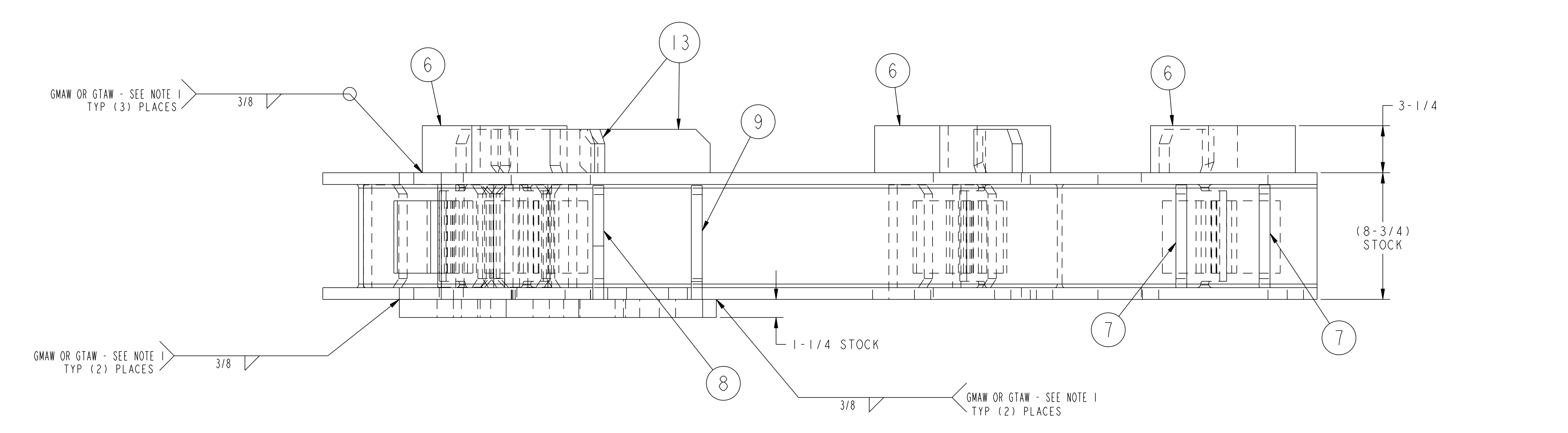


REFERENCE ISOMETRIC
SCALE 0.125

NOTES

1. WELDING SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF AWS D14.1 OR PPPL PROCEDURE ENG-037. VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH THE ACCEPTANCE CRITERIA OF AWS D1.1 Section 6.
2. LIFTING FIXTURE FRAME IS TO BE CLEARLY MARKED WITH THE FINISHED WEIGHT OF THE FIXTURE IN 1/4" HIGH LETTERS EITHER BY STAMPING OR PERMANENT INDELIBLE INK.

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NO.	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		

WEIGHT
228.9 lbs

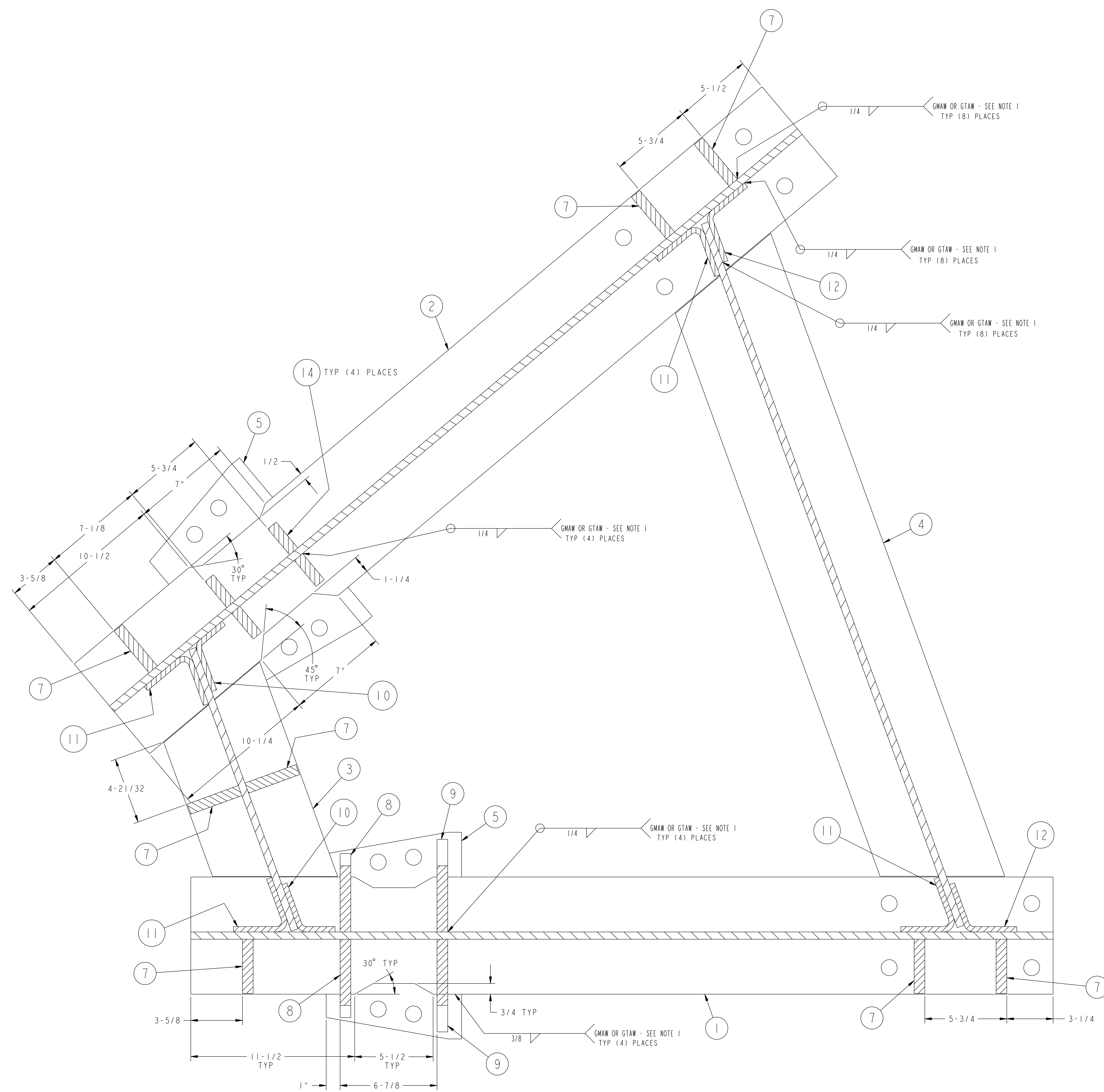
MODEL NAME
SE185-316-2

WELDING ENGINEER
L. DUDEK 11-14-07

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 FIELD PERIOD ASSEMBLY FIXTURE MCWF HALF PERIOD LIFTING FIXTURE FRAME WELDMENT	
NEXT ASSEMBLY	TOLERANCES NON-CUMULATIVE	DSN: L. MORRIS 11-19-07	DRAWING NO:
	DECIMAL-INCH FRACTIONS	CHK: M. COLE 11-19-07	SE185-316
	.XX +/- .000 12"-12' +/- .125	ENGR: T. BROWN 11-19-07	
	.XXX +/- .005 12"-120" +/- .125	SUPV: J. SIEGEL 11-19-07	SHEET 1 OF 5
	ANGULAR +/- .015 12"-120" +/- .125		REVQ. 15

RELEASE LEVEL: Fabrication
DWG VERSION NO: 6

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



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SECTION A-A

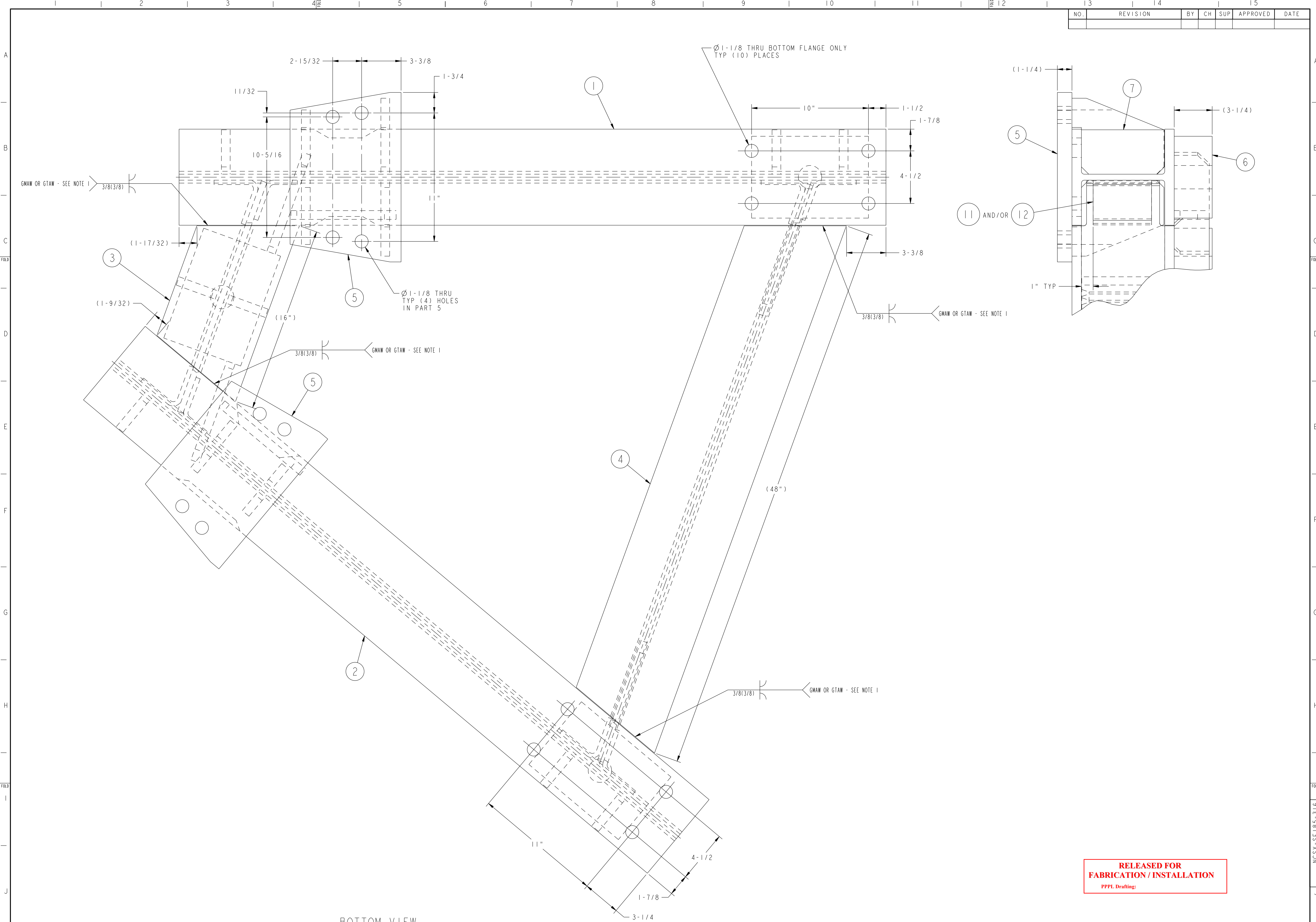
RELEASE LEVEL: FABRICATION
 DWG VERSION NO: 24

WEIGHT	2072.5 lbs
MODEL NAME	
WELDING ENGINEER	

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	NATIONAL COMPACT STELLARATOR EXPERIMENT	
NEXT ASSEMBLY	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX +/- .000 .XXX +/- .005 ANGULAR +/- .05	DSN: L. MORRIS	11-19-07
		CHK: M. COLE	11-19-07
		ENGR: T. BROWN	11-19-07
		SUPV: J. SIEGEL	11-19-07
		DRAWING NO:	SE185-316
		SHEET 2 OF 5	REVQ. 15

NCSX-SE185-316

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



BOTTOM VIEW

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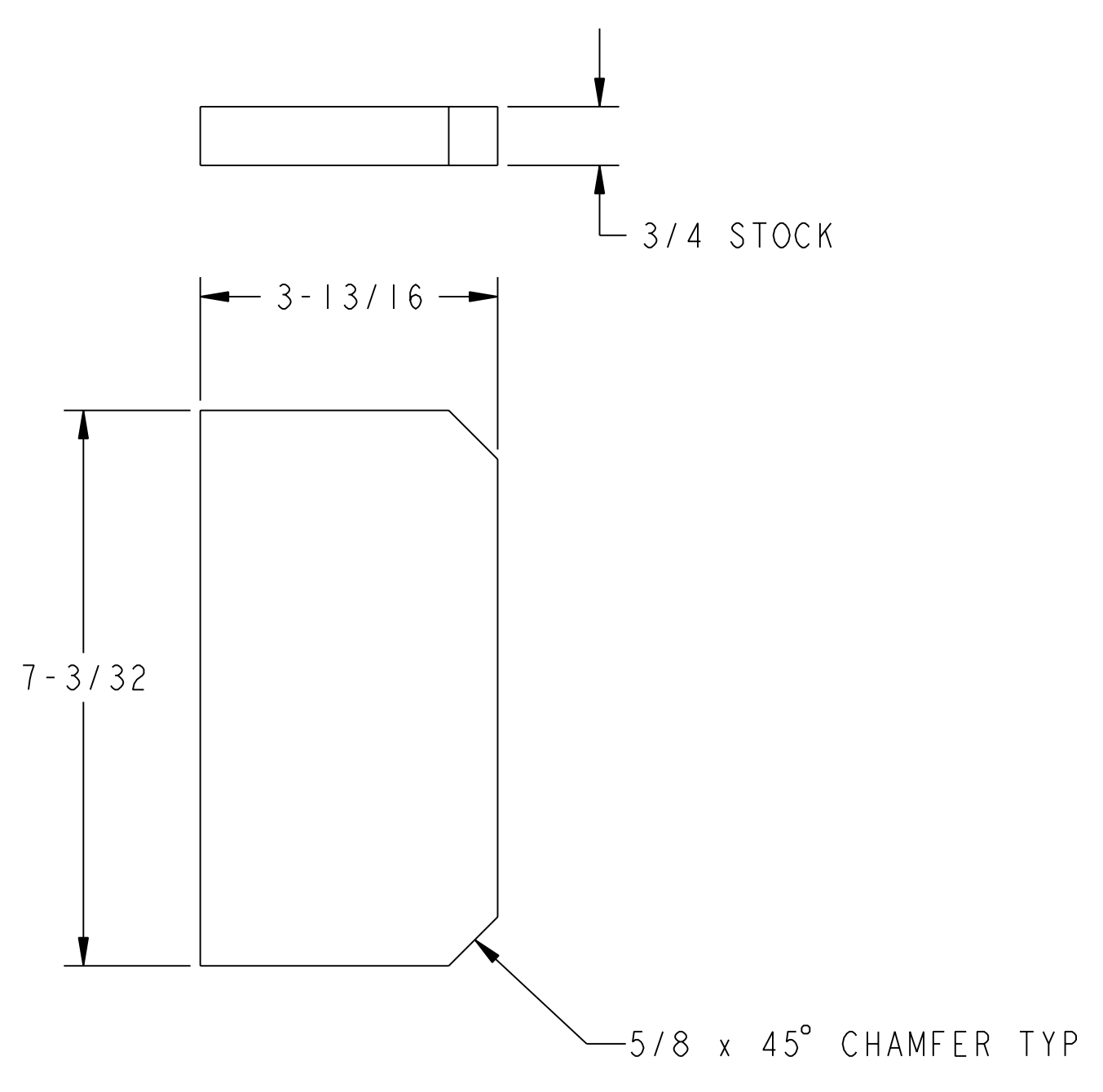
FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

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	
DECIMAL - INCH FRACTIONS	DIMENSIONS ARE IN INCHES		FIELD PERIOD ASSEMBLY
BREAK SHARP EDGES .005/.020	MACHINE SURFACES		FIELD PERIOD ASSEMBLY FIXTURE
TOLERANCES NON-CUMULATIVE	DSN: L. MORRIS	11-19-07	DRAWING NO:
	CHK: M. COLE	11-19-07	SE185-316
	ENGR: T. BROWN	11-19-07	
	SUPV: J. SIEGEL	11-19-07	SHEET 3 OF 5
			REVQ. 15

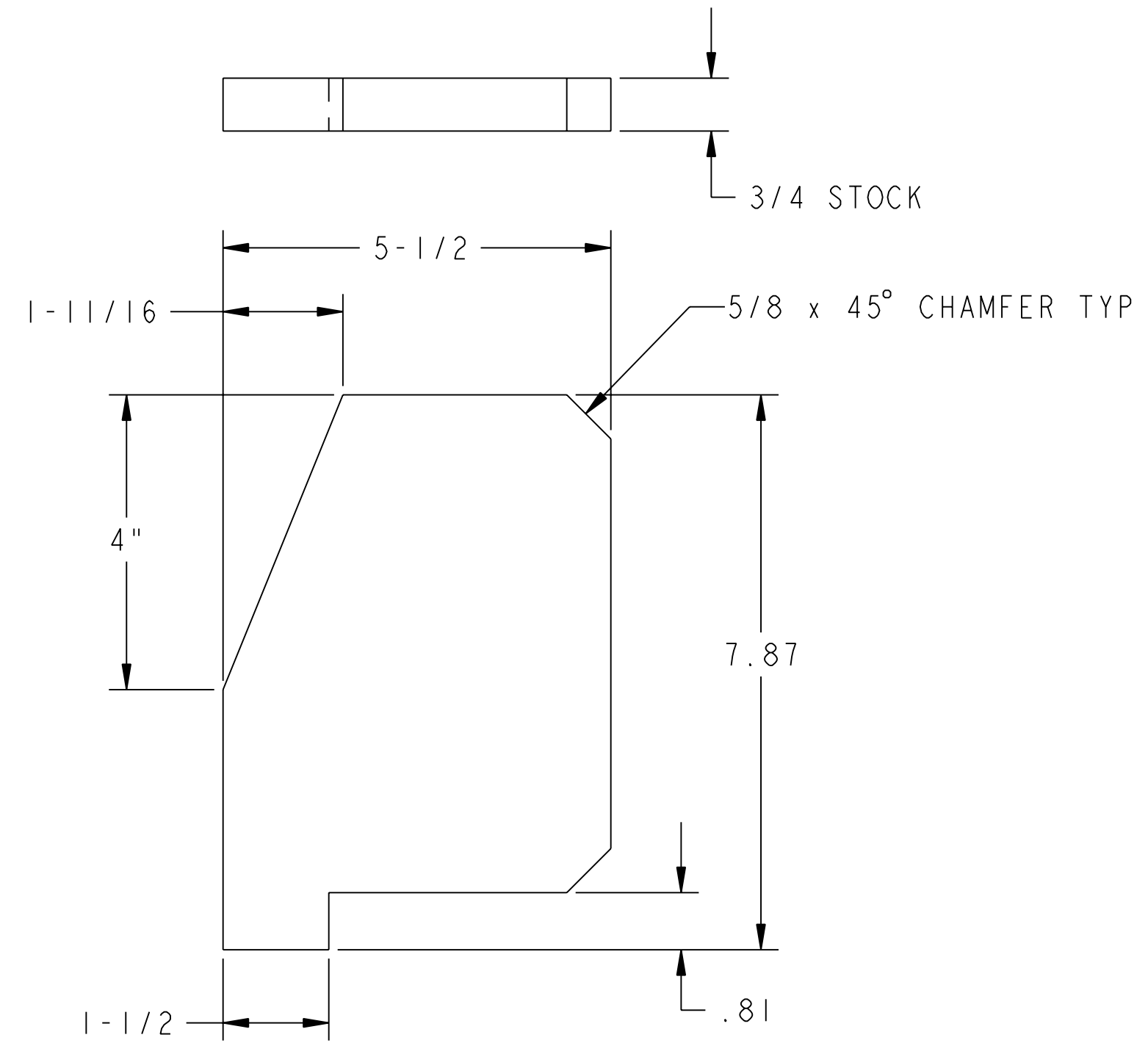
RELEASE LEVEL: Fabrication
DWG VERSION NO: 6

NCSX-SE185-316

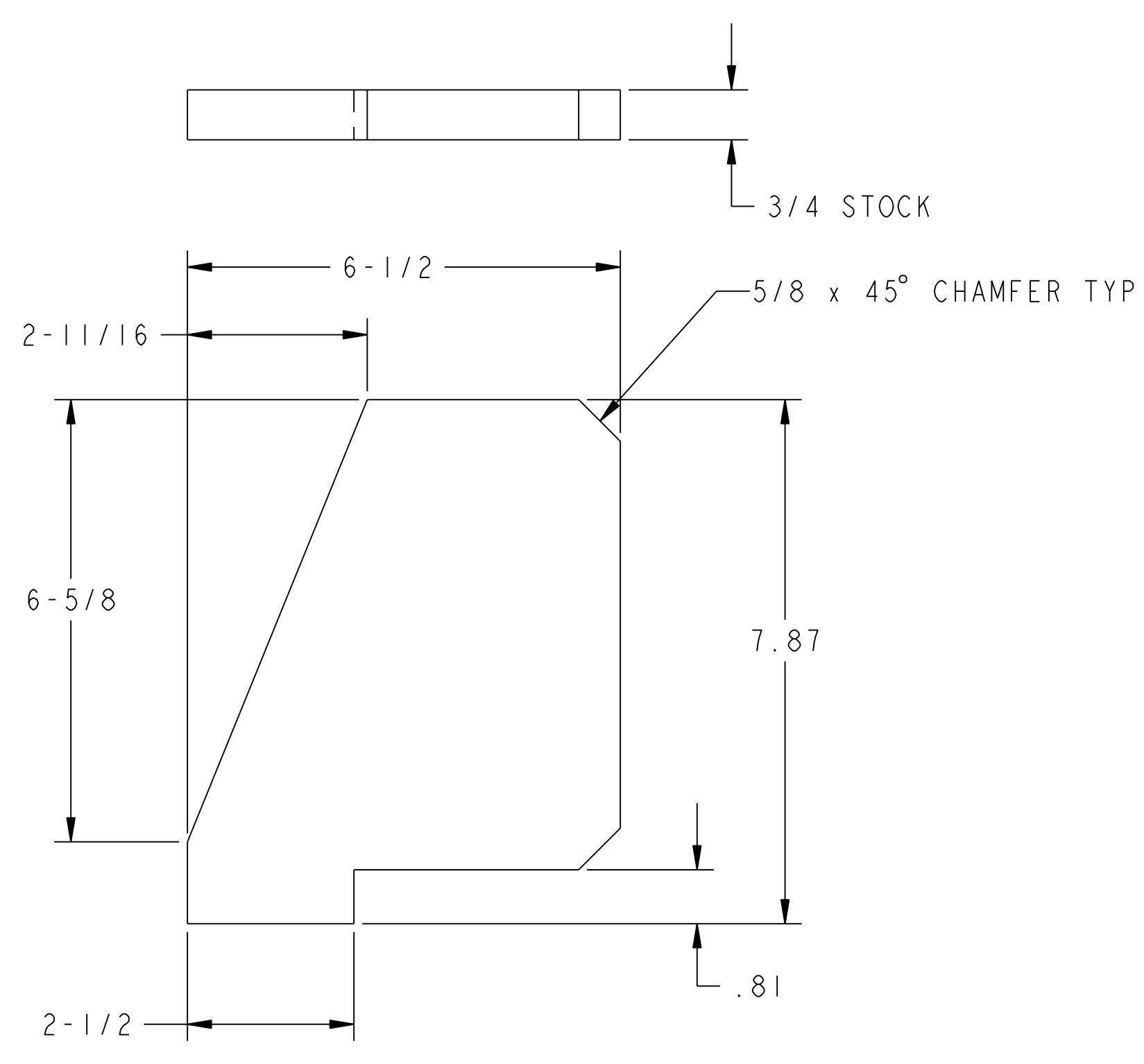
NO.	REVISION	BY	CH	SUP	APPROVED	DATE



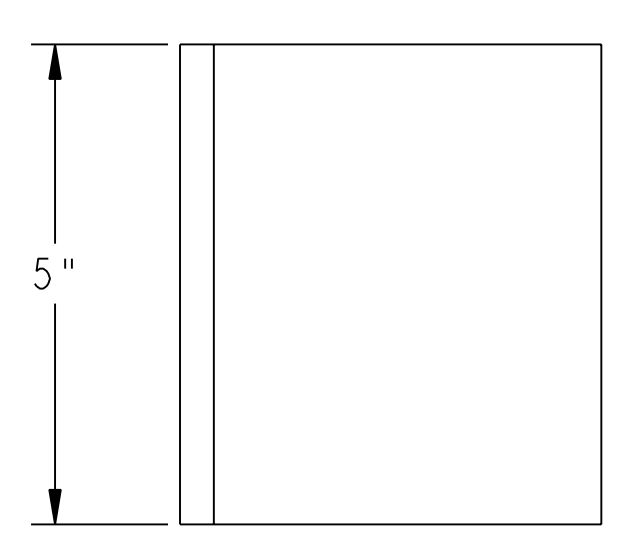
7 GUSSET - TYPE "A"



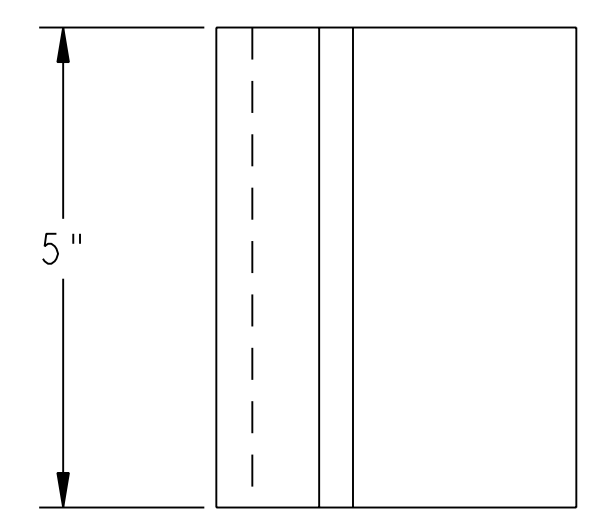
8 GUSSET - TYPE "B"



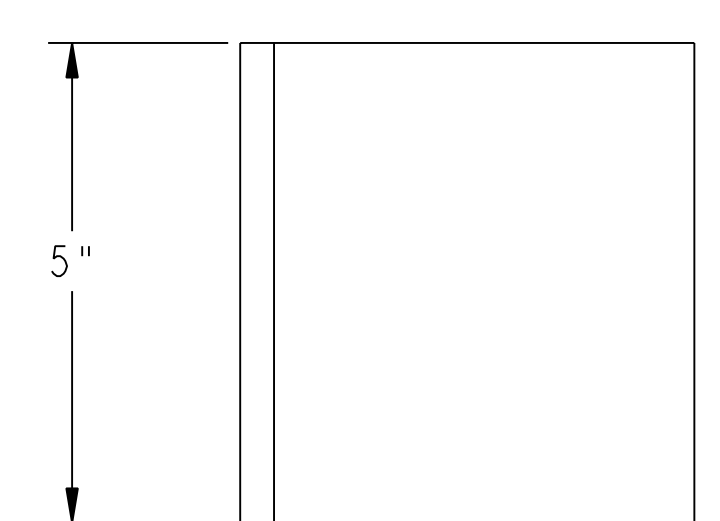
9 GUSSET - TYPE "C"



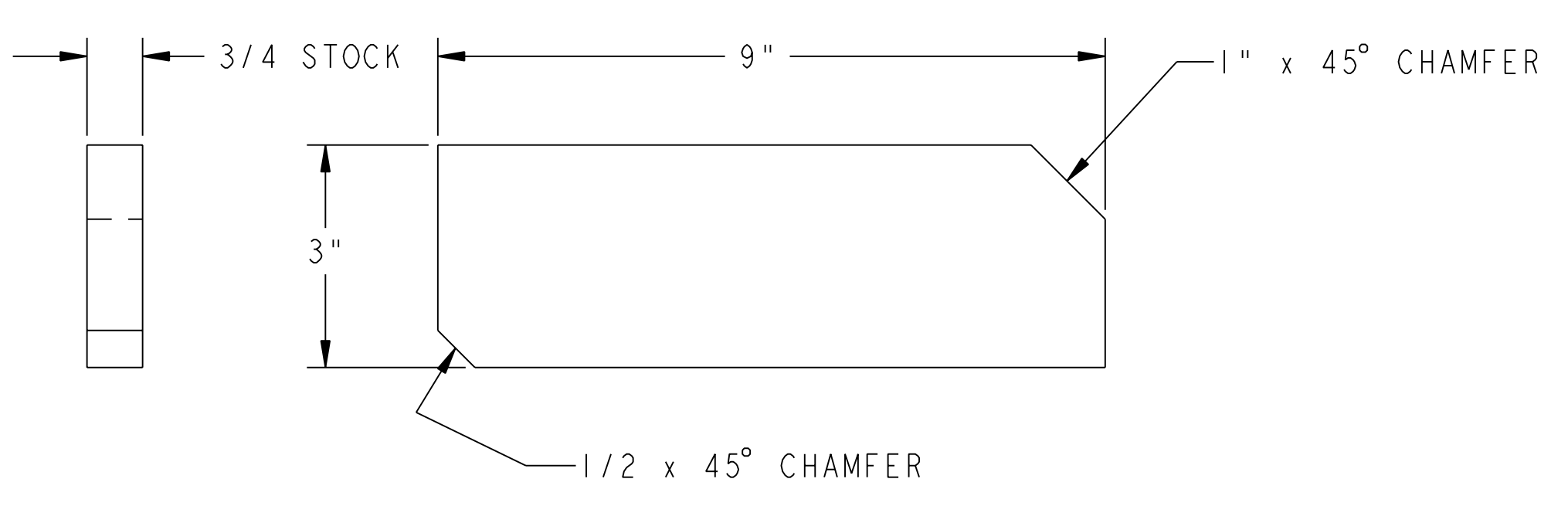
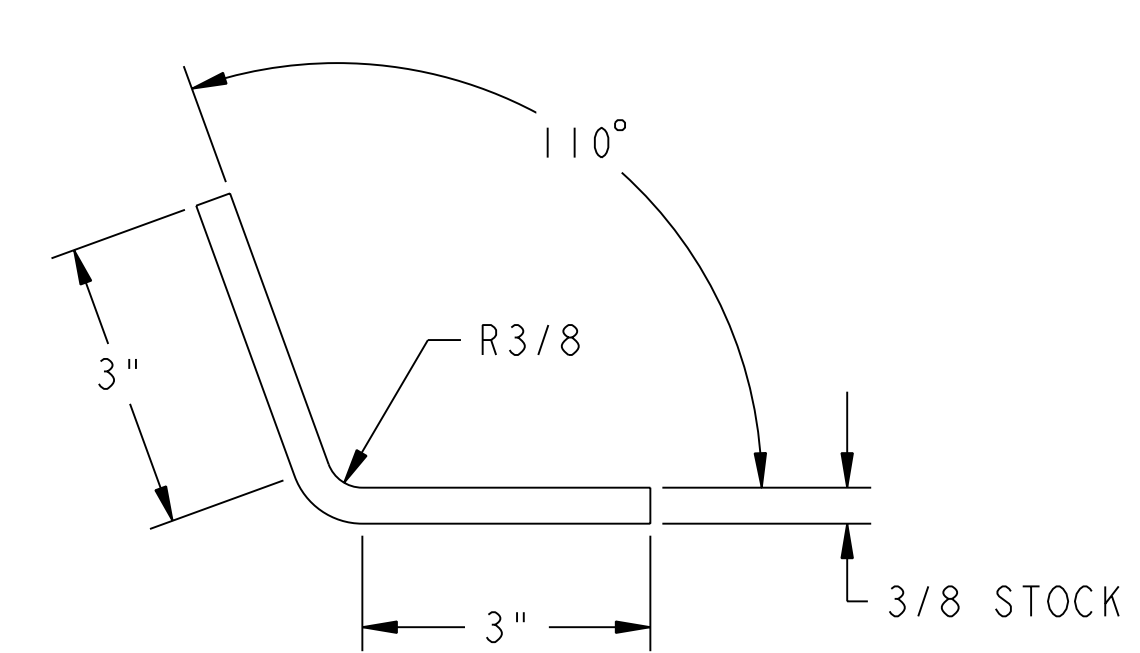
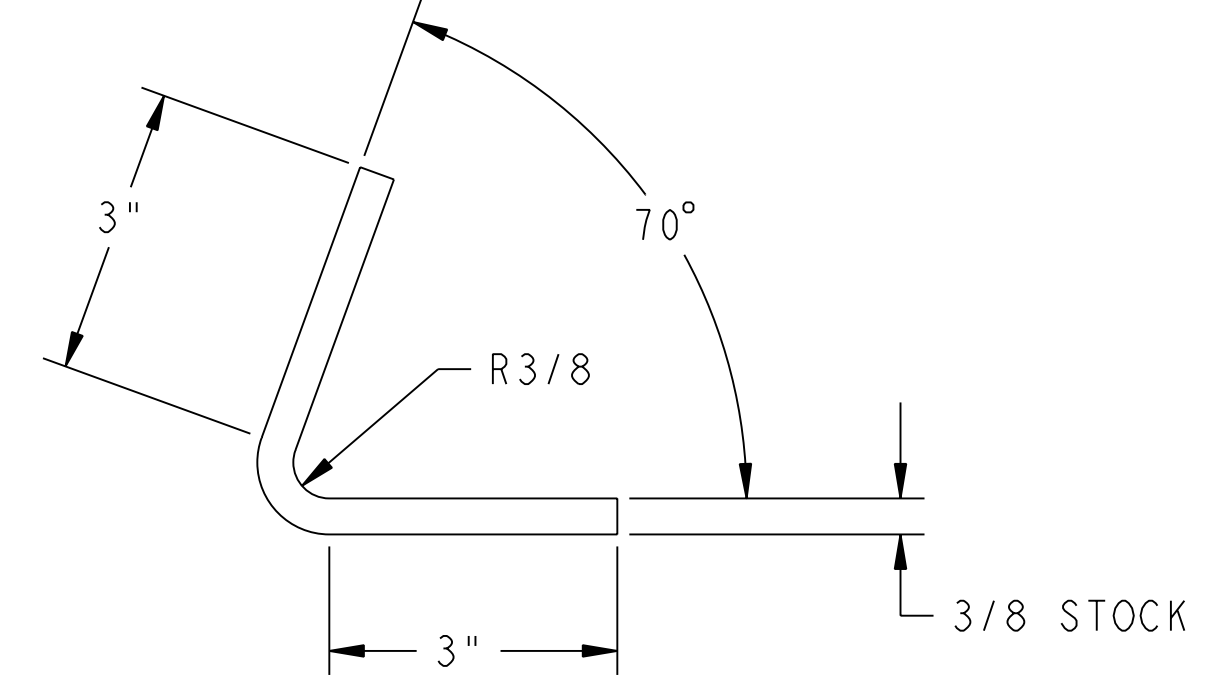
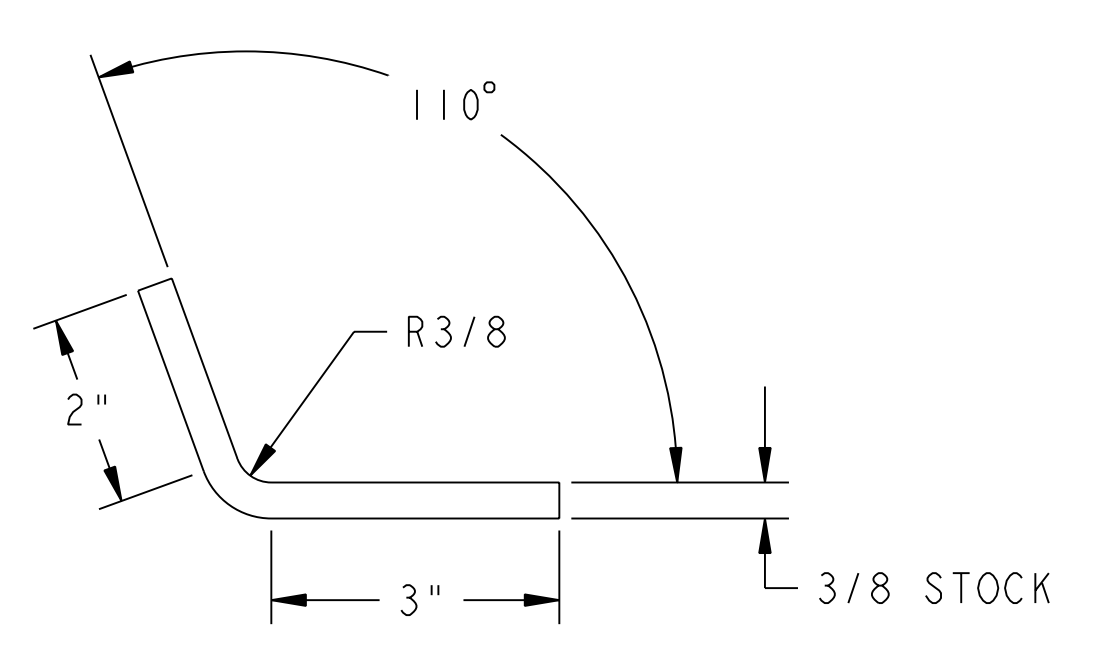
10 FORMED CLIP ANGLE - TYPE "A"



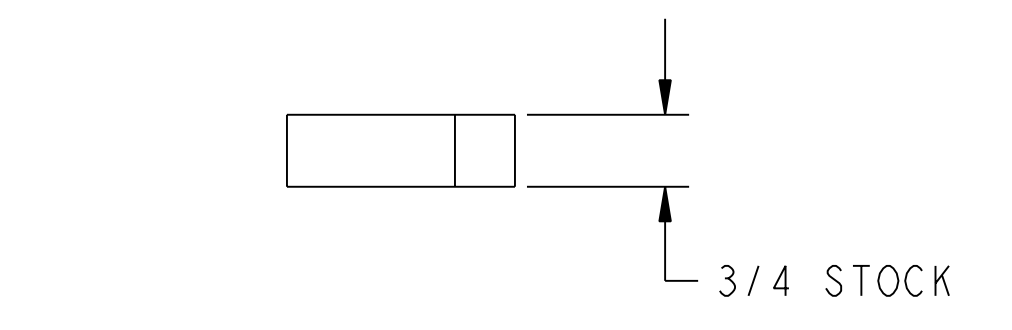
11 FORMED CLIP ANGLE - TYPE "B"



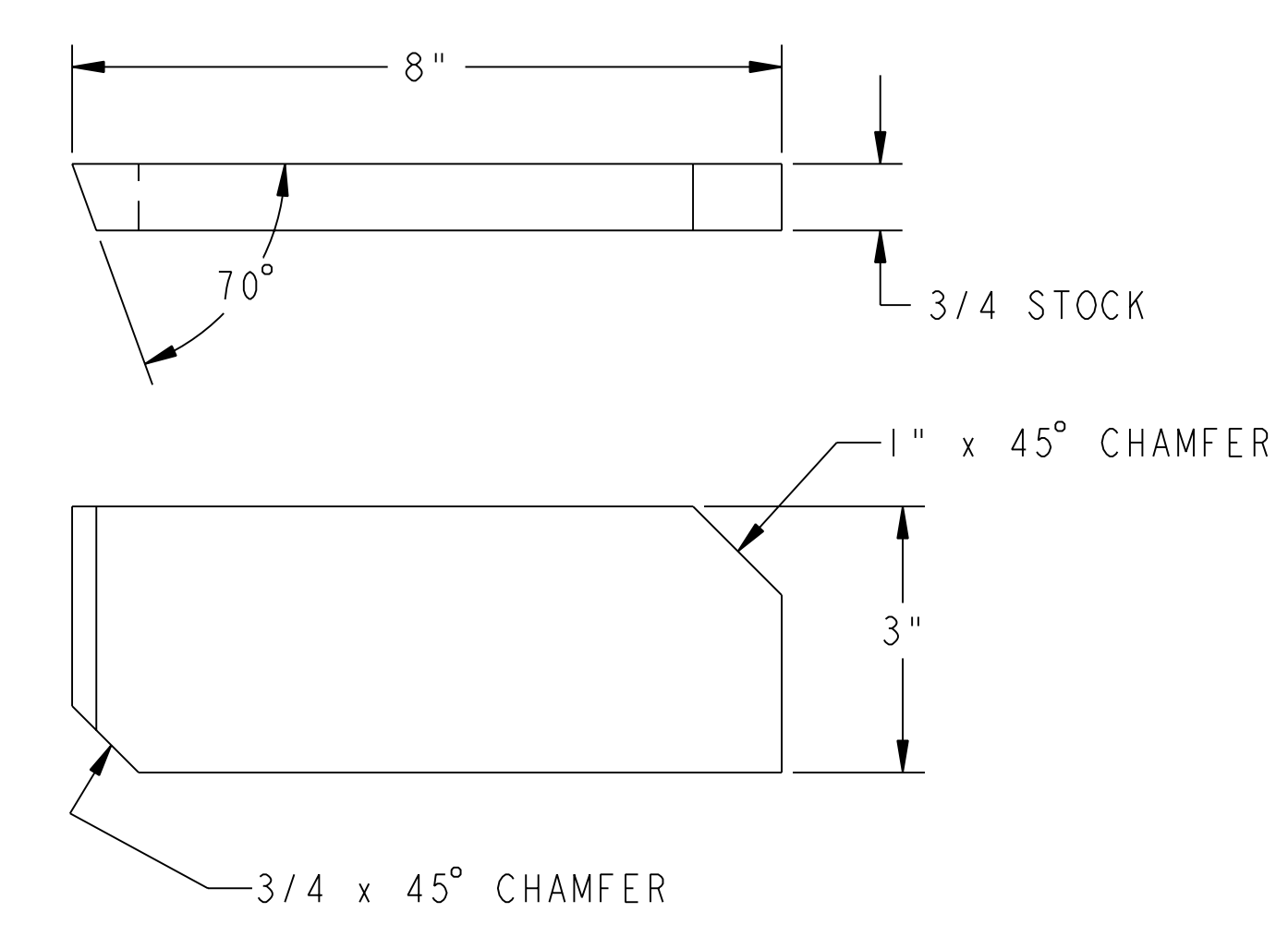
12 FORMED CLIP ANGLE - TYPE "C"



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

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FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

WEIGHT	2072.5 lbs
MODEL NAME	
WELDING ENGINEER	

RELEASE LEVEL: FABRICATION
DWG VERSION NO: 24

COMPUTER GENERATED DRAWING MANUAL 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 +/- .172	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