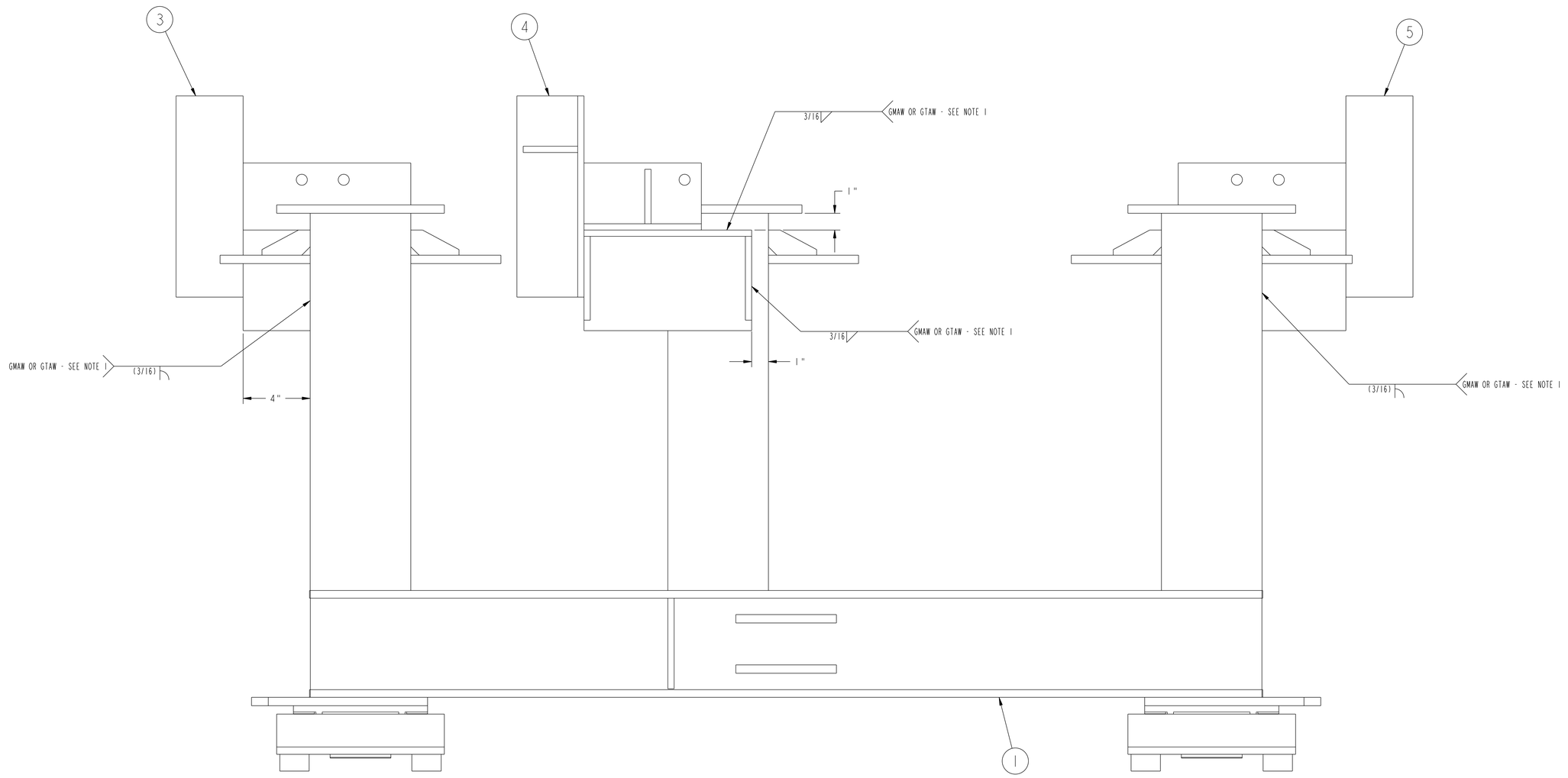
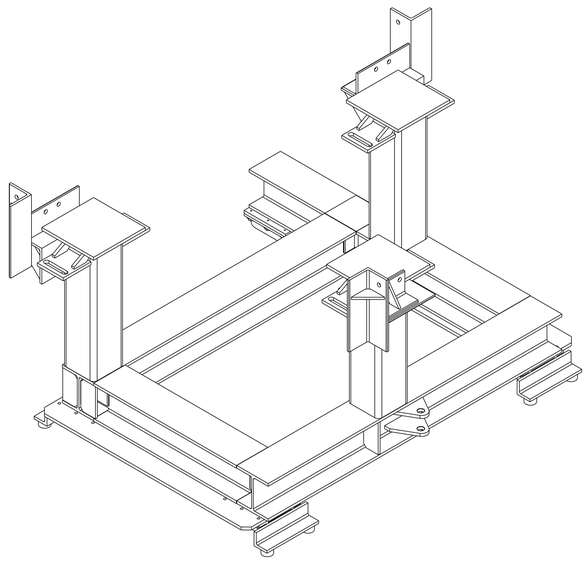
NO.	REVISION	BY	CH	SUP	APPROVED	DATE



01 ASSEMBLY

FRONT VIEW



REFERENCE ISOMETRIC

SCALE 0.125

NOTES

1. WELDING TO 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.

02 ASSY	01 ASSY	PART NO.	DRAWING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY REQD
1		8	SE186-335-06	POSITIONER BRACKET WELDMENT - TYPE "F"	SEE DWG	
1		7	SE186-335-05	POSITIONER BRACKET WELDMENT - TYPE "E"	SEE DWG	
1		6	SE186-335-04	POSITIONER BRACKET WELDMENT - TYPE "D"	SEE DWG	
	1	5	SE186-335-03	POSITIONER BRACKET WELDMENT - TYPE "C"	SEE DWG	
	1	4	SE186-335-02	POSITIONER BRACKET WELDMENT - TYPE "B"	SEE DWG	
	1	3	SE186-335-01	POSITIONER BRACKET WELDMENT - TYPE "A"	SEE DWG	
1		2	SE186-330-02	MCWF LEFT SIDE SUPPORT CART WELDMENT	SEE DWG	
	1	1	SE186-315	MCWF RIGHT SIDE SUPPORT CART ASSEMBLY	SEE DWG	
X	X	—	THIS DWG	LEFT SIDE CART WITH POSITIONER BRACKETS WELDMENT	———	1
X	X	—	THIS DWG	RIGHT SIDE CART WITH POSITIONER BRACKETS WELDMENT	———	1

PARTS LIST

NCSX-SE186-334

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY NATIONAL COMPACT STELLARATOR EXPERIMENT	
Pro E	DIMENSIONS ARE IN INCHES MACHINE SURFACES 125	FIELD PERIOD ASSEMBLY TOOLING DESIGN AND FABRICATION R.H. AND L.H. CART WITH POSITIONER BRACKET WELDMENTS	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	BREAK SHARP EDGES .005/.020		
	TOLERANCES NON-CUMULATIVE	DSN: L. MORRIS	DRAWING NO:
NEXT ASSEMBLY	DECIMAL-INCH: .X +/-.100, .XX +/-.030, .XXX +/-.005, ANGULAR +/-0°-15' / FRACTIONS: 0°-12° +/-1/16, 12°-72° +/-1/8, 72°-120° +/-1/4, OVER 120° +/-1/2	CHK:	SE186-334
		ENGR: T. BROWN	
		SUPV:	SHEET 1 OF 6 REV 0

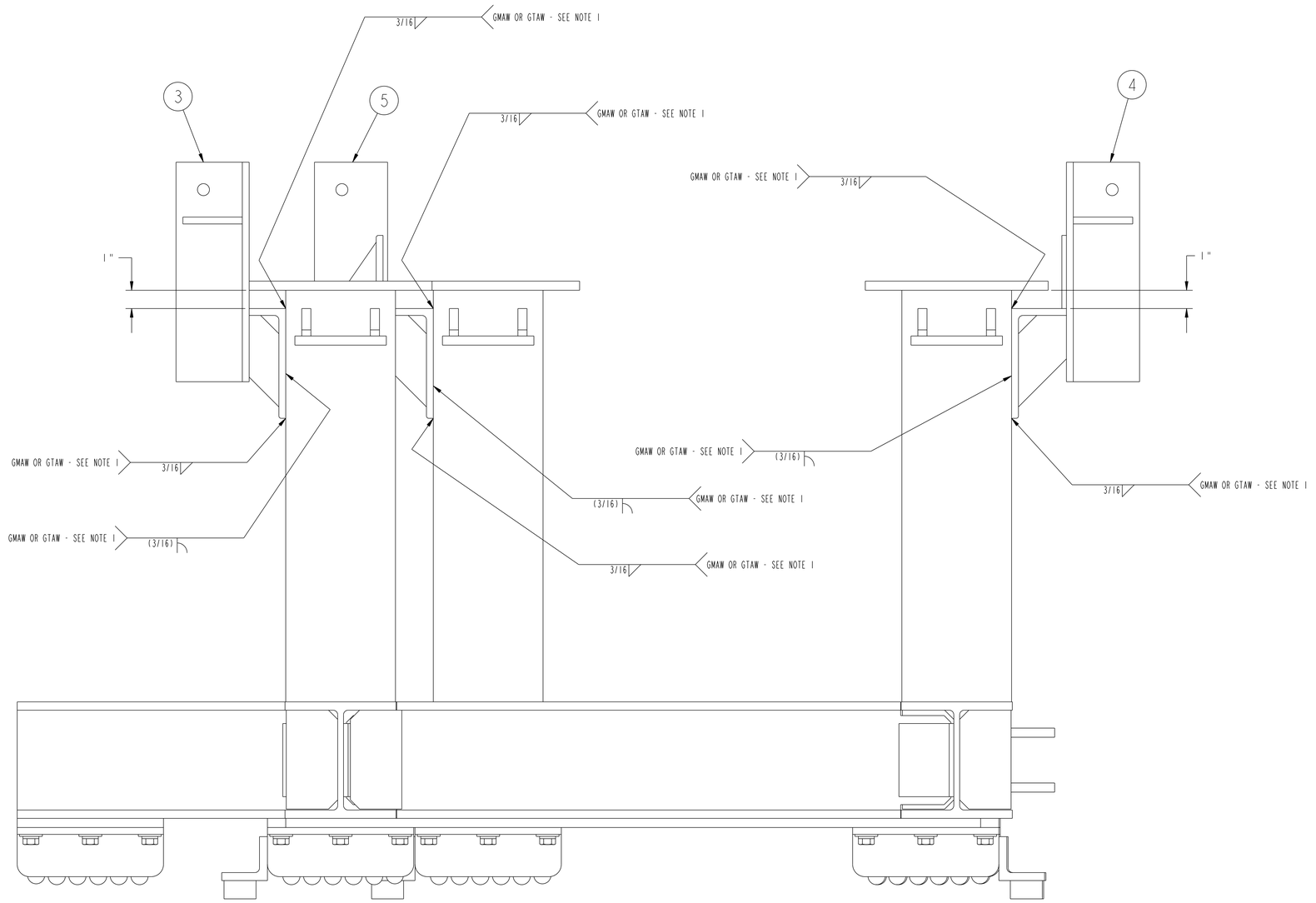
WEIGHT	1271.3 lbs
MODEL NAME	SE186-334-01
WELDING ENGINEER	

RELEASE LEVEL: WIP

DWG VERSION NO: 0

NCSX_ASSY_FORMAT_E

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



01 ASSEMBLY

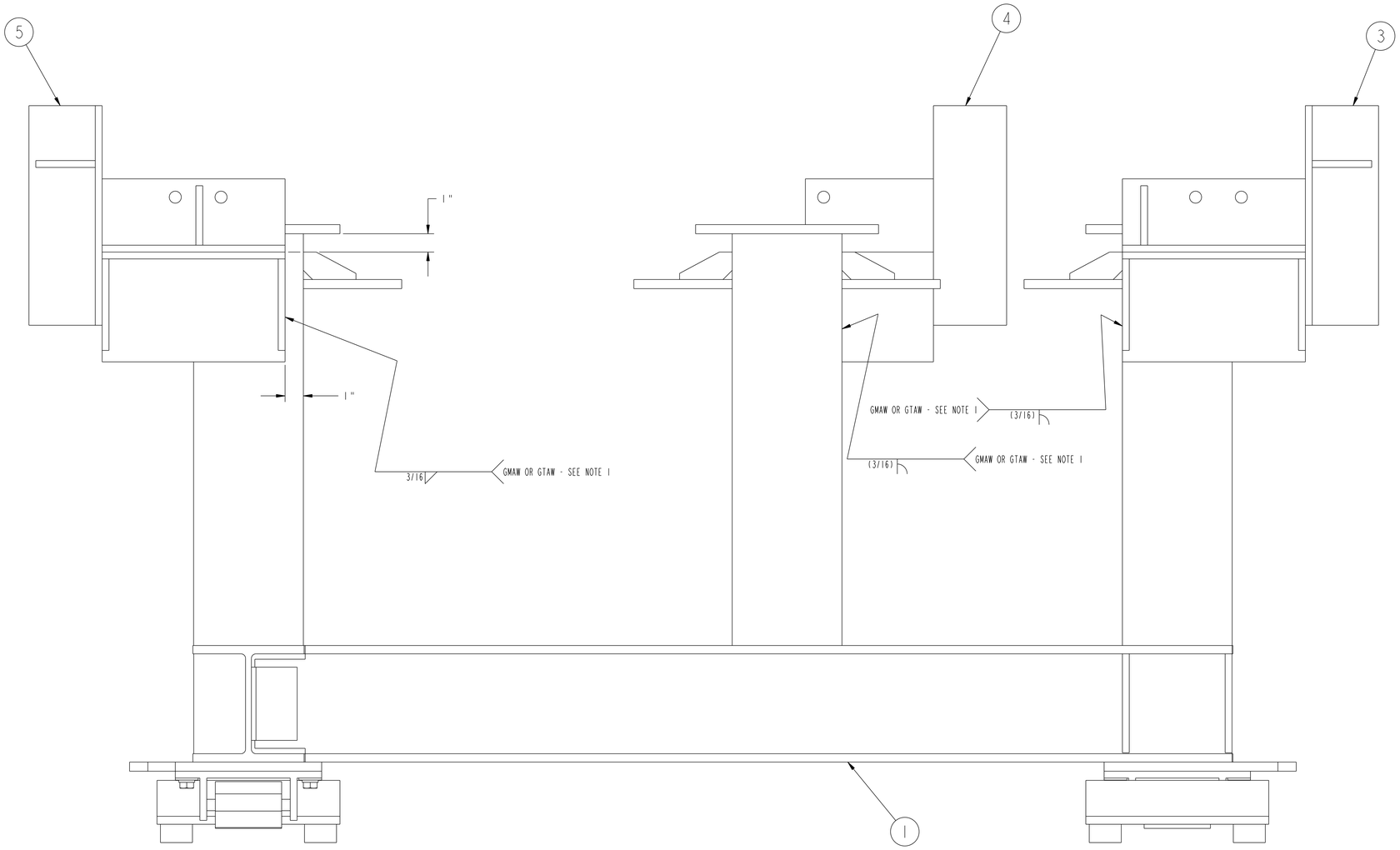
LEFT SIDE VIEW

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

COMPUTER GENERATED DRAWING MANUAL 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 TOOLING DESIGN AND FABRICATION R.H. AND L.H. CART WITH POSITIONER BRACKET WELDMENTS	
WEIGHT 1271.3 lbs	TOLERANCES NON-CUMULATIVE	DSN: L. MORRIS	DRAWING NO:
MODEL NAME SE186-334-01	NEXT ASSEMBLY	CHK:	SE186-334
RELEASE LEVEL: WIP	DECIMAL-INCH: .X +/-.100, .XX +/-.030, .XXX +/-.005, ANGULAR +/-0°15' / FRACTIONS: 0"-12" +/-1/16, 12"-72" +/-1/8, 72"-120" +/-1/4, OVER 120" +/-1/2	ENGR: T. BROWN	
DWG VERSION NO: 0	WELDING ENGINEER	SUPV:	SHEET 2 OF 6 REV 0.0

NCSX_ASSY_FORMAT_E

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



01 ASSEMBLY

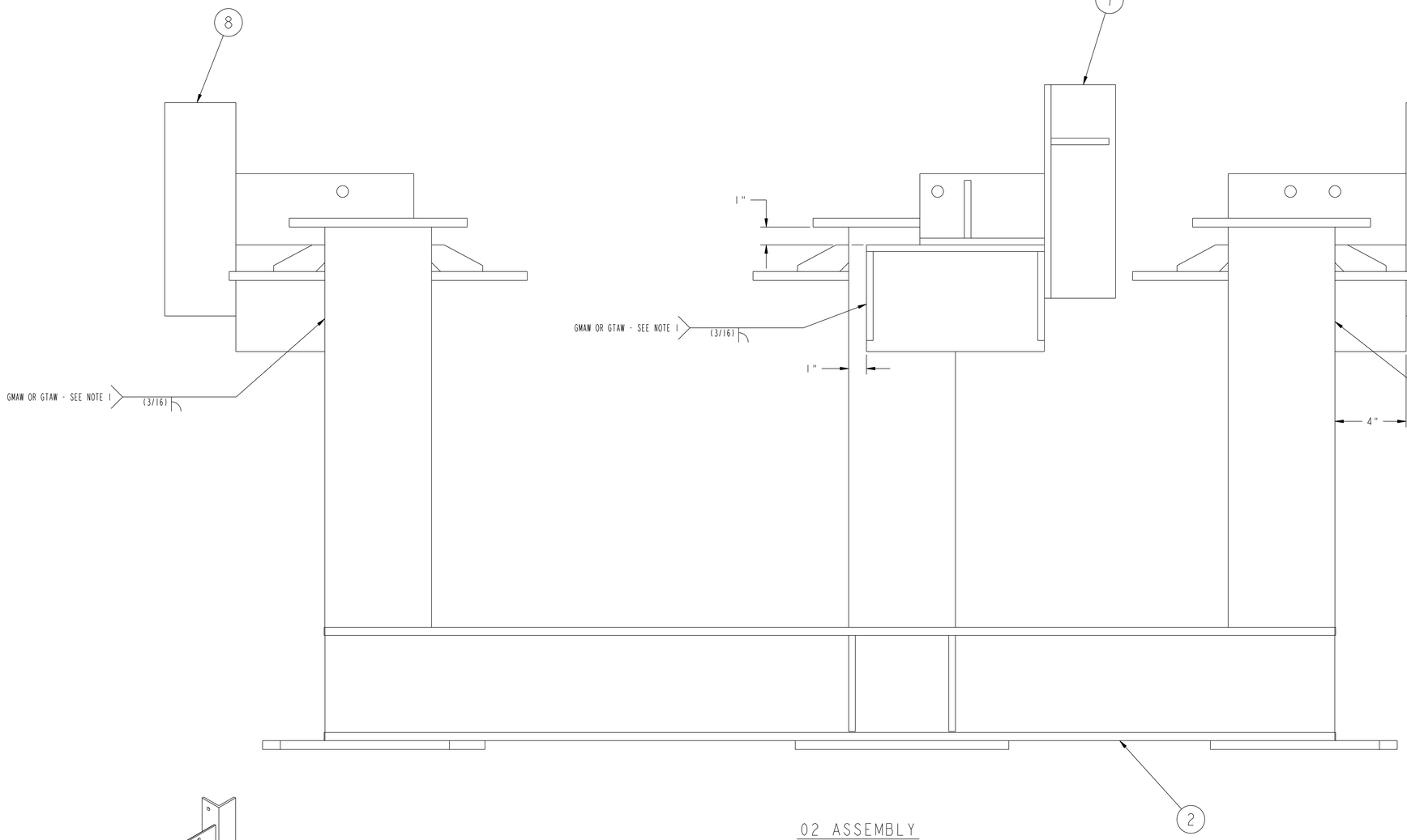
BACK VIEW

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY NATIONAL COMPACT STELLARATOR EXPERIMENT	
Pro E	DIMENSIONS ARE IN INCHES MACHINE SURFACES 125	FIELD PERIOD ASSEMBLY TOOLING DESIGN AND FABRICATION R.H. AND L.H. CART WITH POSITIONING BRACKET WELDMENTS	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	BREAK SHARP EDGES .005/.020		
WEIGHT 1271.3 lbs	TOLERANCES NON-CUMULATIVE	DSN: L. MORRIS	DRAWING NO: SE186-334
MODEL NAME SE186-334-01	DECIMAL-INCH: .X +/-.100, .XX +/-.030, .XXX +/-.005, ANGULAR +/-0°-15'; FRACTIONS: 0°-12° +/-1/16, 12°-72° +/-1/8, 72°-120° +/-1/4, OVER 120° +/-1/2	CHK:	
NEXT ASSEMBLY		ENGR: T. BROWN	
RELEASE LEVEL: WIP	WELDING ENGINEER	SUPV:	SHEET 3 OF 6 REV 0.0
DWG VERSION NO: 0			NCSX_ASSY_FORMAT_E

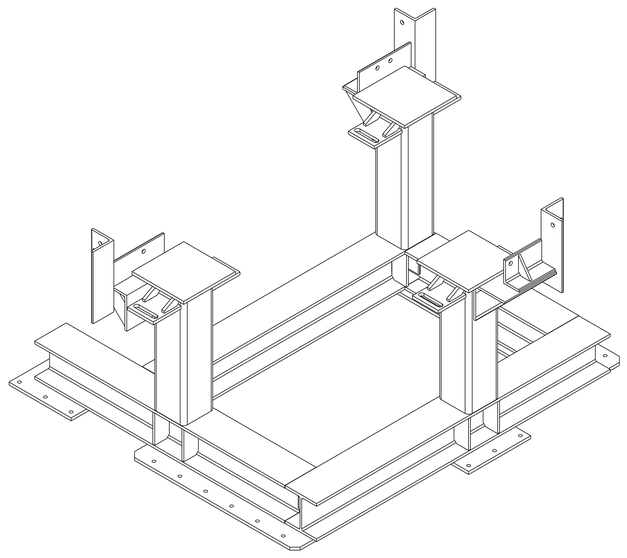
NCSX-SE186-334

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



02 ASSEMBLY

FRONT VIEW



REFERENCE ISOMETRIC

SCALE 0.125

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

RELEASE LEVEL: WIP

DWG VERSION NO: 0

WEIGHT
1271.3 lbs

MODEL NAME
SE186-334-01

WELDING ENGINEER

COMPUTER GENERATED DRAWING
MANUAL CHANGES NOT PERMITTED

Pro E

DO NOT VERIFY INFORMATION BY SCALING DRAWING

NEXT ASSEMBLY

CENTRAL FILES:
UNLESS OTHERWISE SPECIFIED

DIMENSIONS ARE IN INCHES
MACHINE SURFACES

BREAK SHARP EDGES .005/.020

TOLERANCES NON-CUMULATIVE

DECIMAL-INCH		FRACTIONS
.X	+/-.100	0°-12° +/-1/16
.XX	+/-.030	12°-72° +/-1/8
.XXX	+/-.005	72°-120° +/-1/4
ANGULAR +/-0°-15'		OVER 120° +/-1/2

PRINCETON PLASMA PHYSICS LABORATORY
PRINCETON UNIVERSITY
NATIONAL COMPACT STELLARATOR EXPERIMENT

FIELD PERIOD ASSEMBLY
TOOLING DESIGN AND FABRICATION
R.H. AND L.H. CART WITH POSITIONER BRACKET WELDMENTS

DSN:
CHK:
ENGR: T. BROWN
SUPV:

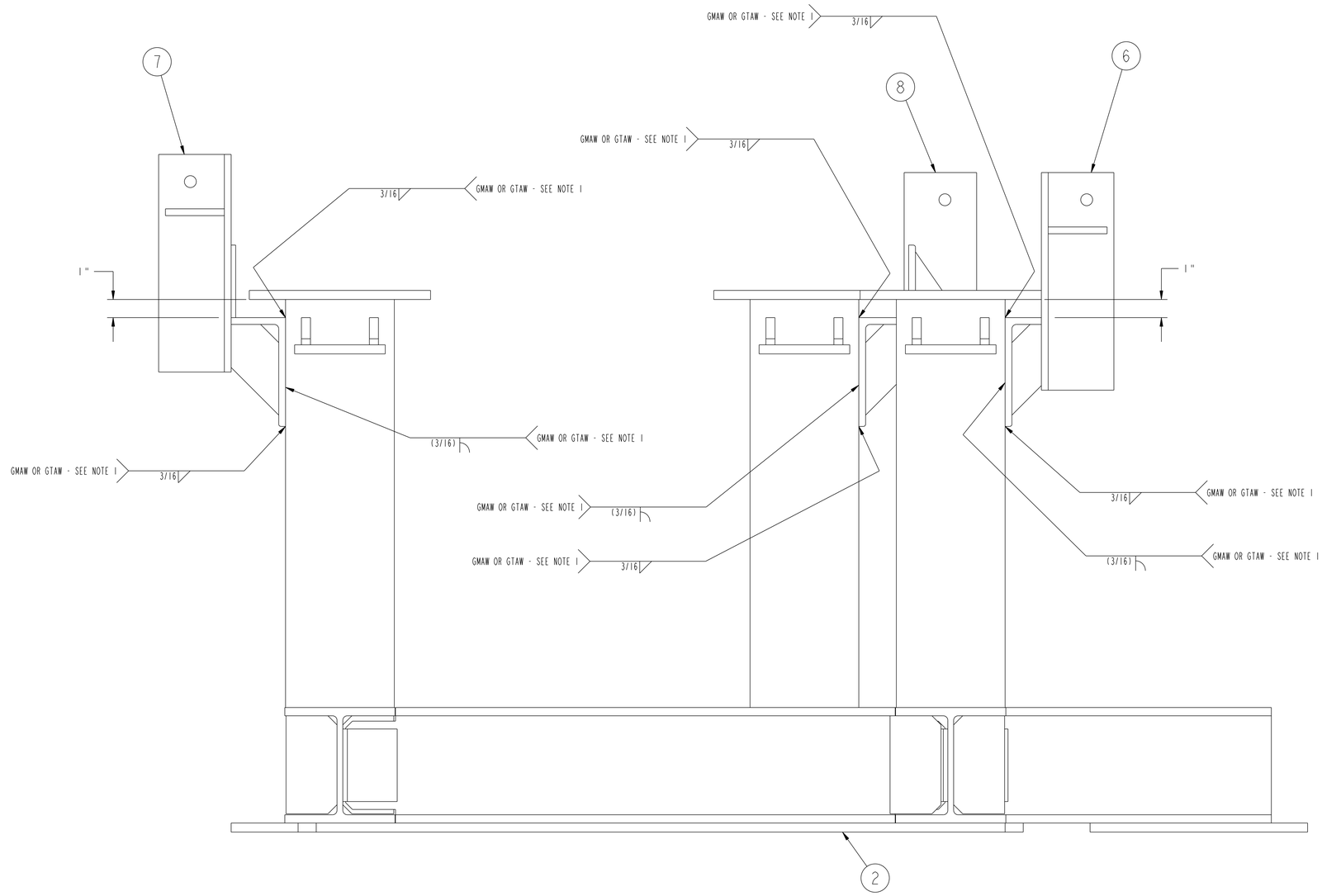
DRAWING NO:
SE186-334

SHEET 4 OF 6 REV 0.0

NCSX-SE186-334

NCSX_ASSY_FORMAT_E

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



02 ASSEMBLY

RIGHT SIDE VIEW

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

RELEASE LEVEL: WIP

DWG VERSION NO: 0

WEIGHT
1423.1 lbs

MODEL NAME
SE186-334-02

WELDING ENGINEER

NEXT ASSEMBLY

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED

Pro E

DO NOT VERIFY INFORMATION BY SCALING DRAWING

CENTRAL FILES: UNLESS OTHERWISE SPECIFIED

DIMENSIONS ARE IN INCHES
MACHINE SURFACES 125

BREAK SHARP EDGES .005/.020

TOLERANCES NON-CUMULATIVE

DECIMAL-INCH	FRACTIONS
.X +/-.100	0°-12° +/-1/16
.XX +/-.030	12°-72° +/-1/8
.XXX +/-.005	72°-120° +/-1/4
ANGULAR +/-0°-15'	OVER 120° +/-1/2

PRINCETON PLASMA PHYSICS LABORATORY
PRINCETON UNIVERSITY
NATIONAL COMPACT STELLARATOR EXPERIMENT

FIELD PERIOD ASSEMBLY
TOOLING AND DESIGN FABRICATION
R.H. AND L. H. CART WITH POSITIONER BRACKET WELDMENTS

DSN: L. MORRIS
CHK:
ENGR: T. BROWN
SUPV:

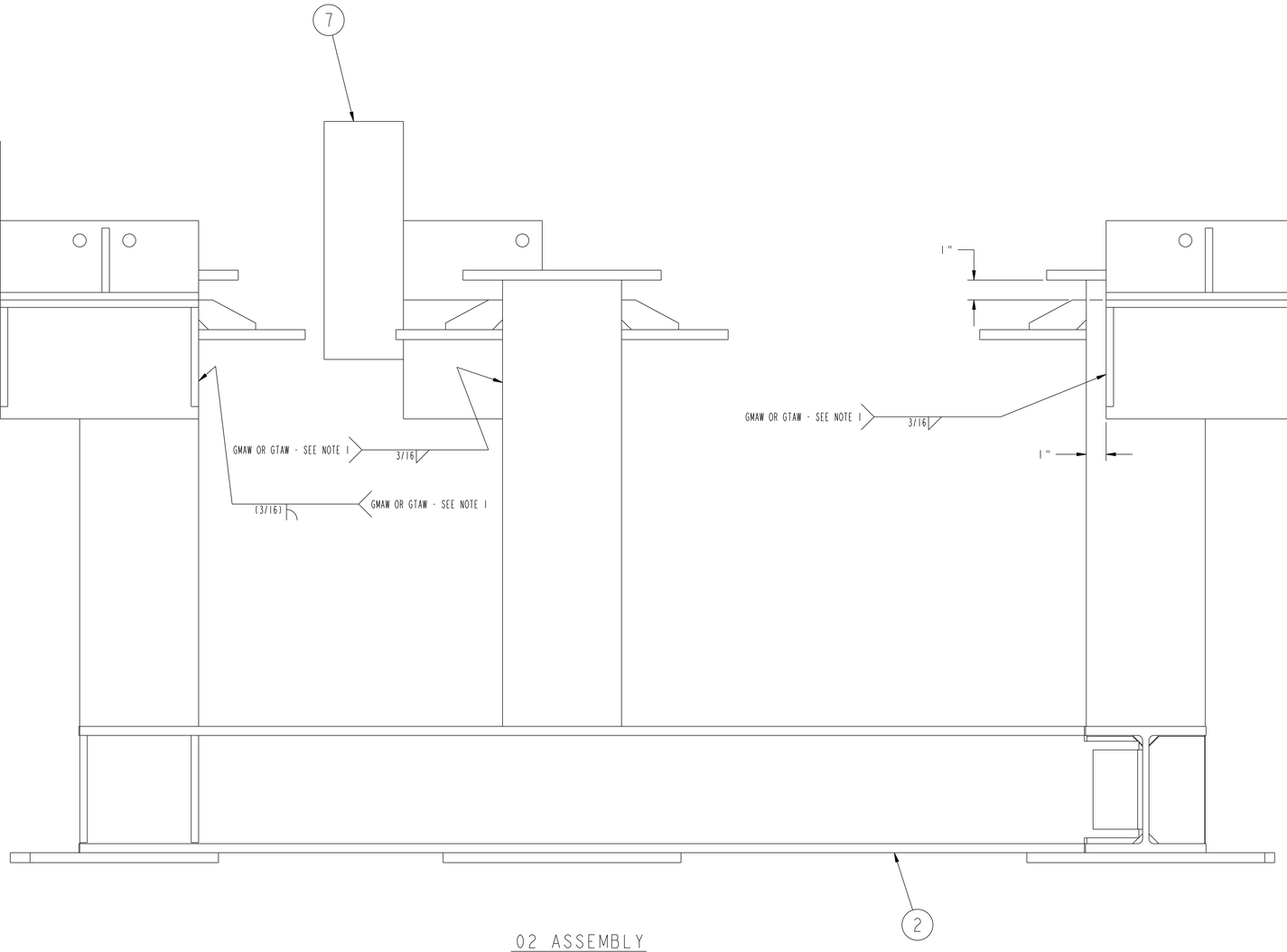
DRAWING NO:
SE186-334

SHEET 5 OF 6 REV 0.0

NCSX-SE186-334

NCSX_ASSY_FORMAT_E

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



02 ASSEMBLY

BACK VIEW

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

RELEASE LEVEL: WIP

DWG VERSION NO: 0

WEIGHT
1423.1 lbs

MODEL NAME
SE186-334-02

WELDING ENGINEER

NEXT ASSEMBLY

COMPUTER GENERATED DRAWING
MANUAL CHANGES NOT PERMITTED

Pro E

DO NOT VERIFY INFORMATION BY SCALING DRAWING

CENTRAL FILES:
UNLESS OTHERWISE SPECIFIED

DIMENSIONS ARE IN INCHES
MACHINE SURFACES

BREAK SHARP EDGES .005/.020R

TOLERANCES NON-CUMULATIVE

DECIMAL-INCH	FRACTIONS
.X +/-.100	0°-12° +/-1/16
.XX +/-.030	12°-72° +/-1/8
.XXX +/-.005	72°-120° +/-1/4
ANGULAR+/-0°-15'	OVER 120°+/-1/2

PRINCETON PLASMA PHYSICS LABORATORY
PRINCETON UNIVERSITY
NATIONAL COMPACT STELLARATOR EXPERIMENT

FIELD PERIOD ASSEMBLY
TOOLING DESIGN AND FABRICATION
H. AND L.H. CART WITH POSITIONAL BRACKET WELDMENT

DSN:L. MORRIS

CHK:

ENGR:T. BROWN

SUPV:

DRAWING NO:
SE186-334

SHEET 6 OF 6 REV 0.0

NCSX-SE186-334

NCSX_ASSY_FORMAT_E