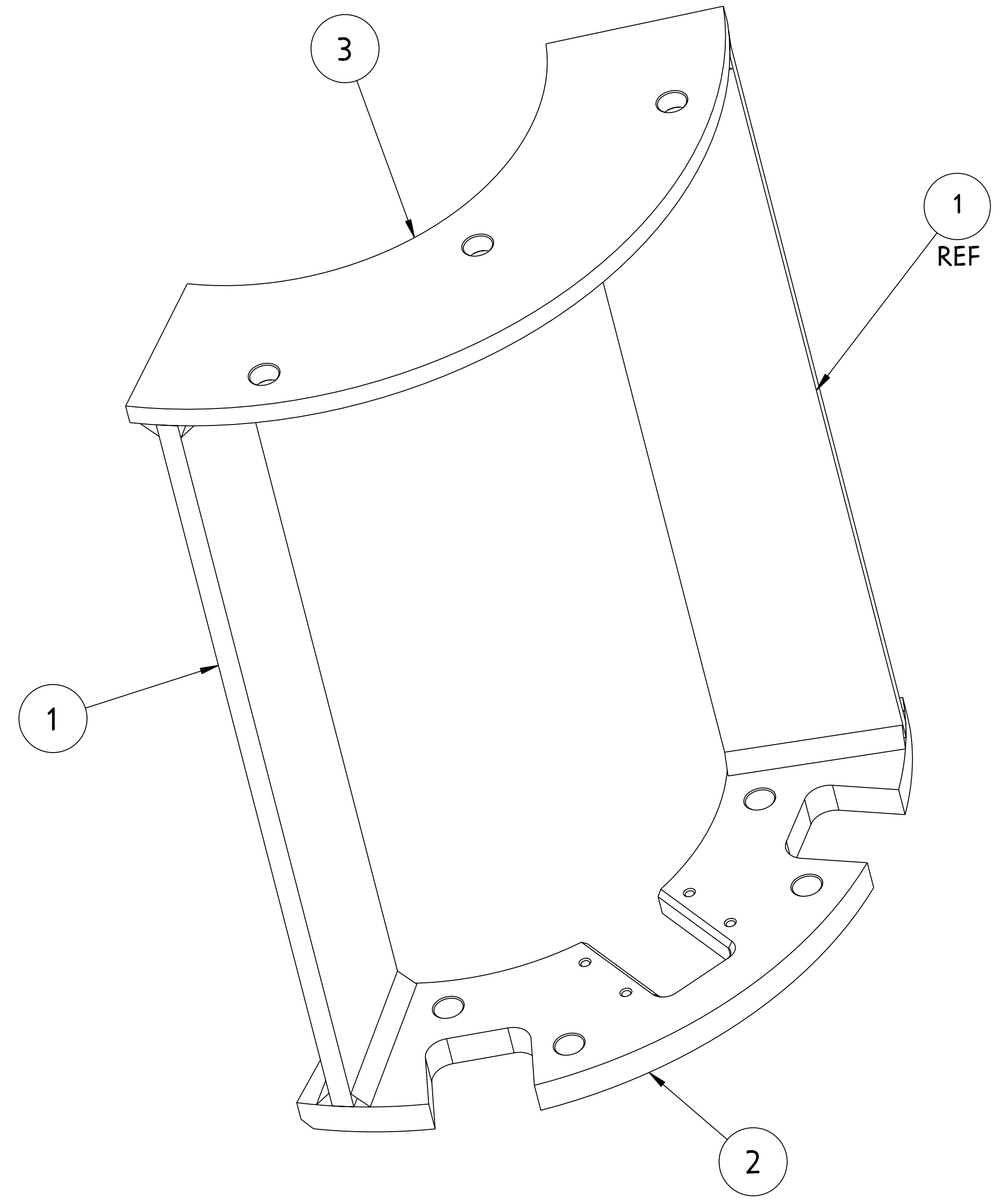
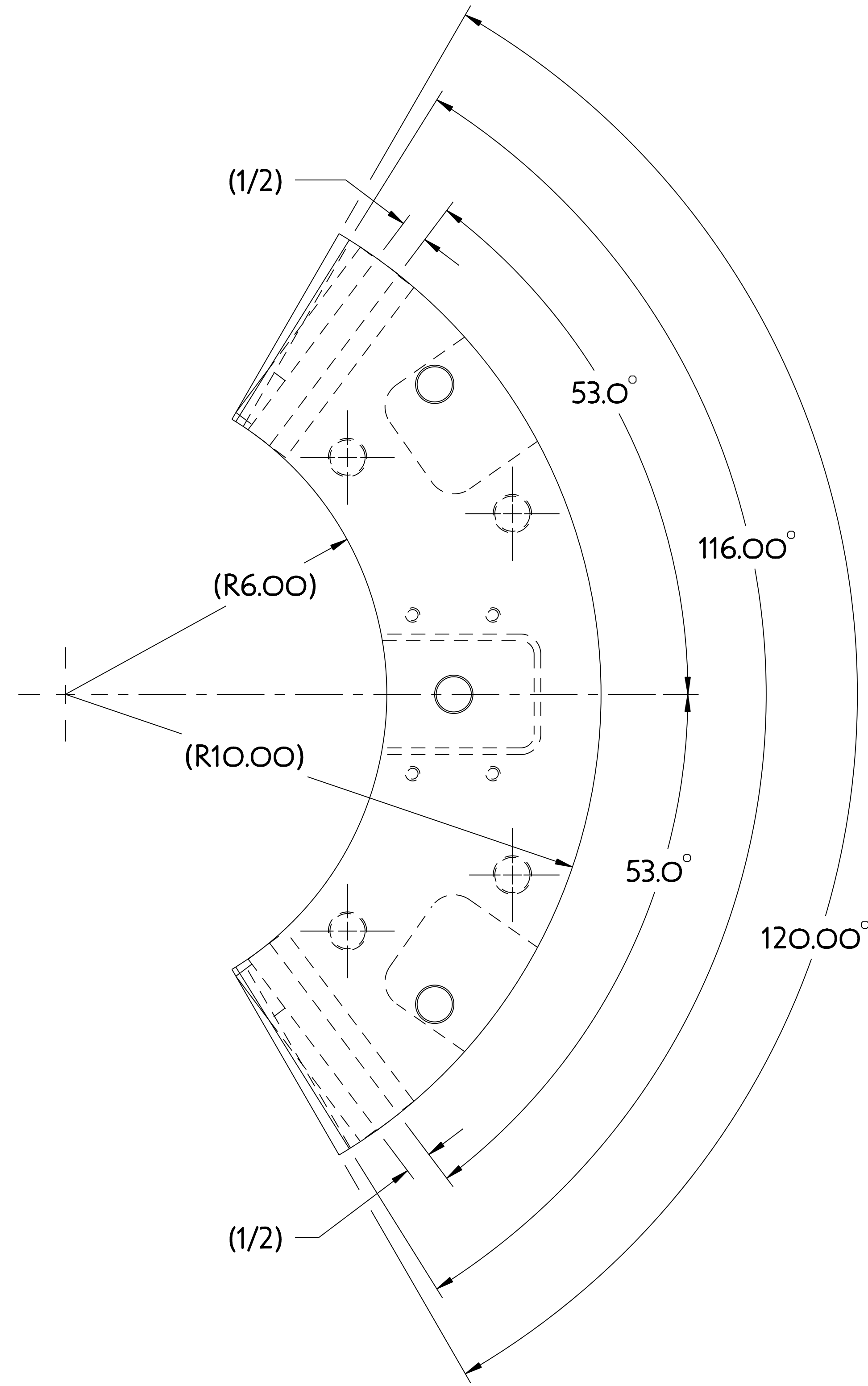


NO.	REVISION	BY	CH	SUP	APPROVED	DATE



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.

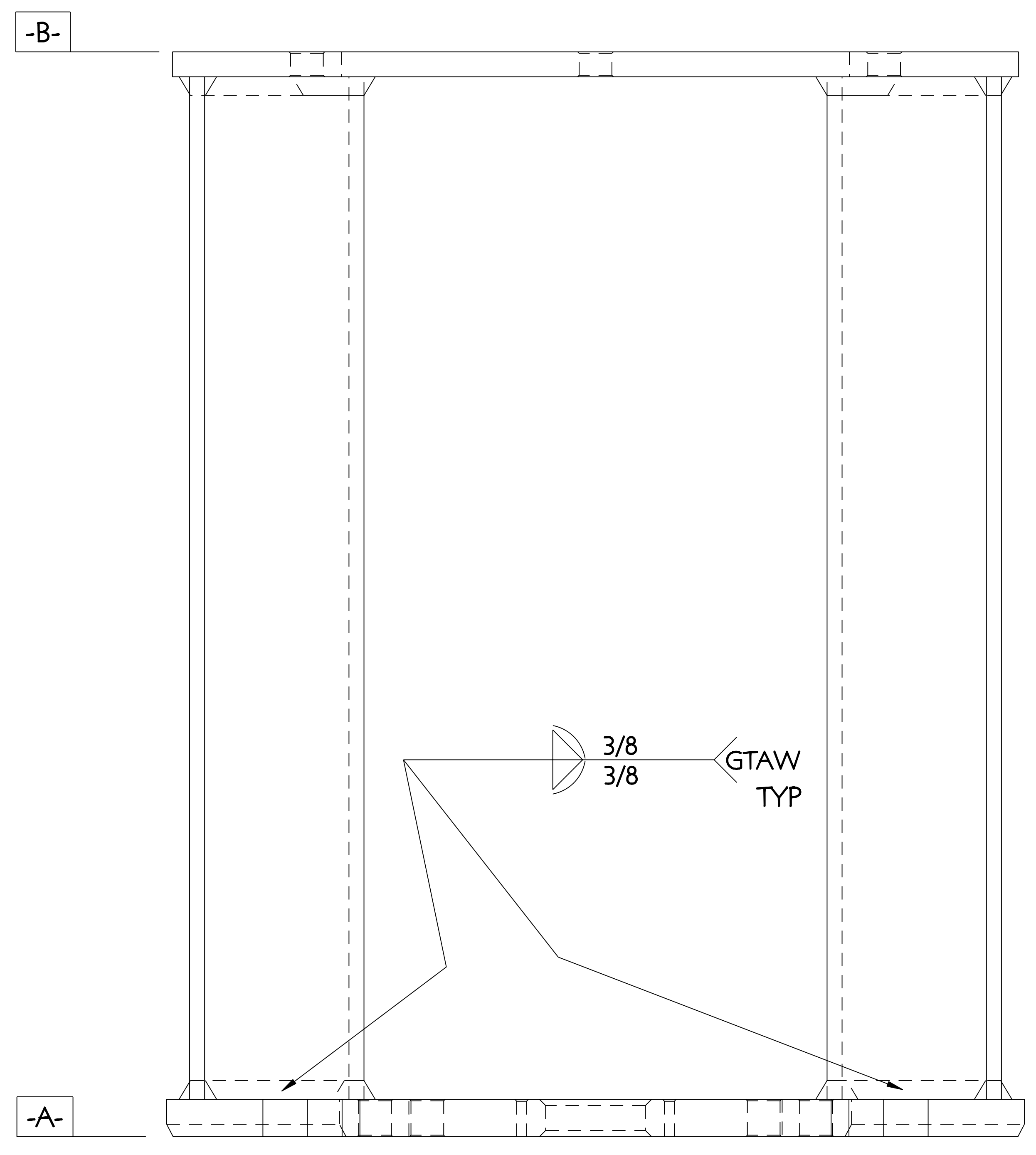
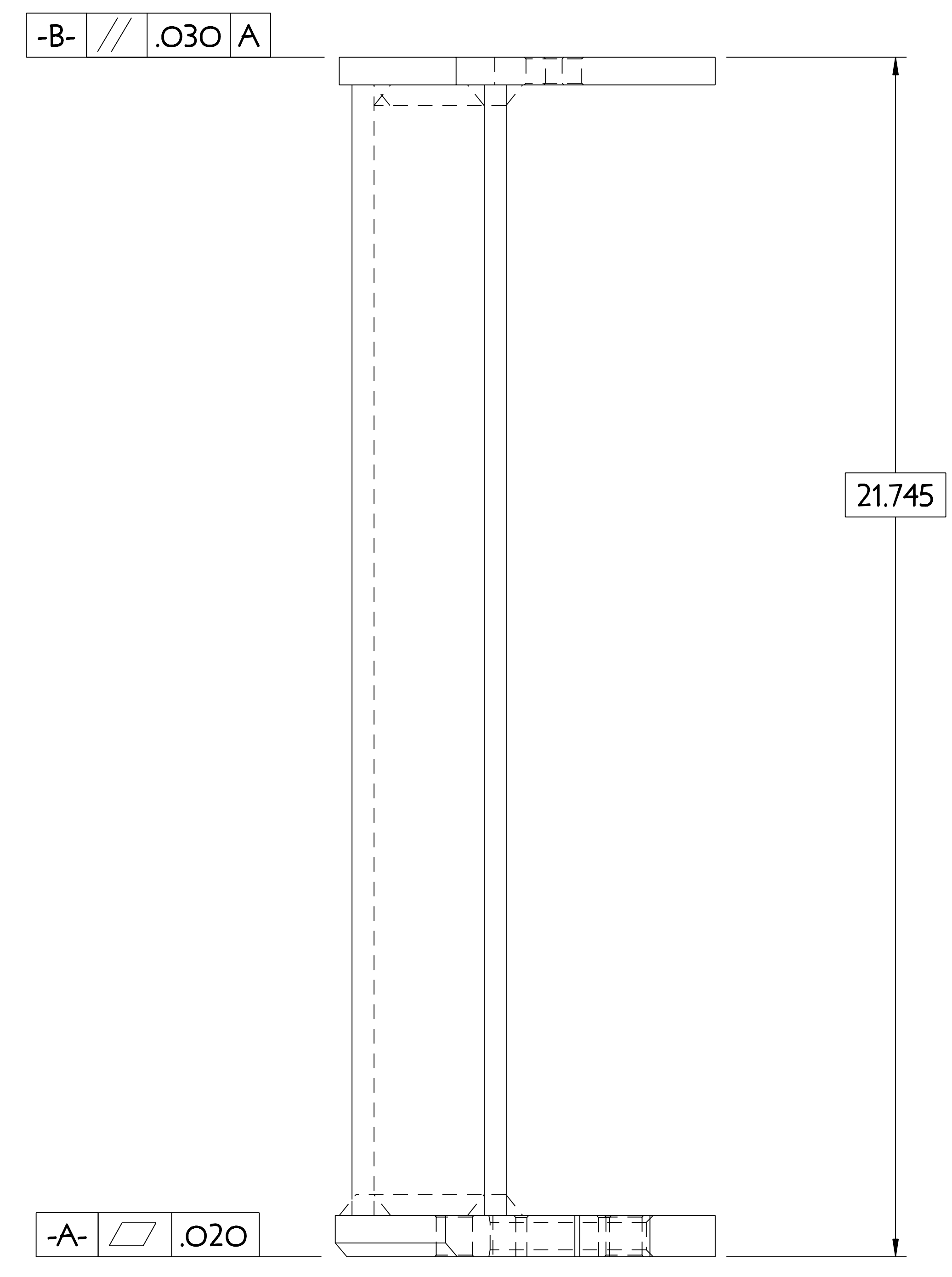
WELDING SHALL BE PERFORMED IN ACCORDANCE
 WITH THE REQUIREMENTS OF AWS D1.6. WELDING
 PERFORMED ONSITE SHALL ALSO MEET THE REQUIREMENTS
 OF PPPL PROCEDURE ENG-037.

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	REOD
3	SE132-215-2	CENTER SOLENOID LOWER SUPPORT PLATE 1	304 STN STL	1	
2	SE132-214-3	CENTER SOLENOID UPR/LWR SUPPORT TOP PLATE CUT	304 STN STL	1	
1	SE132-214-2	CENTER SOLENOID UPR/LWR SUPPORT GUSSET PLATE	304 STN STL	2	

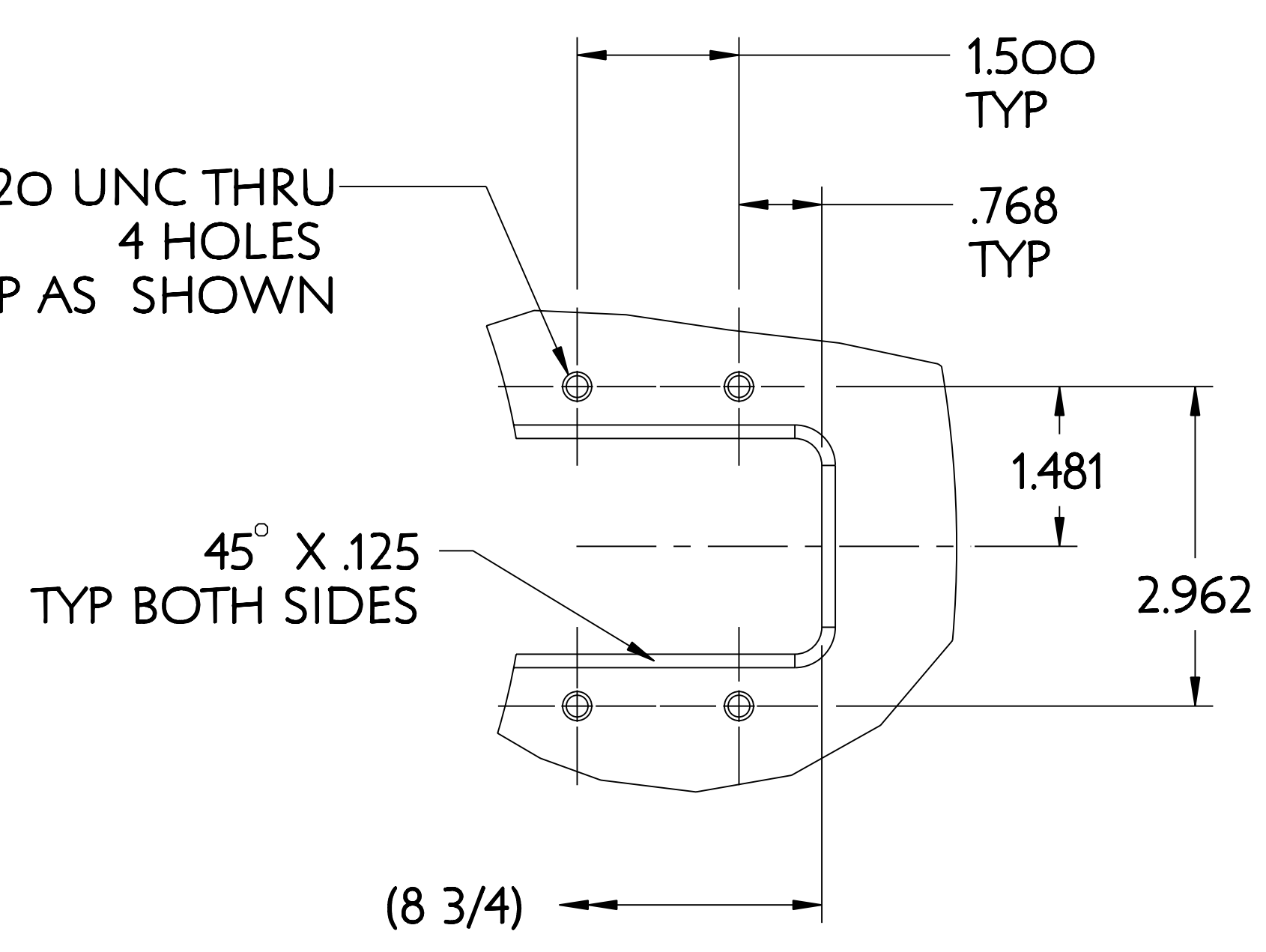
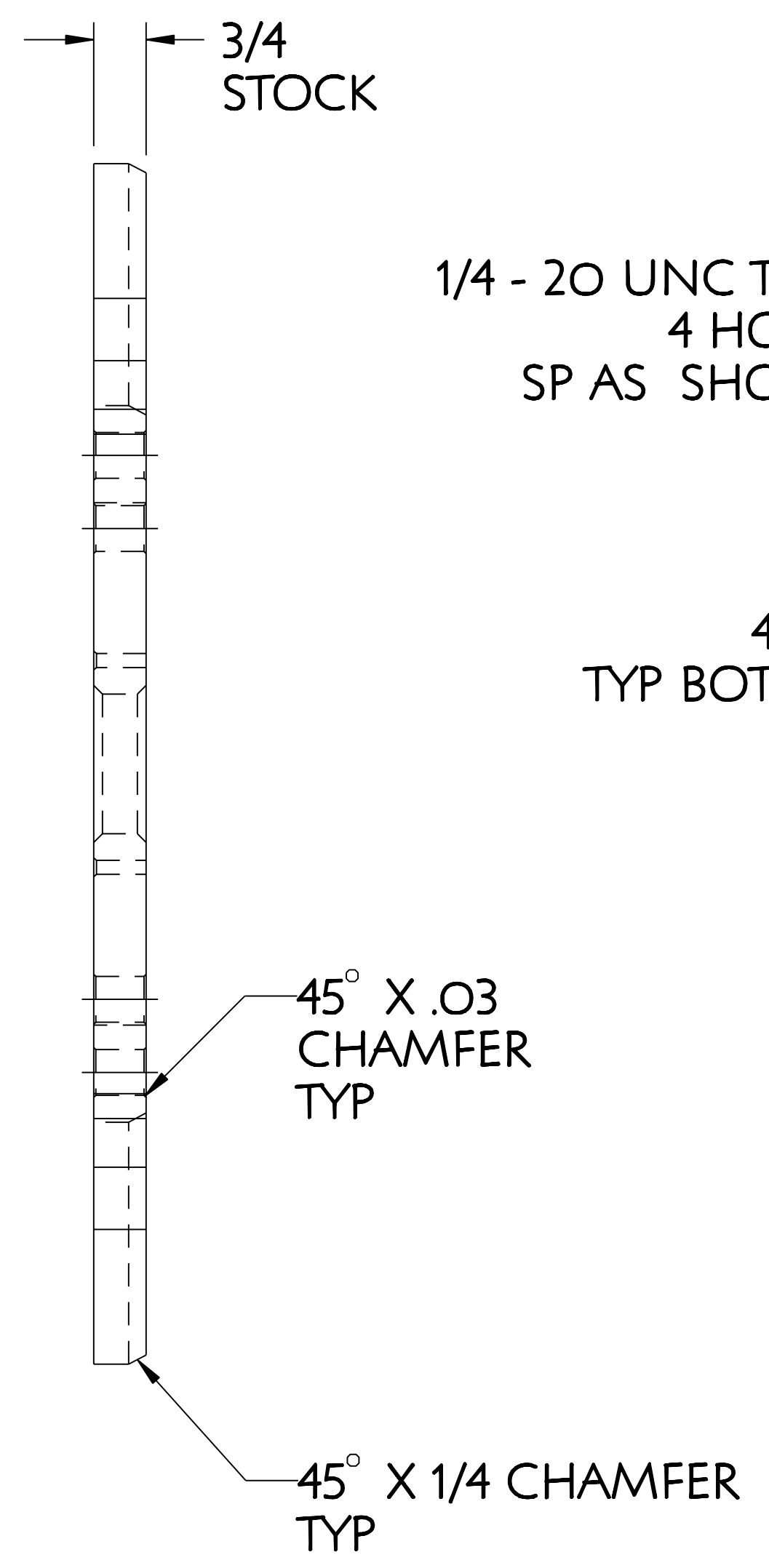
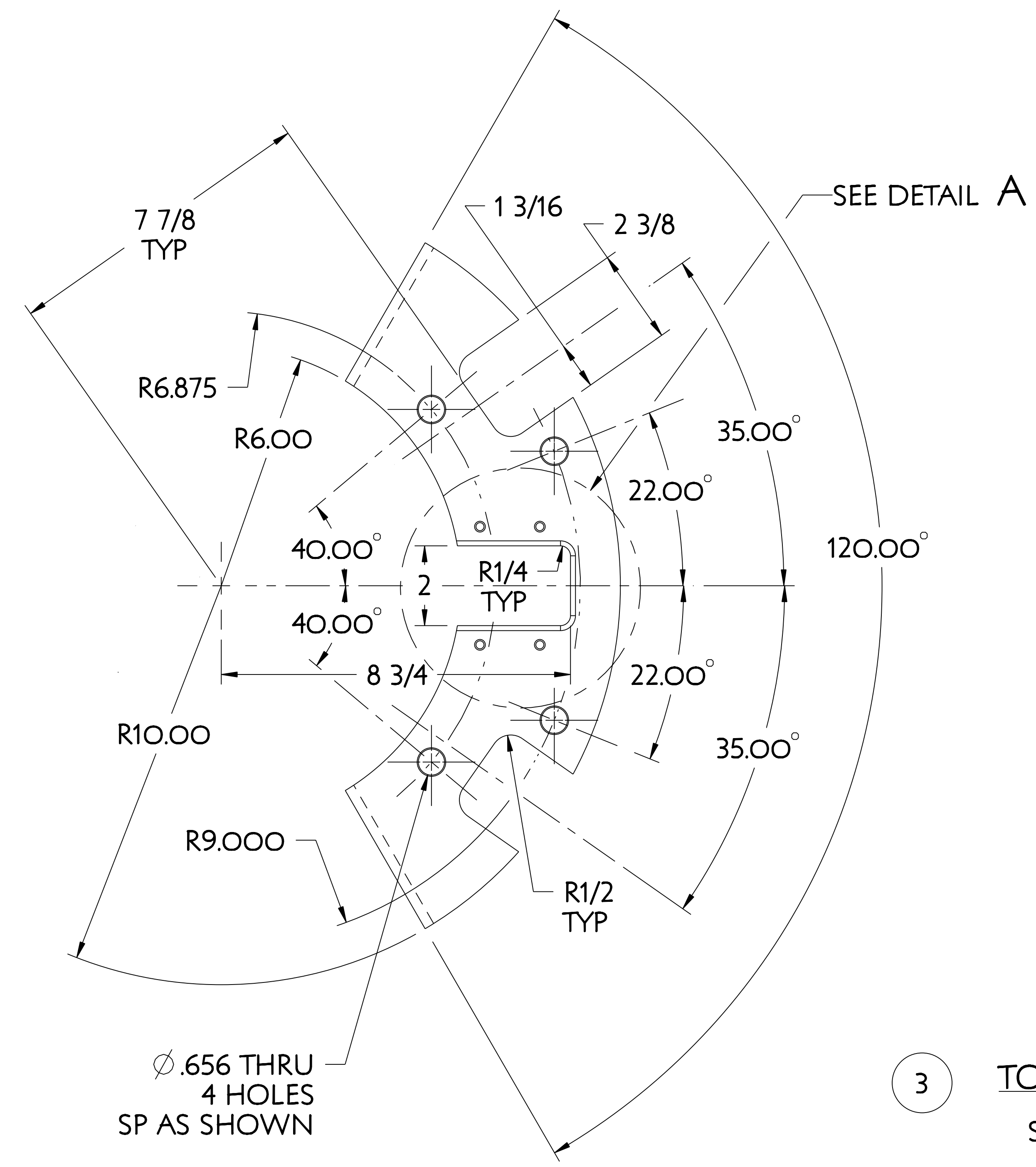
PARTS LIST

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 CONVENTIONAL COILS CENTER SOLENOID UPPER SUPPORT ASSEMBLY WITH LEAD CUTOUPS	
SCALE 0.625	TOLERANCES NON-CUMULATIVE	DSN: J. RUSHINSKI	DRAWING NO:
NEXT ASSEMBLY	DECIMAL-INCH FRACTIONS	CHK: ENGR: F. DAHLGREN	SE132-214
	.XX +/- .000 0°-120° +/- 1/16 .XXX +/- .005 120°-120° +/- 1/16 ANGULAR +/- 0°-15° OVER 120° +/- 1/16	SUPV:	SHEET 1 OF 2 REV 0

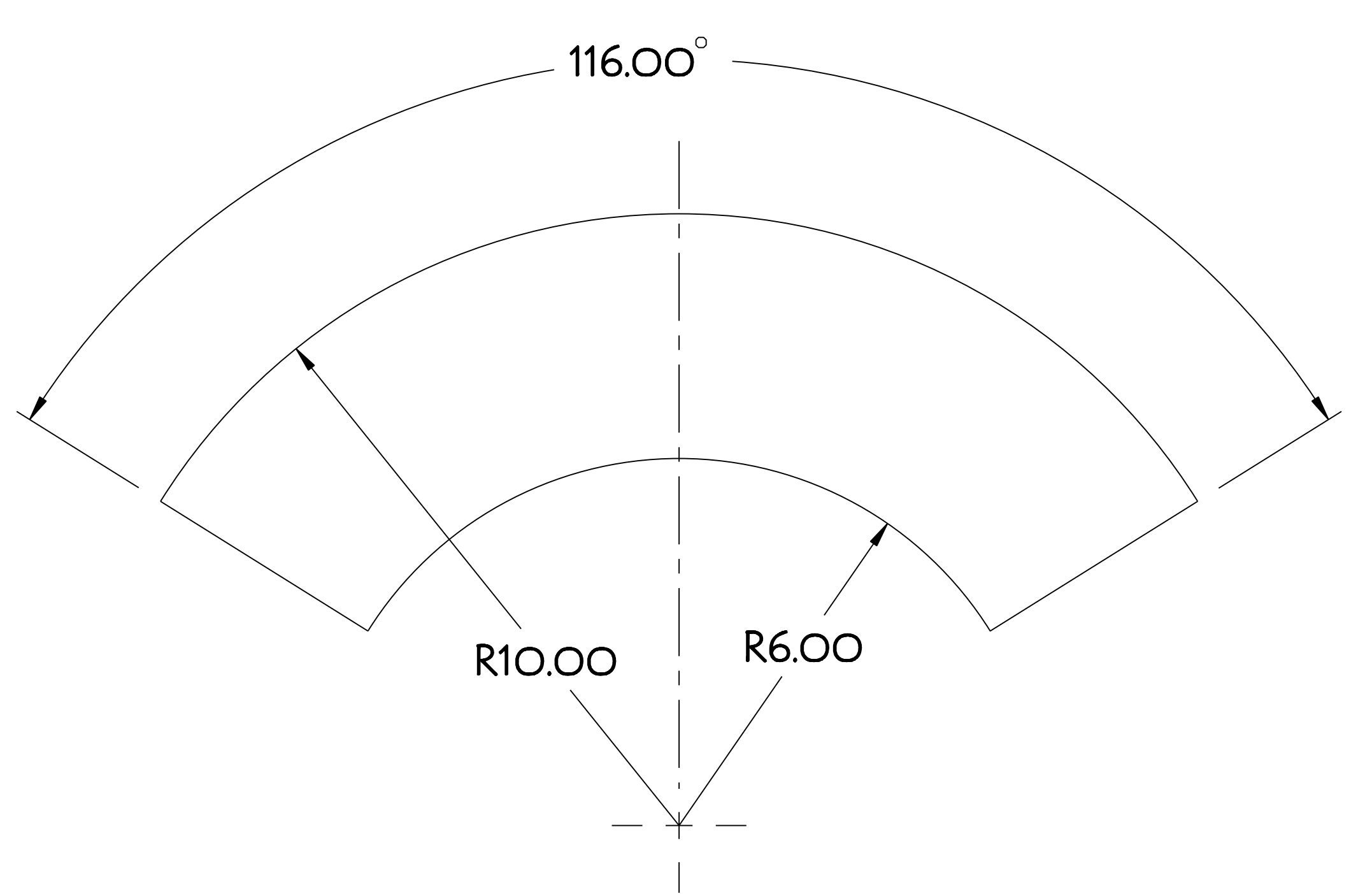
RELEASE LEVEL: WIP
 DWG VERSION NO: 6

WELDING ENGINEER

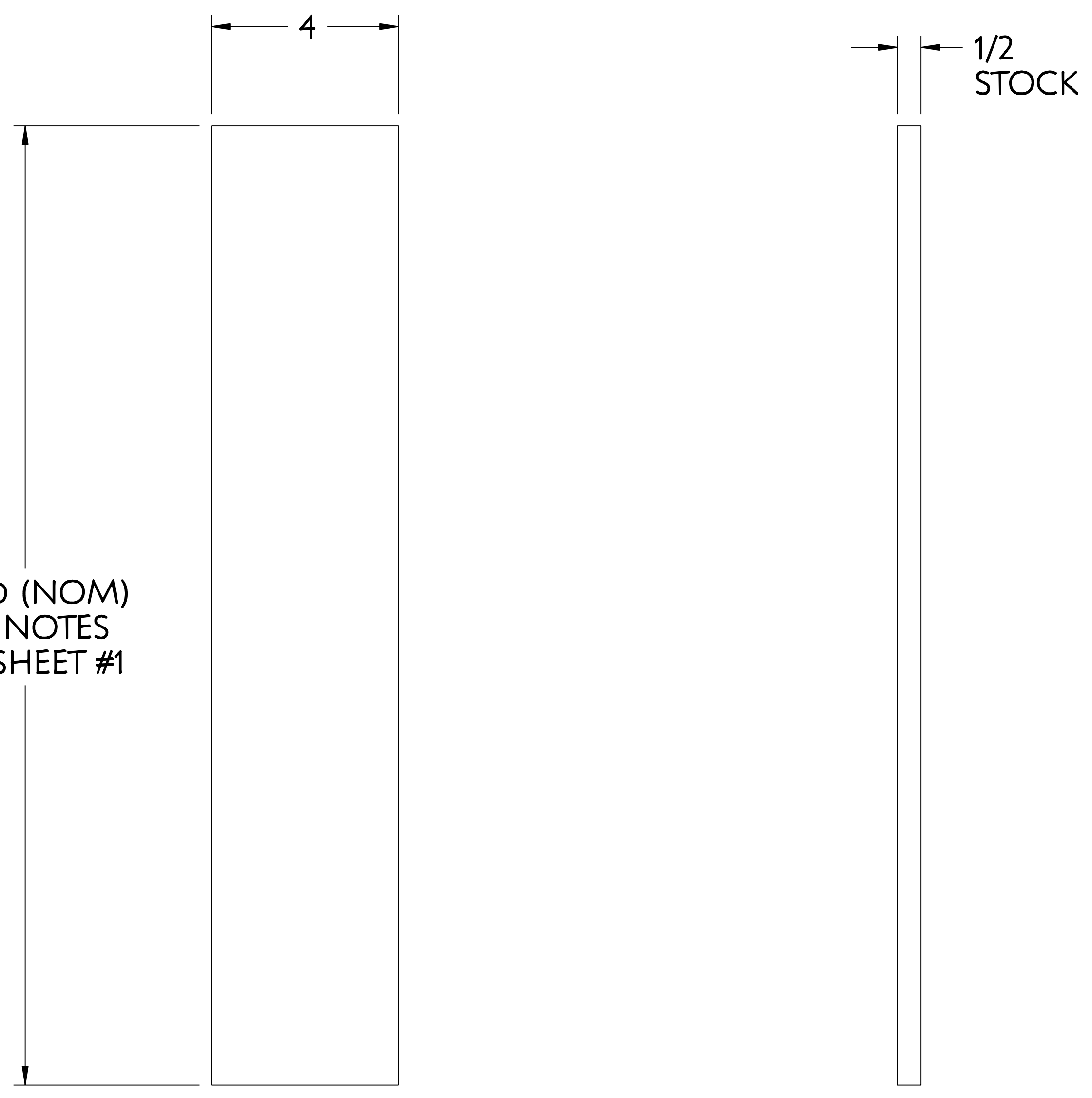
NO.	REVISION	BY	CH	SUP	APPROVED	DATE



3 TOP PLATE CUT
SCALE 0.500



1 BOTTOM SUPPORT PLATE #1
SCALE 0.500



2 GUSSET PLATE

PART NO.	DRAWING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY RECD
3	SE132-214-3	CENTER SOLENOID UPR/LWR SUPPORT TOP PLATE CUT	304 STN STL	
2	SE132-214-2	CENTER SOLENOID UPR/LWR SUPPORT GUSSET PLATE	304 STN STL	
1	SE132-214-1	CENTER SOLENOID UPPER SUPPORT PLATE I	304 STN STL	

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	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 CONVENTIONAL COILS CENTER SOLENOID UPPER SUPPORT BRACKET DETAILS
DO NOT VERIFY INFORMATION BY SCALING DRAWING	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX ±.010 0°-12° ±.125 .XX ±.030 12°-72° ±.125 .XX ±.005 72°-120° ±.125 ANGULAR ±.0°-15° OVER 120° ±.125	DSN: J. RUSHINSKI CHK: ENGR: F. DAHLGREN SUPV:
WEIGHT 43.6 lbs	MODEL NAME SE132-214-3	DRAWING NO: SE132-214
RELEASE LEVEL: WIP DWG VERSION NO: 6	WELDING ENGINEER	SHEET 2 OF 2 REV B, 2

NCSX-SE132-214