



- NOTES:
1. WELDING SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF AWS D1.1 OR PPL PPPL PROCEDURE ENG-037. VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH THE ACCEPTANCE CRITERIA OF AWS D1.1 Section 6.
  2. VENDOR TO CERTIFY THAT STOCK MATERIAL EXHIBITED MAGNETIC PERMEABILITY OF LESS THAN  $1.02 \mu_0$ .
  3. IF AFTER WORKING OR MACHINING PART HAS MAGNETIC PERMEABILITY GREATER THAN  $1.02 \mu_0$ , THEN PART IS TO BE VACUUM HEAT TREATED AT  $1100^\circ\text{C}$  FOR 2.5 HRS TO BRING THE MAGNETIC PERMEABILITY BELOW  $1.02 \mu_0$ .
  4. SPECIAL PROCESS WITH HEAT SINK REQUIRED TO GAURENTEE COIL TEMPERATURE DOES NOT EXCEED  $100^\circ\text{C}$  FURTHER WELDING PROCESS DEVELOPMENT IS REQUIRED.

PART NO.	DRAWING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY REOD
8	SEI33-044-4	TRIM COIL #1, CHANNEL SUPPORT CAP #4	316 SS/STL	1
7	SEI33-044-3	TRIM COIL #1, CHANNEL SUPPORT CAP #3	316 SS/STL	1
6	SEI33-044-2	TRIM COIL #1, CHANNEL SUPPORT CAP #2	316 SS/STL	1
5	SEI33-044-1	TRIM COIL #1, CHANNEL SUPPORT CAP #1	316 SS/STL	1
4	SEI33-041	TRIM COIL #2 GROUND-WRAPPED ASSEMBLY	COPPER/EPOXY	1
3	SEI33-063-3	TRIM COIL #1 BASE, SUPPORT #3	316 SS/STL	1
2	SEI33-063-2	TRIM COIL #1 BASE, SUPPORT #2	316 SS/STL	2
1	SEI33-063-1	TRIM COIL #1 BASE, SUPPORT #1	316 SS/STL	1

WEIGHT	123.1 lbs	MODEL NAME	SEI33-063-01	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	PRINCETON PLASMA PHYSICS LABORATORY			
DIMENSIONS ARE IN INCHES		NATIONAL COMPACT STELLARATOR EXPERIMENT			
MACHINE SURFACES		STELLARATOR CORE			
BREAK SHARP EDGES .005/.020		TRIM COILS			
TOLERANCES NON-CUMULATIVE		TRIM COIL #1 WELDMENT			
DECIMAL-INCH	FRACTIONS	DSN: R. UPCAVAGE	6/9/08	DRAWING NO:	
.XX	+/-.100	0"-.125	+/-.125	CHK: M. KALISH	6/9/08
.XX	+/-.030	12"-.125	+/-.125	ENGR: M. KALISH	6/9/08
.XX	+/-.005	72"-.125	+/-.125	SUPV: J. SIEGEL	6/9/08
ANGULAR	+/-.15	OVER 120"-.125			

RELEASE LEVEL: \*\*\*  
DWG VERSION NO: 25

NCSX-SEI33-063

NCSX-ASSY-FORMAT.E