



NOTES

1. WELDING SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF AWS D1.1 SECTION 6, AND PPPL PROCEDURE EM-002. VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH THE ACCEPTANCE CRITERIA OF AWS D1.1 SECTION 6.
2. DISTORTION OF BASE PLATE, PART 1, DUE TO WELDING MUST BE KEPT TO A MINIMUM.
3. ALL HOLES ARE TO BE MACHINED AFTER ALL WELDING IS COMPLETE.

QTY	PART NO.	DRAWING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY REQD
1	4	SE144-126-03	JACK CLEVIS BRACKET WELDMENT	SEE DWG	
1	3	THIS DWG	CENTERING RING	ASTM A569	
A/R	2	THIS DWG	STIFFENER RIB (TO LENGTH REQ'D)	ASTM A569	
1	1	THIS DWG	TURNTABLE BASE PLATE	ASTM A569	
1			TURNTABLE TOP WELDMENT		1

PARTS LIST

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES MACHINE SURFACES UNLESS OTHERWISE SPECIFIED BREAK SHARP EDGES .005/0.020	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY NATIONAL COMPACT STELLARATOR EXPERIMENT MODULAR COIL WINDING FACILITY COPPER SPOOLS MANIPULATOR TURNTABLE TOP WELDMENT	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX ±.000 .XXX ±.005 ANGULAR ±.0°-15°	DSN: L. MORRIS CHK: S. RAFTOPOULOS ENGR: J. CHRZANOWSKI SUPV: J. SIEGEL	DRAWING NO: SE144-123 SHEET 1 OF 1 REV 0

RELEASE LEVEL: Fabrication
DWG VERSION NO: 3

WEIGHT 165.4 lbs	MODEL NAME SE144-123
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NCSX-SE144-123