



NOTES

1. WELDING SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF AWS D1.1 AND/OR PPPL PROCEDURE EM-002. VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH THE ACCEPTANCE CRITERIA OF AWS D1.1 Section 6.
2. HOLES AS NOTED TO BE MACHINED AFTER ALL WELDING IS PERFORMED.

RELEASED FOR FABRICATION / INSTALLATION
PPPL Drafting:

REV	NO.	DESCRIPTION	MATERIAL	QTY REQD	
	11	THIS DWG	MAIN BASE PLATE EXTENSION - SHORT	ASTM A36 4	
	2	10	THIS DWG	GUSSET	ASTM A36 16
	9	THIS DWG	SPLICE PLATE EXTENSION	ASTM A36 4	
	8	THIS DWG	SPLICE PLATE	ASTM A36 4	
	7	THIS DWG	MAIN BASE PLATE EXTENSION - LONG	ASTM A36 4	
	6	THIS DWG	MAIN BASE PLATE	ASTM A36 4	
	5	THIS DWG	OUTRIGGER MOUNTING PLATE	ASTM A36 16	
	4	THIS DWG	OUTRIGGER SQUARE TUBE - 4" SQUARE TUBE x 1/4" WALL	ASTM A500 16	
	3	THIS DWG	OUTRIGGER BASE PLATE	ASTM A36 16	
	2	THIS DWG	UPRIGHT CHANNEL - MC10" x 33.6#	ASTM A36 8	
	1	THIS DWG	BASE PLATE	ASTM A36 8	
		THIS DWG	SPLICE PLATE WELDMENT	4	
		THIS DWG	MAIN BASE PLATE WELDMENT	4	
		THIS DWG	OUTRIGGER WELDMENT	16	
		THIS DWG	UPRIGHT WELDMENT	8	

ASSY	ASSY	ASSY	ASSY	PART	DRAWING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY REQD
04	03	02	01					

PARTS LIST

COMPUTER GENERATED DRAWING CHANGES NOT PERMITTED	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY			
Pro E	DIMENSIONS ARE IN INCHES MACHINE SURFACES UNLESS OTHERWISE SPECIFIED	NATIONAL COMPACT STELLARATOR EXPERIMENT			
DO NOT VERIFY INFORMATION BY SCALING DRAWING	BREAK SHARP EDGES .005/.020	MODULAR COIL ASSEMBLY WINDING SUPPORT FRAME WELDMENTS AND DETAILS			
SCALE: 1/8 AND AS NOTED	TOLERANCES NON-CUMULATIVE	DSN: L. MORRIS	12-23-03	DRAWING NO:	
NEXT ASSEMBLY	DECIMAL-INCH FRACTIONS	CHK: S. RAFTOPOULOS	12-23-03	SE144-009	
	.XX +/- .000 0"-12" +/- .010	ENGR: S. RAFTOPOULOS	12-23-03	SHEET 1 OF 1	
	.XXX +/- .005 12"-120" +/- .010	SUPV: J. SIEGEL	12-23-03	REV 1	
	ANGULAR +/- 0°-15° OVER 120° +/- .12°				

RELEASE LEVEL:
DWG VERSION NO:

NCSX-SE144-009

NCSX-ASSY-FORMAT.E