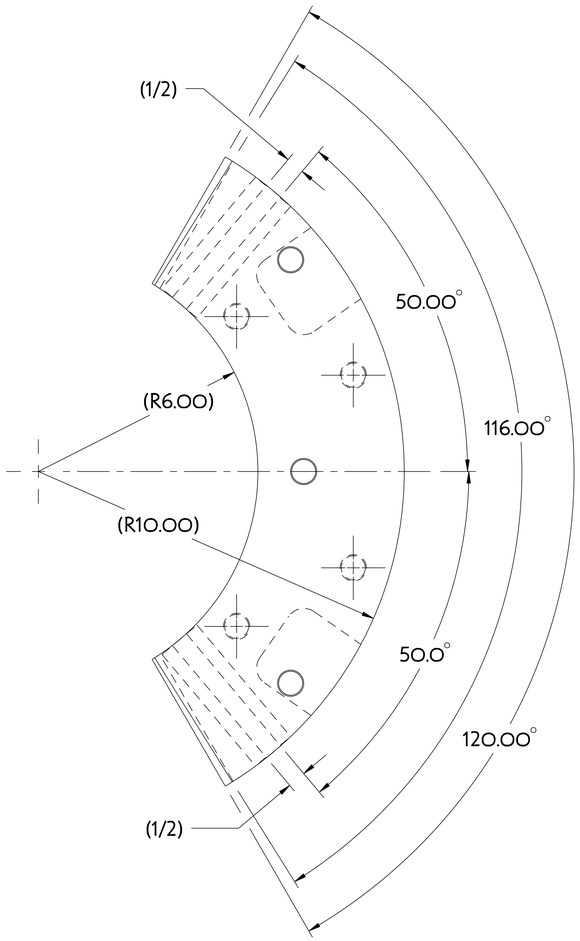
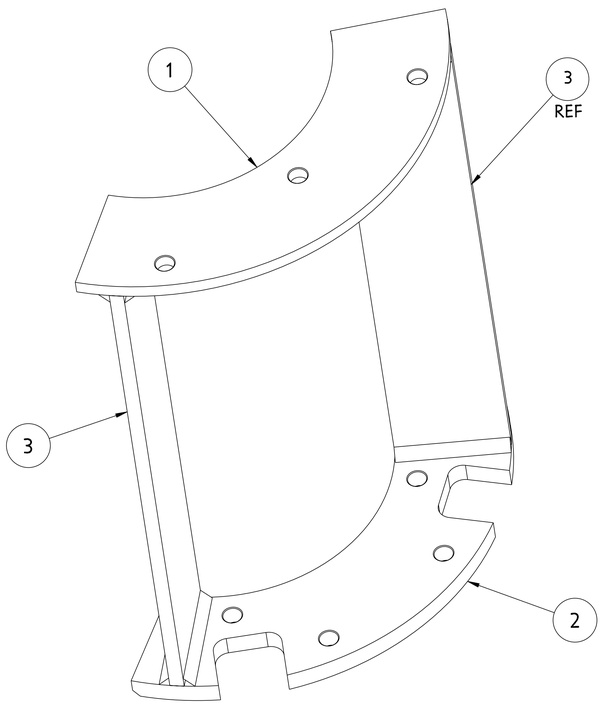
NO.	REVISION	BY	CH	SUP	APPROVED	DATE





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.

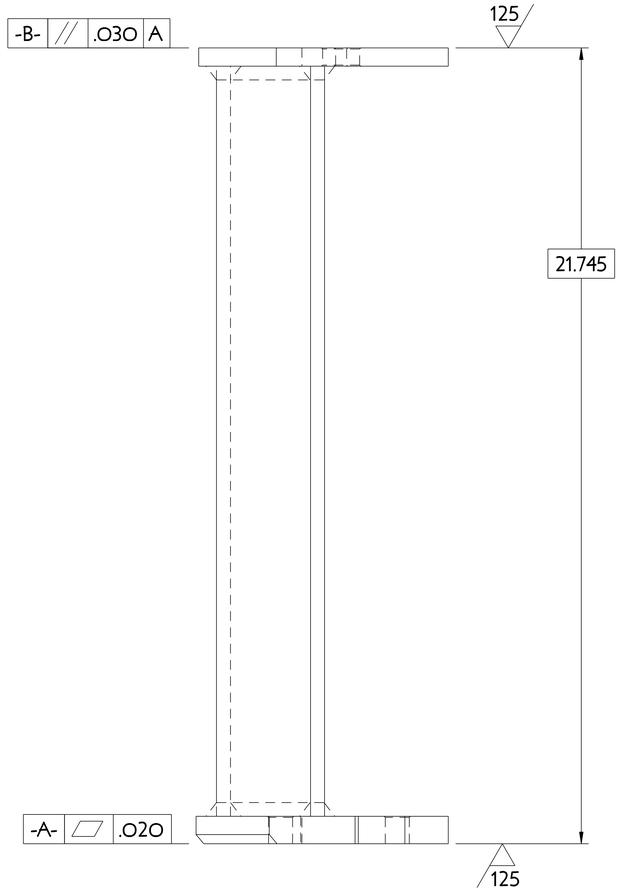
WELDING SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF AWS D1.6. WELDING PERFORMED ONSITE SHALL ALSO MEET THE REQUIREMENTS OF PPPL PROCEDURE ENG-037.

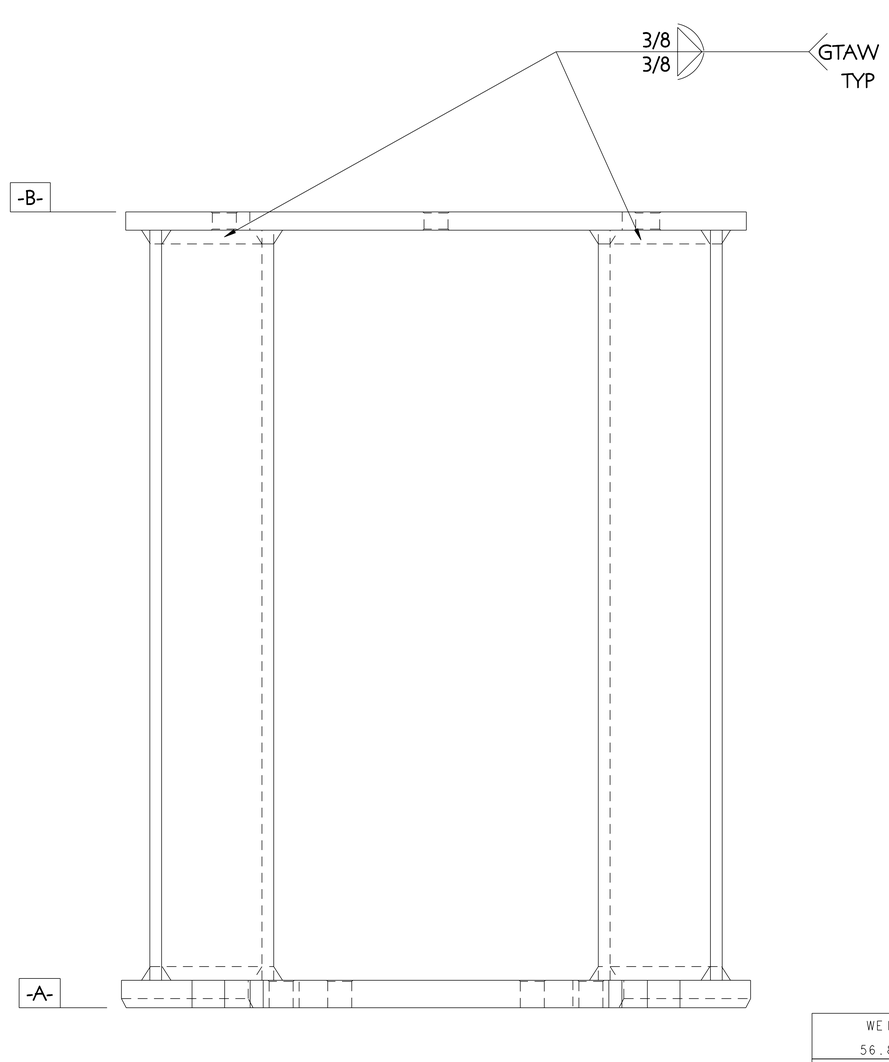
VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH THE ACCEPTANCE CRITERIA OF AWS D1.6.

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

PARTS LIST

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 125	NATIONAL COMPACT STELLARATOR EXPERIMENT	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	BREAK SHARP EDGES .005/.020	STELLARATOR CORE CONVENTIONAL COILS CENTER SOLENOID UPPER SUPPORT ASSEMBLY	
SCALE 0.625	TOLERANCES NON-CUMULATIVE	DSN: J. RUSHINSKI	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:	SE132-215
		ENGR: F. DAHLGREN	
		SUPV:	SHEET 1 OF 2 REV 0

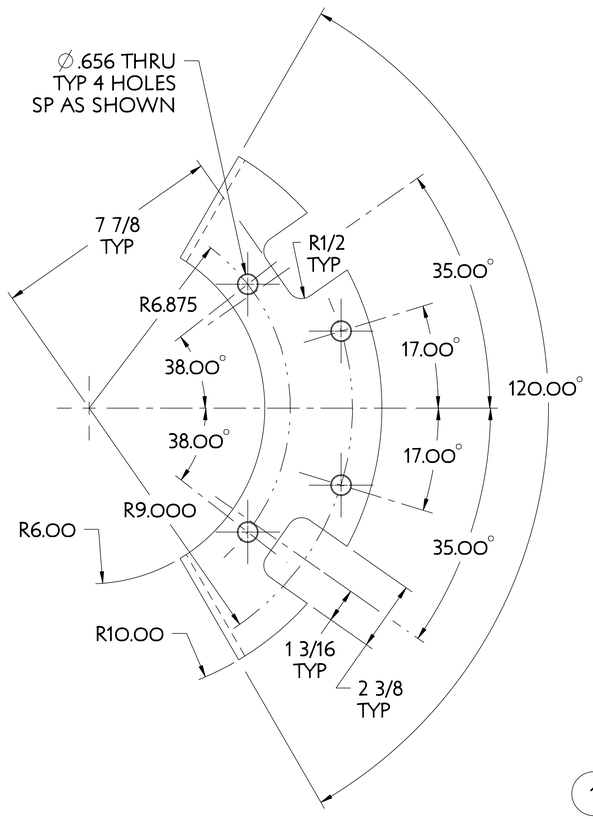
WEIGHT	MODEL NAME	WELDING ENGINEER
56.8 lbs	SE132-215	

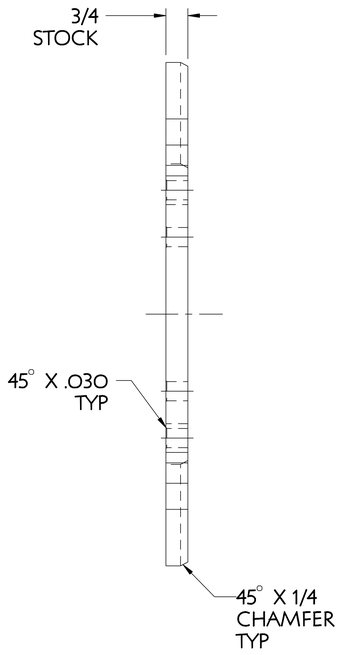
RELEASE LEVEL: WIP
DWG VERSION NO: 3

NCSX-SE132-215

NCSX_ASSY_FORMAT_E

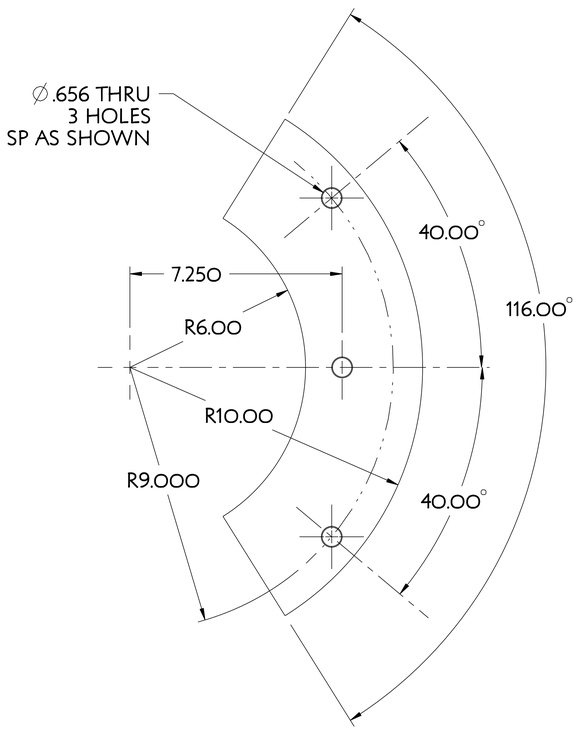
NO.	REVISION	BY	CH	SUP	APPROVED	DATE

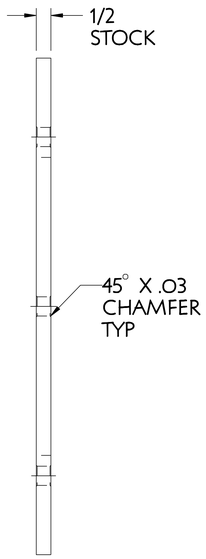




1 TOP PLATE

SCALE 0.500





2 SUPPORT PLATE 1

SCALE 0.500

PART NO.	DRAWING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY REQD
2	SE132-215-2	CENTER SOLENOID LOWER SUPPORT PLATE 1	304 STN STL	
1	SE132-215-1	CENTER SOLENOID BOTTOM SUPPORT TOP PLATE	304 STN STL	

PARTS LIST

NCSX-SE132-215

WEIGHT
9.2 lbs

MODEL NAME
SE132-215-2

WELDING ENGINEER

RELEASE LEVEL: WIP
DWG VERSION NO: 1

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 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

STELLARATOR CORE
CONVENTIONAL COILS
CENTER SOLENOID UPPER SUPPORT DETAILS

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

DRAWING NO:
SE132-215

SHEET 2 OF 2 REV D.14

NCSX_PART_FORMAT_E