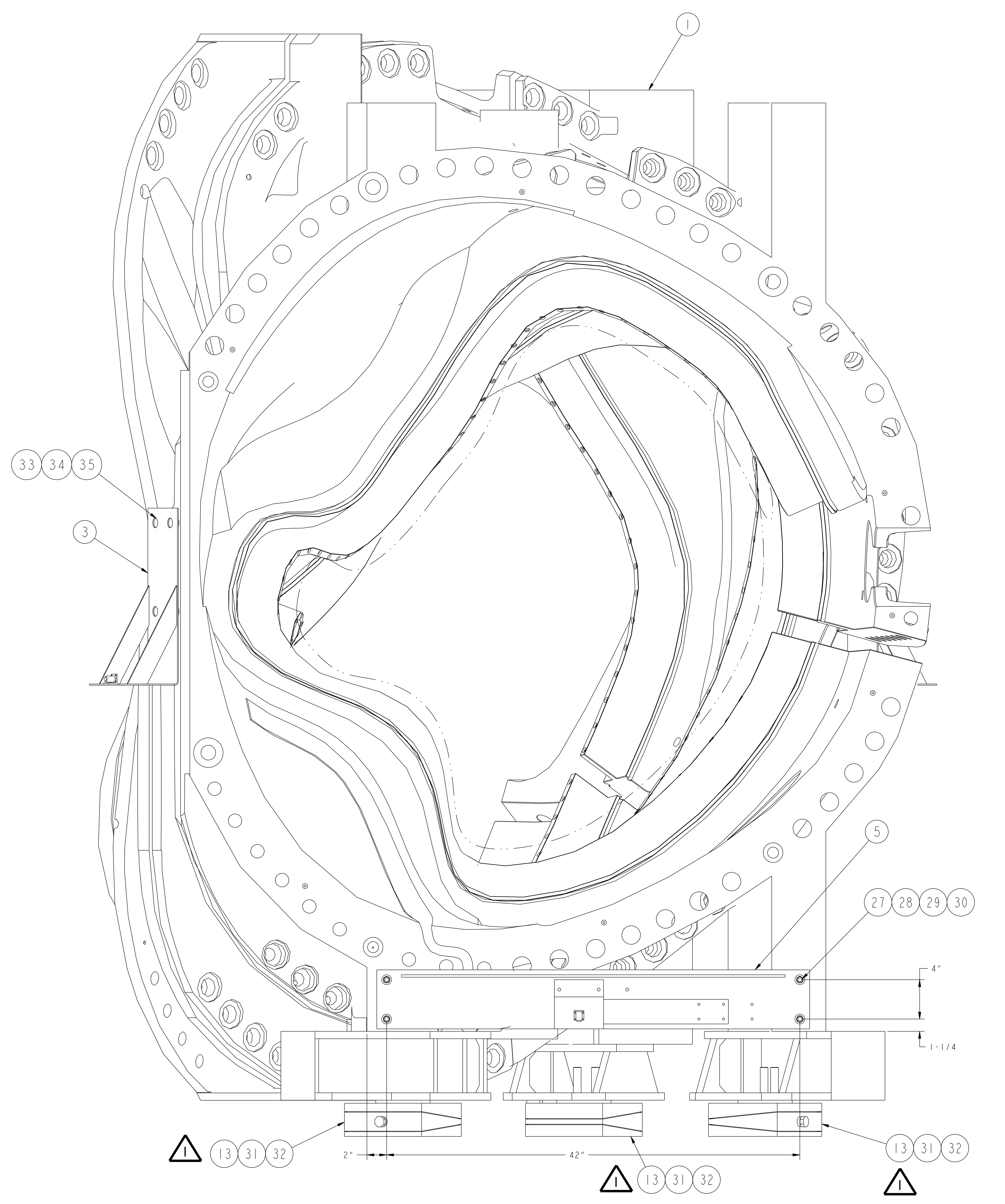


NO.	REVISION	BY	CH	SUP	APPROVED	DATE
1	REVISED PER ECN-	LM	TB	JS	T. BROWN	



**NOTE**  
WORK THIS DRAWING WITH DRAWING SE185-314

2	2	38	COMM	1"-8UNC-2B HEX NUT	C'STL - ZN PLT
4	4	37	COMM	1"-8UNC-2A x 4" LG HEX HD CAP SCREW	C'STL - ZN PLT
3	3	36	COMM	1"-8UNC-2A x 3" LG HEX HD CAP SCREW	C'STL - ZN PLT
8	8	35	COMM	1"-8UNC-2A x 1 1/2 LG HEX HD CAP SCREW	C'STL - ZN PLT
15	15	34	COMM	1" SPLIT LOCK WASHER	C'STL - ZN PLT
17	17	33	COMM	1" FLAT WASHER	C'STL - ZN PLT
6	6	32	COMM	M20 x 2.5MM PITCH METRIC CLASS 8 HEX NUT	C'STL - ZN PLT
6	6	31	COMM	3/4" SPHERICAL WASHER SET - McMASTER-CARR #91131A090	C'STL - ZN PLT
4	4	30	COMM	3/8-16UNC-2B HEX NUT	C'STL - ZN PLT
4	4	29	COMM	3/8" SPLIT LOCK WASHER	C'STL - ZN PLT
4	4	28	COMM	3/8" FLAT WASHER	C'STL - ZN PLT
4	4	27	COMM	WELD STUD - 3/8-16UNC-2A x 1 1/4"LG	C'STL
4	4	26	COMM	1/4-20UNC-2B HEX NUT	C'STL - ZN PLT
4	4	25	COMM	1/4-20UNC-2A x 1" LG HEX HD CAP SCREW	C'STL - ZN PLT
4	4	24	COMM	1/4" SPLIT LOCK WASHER	C'STL - ZN PLT
8	8	23	COMM	1/4" FLAT WASHER	C'STL - ZN PLT
12	12	22	COMM	#10-24UNC-2B HEX NUT	C'STL - ZN PLT
16	16	21	COMM	#10-24UNC-2A x 1" LG HEX SOCKET HD CAP SCREW	C'STL - ZN PLT
16	16	20	COMM	#10 SPLIT LOCK WASHER	C'STL - ZN PLT
32	32	19	COMM	#10 (Ø.190 NOM) FLAT WASHER	C'STL - ZN PLT
12	12	18	COMM	#4-40UNC-2B HEX NUT	C'STL - ZN PLT
12	12	17	COMM	#4 SPLIT LOCK WASHER	C'STL - ZN PLT
24	24	16	COMM	#4 FLAT WASHER	C'STL - ZN PLT
12	12	15	COMM	#4-40UNC-2A x 5/8 LG HEX HD MACH SCR	C'STL - ZN PLT
3	3	14	COMM	ADJUSTABLE-DOT LASER KIT - CLASS 1110 LASER - 110 VAC McMASTER-CARR #2055A21 OR EQUIVALENT	
3	3	13	COMM	AIRLOC WEDGMOUNT PRECISION LEVELER WITH SPHERICAL SEAT, BOLT-ON #1.36206.56-206-VRKC/903	
1	1	12	SE186-338-02	MCWF SEGMENT "C" SUPPORT BRACKET TYPE #2 WELDMENT - OPPOSITE	SEE DWG
1	1	11	SE186-338-01	MCWF SEGMENT "C" SUPPORT BRACKET TYPE #2 WELDMENT - AS SHOWN	SEE DWG
1	1	10	SE186-337-02	MCWF SEGMENT "C" SUPPORT BRACKET WELDMENT - OPPOSITE	SEE DWG
1	1	9	SE186-337-01	MCWF SEGMENT "C" SUPPORT BRACKET TYPE #1 WELDMENT - AS SHOWN	SEE DWG
1	1	8	SE186-336-02	MCWF SEGMENT "A" SUPPORT BRACKET WELDMENT - OPPOSITE	SEE DWG
1	1	7	SE186-336-01	MCWF SEGMENT "A" SUPPORT BRACKET WELDMENT - AS SHOWN	SEE DWG
1	1	6	SE185-311-8	VERTICAL LASER PEN MOUNTING BRACKET BRACE	SEE DWG
1	1	5	SE185-311-04	LASER PEN MOUNTING BRACKET SUPPORT PLATE WELDMENT	SEE DWG
1	1	4	SE185-311-03	VERTICAL LASER PEN MOUNTING BRACKET WELDMENT	SEE DWG
1	1	3	SE185-311-02	REAR LASER PEN MOUNTING BRACKET WELDMENT	SEE DWG
1	1	2	SE185-311-01	FRONT LASER PEN MOUNTING BRACKET WELDMENT	SEE DWG
1	1	1		MODULAR COIL HALF PERIOD ASSEMBLY	
				THIS DWG	RIGHT HALF PERIOD ASSEMBLY
				THIS DWG	LEFT HALF PERIOD ASSEMBLY

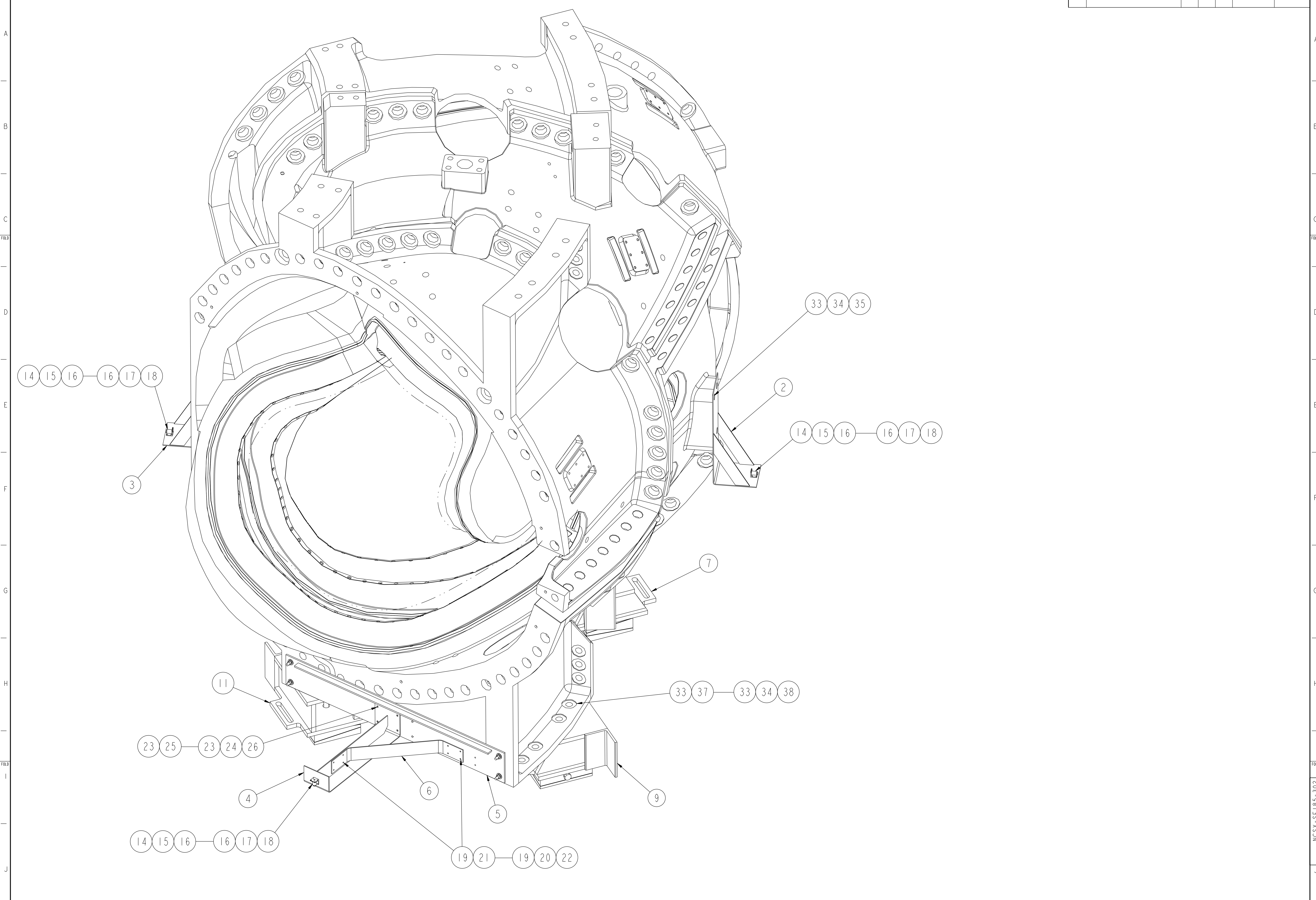
02 ASSY	01 ASSY	PART NO.	DRAWING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY REQ'D
<b>PARTS LIST</b>						
COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED		CENTRAL FILES: UNLESS OTHERWISE SPECIFIED		PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY <b>NATIONAL COMPACT STELLARATOR EXPERIMENT</b>		
DO NOT VERIFY INFORMATION BY SCALING DRAWING		DIMENSIONS ARE IN INCHES MACHINE SURFACES UNLESS SHOWN OTHERWISE		FIELD PERIOD ASSEMBLY FIELD PERIOD ASSEMBLY FIXTURE HALF FIELD PERIOD ASSEMBLY WITH SUPPORTS AND LASER PENS		
NEXT ASSEMBLY		TOLERANCES NON-CUMULATIVE		DSN: L. MORRIS 11-26-07 DRAWING NO:		
WEIGHT		DECIMAL-INCH FRACTIONS		CHK: M. COLE 11-26-07		
MODEL NAME SE185-300		BREAK SHARP EDGES .005/.020		ENGR: T. BROWN 11-26-07		
WELDING ENGINEER		TOLERANCES NON-CUMULATIVE		SUPV: J. SIEGEL 11-26-07 SHEET 1 OF 6 REV 1.0		

01 ASSEMBLY - LEFT HALF PERIOD ASSEMBLY

RELEASE LEVEL: WIP  
DWG VERSION NO: 0

NCSX-SE185-302

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



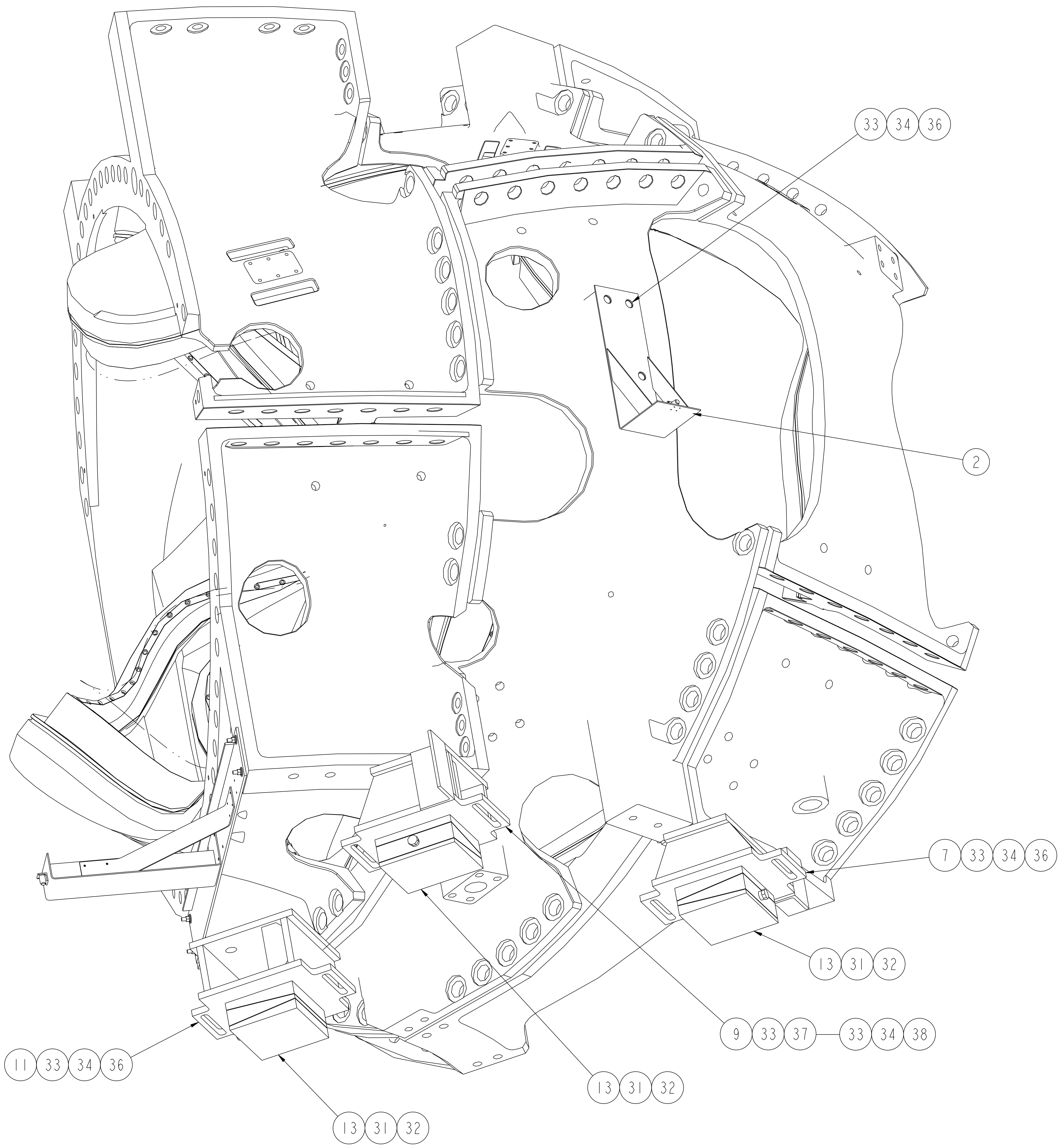
01 ASSEMBLY - LEFT HALF PERIOD ASSEMBLY

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 FIELD PERIOD ASSEMBLY FIXTURE HALF FIELD PERIOD ASSEMBLY WITH SUPPORTS AND LASER PENS	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	TOLERANCES NON-CUMULATIVE	DSN: L. MORRIS 11-26-07 DRAWING NO:
NEXT ASSEMBLY	DECIMAL-INCH FRACTIONS	CHK: M. COLE 11-26-07	ENGR: T. BROWN 11-26-07
WEIGHT	.XX +/- .000 0°-120° +/- 12.0° .XXX +/- .005 120°-120° +/- 12.0° ANGULAR +/- 0°-15° OVER 120° +/- 12.0°	SUPV: J. SIEGEL 11-26-07	<b>SE185-302</b> SHEET 2 OF 6 REV 1.0
MODEL NAME SE185-300	RELEASE LEVEL: WIP DWG VERSION NO: 0		

NCSX-SE185-302

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



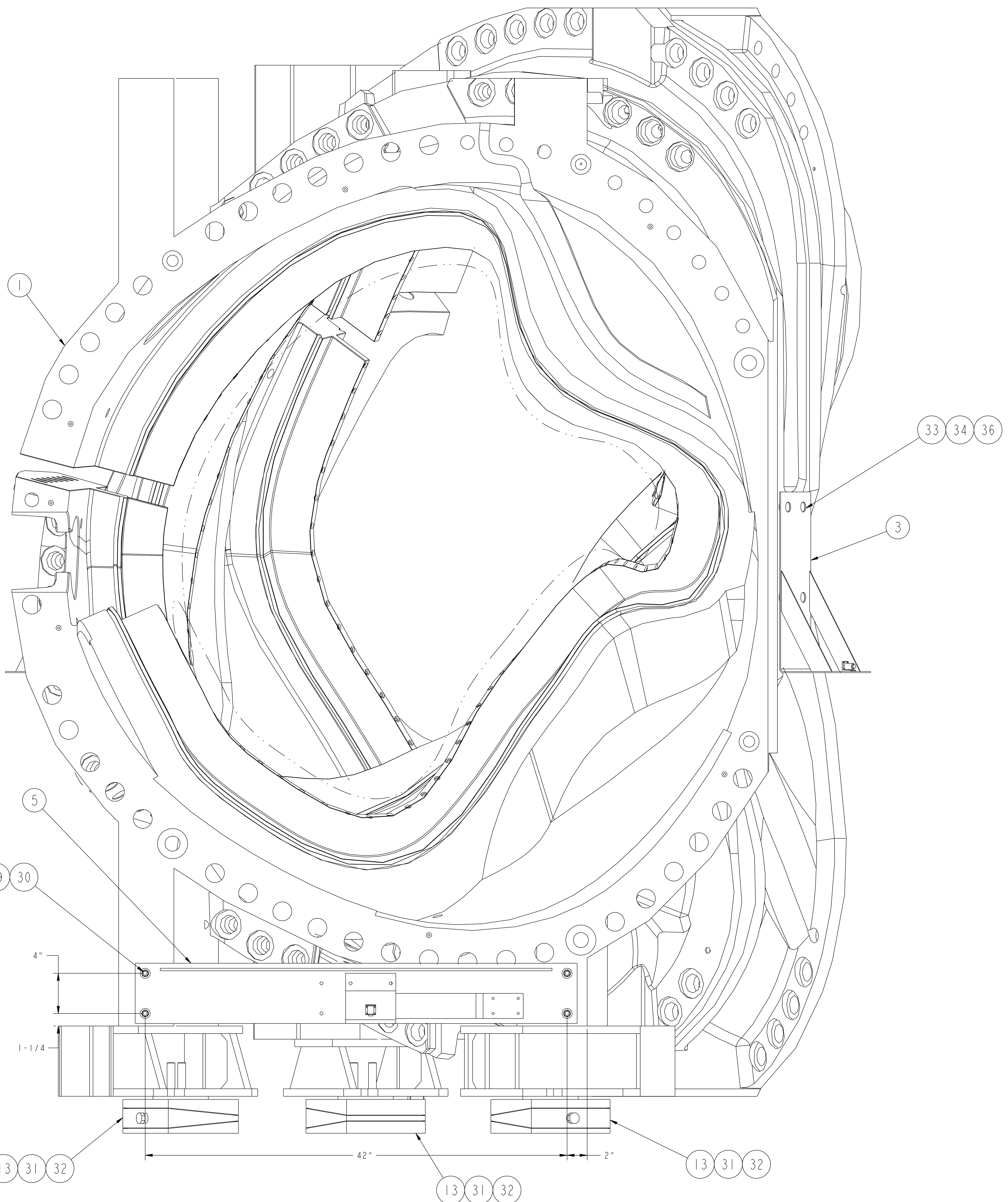
01 ASSEMBLY - BOTTOM ISOMETRIC VIEW

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 FIXTURE	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	DIMENSIONS ARE IN INCHES MACHINE SURFACES	FIELD PERIOD ASSEMBLY WITH SUPPORTS AND LASER PENS	
	BREAK SHARP EDGES .005/.020		
	TOLERANCES NON-CUMULATIVE	DSN: L. MORRIS	11-26-07 DRAWING NO:
NEXT ASSEMBLY	DECIMAL-INCH FRACTIONS	CHK: M. COLE	11-26-07
	.X +/- .000 0°-12° +/- .010	ENGR: T. BROWN	11-26-07
	.XX +/- .030 12°-12° +/- .10		
	.XXX +/- .005 12°-120° +/- .10	SUPV: J. SIEGEL	11-26-07
	ANGULAR +/- .0°-15° OVER 120° +/- .10		

RELEASE LEVEL: WIP  
DWG VERSION NO: 0

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



FOR BILL OF MATERIAL AND NOTES SEE SHEET 1

02 ASSEMBLY - RIGHT HALF PERIOD ASSEMBLY

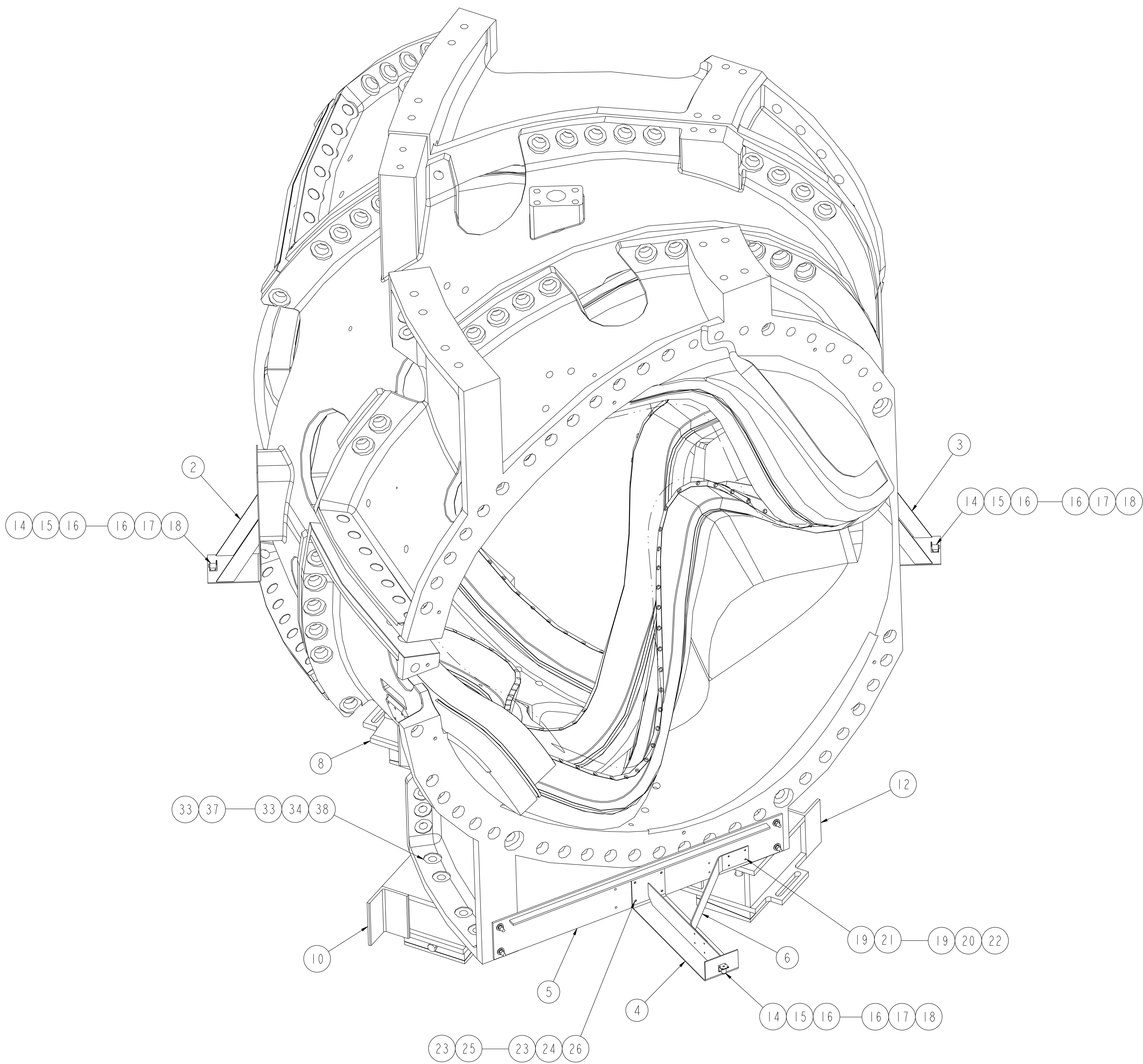
RELEASE LEVEL: WIP  
DWG VERSION NO: 0

WEIGHT	
MODEL NAME	SE185-300
WELDING ENGINEER	

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY <b>NATIONAL COMPACT STELLARATOR EXPERIMENT</b>	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	FIELD PERIOD ASSEMBLY FIELD PERIOD ASSEMBLY FIXTURE HALF FIELD PERIOD ASSEMBLY WITH SUPPORTS AND LASER PENS	
NEXT ASSEMBLY	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX +/- .000 0°-12° +/- .010 .XXX +/- .005 12°-120° +/- .010 ANGULAR +/- .0°-15° OVER 120° +/- .120	DSN: L. MORRIS CHK: M. COLE ENGR: T. BROWN SUPV: J. SIEGEL	11-26-07 11-26-07 11-26-07 11-26-07
		DRAWING NO: <b>SE185-302</b>	SHEET 4 OF 6 REV 1.0

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NO.	REVISION	BY	CH	SUP	APPROVED	DATE



02 ASSEMBLY - RIGHT HALF PERIOD ASSEMBLY

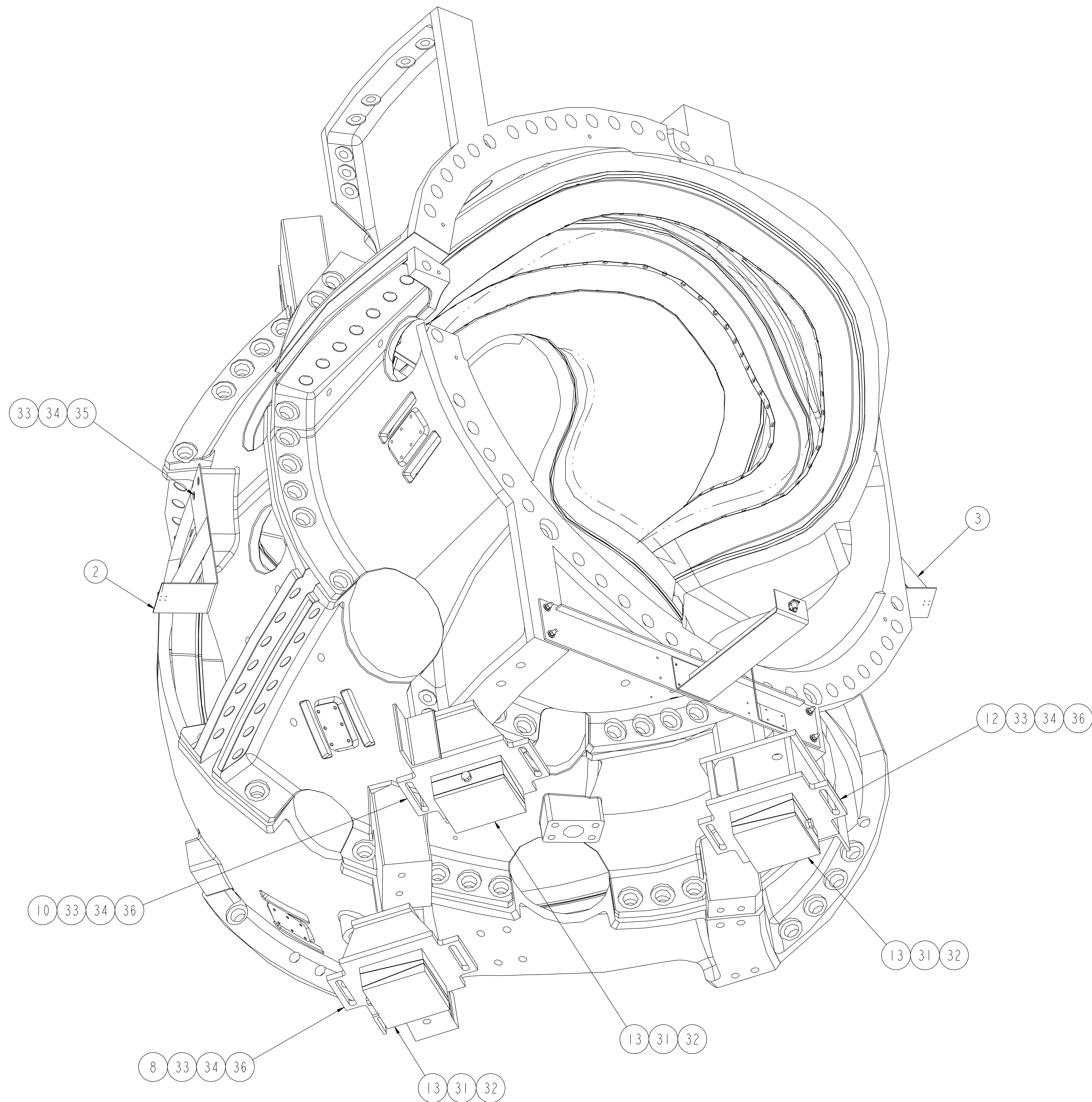
RELEASE LEVEL: WIP  
DWG VERSION NO: 0

WEIGHT	
MODEL NAME	SE185-300
WELDING ENGINEER	

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY NATIONAL COMPACT STELLARATOR EXPERIMENT	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	FIELD PERIOD ASSEMBLY FIELD PERIOD ASSEMBLY FIXTURE HALF FIELD PERIOD ASSEMBLY WITH SUPPORTS AND LASER PENS	
NEXT ASSEMBLY	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX +/- .000 0°-120° +/- .010 .XXX +/- .005 120°-120° +/- .010 ANGULAR +/- 0°-15° OVER 120° +/- .112	DSN: L. MORRIS CHK: M. COLE ENGR: T. BROWN SUPV: J. SIEGEL	11-26-07 11-26-07 11-26-07 11-26-07
		DRAWING NO:	SE185-302
		SHEET 5 OF 6	REV 1.0

NCSX-SE185-302

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



02 ASSEMBLY - BOTTOM ISOMETRIC VIEW

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

RELEASE LEVEL: WIP  
DWG VERSION NO: 0

WEIGHT  
MODEL NAME  
SE185-300  
WELDING  
ENGINEER

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY NATIONAL COMPACT STELLARATOR EXPERIMENT	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	FIELD PERIOD ASSEMBLY FIELD PERIOD ASSEMBLY FIXTURE HALF FIELD PERIOD ASSEMBLY WITH SUPPORTS AND LASER PENS	
NEXT ASSEMBLY	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX +/- .000 0°-12° +/- .010 .XXX +/- .005 12°-120° +/- .010 ANGULAR +/- .0°-15° OVER 120° +/- .120	DSN: L. MORRIS CHK: M. COLE ENGR: T. BROWN SUPV: J. SIEGEL	11-26-07 11-26-07 11-26-07 11-26-07
		DRAWING NO: <b>SE185-302</b>	SHEET 6 OF 6 REV 1.0

NCSX-SE185-302