

IDENTIFIER FOR O2 ASSEMBLY AS SHOWN.
IDENTIFIER FOR O1 ASSEMBLY TO BE ON OPPOSITE SIDE.
SEE NOTES.

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

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.

BRACKET ASSEMBLY IS TO BE STAMPED OR PERMANENTLY MARKED WITH IDENTIFIER AS INDICATED.

SAND BLAST AND APPLY 2 COATS "SAFETY YELLOW" PAINT.

O1 ASSEMBLY - AS SHOWN - (1) REQ'D
O2 ASSEMBLY - OPPOSITE - (1) REQ'D

RELEASED FOR FABRICATION / INSTALLATION
PPPL Drafting

RELEASE LEVEL: FABRICATION
DWG VERSION NO: 4

WEIGHT	112.1 lbs
MODEL NAME	SE186-308-01
WELDING ENGINEER	G. GETTELFINGER 8-2-2007

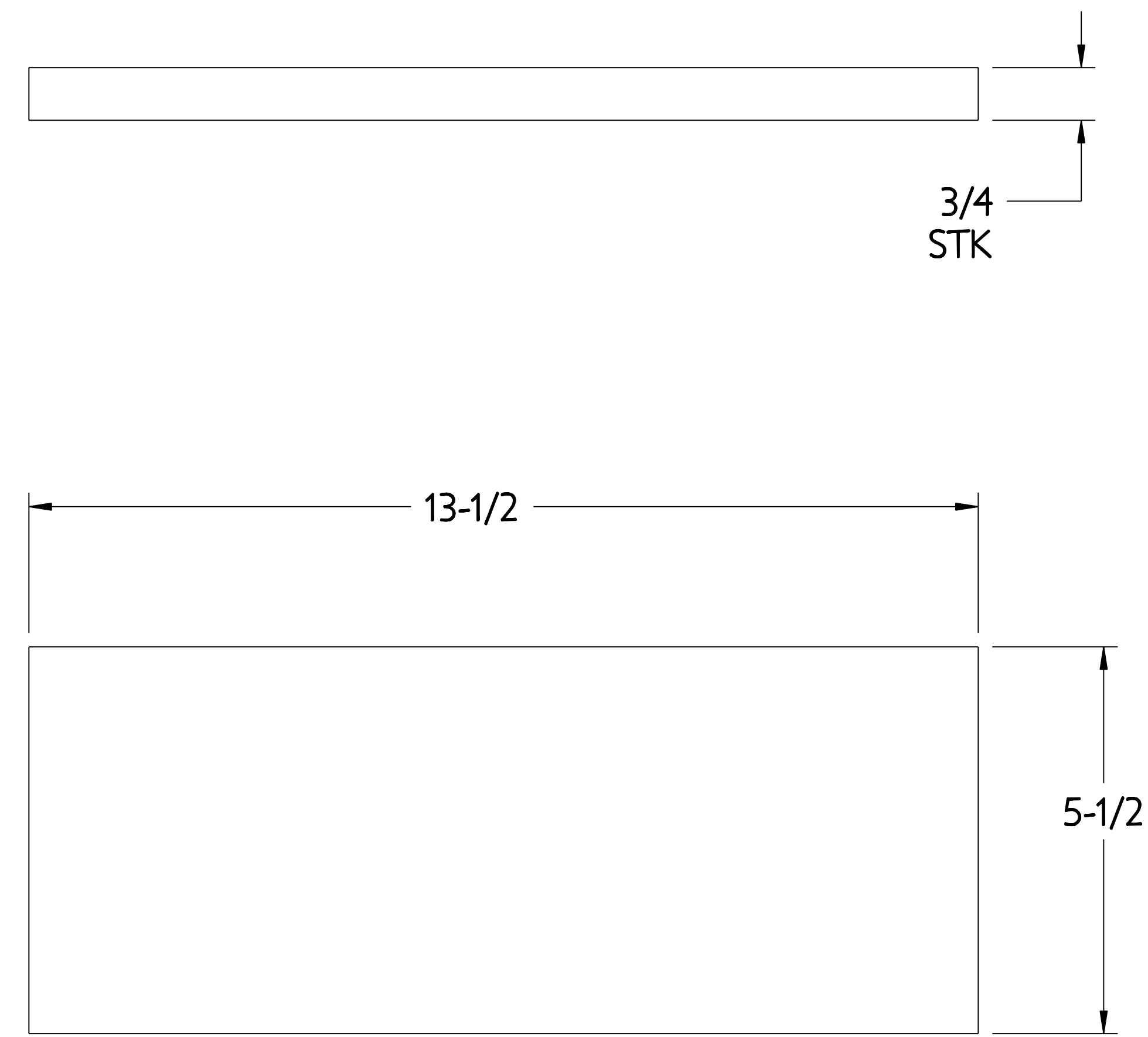
PART NO.	DRAWING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY REQ'D
4	SE186-308-3	BOTTOM PLATE MCWF SEGMENT "C" SUPPORT BRACKET TYPE #2	CARBON STEEL	1
3	SE186-308-2	TOP PLATE MCWF SEGMENT "C" SUPPORT BRACKET TYPE #2	CARBON STEEL	1
2	SE186-308-1	SIDE PLATE MCWF SEGMENT "C" SUPPORT BRACKET TYPE #2	CARBON STEEL	2
1	SE186-307-4	GUSSET SEGMENT "C" MCWF BRACKET	ASTM A36	2

PARTS LIST

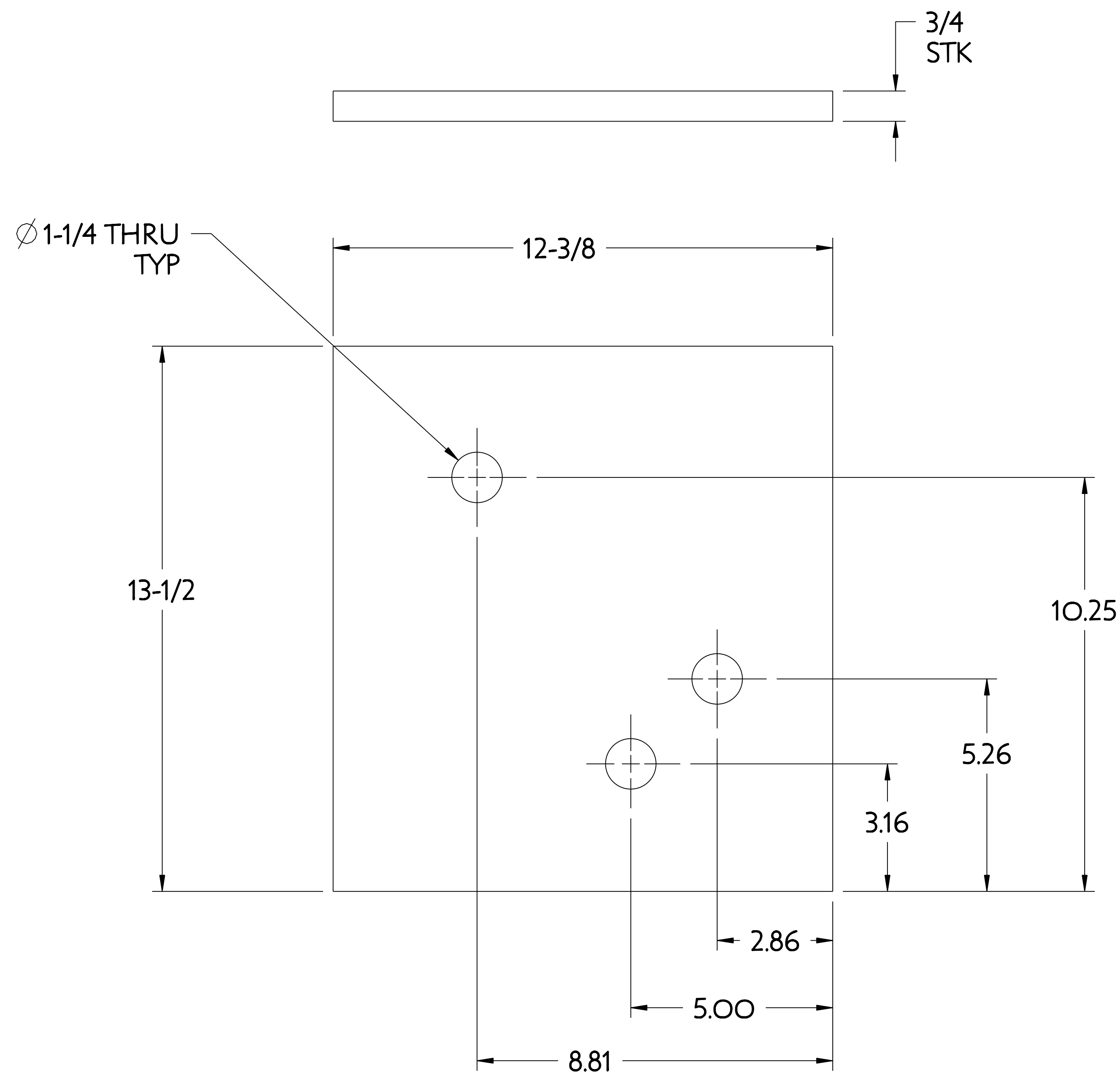
COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY NATIONAL COMPACT STELLARATOR EXPERIMENT
DO NOT VERIFY INFORMATION BY SCALING DRAWING	DIMENSIONS ARE IN INCHES MACHINE SURFACES UNLESS OTHERWISE SPECIFIED BREAK SHARP EDGES .005/.020	STELLARATOR CORE TOOLING DESIGN & FABRICATION MCWF SEGMENT "C" SUPPORT BRACKET TYPE #2 WELDMENTS
SCALE 0.750	TOLERANCES NON-CUMULATIVE	DSN: J. RUSHINSKI 8-2-2007 DRAWING NO:
NEXT ASSEMBLY	DECIMAL-INCH FRACTIONS	CHK: M. COLE 8-2-2007
	.XX +/- .000 0"-.125" +/- .010	ENGR: T. BROWN 8-2-2007
	.XXX +/- .005 .125"-.250" +/- .015	SUPV: J. SIEGEL 8-2-2007
	ANGULAR +/- .015	8-2-2007 SHEET 1 OF 2 REV 0

NCSX-SE186-308

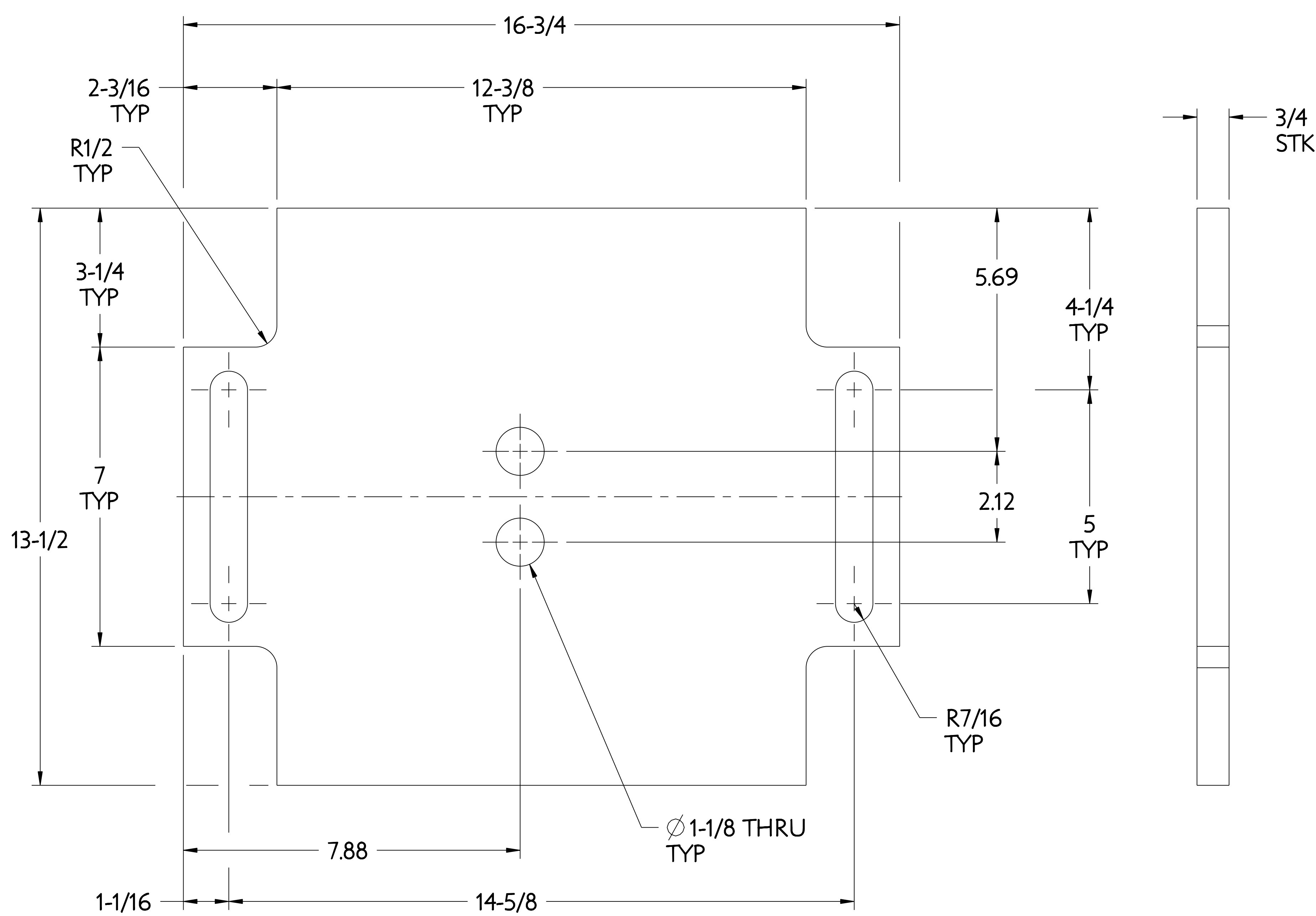
NO.	REVISION	BY	CH	SUP	APPROVED	DATE



1 SIDE PLATE



2 TOP PLATE



3 BOTTOM PLATE

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FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

WEIGHT	112.1 lbs
MODEL NAME	SE186-308-01
WELDING ENGINEER	

RELEASE LEVEL: FABRICATION
 DWG VERSION NO: 4

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY NATIONAL COMPACT STELLARATOR EXPERIMENT	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	STELLARATOR CORE TOOLING DESIGN & FABRICATION MCWF SEGMENT "C" SUPPORT BRACKET TYPE #2 WELDMENTS	
NEXT ASSEMBLY	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX +/- .000 0°-12° +/- .010 .XXX +/- .005 12°-120° +/- .010 ANGULAR +/- 0°-15° OVER 120° +/- .112	DSN: J. RUSHINSKI CHK: M. COLE ENGR: T. BROWN SUPV: J. SIEGEL	8-2-2007 8-2-2007 8-2-2007 8-2-2007
		DRAWING NO: SE186-308	SHEET 2 OF 2 REV 0

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