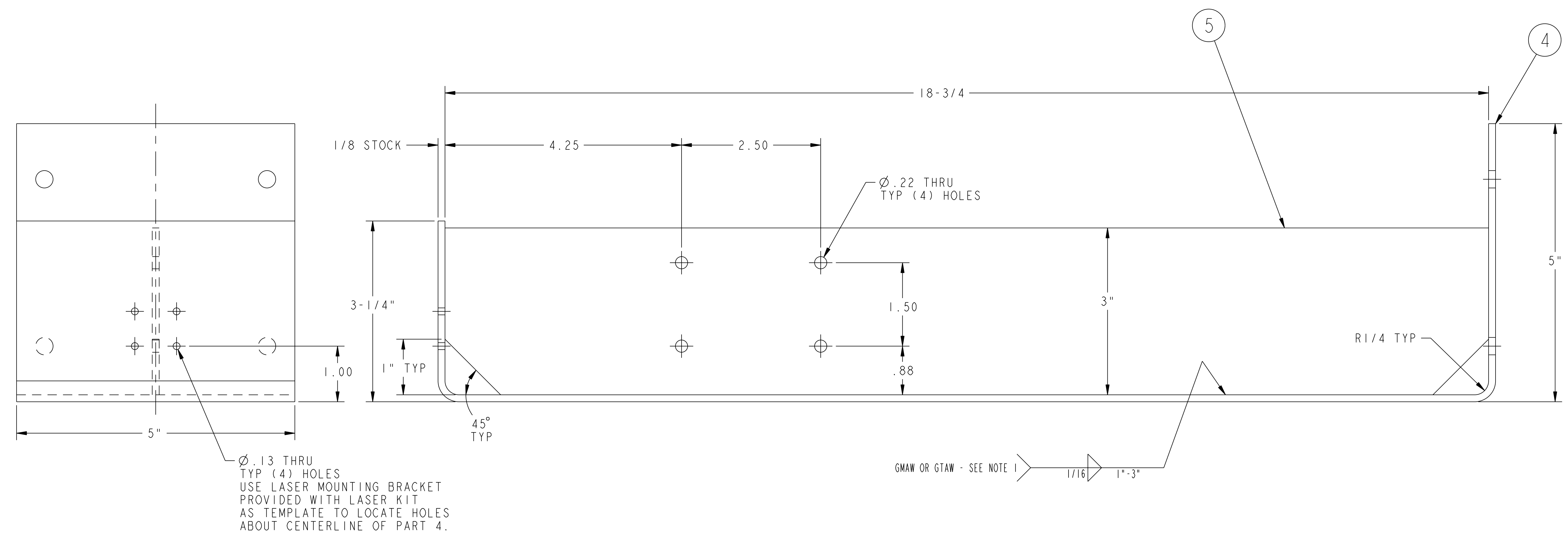
**02 ASSEMBLY - REAR LASER PEN MOUNTING BRACKET WELDMENT**

SCALE: 1.000

**RELEASE LEVEL: Fabrication**  
**DWG VERSION NO: 7**

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	FIELD PERIOD ASSEMBLY FIXTURE	
	DECIMAL - INCH FRACTIONS .X +/- .000 0°-120° +/- .010 .XX +/- .030 120°-120° +/- .010 .XXX +/- .005 72°-120° +/- .010 ANGULAR +/- .0°-15° OVER 120° +/- .010	DSN: L. MORRIS 11-26-07 CHK: M. COLE 11-26-07 ENGR: T. BROWN 11-26-07 SUPV: J. SIEGEL 11-26-07	DRAWING NO: <b>SE185-311</b>
WEIGHT 8.5 lbs	MODEL NAME SE185-311-02	LASER PEN MOUNTING BRACKET WELDMENTS AND DETAILS SHEET 2 OF 4	
NEXT ASSEMBLY	WELDING ENGINEER	REVQ. 11	NCSX-SE185-311

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



Ø.13 THRU  
TYP (4) HOLES  
USE LASER MOUNTING BRACKET  
PROVIDED WITH LASER KIT  
AS TEMPLATE TO LOCATE HOLES  
ABOUT CENTERLINE OF PART 4.

03 ASSEMBLY - VERTICAL LASER PEN MOUNTING BRACKET WELDMENT

**RELEASED FOR  
FABRICATION / INSTALLATION**  
 PPPL Drafting

FOR NOTES AND B/M 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 PRINCETON UNIVERSITY	
	UNLESS OTHERWISE SPECIFIED	<b>NATIONAL COMPACT STELLARATOR EXPERIMENT</b>	
	DIMENSIONS ARE IN INCHES MACHINE SURFACES	FIELD PERIOD ASSEMBLY FIELD PERIOD ASSEMBLY FIXTURE LASER PEN MOUNTING BRACKET WELDMENTS AND DETAILS	
	BREAK SHARP EDGES .005/.020	DSN: L. MORRIS	11-26-07 DRAWING NO:
	TOLERANCES NON-CUMULATIVE	CHK: M. COLE	11-26-07
	DECIMAL-INCH FRACTIONS	ENGR: T. BROWN	11-26-07
	.XX +/- .030 0°-12° +/- .010	SUPV: J. SIEGEL	11-26-07
	.XXX +/- .005 12°-120° +/- .010		
	ANGULAR +/- .0°-15° OVER 120° +/- .125		

**RELEASE LEVEL: Fabrication**  
**DWG VERSION NO: 7**

**SE185-311**  
SHEET 3 OF 4  
REVQ. 11

NCSX-SE185-311

