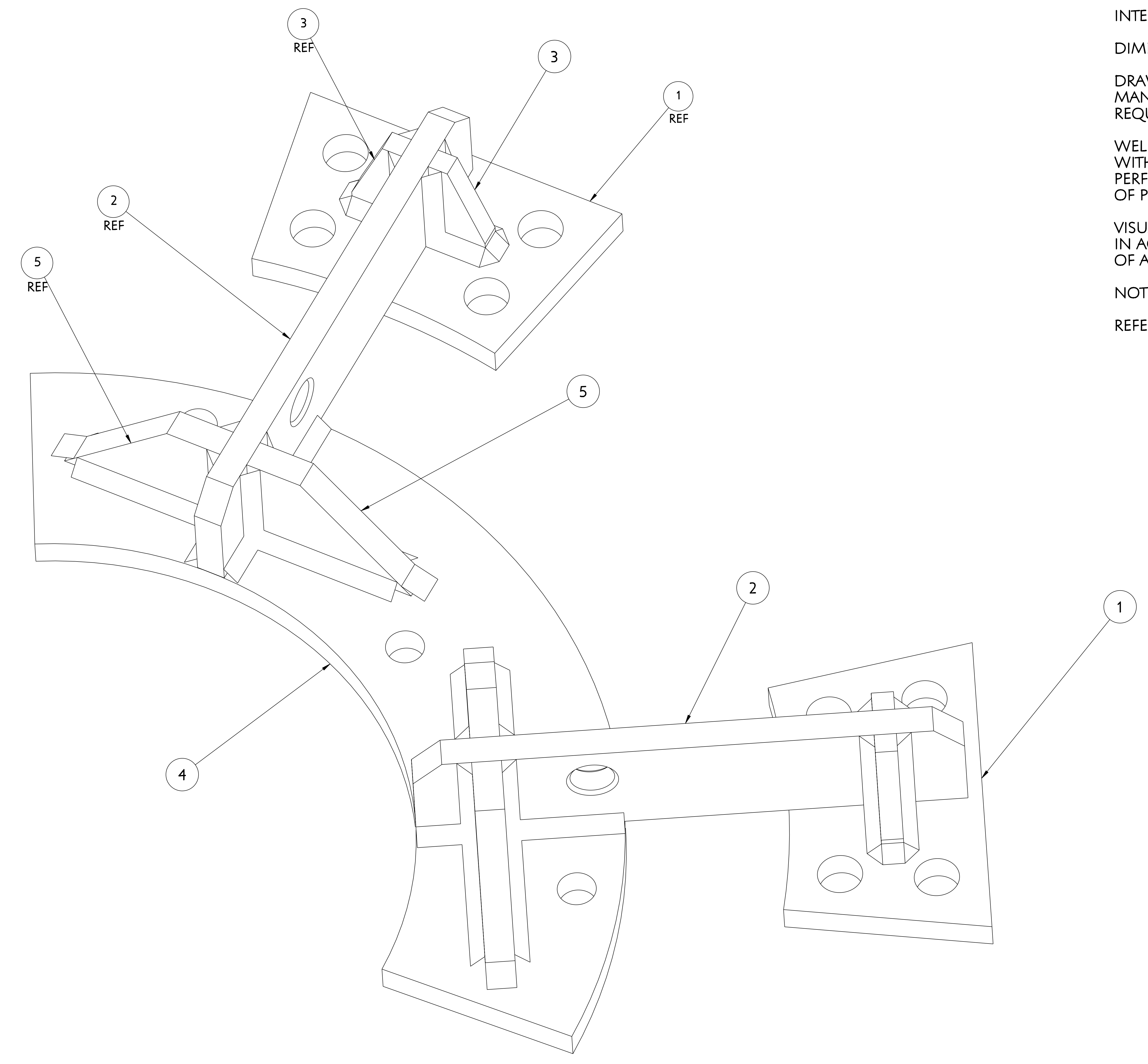


NO.	REVISION	BY	CH	SUP	APPROVED	DATE



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

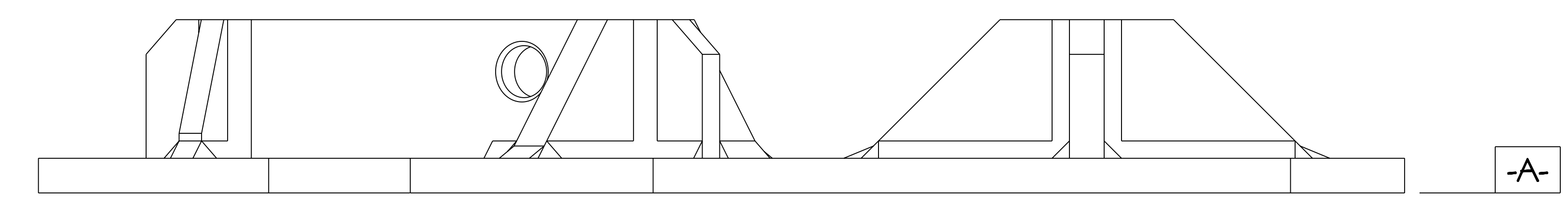
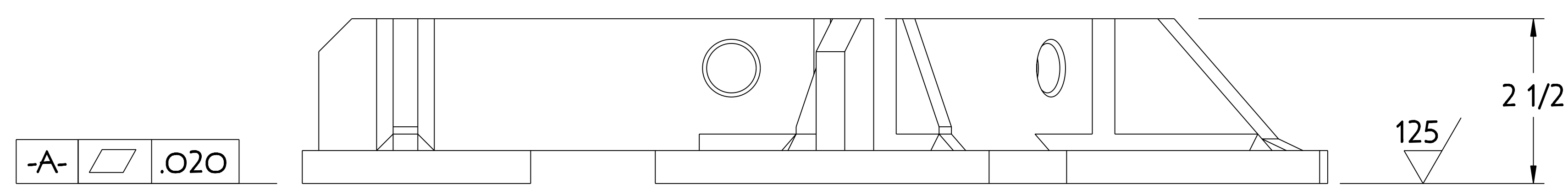
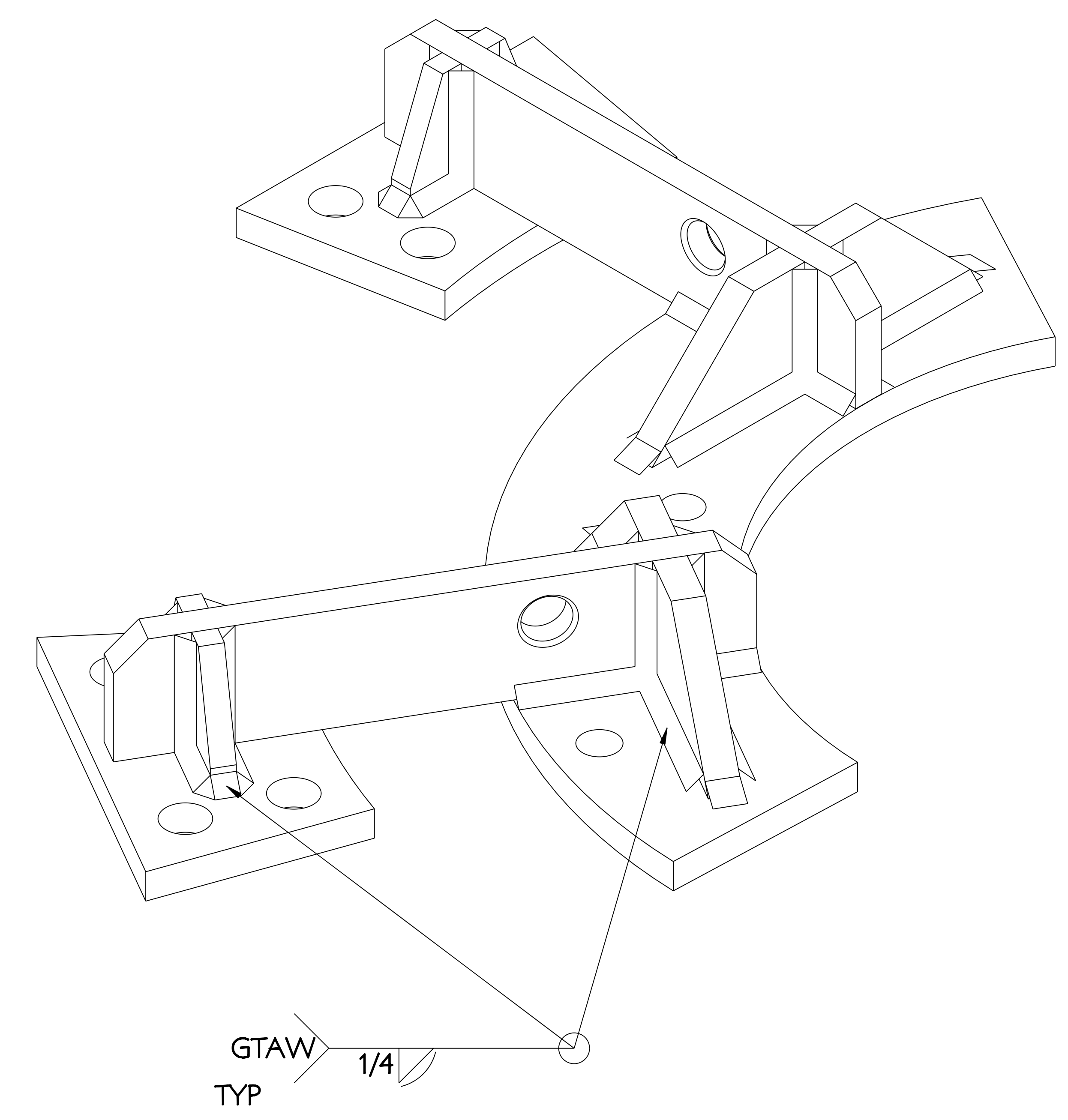
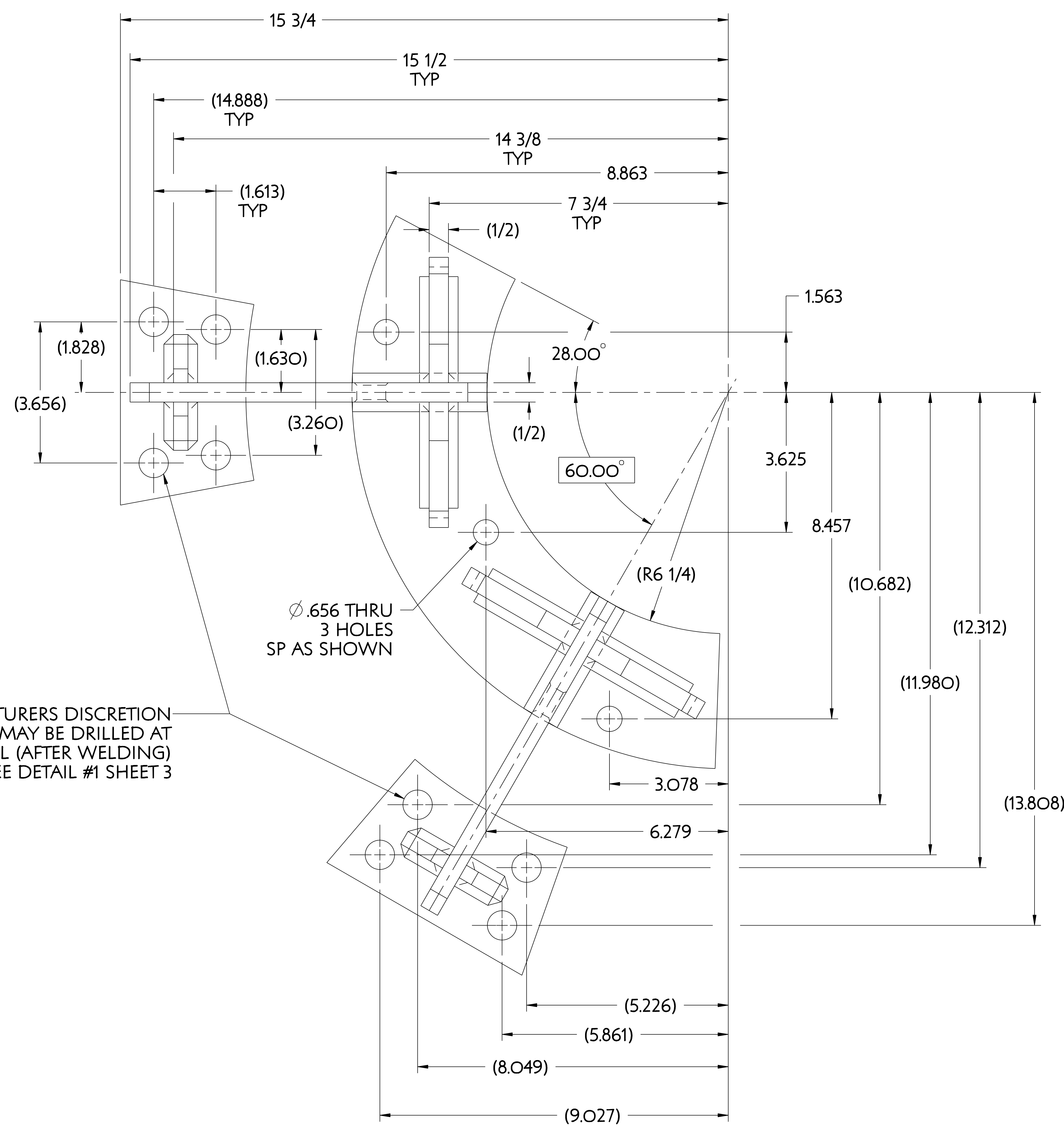
PART NO.	DRAWING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY	REOD
5	SE132-250-5	HUB SUPPORT BRACKET GUSSET #2	304 STN STL	4	
4	SE132-250-4	HUB SUPPORT BRACKET CURVED MOUNTING PLATE	304 STN STL	1	
3	SE132-250-3	HUB SUPPORT BRACKET GUSSET #1	304 STN STL	4	
2	SE132-250-2	HUB SUPPORT BRACKET RADIAL TIE PLATE	304 STN STL	2	
1	SE132-250-1	HUB SUPPORT BRACKET MOUNTING 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 ENTER SOLENOID TO UPPER/LOWER HUB SUPPORT BRACKET	
WEIGHT 20.7 lbs	TOLERANCES NON-CUMULATIVE	DSN: J. RUSHINSKI	DRAWING NO:
MODEL NAME SE132-250	DECIMAL-INCH FRACTIONS	CHK: ENGR: F. DAHLGREN	SE132-250
RELEASE LEVEL: WIP DWG VERSION NO: 3	WELDING ENGINEER	SUPV:	SHEET 1 OF 3 REV 0

NCSX-SE132-250

NO.	REVISION	BY	CH	SUP	APPROVED	DATE

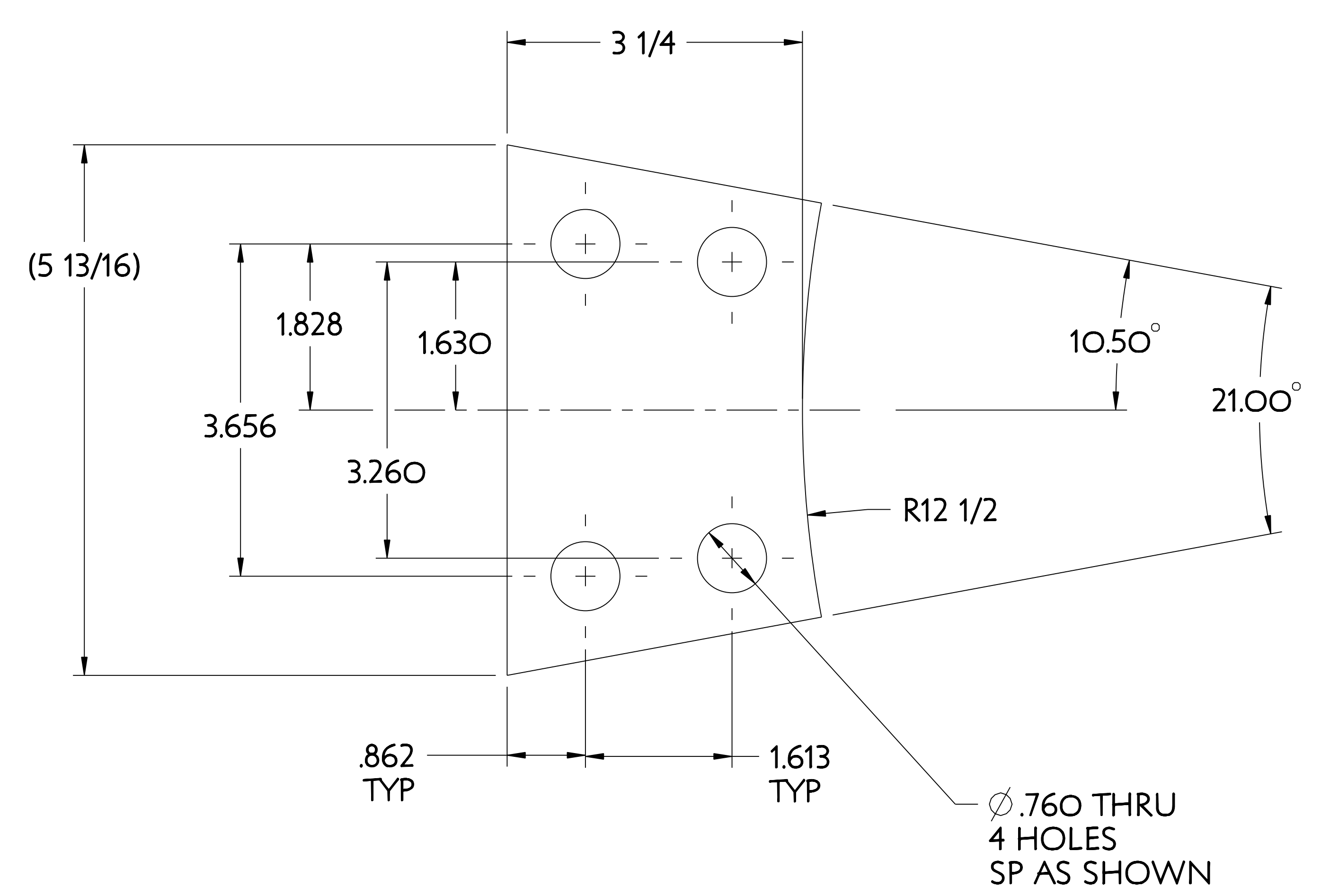


RELEASE LEVEL: WIP
DWG VERSION NO: 3

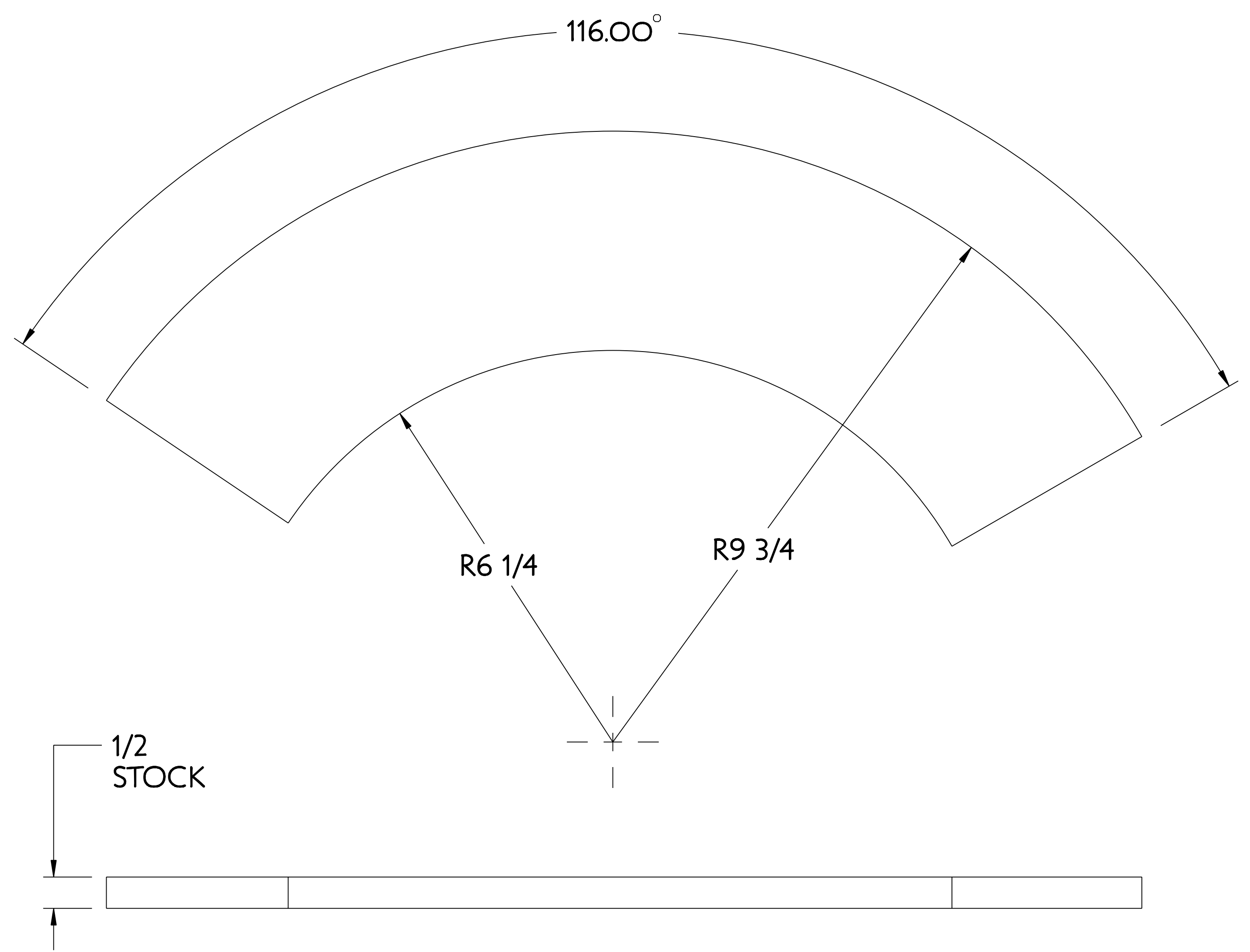
WEIGHT
20.7 lbs
MODEL NAME
SEI32-250
WELDING
ENGINEER

PART NO.	DRAWING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY RECD
PARTS LIST				
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 CONVENTIONAL COILS ENTER SOLENOID TO UPPER/LOWER HUB SUPPORT BRACKET	
SCALE 0.750		TOLERANCES NON-CUMULATIVE	DSN: J. RUSHINSKI	DRAWING NO:
NEXT ASSEMBLY		DECIMAL-INCH FRACTIONS	CHK: ENGR: F. DAHLGREN	SEI32-250
		XXX +/- .005 72°-120° +/- .124 ANGULAR +/- .0°-15° OVER 120° +/- .124	SUPV:	SHEET 2 OF 3 REV D, 14

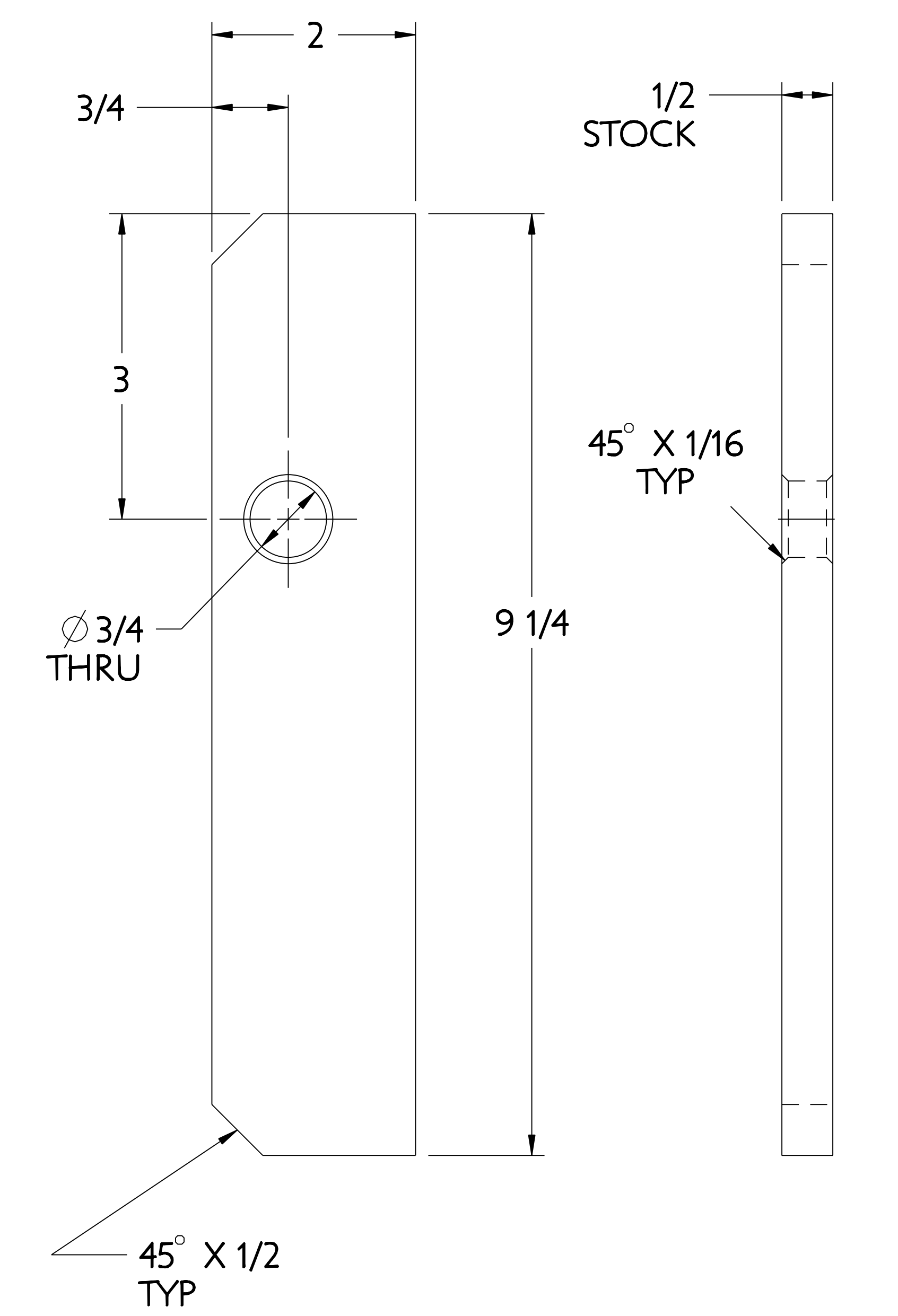
NO.	REVISION	BY	CH	SUP	APPROVED	DATE



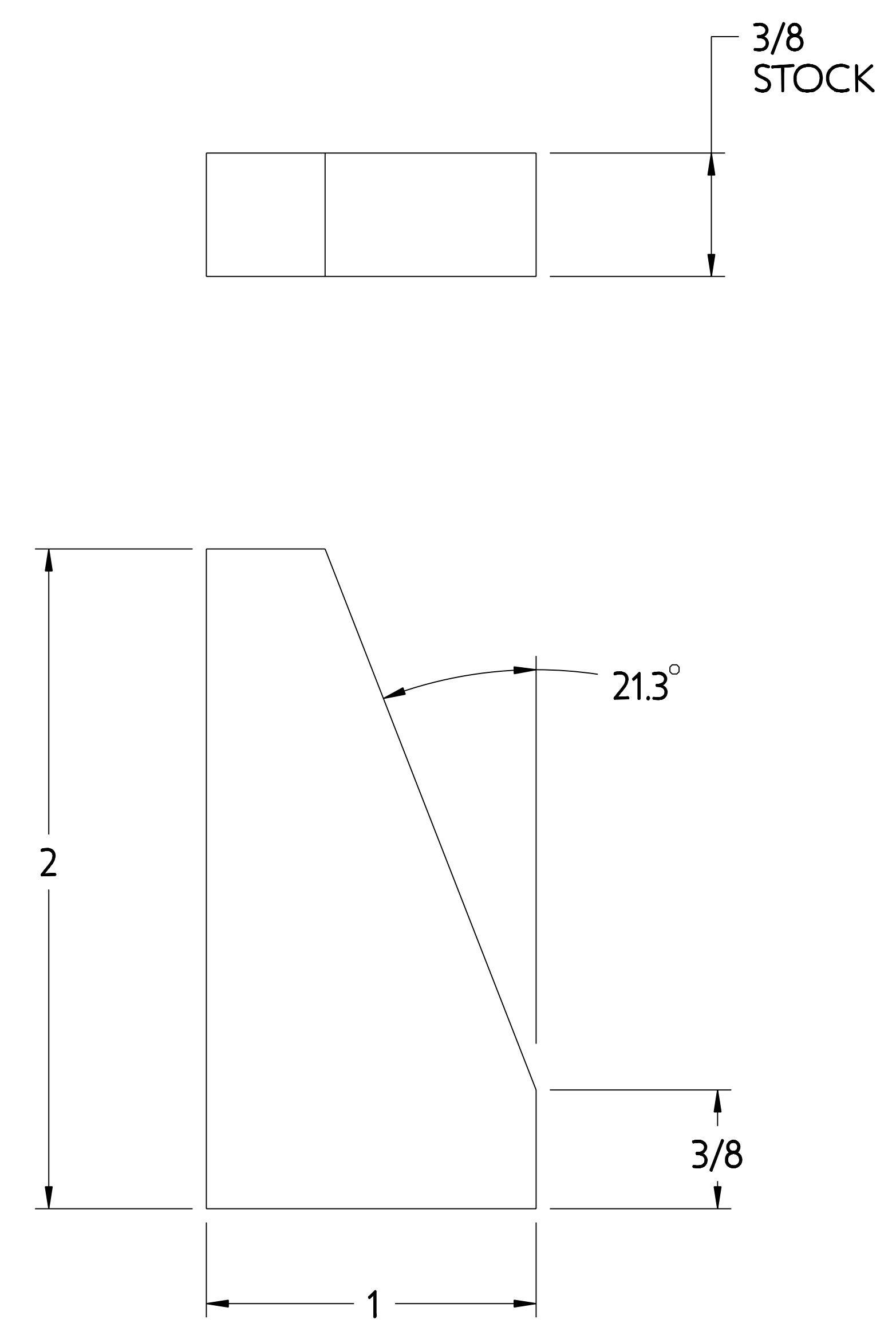
1 HUB MOUNTING PLATE



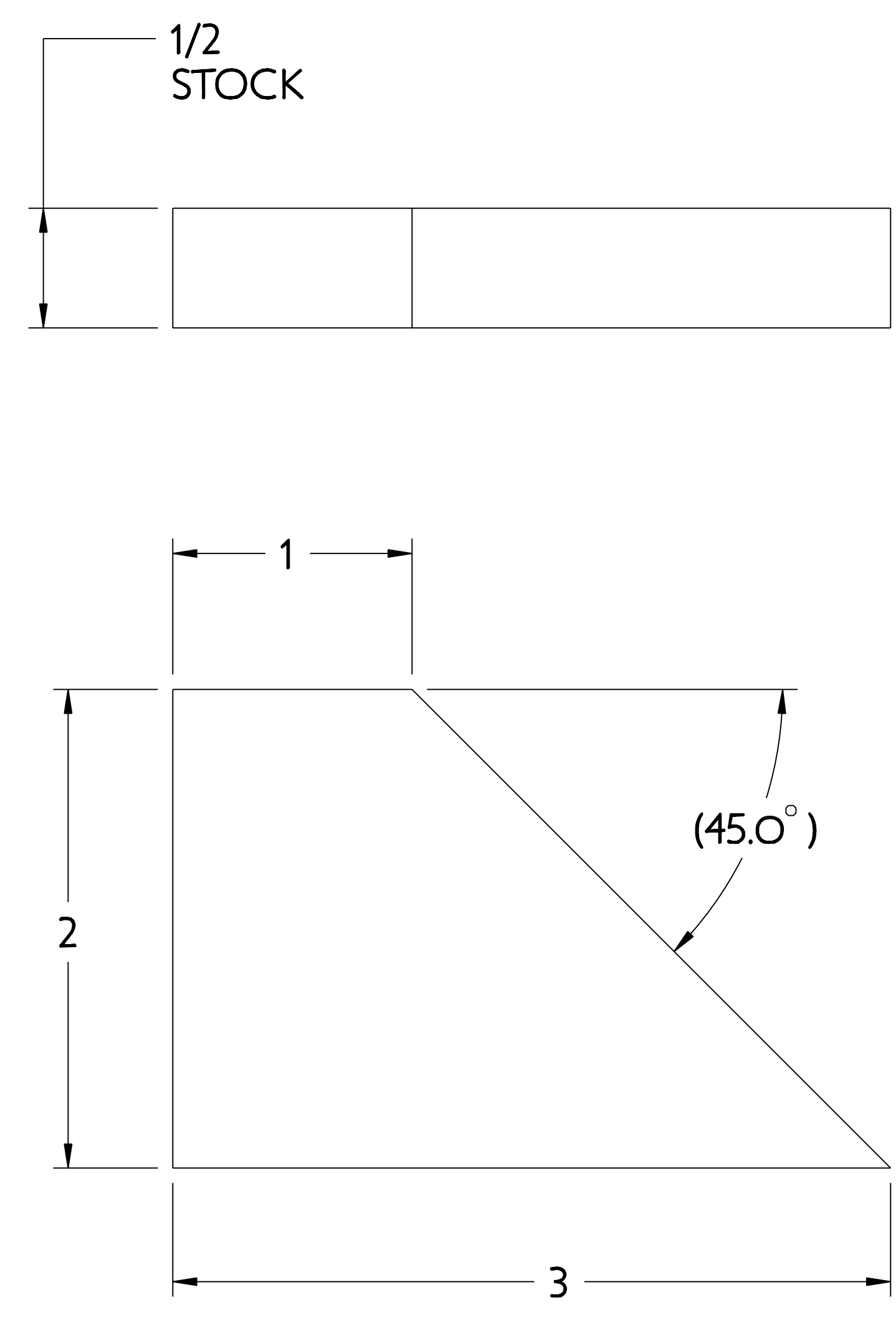
4 CURVED MOUNTING PLATE



2 RADIAL TIE PLATE



3 GUSSET PLATE #1



5 GUSSET PLATE #2

PART NO.	DRAWING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY RECD
5	SE132-250-5	HUB SUPPORT BRACKET GUSSET #2	304 STN STL	
4	SE132-250-4	HUB SUPPORT BRACKET CURVED MOUNTING PLATE	304 STN STL	
3	SE132-250-3	HUB SUPPORT BRACKET GUSSET #1	304 STN STL	
2	SE132-250-2	HUB SUPPORT BRACKET RADIAL TIE PLATE	304 STN STL	
1	SE132-250-1	HUB SUPPORT BRACKET MOUNTING PLATE	304 STN STL	

PARTS LIST

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 CONVENTIONAL COILS CENTER SOLENOID TO UPPER/LOWER HUB SUPPORT BRACKET DETAILS	
NEXT ASSEMBLY	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX ±.000 .XXX ±.005 ANGULAR ±.0°-15° OVER 120° ±.1°	DSN: J. RUSHINSKI CHK: ENGR: F. DAHLGREN SUPV:	DRAWING NO: SE132-250

RELEASE LEVEL: WIP
DWG VERSION NO: 3

SHEET 3 OF 3 REV D, 14

NCSX-SE132-250