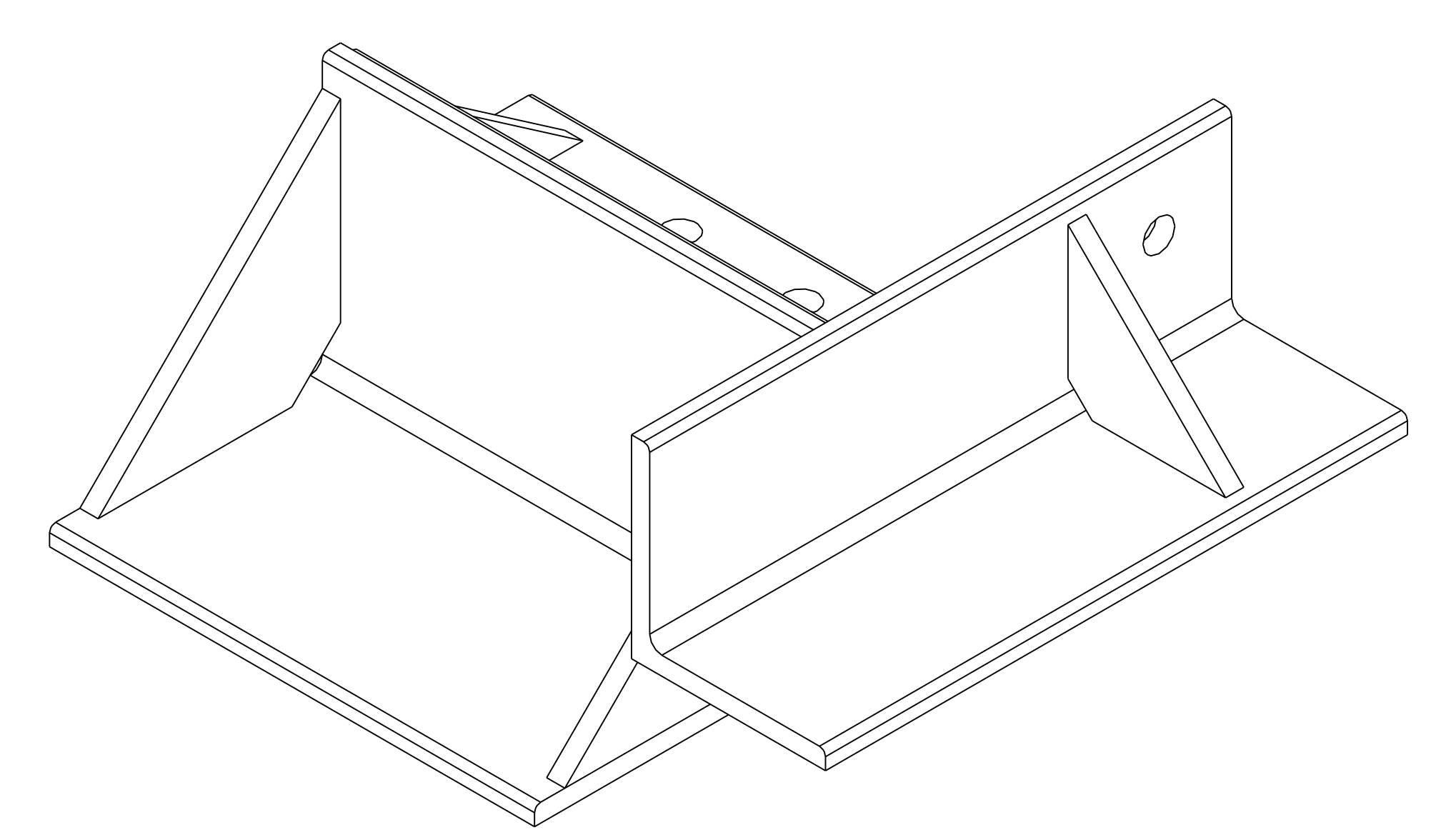
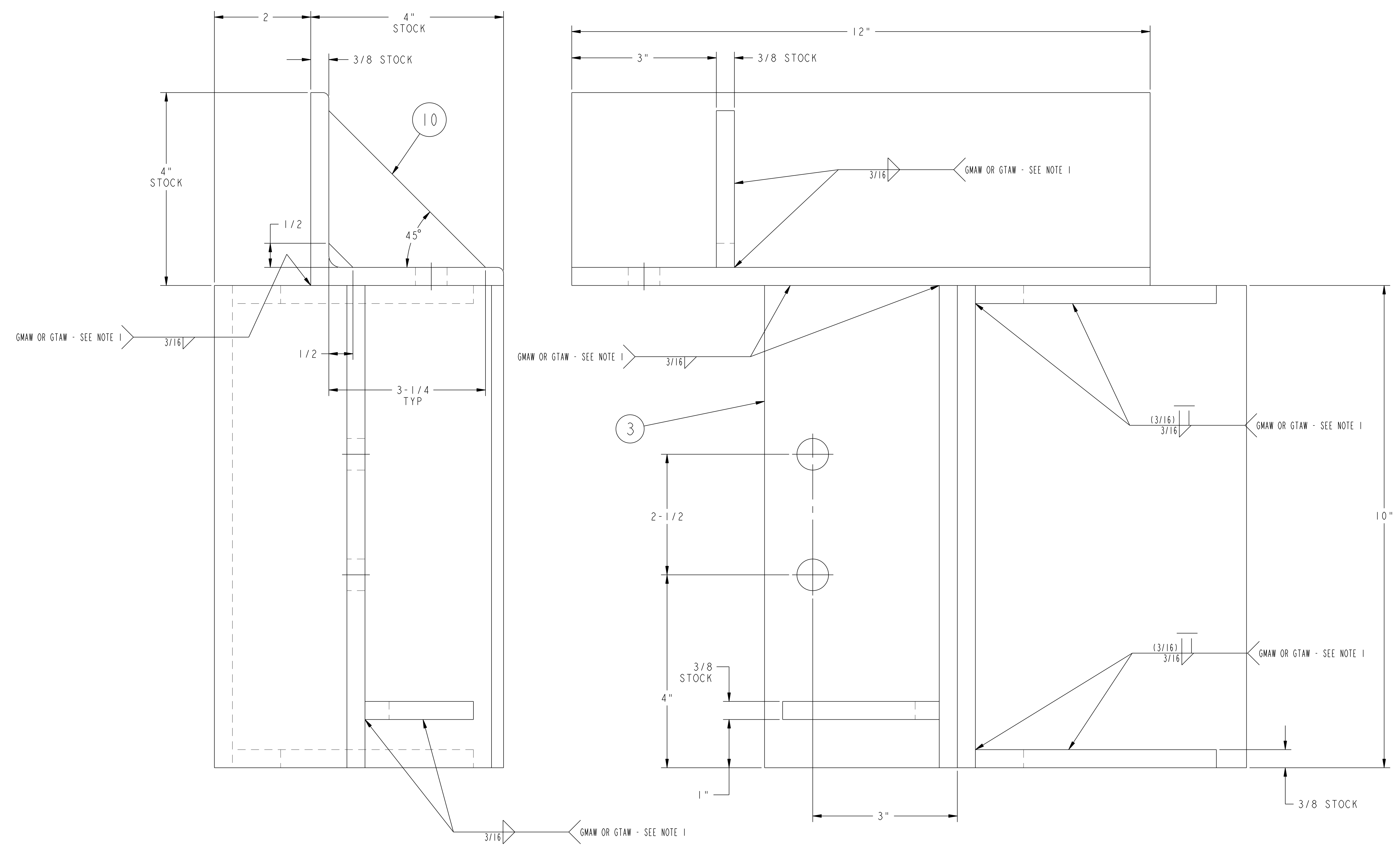
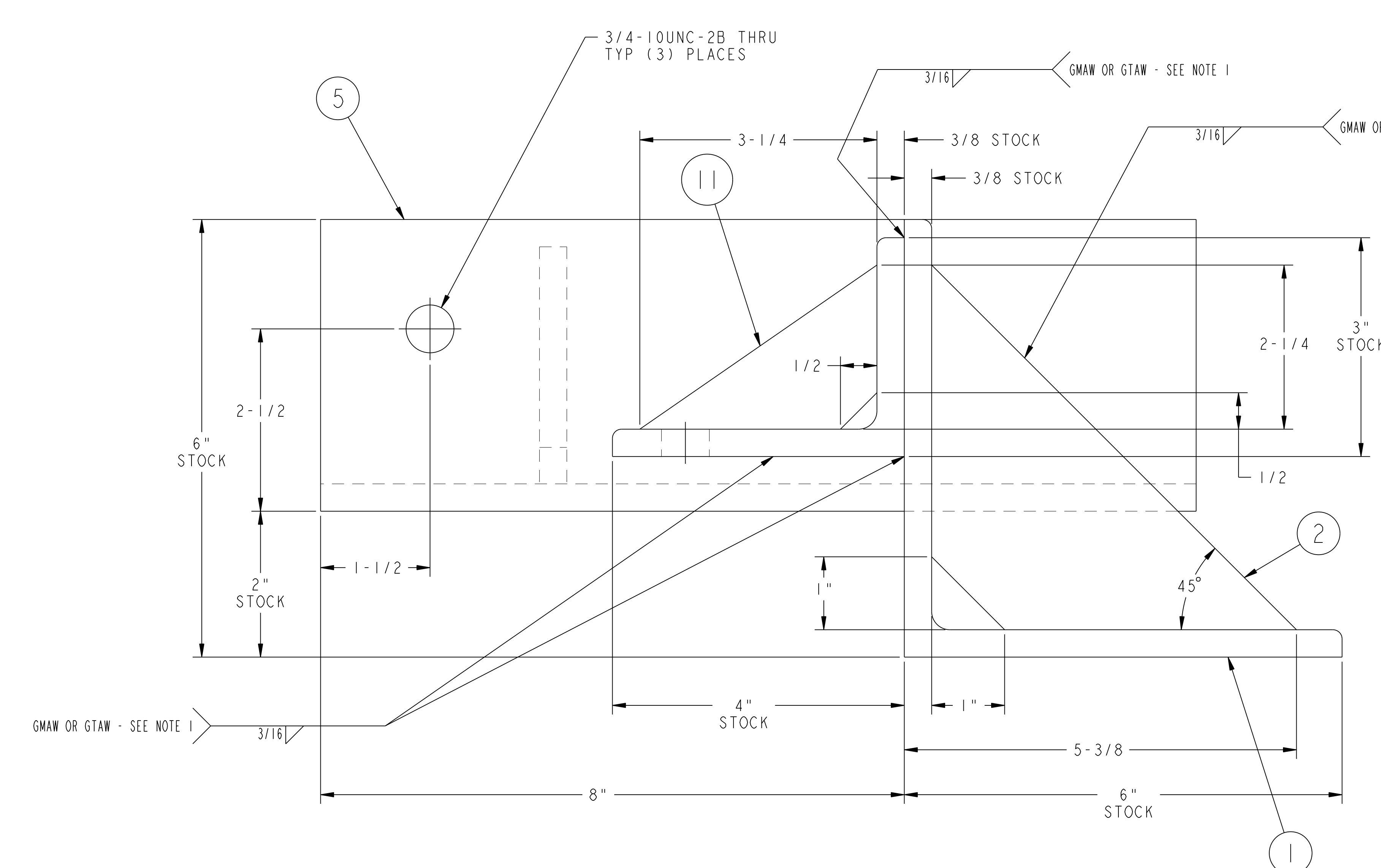


NO.	REVISION	BY	CH	SUP	APPROVED	DATE



REFERENCE ISOMETRIC
SCALE 0.500

NOTES
1. WELDING SHALL 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.



REV	DATE	BY	CHK	DESCRIPTION
1				THIS DWG POSITIONER ANGLE GUSSET - TYPE "B" ASTM A36
1				THIS DWG POSITIONER ANGLE GUSSET - TYPE "A" ASTM A36
1				THIS DWG POSITIONER ANGLE - TYPE "G" ASTM A36
1				THIS DWG POSITIONER ANGLE - TYPE "F" ASTM A36
1				THIS DWG POSITIONER ANGLE - TYPE "E" ASTM A36
1				THIS DWG POSITIONER ANGLE - TYPE "D" ASTM A36
1				THIS DWG POSITIONER ANGLE - TYPE "C" ASTM A36
1				THIS DWG POSITIONER ANGLE - TYPE "B" ASTM A36
1				THIS DWG POSITIONER ANGLE - TYPE "A" ASTM A36
2				THIS DWG BASE ANGLE GUSSET ASTM A36
1				THIS DWG POSITIONER BASE ANGLE ASTM A36
				THIS DWG POSITIONER BRACKET WELDMENT - TYPE "F" _____
				THIS DWG POSITIONER BRACKET WELDMENT - TYPE "E" _____
				THIS DWG POSITIONER BRACKET WELDMENT - TYPE "D" _____
				THIS DWG POSITIONER BRACKET WELDMENT - TYPE "C" _____
				THIS DWG POSITIONER BRACKET WELDMENT - TYPE "B" _____
				THIS DWG POSITIONER BRACKET WELDMENT - TYPE "A" _____

REV	DATE	BY	CHK	DESCRIPTION
06				ASSY
05				ASSY
04				ASSY
03				ASSY
02				ASSY
01				ASSY

01 ASSEMBLY - POSITIONER BRACKET WELDMENT - TYPE "A"

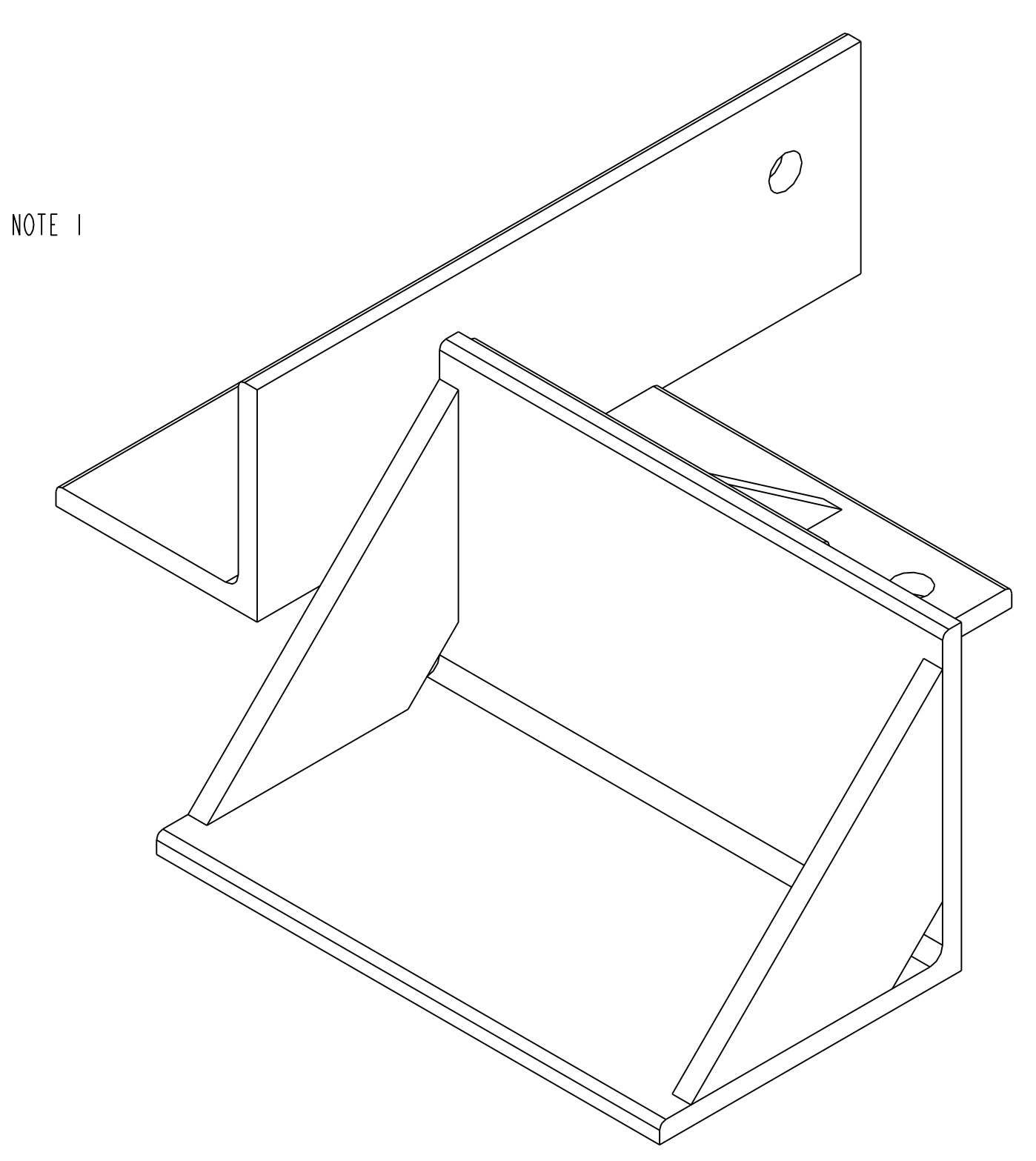
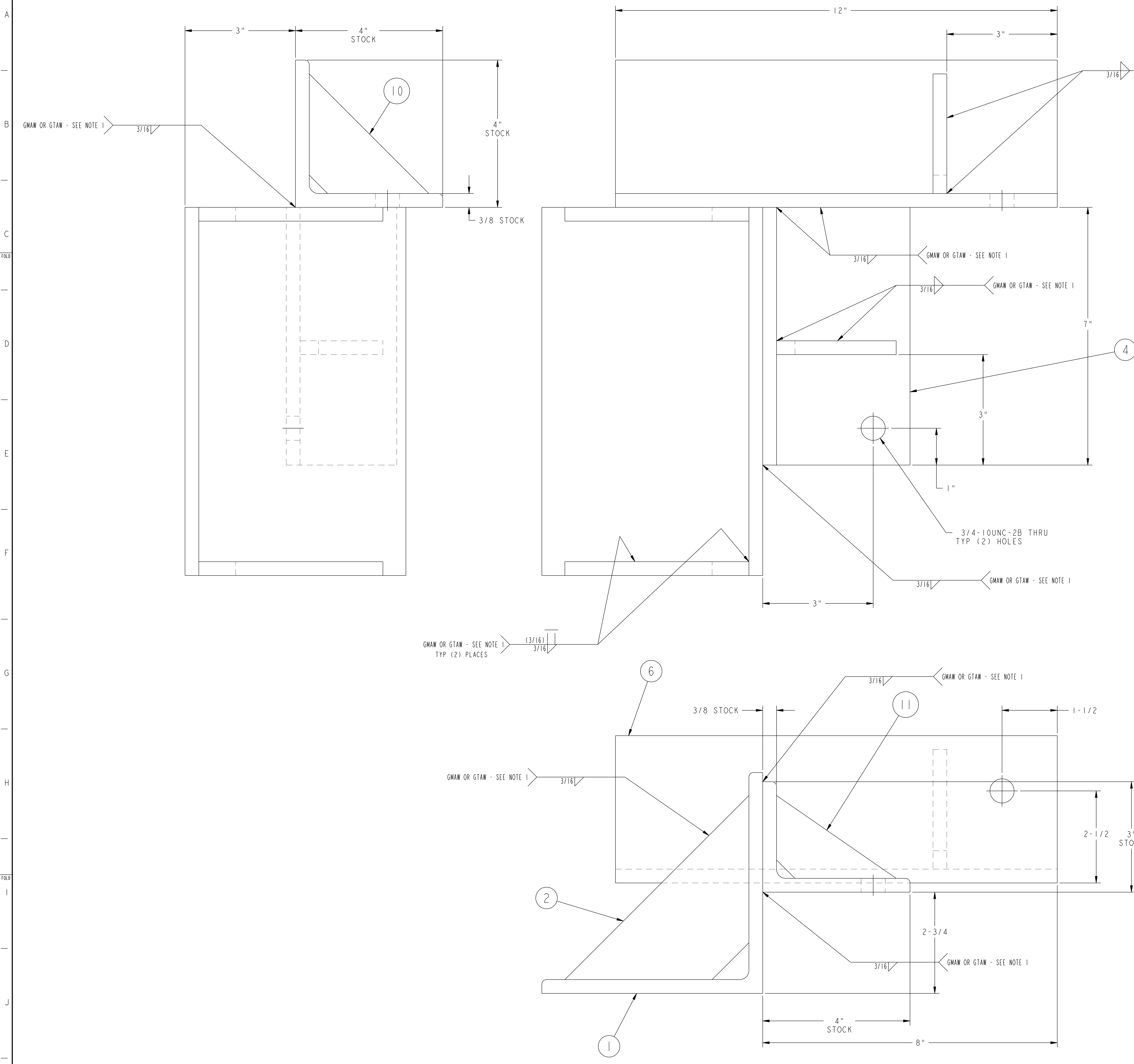
RELEASE LEVEL: WIP
DWG VERSION NO: 0

WEIGHT
33.3 lbs
MODEL NAME
SE186-335-01
WELDING
ENGINEER

COMPUTER GENERATED DRAWING CHANGES NOT PERMITTED Pr o E DO NOT VERIFY INFORMATION BY SCALING DRAWING	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY NATIONAL COMPACT STELLARATOR EXPERIMENT STELLARATOR CORE TOOLING DESIGN AND FABRICATION FPA POSITIONER BRACKET WELDMENTS
TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX ±.000 .XXX ±.005 ANGULAR ±.0°-15'	DSN: L. MORRIS CHK: ENGR: T. BROWN SUPV:	DRAWING NO: SE186-335 SHEET 1 OF 6 REV 0

NCSX-SE186-335

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



REFERENCE NOTE: FOR DIMENSIONS NOT SHOWN
SEE SHEET 1

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

02 ASSEMBLY - POSITIONER BRACKET WELDMENT - TYPE "B"

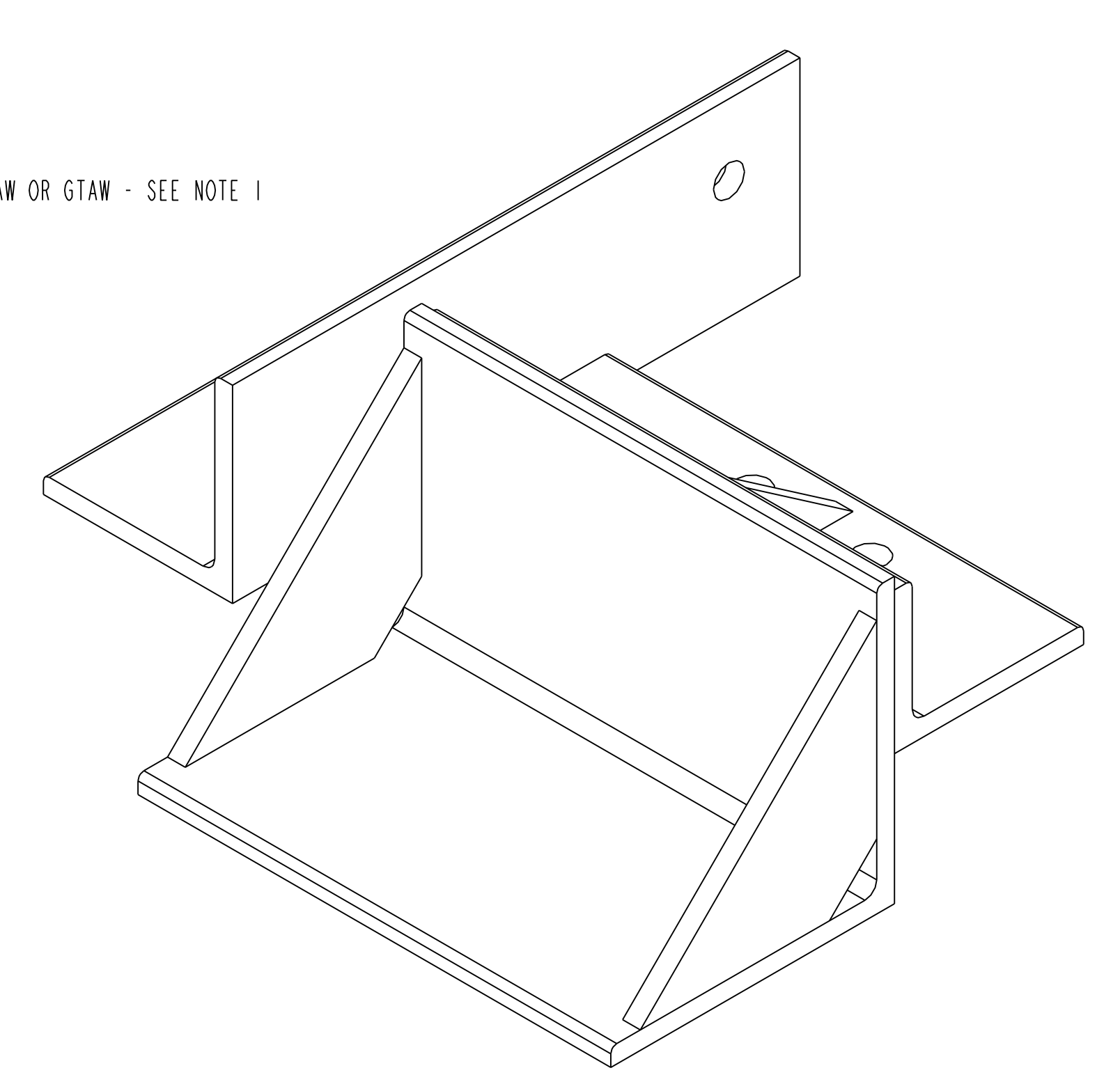
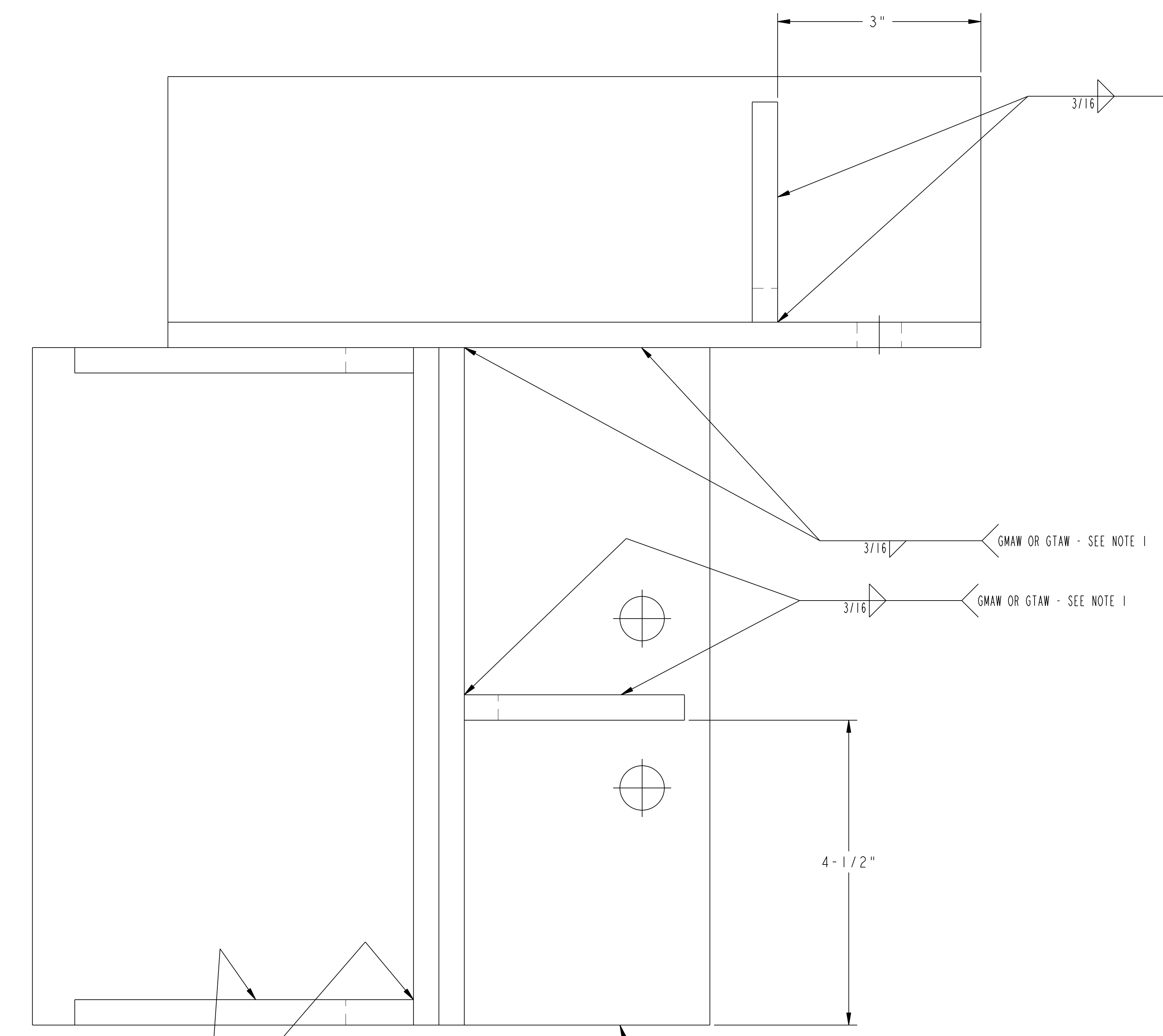
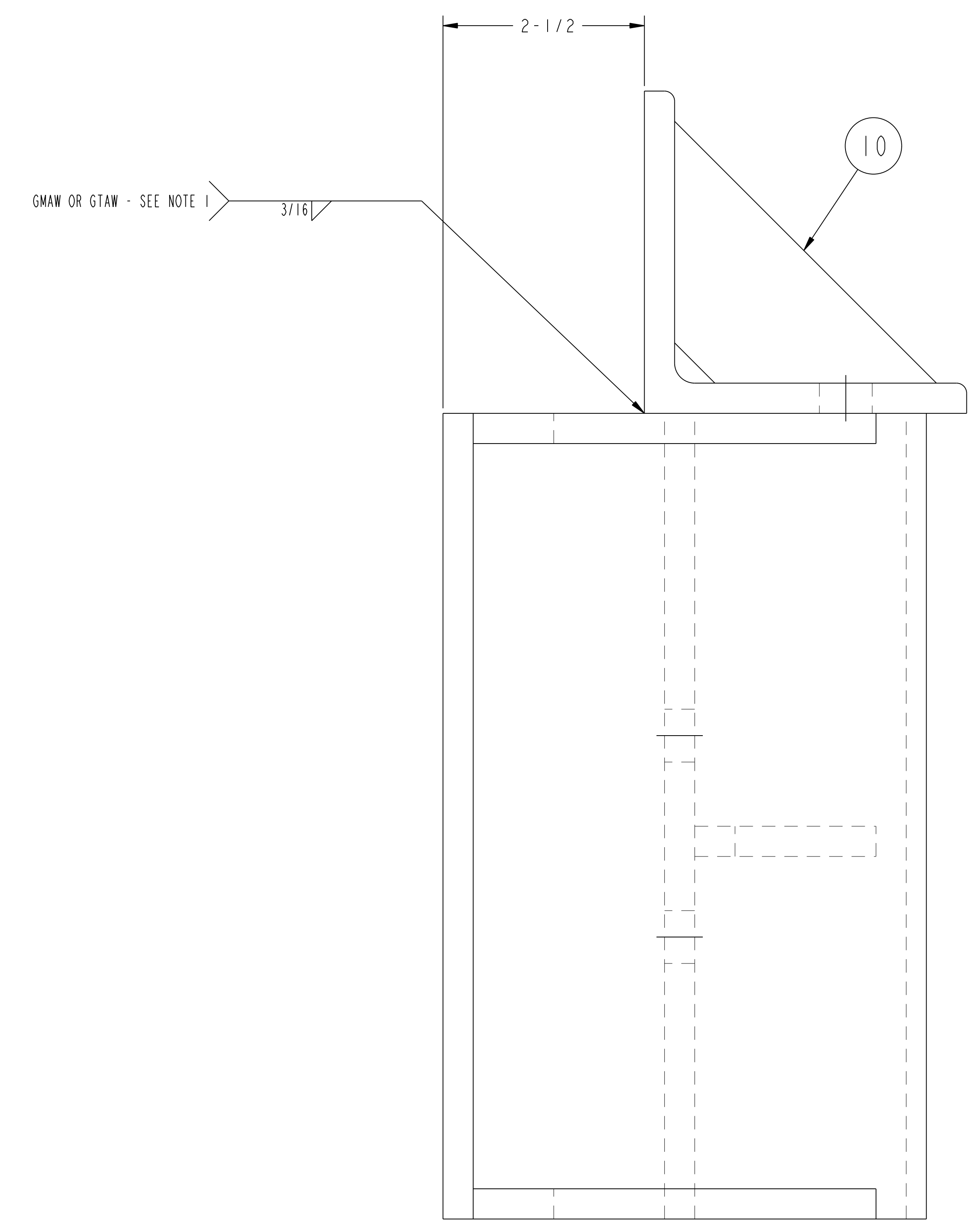
WEIGHT	33.3 lbs
MODEL NAME	SE186-335-01
WELDING ENGINEER	

RELEASE LEVEL: WIP
DWG VERSION NO: 0

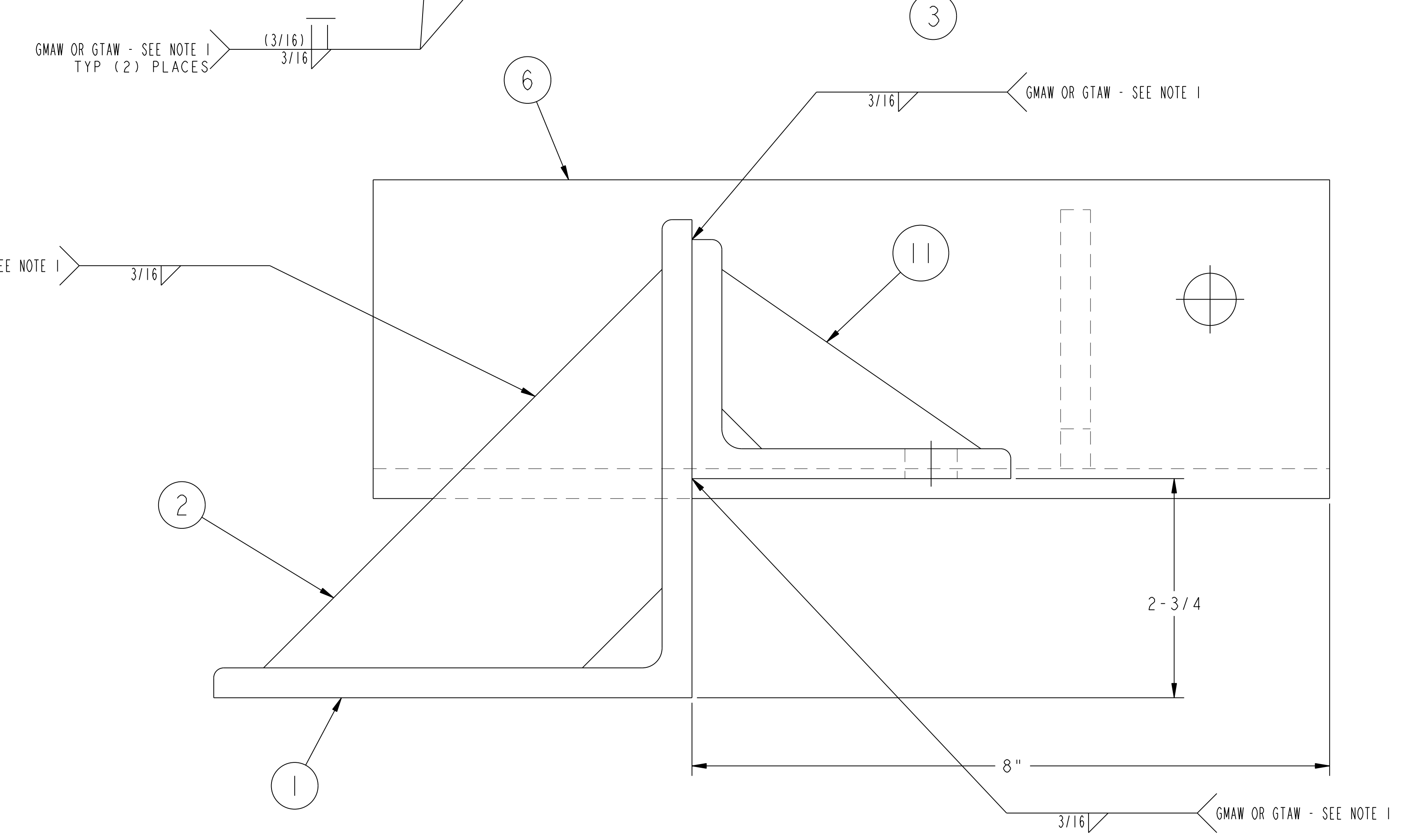
COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY NATIONAL COMPACT STELLARATOR EXPERIMENT	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	STELLARATOR CORE TOOLING DESIGN AND FABRICATION FPA POSITIONER BRACKET WELDMENTS	
NEXT ASSEMBLY	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX +/- .000 0°-12° +/- .010 .XXX +/- .005 12°-120° +/- .010 ANGULAR +/- 0°-15° OVER 120° +/- .10	DSN: L. MORRIS	DRAWING NO: SE186-335
		ENGR: T. BROWN	SHEET 2 OF 6
		SUPV:	REV 0.0

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REFERENCE ISOMETRIC
SCALE 0.500



REFERENCE NOTE: FOR DIMENSIONS NOT SHOWN
SEE SHEETS 1 AND 2

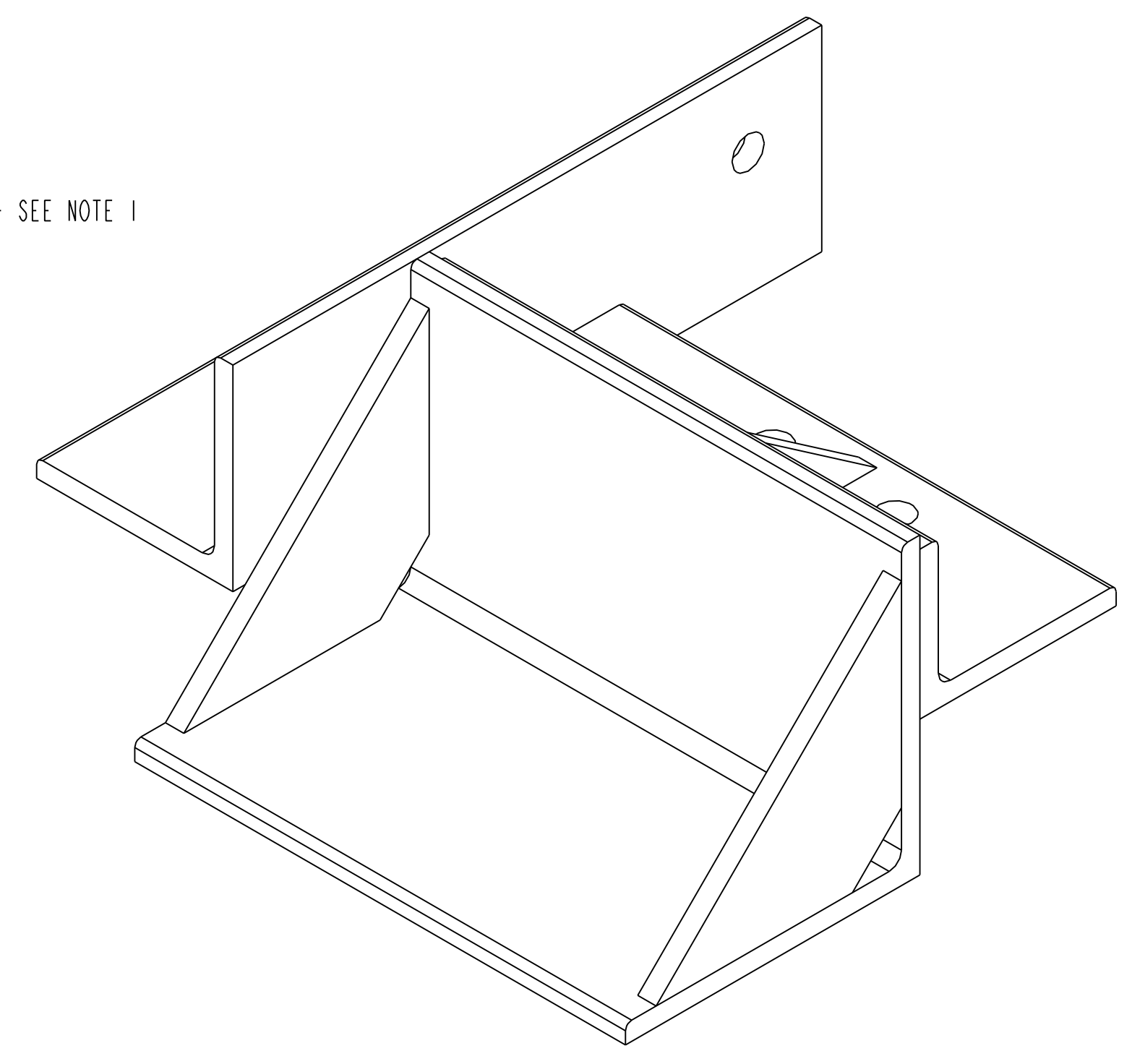
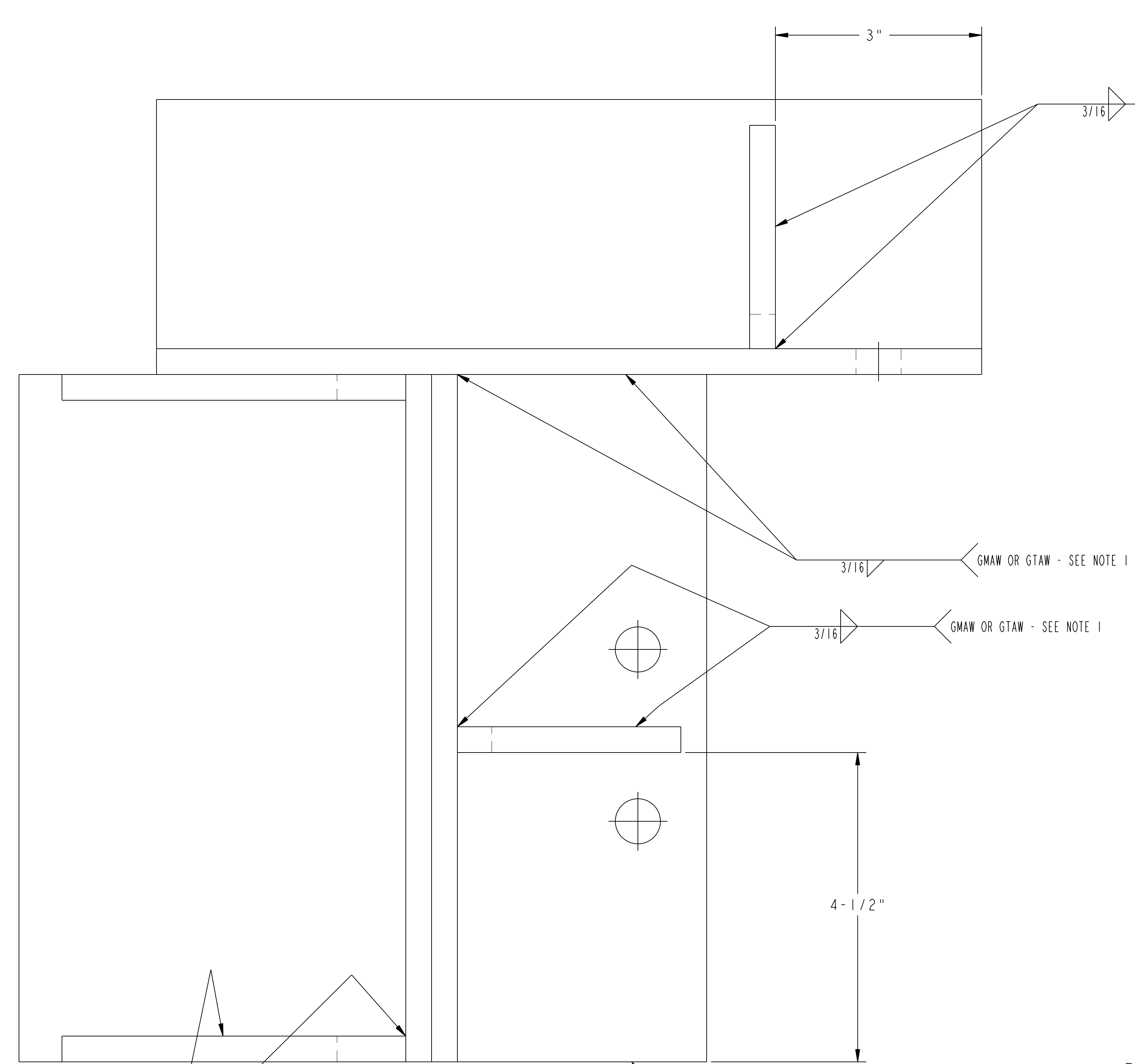
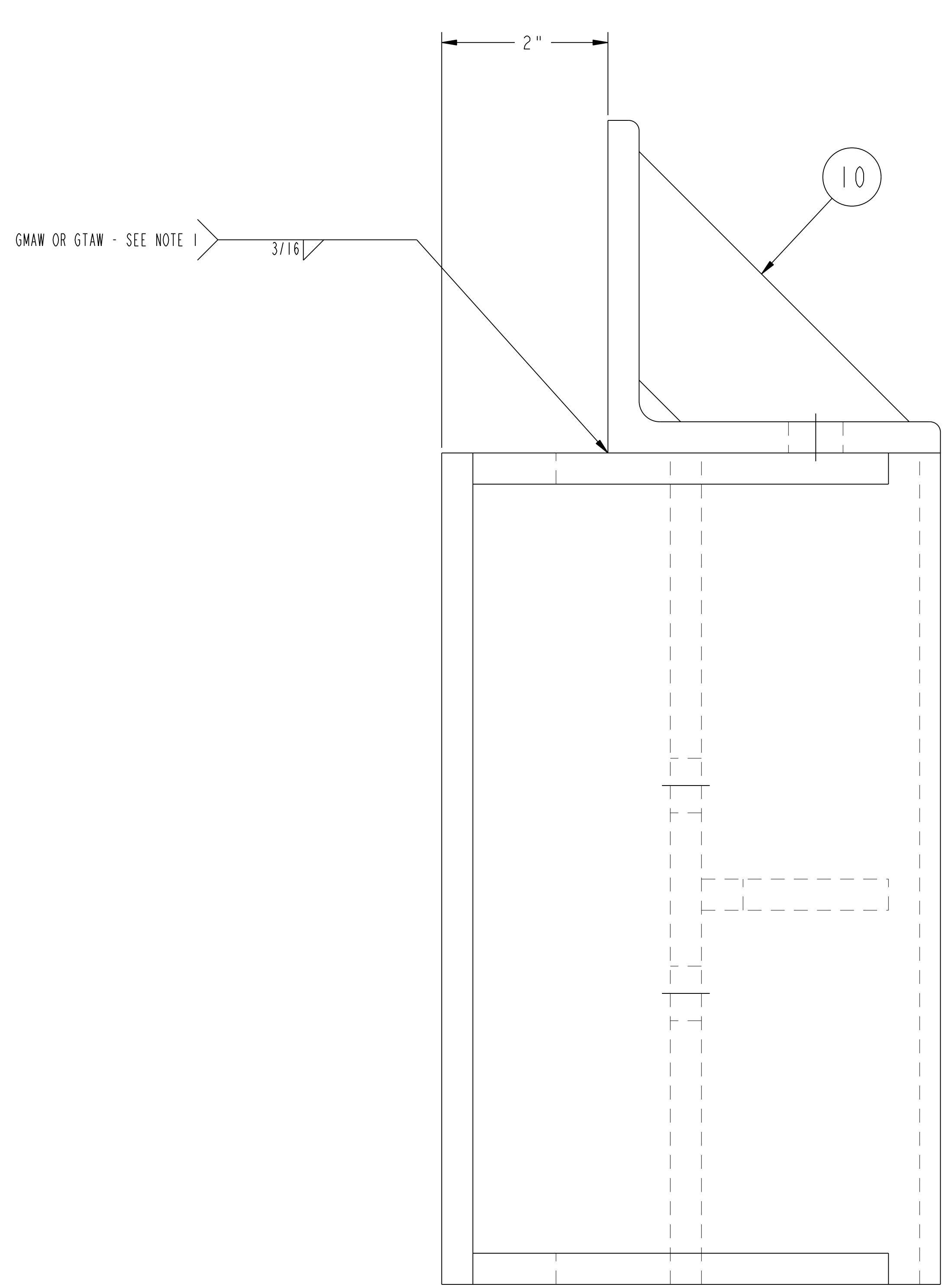
03 ASSEMBLY - POSITIONER BRACKET WELDMENT - TYPE "C"

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	STELLARATOR CORE TOOLING DESIGN AND FABRICATION FPA POSITIONER BRACKET WELDMENTS	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	DSN: L. MORRIS	DRAWING NO: SE186-335
NEXT ASSEMBLY	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX ±.000 .XXX ±.005 ANGULAR ±.0°-15° OVER 120° ±.1°-1.2°	CHK: ENGR. T. BROWN	REV 0.0
WEIGHT 31.2 lbs	MODEL NAME SE186-335-02	SUPV:	SHEET 3 OF 6
WELDING ENGINEER	RELEASE LEVEL: WIP DWG VERSION NO: 0		REV 0.0

NCSX-SE186-335

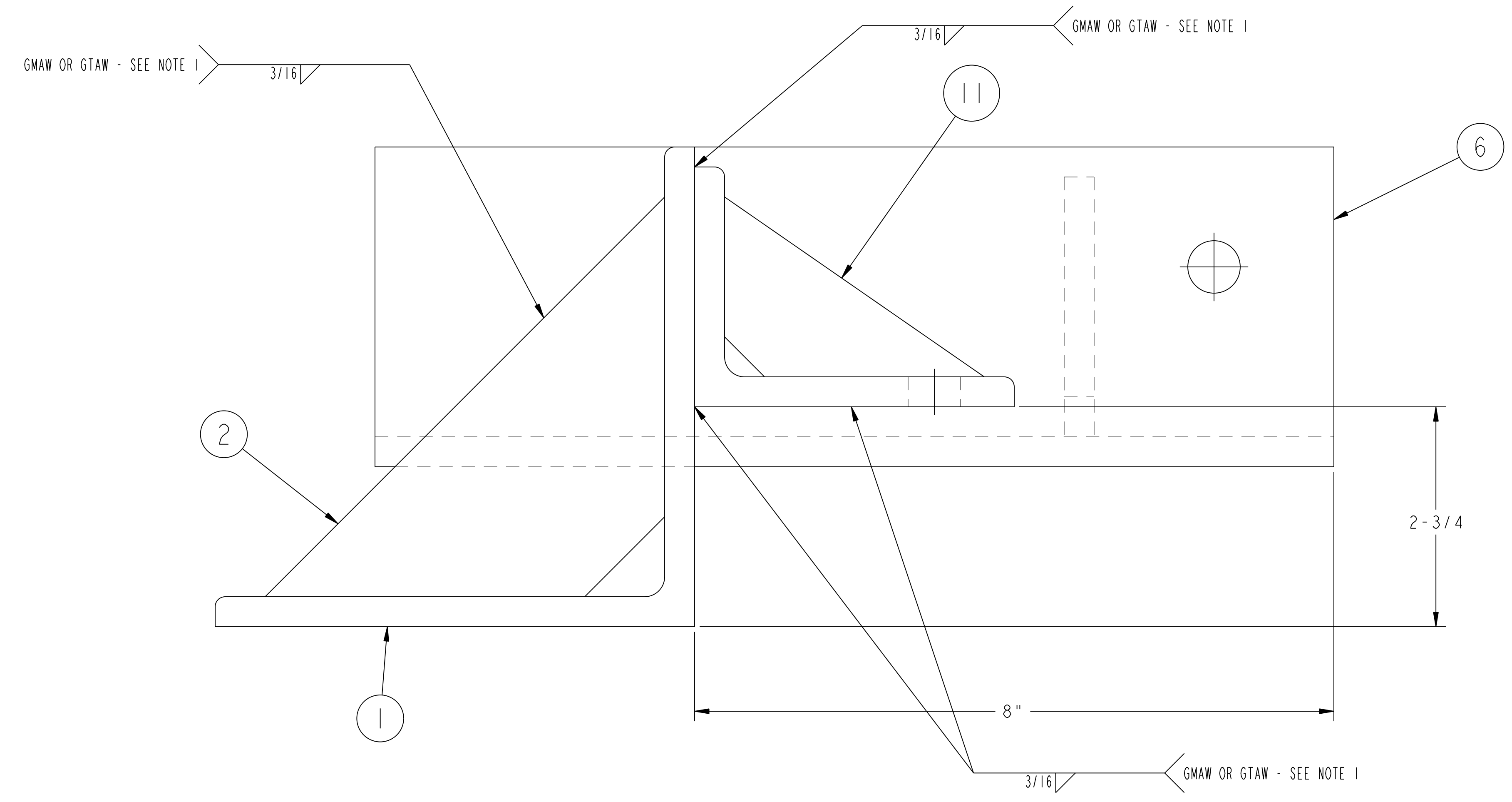
NO.	REVISION	BY	CH	SUP	APPROVED	DATE



REFERENCE ISOMETRIC
SCALE 0.500

GMAW OR GTAW - SEE NOTE 1
TYP (2) PLACES

REFERENCE NOTE: FOR DIMENSIONS NOT SHOWN
SEE SHEETS 1 AND 3



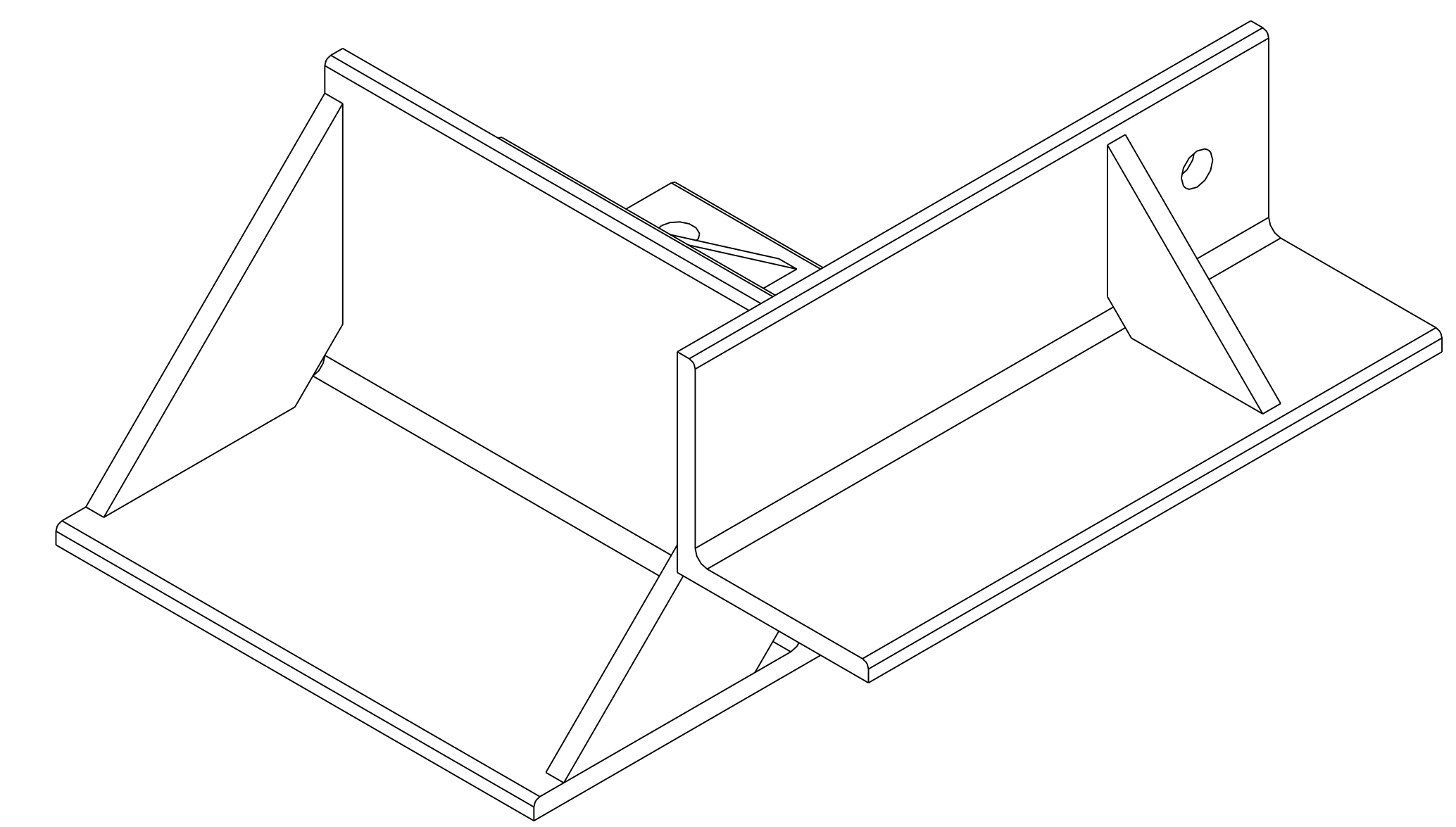
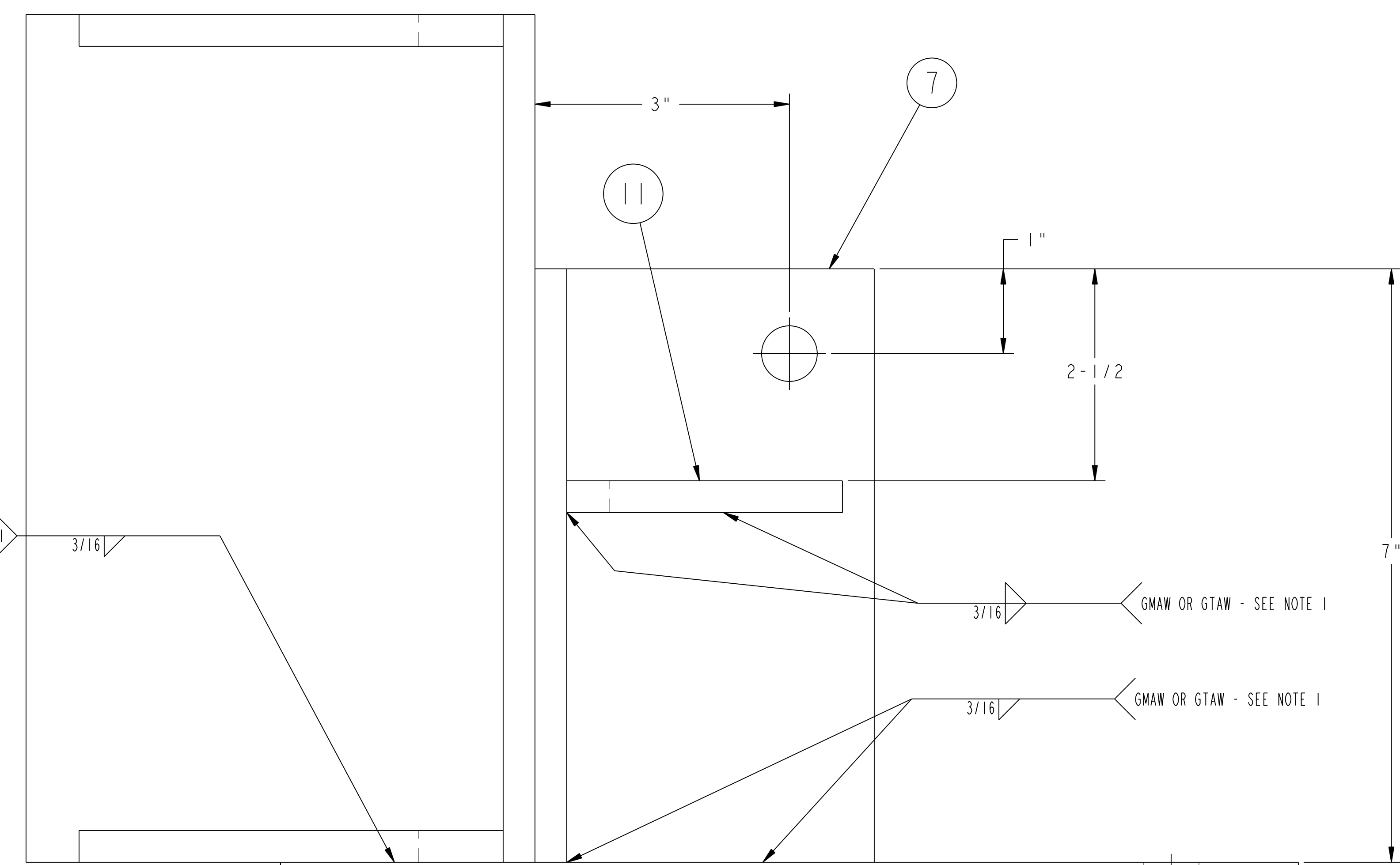
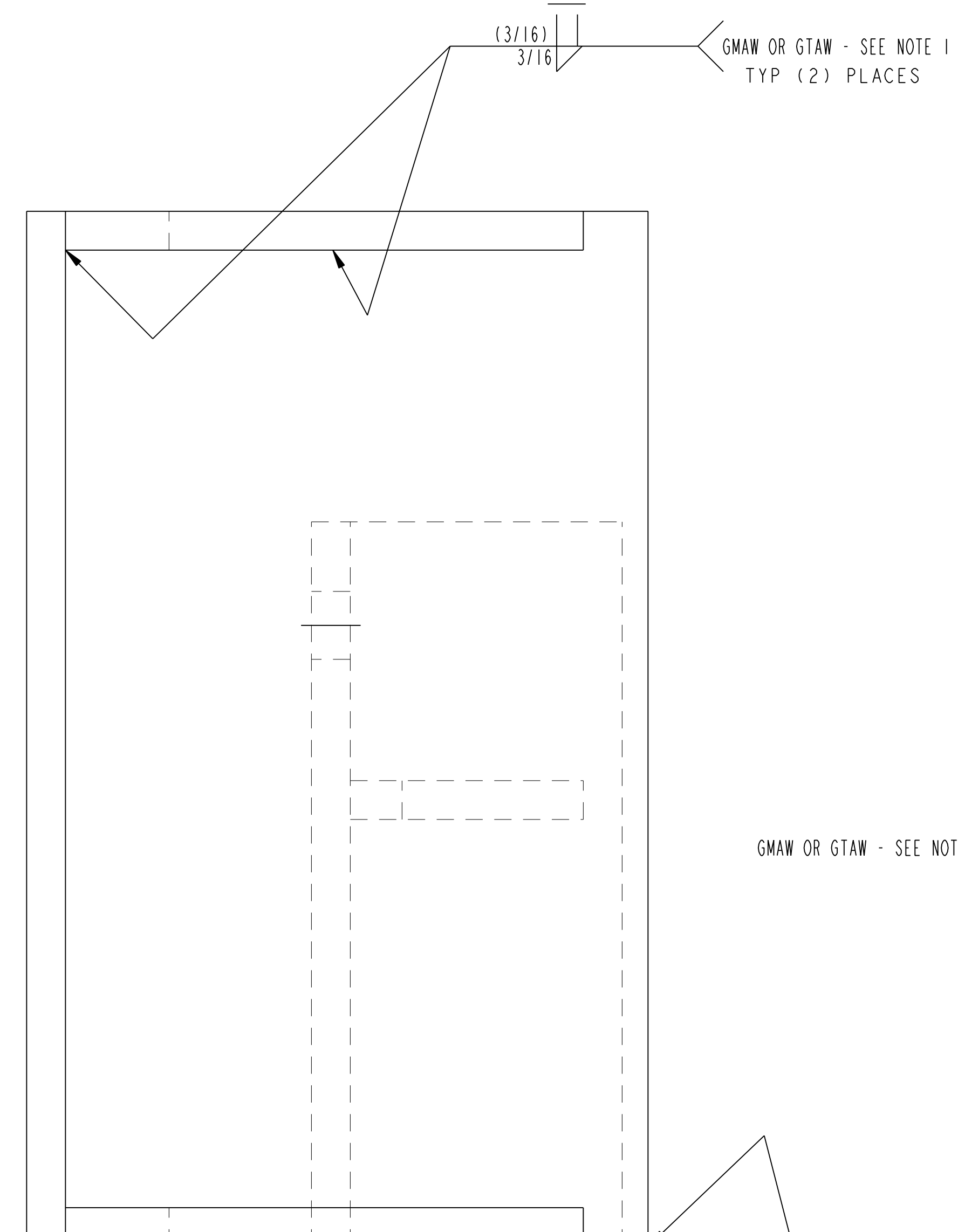
FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

04 ASSEMBLY - POSITIONER BRACKET WELDMENT - TYPE "D"

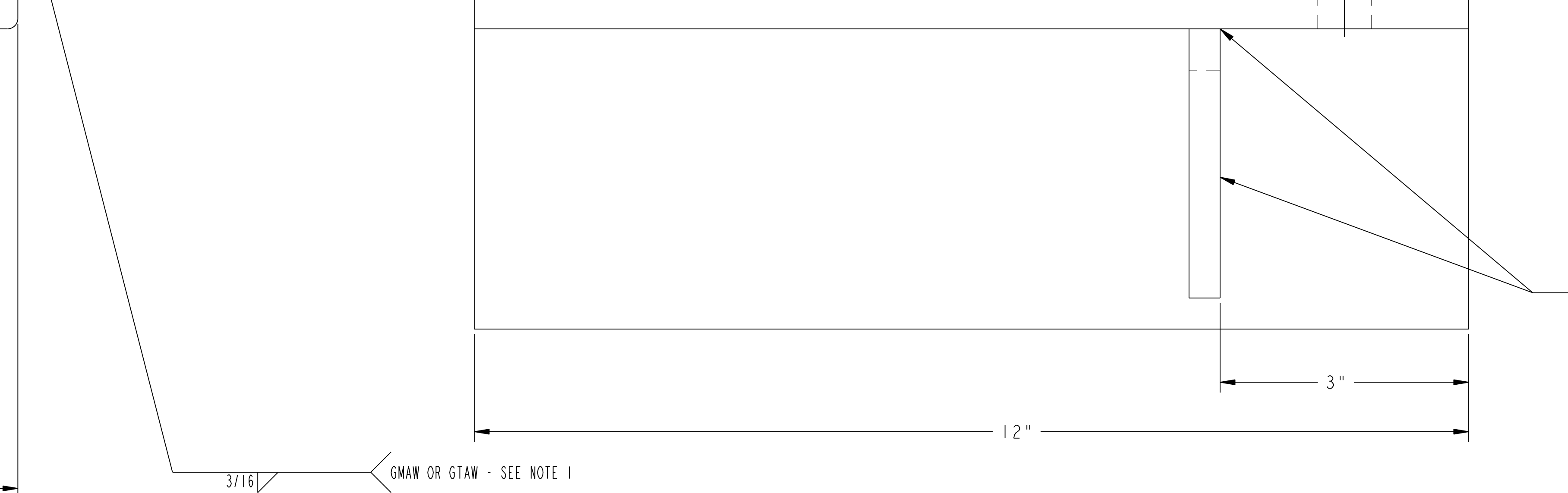
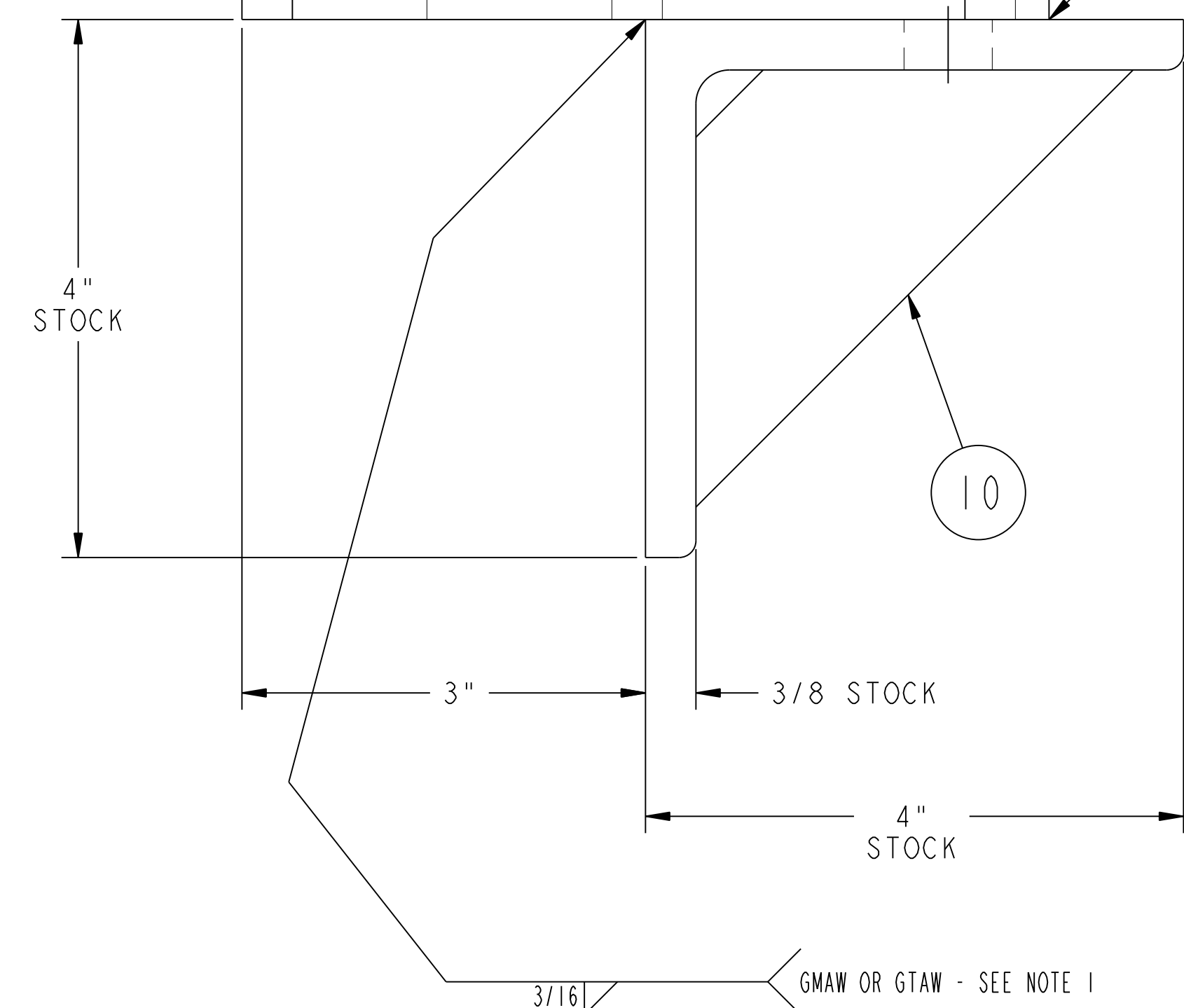
COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED	CENTRAL FILES:	PRINCETON PLASMA PHYSICS LABORATORY NATIONAL COMPACT STELLARATOR EXPERIMENT	
	UNLESS OTHERWISE SPECIFIED	STELLARATOR CORE TOOLING DESIGN AND FABRICATION FPA POSITIONER BRACKET WELDMENTS	
Pro E	DIMENSIONS ARE IN INCHES MACHINE SURFACES	BREAK SHARP EDGES .005/.020	DSN: L. MORRIS
DO NOT VERIFY INFORMATION BY SCALING DRAWING	TOLERANCES NON-CUMULATIVE	DECIMAL-INCH FRACTIONS	CHK: ENGR: T. BROWN
NEXT ASSEMBLY	.XX ±.005 .XXX ±.005 ANGULAR ±.0°-15°	0°-12° ±.124 12°-12° ±.118 OVER 120° ±.112	SUPV: SE186-335
WEIGHT 33.3 lbs	MODEL NAME SE186-335-03	WELDING ENGINEER	DRAWING NO: SE186-335
RELEASE LEVEL: WIP DWG VERSION NO: 0	SHEET 4 OF 6		REV 0.0

NCSX-SE186-335

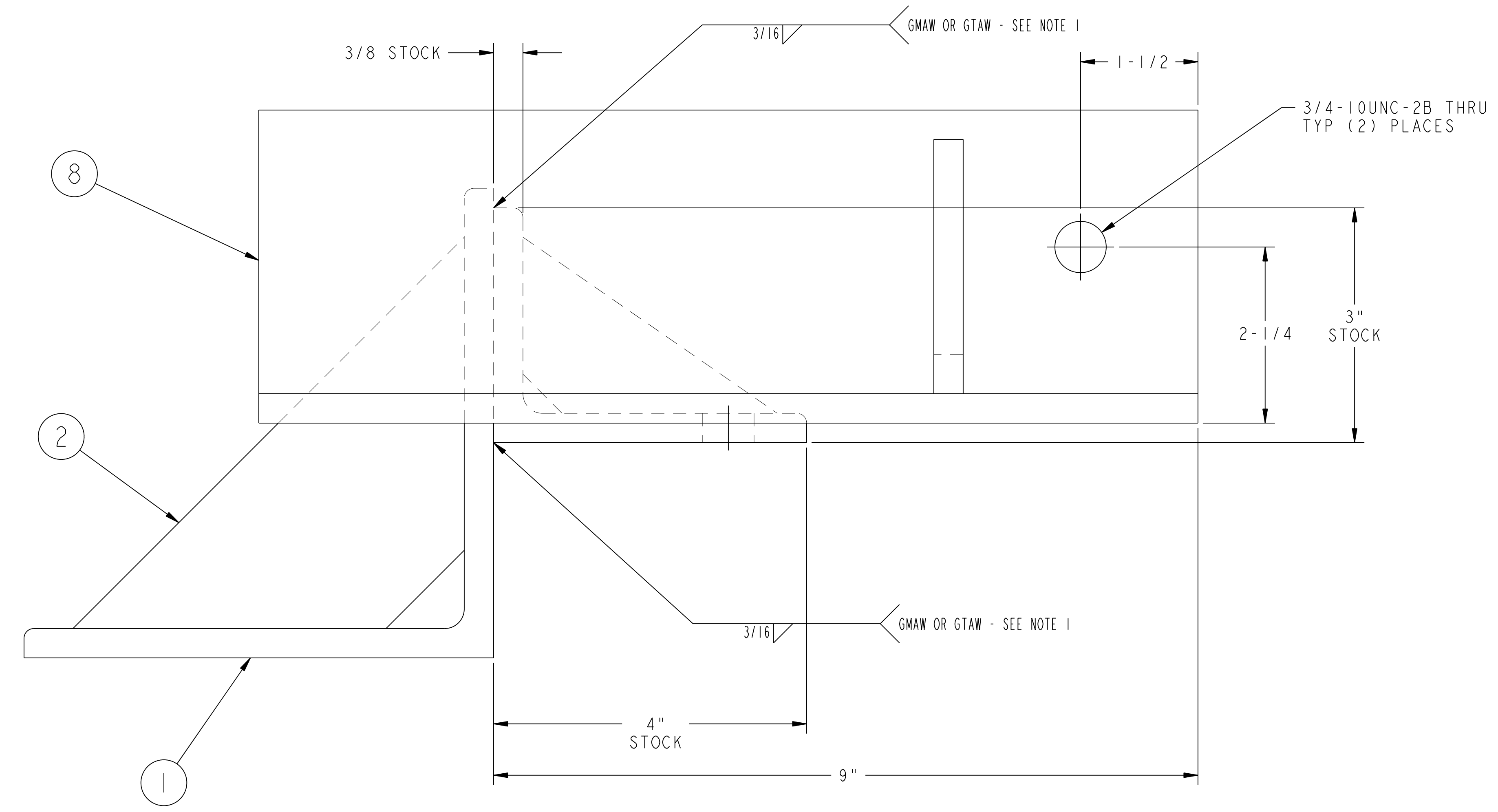
NO.	REVISION	BY	CH	SUP	APPROVED	DATE



REFERENCE ISOMETRIC
SCALE 0.500



REFERENCE NOTE: FOR DIMENSIONS NOT SHOWN
SEE SHEET 1



FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

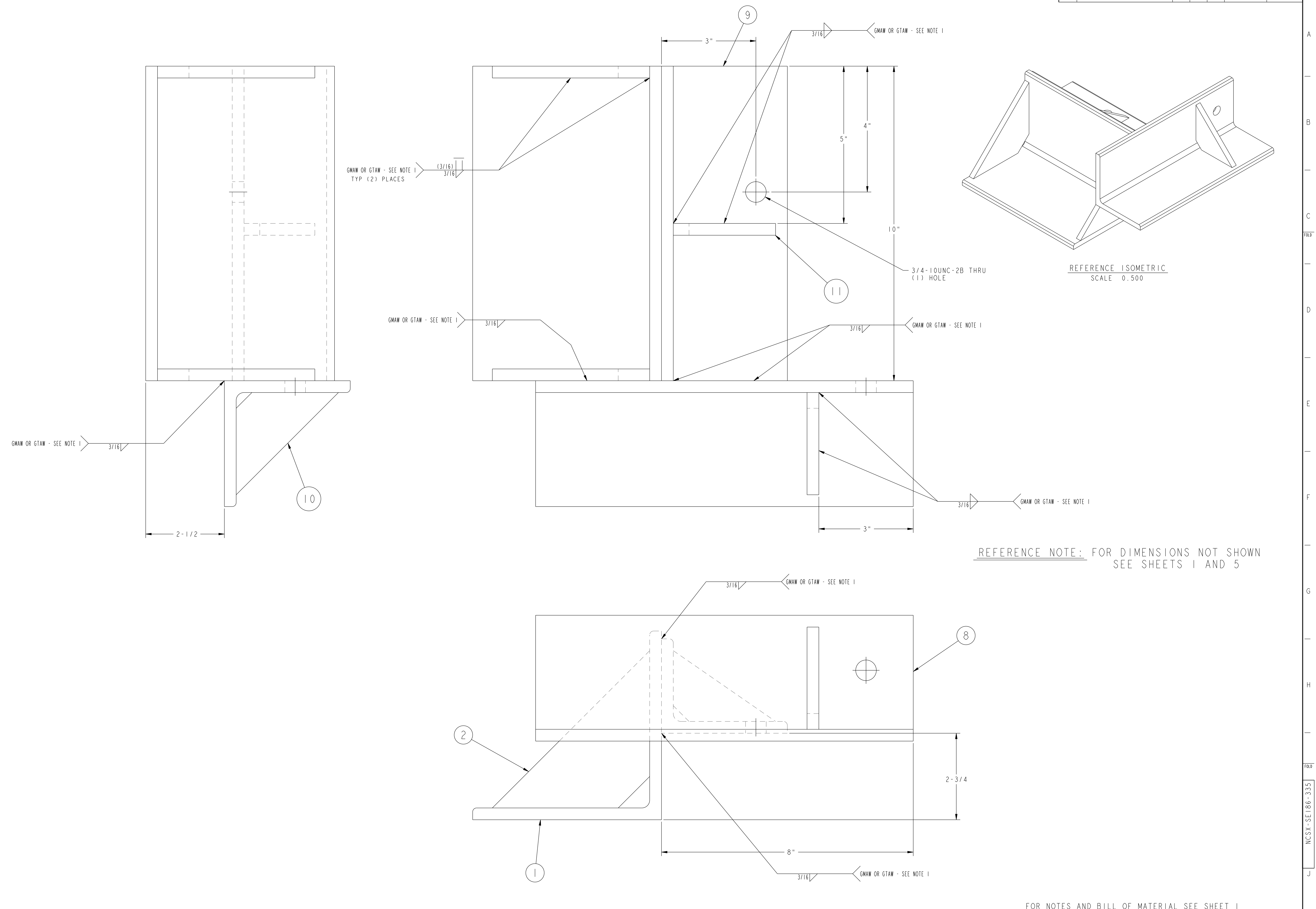
05 ASSEMBLY - POSITIONER BRACKET WELDMENT - TYPE "E"

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 AND FABRICATION FPA POSITIONER BRACKET WELDMENTS	
NEXT ASSEMBLY	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX ±.000 0°-120° ±.125 .XXX ±.005 120°-120° ±.125 ANGULAR ±.0°-15° OVER 120° ±.125	DSN: L. MORRIS CHK: ENGR. T. BROWN SUPV:	DRAWING NO: SE186-335 SHEET 5 OF 6 REV 0.0

RELEASE LEVEL: WIP
DWG VERSION NO: 0

NCSX-SE186-335

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



REFERENCE ISOMETRIC
SCALE 0.500

REFERENCE NOTE: FOR DIMENSIONS NOT SHOWN
SEE SHEETS 1 AND 5

06 ASSEMBLY - POSITIONER BRACKET WELDMENT - TYPE "F"

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES:	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY	
	UNLESS OTHERWISE SPECIFIED	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 AND FABRICATION FPA POSITIONER BRACKET WELDMENTS	
NEXT ASSEMBLY	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX ±.005 0°-120° ±.125 .XXX ±.005 120°-120° ±.125 ANGULAR ±.0°-15° OVER 120° ±.125	DSN: L. MORRIS	DRAWING NO: SE186-335
WEIGHT 31.2 lbs	MODEL NAME SE186-335-05	ENGR: T. BROWN	SHEET 6 OF 6
WELDING ENGINEER	RELEASE LEVEL: WIP DWG VERSION NO: 0	SUPV:	REV 0.0

NCSX-SE186-335