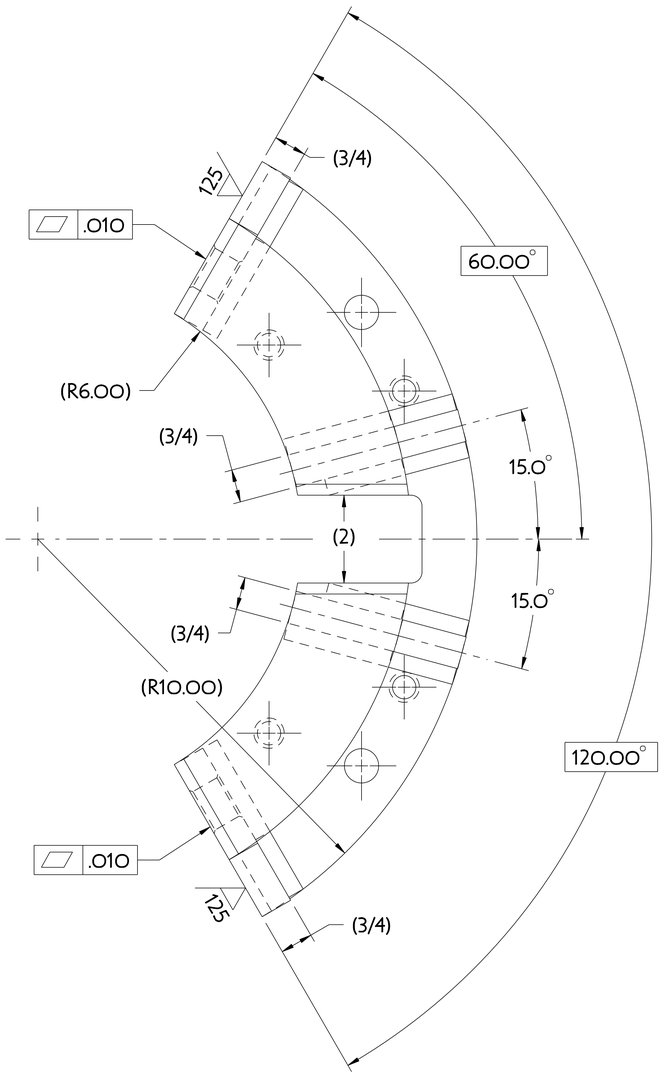
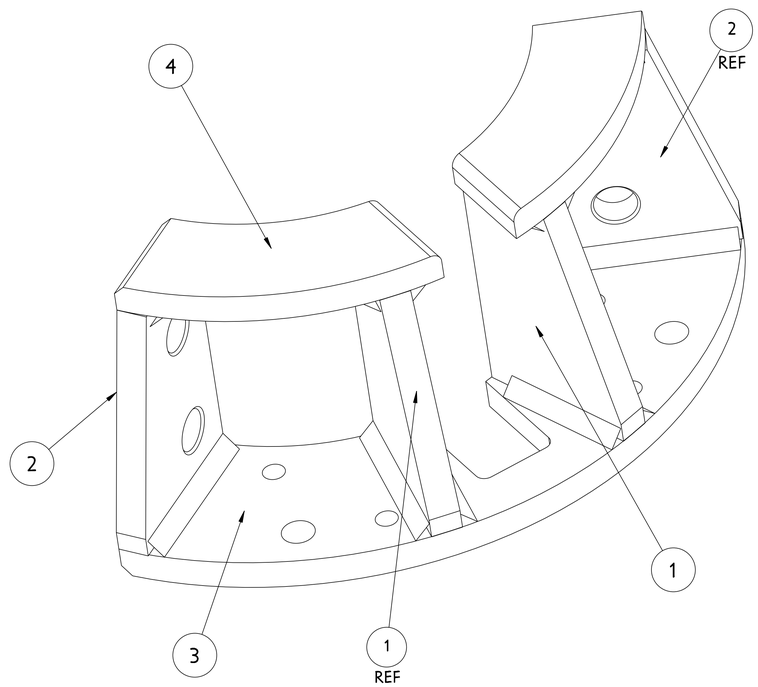
NO.	REVISION	BY	CH	SUP	APPROVED	DATE





NOTE

INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5

DIMENSIONS ARE IN INCHES UNLESS OTHERWISE INDICATED.

DRAWING DEPICTS FINAL MACHINED STATE OF ASSEMBLY. MANUFACTURING TO DETERMINE MATERIAL ALLOWANCES REQUIRED TO ACHIEVE FINAL MACHINED STATE.

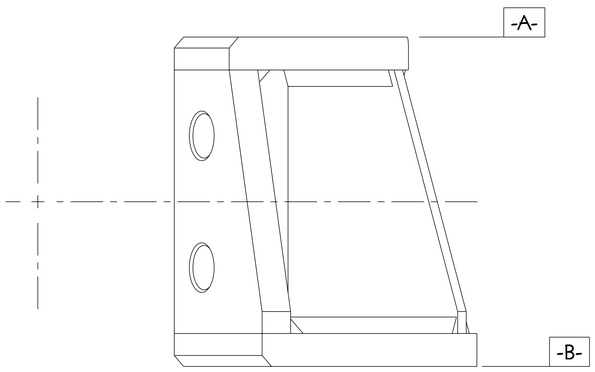
WELDING SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF AWS D1.6. WELDING PERFORMED ONSITE SHALL ALSO MEET THE REQUIREMENTS OF PPPL PROCEDURE ENG-037.

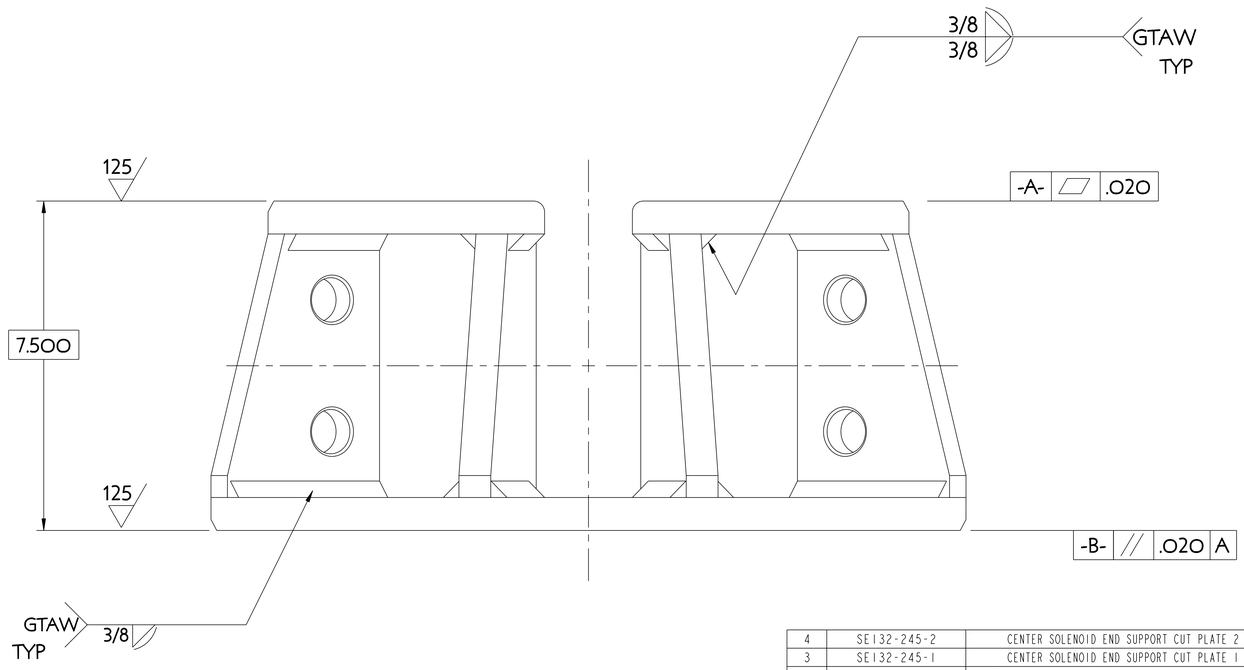
VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH THE ACCEPTANCE CRITERIA OF AWS D1.6.

NOTE ORIENTATION OF ALL PARTS PRIOR TO WELDING.

REFERENCE PERMEABILITY:

BASE MATERIAL	1.05
FABRICATED PART	1.2
WELD	2.0





PART NO.	DRAWING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY REQD
4	SE132-245-2	CENTER SOLENOID END SUPPORT CUT PLATE 2	304 STN STL	1
3	SE132-245-1	CENTER SOLENOID END SUPPORT CUT PLATE 1	304 STN STL	1
2	SE132-240-4	CENTER SOLENOID END SUPPORT GUSSET PLATE WITH HOLES	304 STN STL	2
1	SE132-240-3	CENTER SOLENOID CENTER SUPPORT GUSSET PLATE	304 STN STL	2

PARTS LIST

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED

CENTRAL FILES:

UNLESS OTHERWISE SPECIFIED

Pro E

DIMENSIONS ARE IN INCHES MACHINE SURFACES ▽

DO NOT VERIFY INFORMATION BY SCALING DRAWING

BREAK SHARP EDGES .005/.020

SCALE 0.750

TOLERANCES NON-CUMULATIVE

NEXT ASSEMBLY

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

WEIGHT
36.2 lbs

MODEL NAME
SE132-213

WELDING ENGINEER

RELEASE LEVEL: WIP
DWG VERSION NO: 3

PRINCETON PLASMA PHYSICS LABORATORY
PRINCETON UNIVERSITY
NATIONAL COMPACT STELLARATOR EXPERIMENT
STELLARATOR CORE
CONVENTIONAL COILS
CENTER SOLENOID END SUPPORT CUT SEGMENT ASSEMBLY

DSN: J. RUSHINSKI
CHK:
ENGR: F. DAHLGREN
SUPV:

DRAWING NO:
SE132-213

SHEET 1 OF 1 REV 0

NCSX-SE132-213

NCSX_ASSY_FORMAT_E