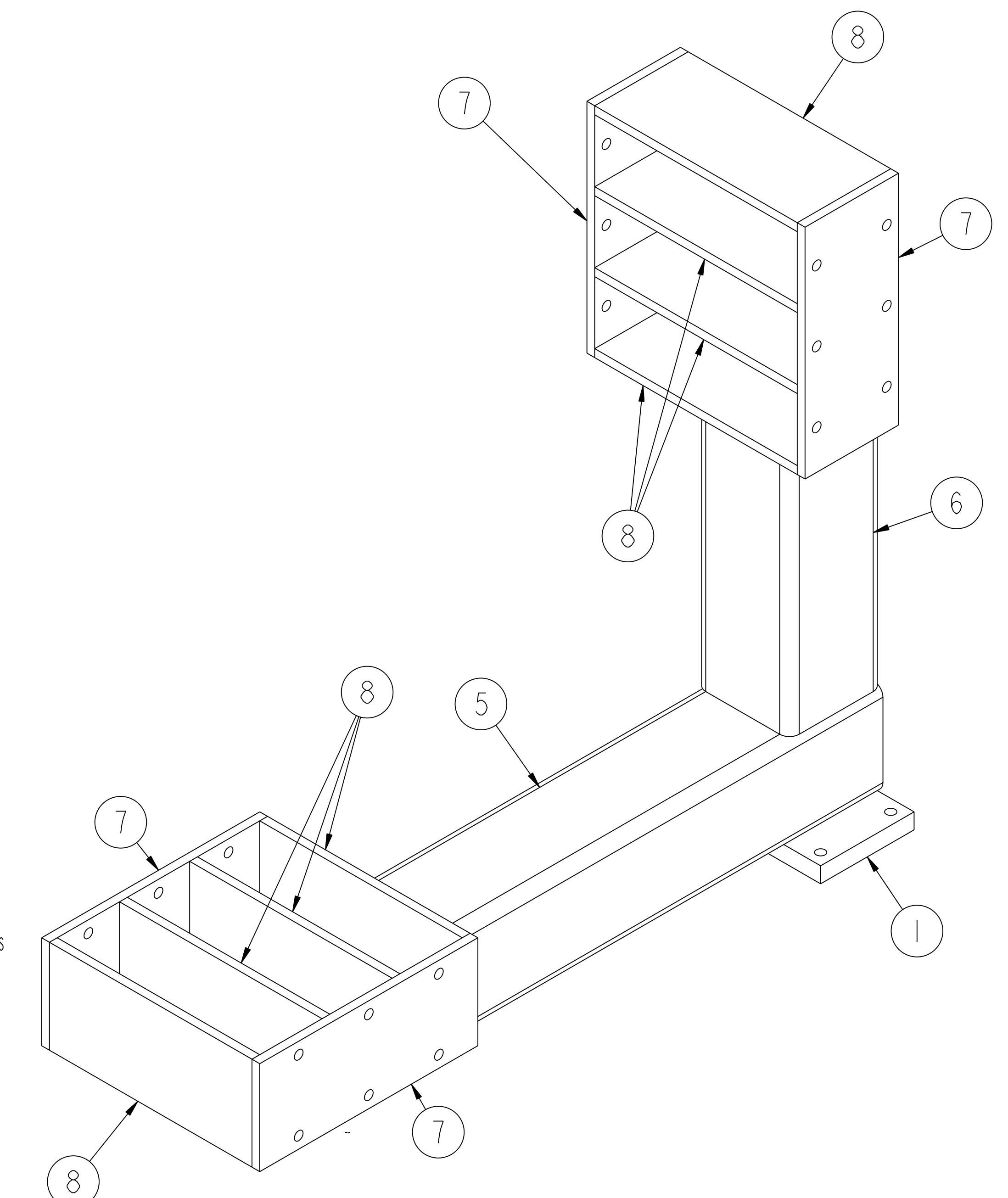
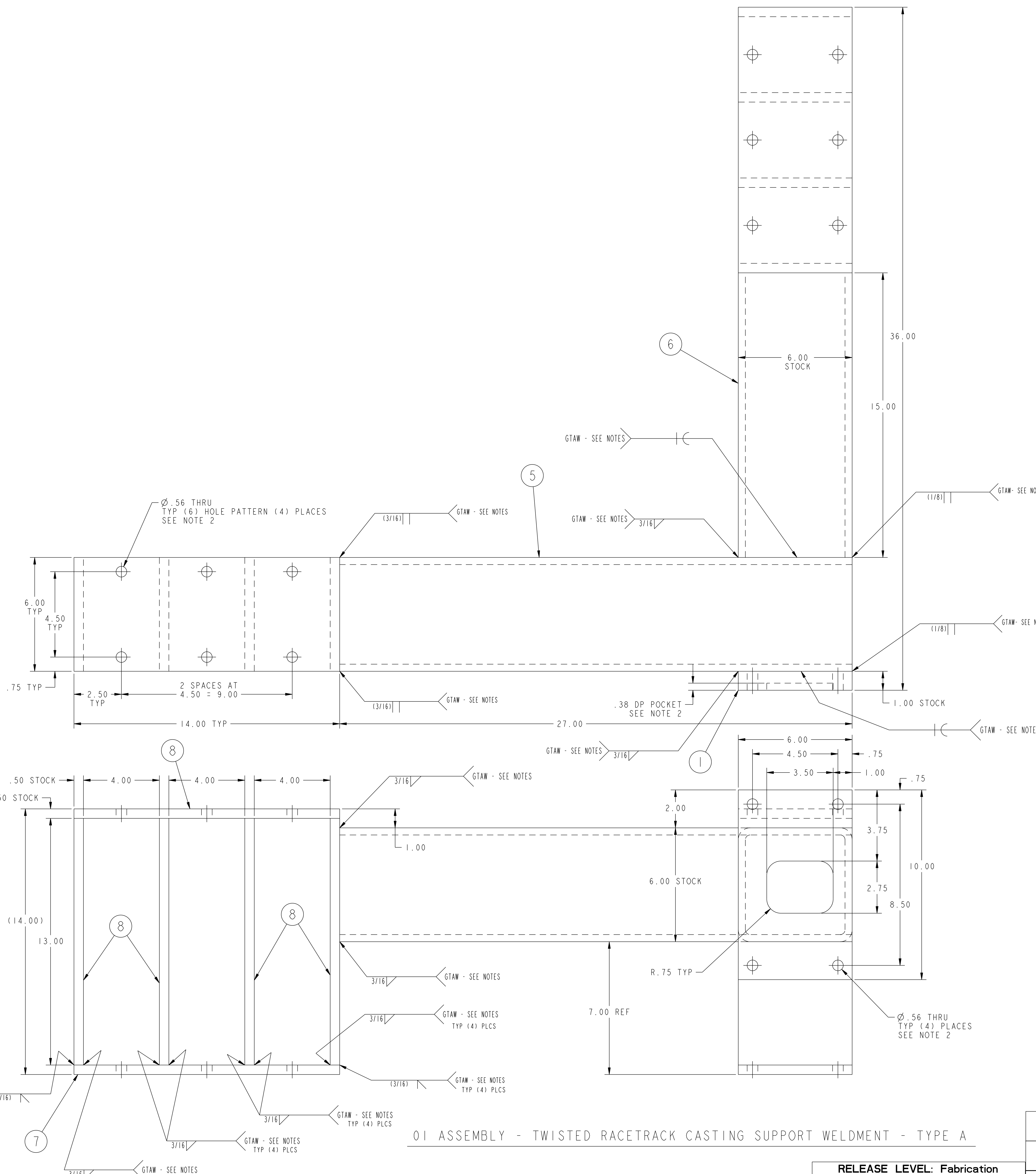


NO.	REVISION	BY	CH	SUP	APPROVED	DATE



- NOTES**
1. WELDING SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS AWS D1.1 SECTION 6 AND PPLP PROCEDURE EM-002. VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH THE ACCEPTANCE CRITERIA OF AWS D1.1 SECTION 6.
 2. ALL HOLES AND POCKET TO BE MACHINED AFTER ALL WELDING IS COMPLETE.

QTY	PART NO.	DRAWING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY REQD
8	8	8	THIS DWG	SUPPORT RIB	ASTM A569
4	4	4	THIS DWG	SUPPORT SIDE PLATE	ASTM A569
1	1	1	THIS DWG	SUPPORT TUBE - TYPE B (6" SO STRUCT TUBE X 3/8" WALL)	ASTM A36
1	1	1	THIS DWG	SUPPORT TUBE - TYPE A (6" SO STRUCT TUBE X 3/8" WALL)	ASTM A36
1	1	4	THIS DWG	SUPPORT ADAPTER PLATE - TYPE D	ASTM A569
1	1	3	THIS DWG	SUPPORT ADAPTER PLATE - TYPE C	ASTM A569
1	1	2	THIS DWG	SUPPORT ADAPTER PLATE - TYPE B	ASTM A569
1	1	1	THIS DWG	SUPPORT ADAPTER PLATE - TYPE A	ASTM A569
1	1	1	THIS DWG	TWISTED RACETRACK CASTING SUPPORT WELDMENT - TYPE D	
1	1	1	THIS DWG	TWISTED RACETRACK CASTING SUPPORT WELDMENT - TYPE C	
1	1	1	THIS DWG	TWISTED RACETRACK CASTING SUPPORT WELDMENT - TYPE B	
1	1	1	THIS DWG	TWISTED RACETRACK CASTING SUPPORT WELDMENT - TYPE A	

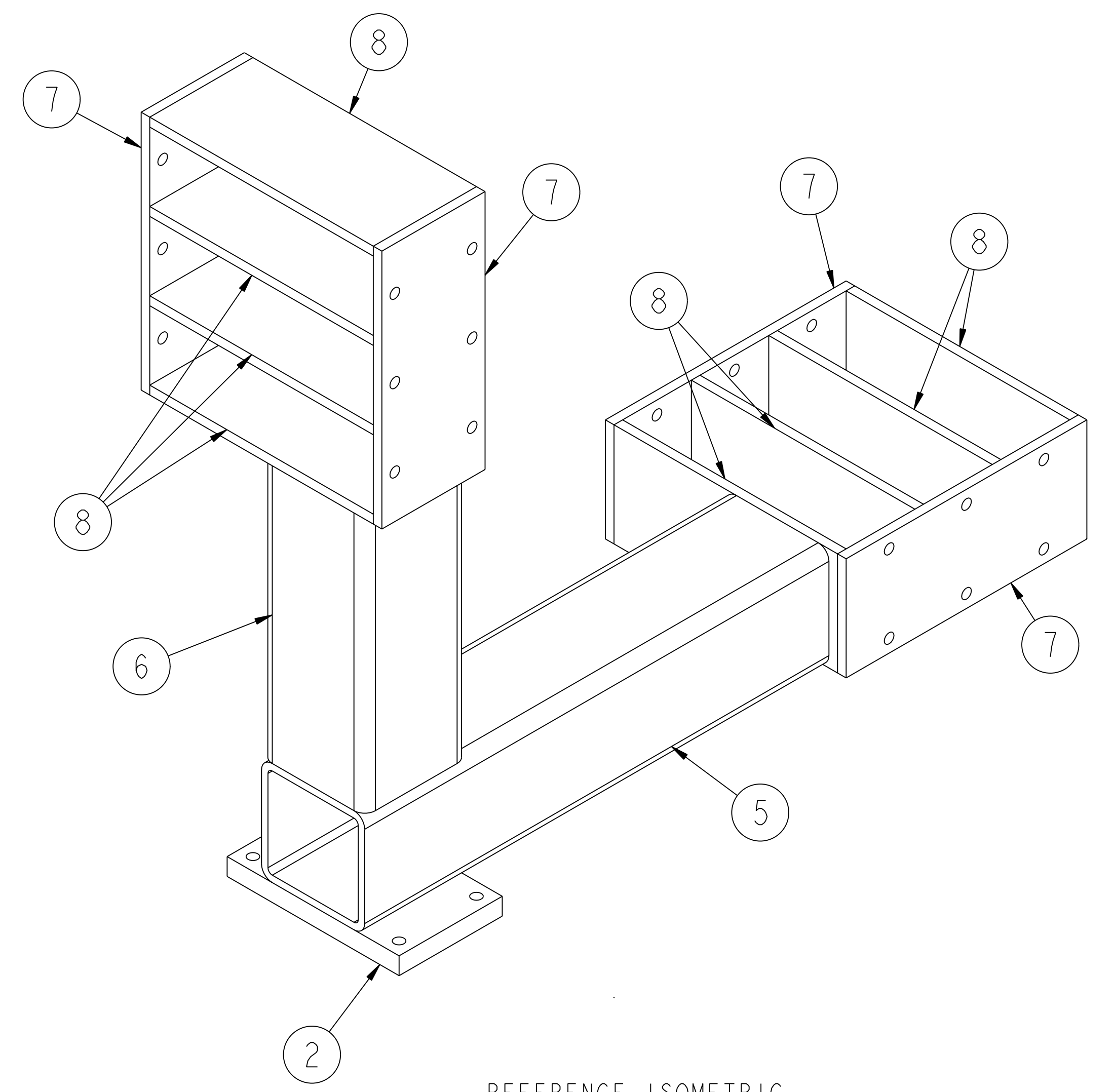
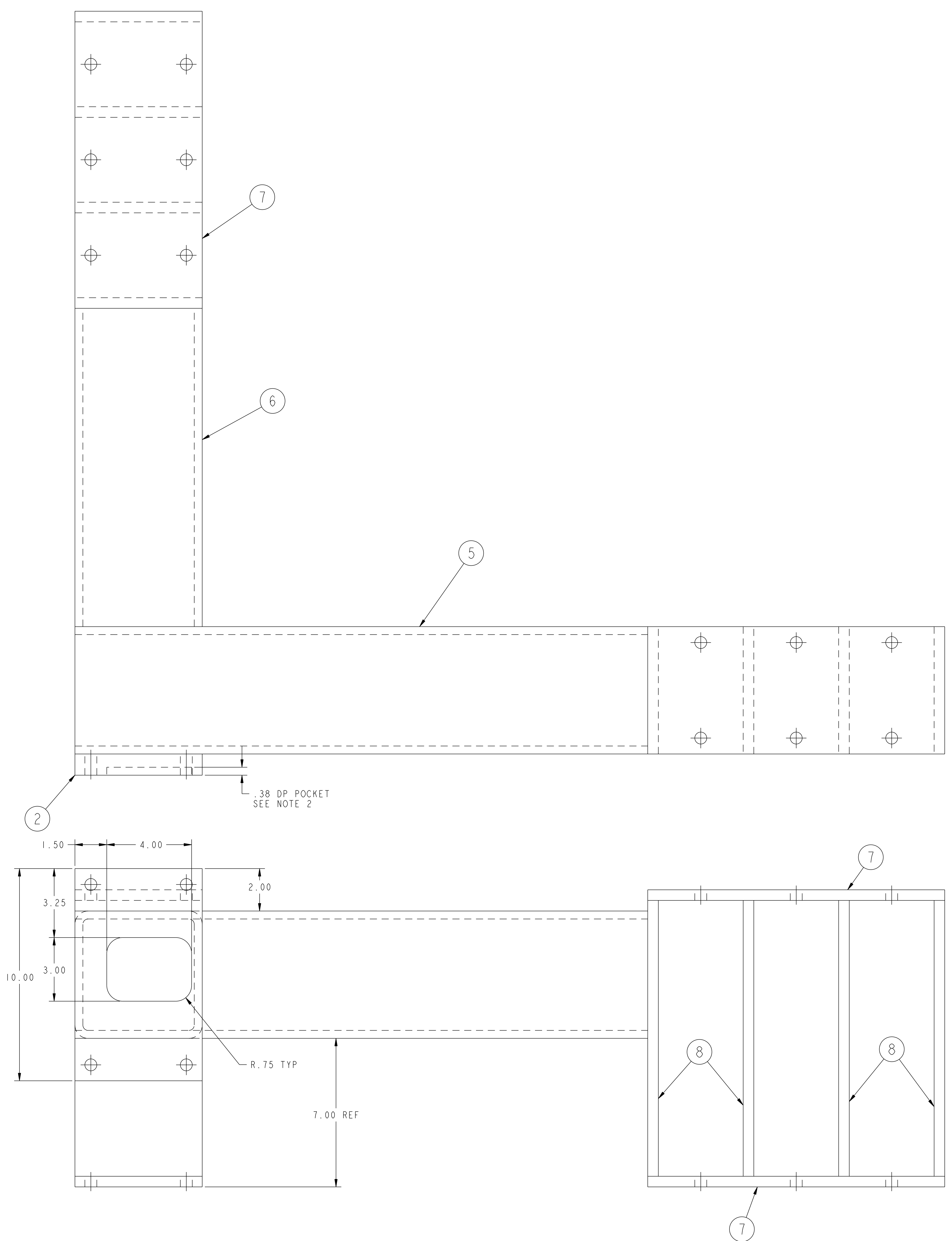
COMPUTER GENERATED DRAWING CHANGES NOT PERMITTED		CENTRAL FILES:		PRINCETON PLASMA PHYSICS LABORATORY	
WEIGHT	245.0 lbs	UNLESS OTHERWISE SPECIFIED	NATIONAL COMPACT STELLARATOR EXPERIMENT		
MODEL NAME	SE144-201	DIMENSIONS ARE IN INCHES	MODULAR COIL WINDING FACILITY		
WELDING ENGINEER		BREAK SHARP EDGES .005/.020	TWISTED RACETRACK WINDING		
		TOLERANCES NON-CUMULATIVE	DSN: L. MORRIS	DRAWING NO:	
		DECIMAL-INCH FRACTIONS	CHK: S. RAFTOPOULOS	SE144-201	
			ENGR: J. CHRZANOWSKI	SHEET 1 OF 4	
			SUPV: J. SIEGEL	REV 0	

01 ASSEMBLY - TWISTED RACETRACK CASTING SUPPORT WELDMENT - TYPE A

RELEASE LEVEL: Fabrication
DWG VERSION NO:

NCSX-SE144-201

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



REFERENCE ISOMETRIC

NOTE:

THIS WELDMENT IS IDENTICAL TO WELDMENT - TYPE A SHOWN ON SHEET 1 EXCEPT AS INDICATED HEREON.

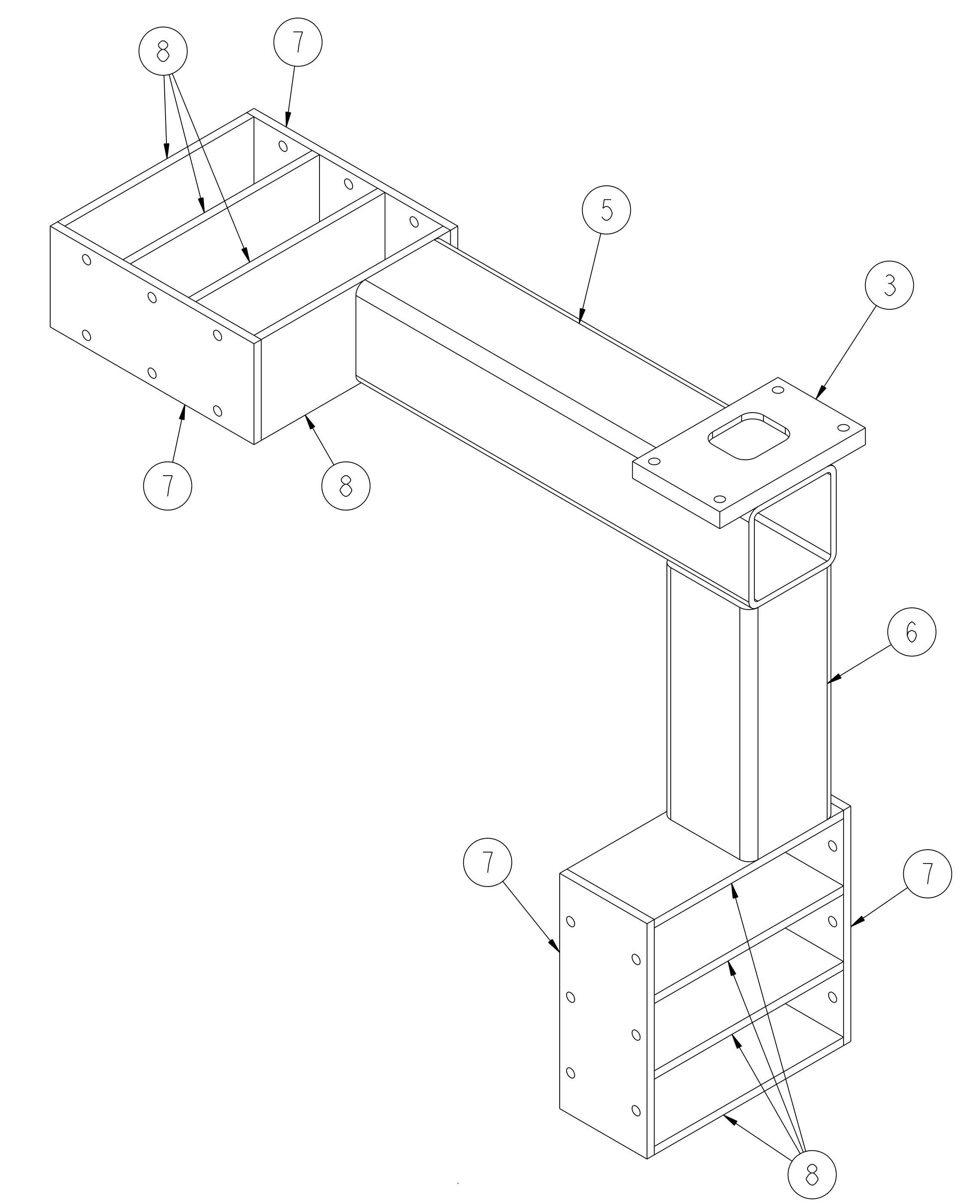
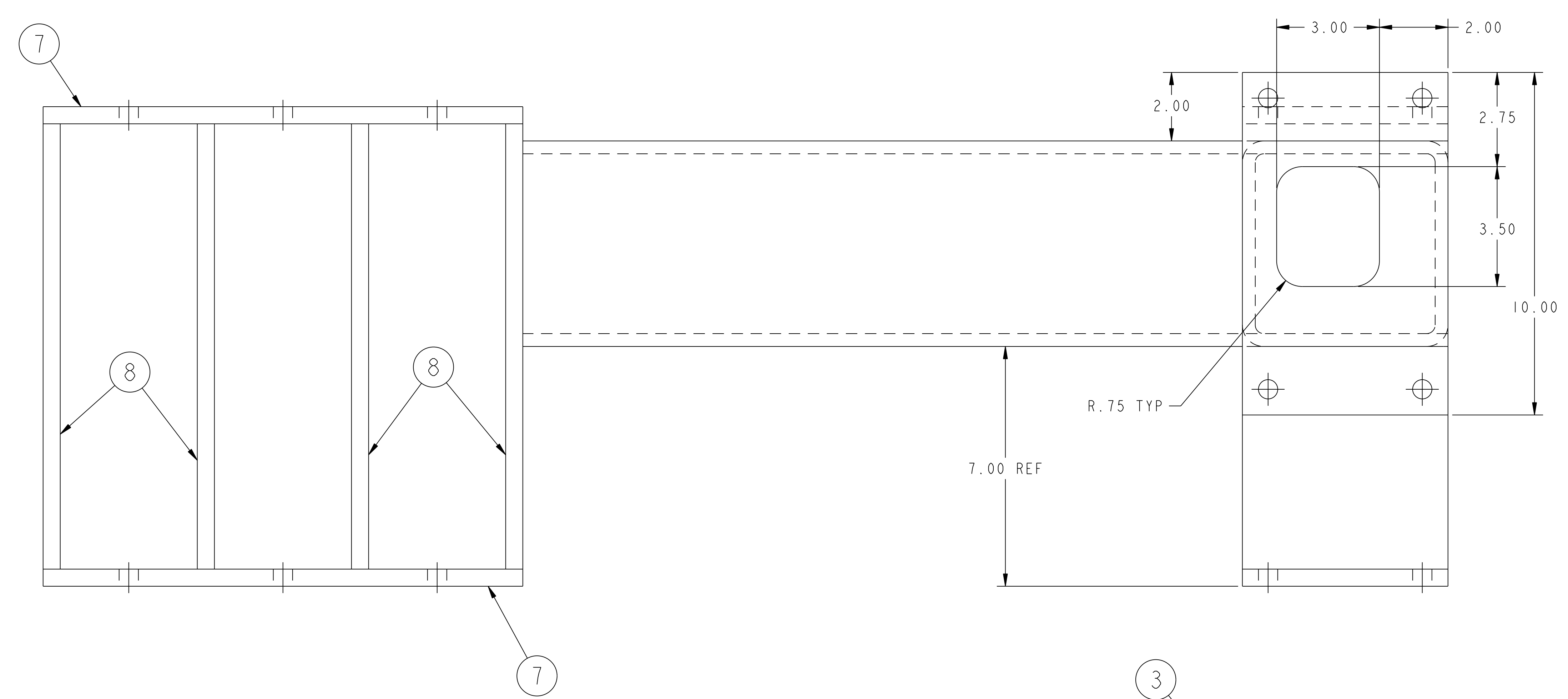
02 ASSEMBLY - TWISTED RACETRACK CASTING SUPPORT WELDMENT - TYPE B

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

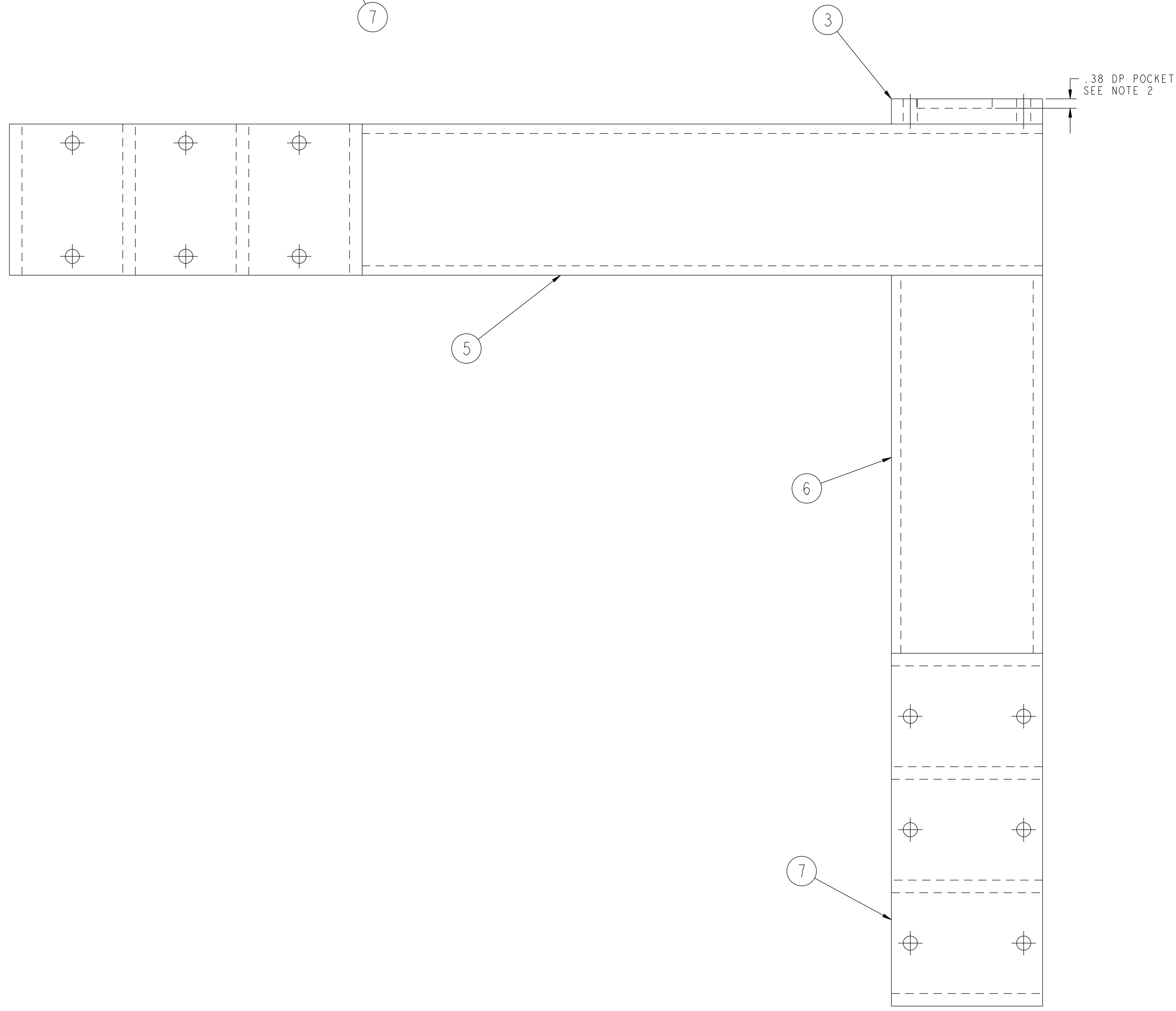
RELEASE LEVEL: Fabrication
DWG VERSION NO: 1

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES:	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY	
	UNLESS OTHERWISE SPECIFIED	NATIONAL COMPACT STELLARATOR EXPERIMENT	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	DIMENSIONS ARE IN INCHES MACHINE SURFACES	MODULAR COIL WINDING FACILITY TWISTED RACETRACK WINDING	
NEXT ASSEMBLY	BREAK SHARP EDGES .005/.020	TWISTED RACETRACK CASTING SUPPORT WELDMENTS	
WEIGHT 245.0 lbs	TOLERANCES NON-CUMULATIVE	DSN: L. MORRIS	DRAWING NO:
	DECIMAL - INCH FRACTIONS	CHK: S. RAFTOPOULOS	SE144-201
MODEL NAME SE144-201	.X +/- .100 0°-120° +/- .100 .XX +/- .030 120°-120° +/- .100 .XXX +/- .005 120°-120° +/- .100 ANGULAR +/- 0°-15° OVER 120° +/- .100	ENGR: J. CHRZANOWSKI	SHEET 2 OF 4
WELDING ENGINEER		SUPV: J. SIEGEL	REV 0

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



REFERENCE ISOMETRIC



NOTE :
THIS WELDMENT IS IDENTICAL TO WELDMENT - TYPE A SHOWN ON SHEET 1 EXCEPT AS INDICATED HEREON.

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

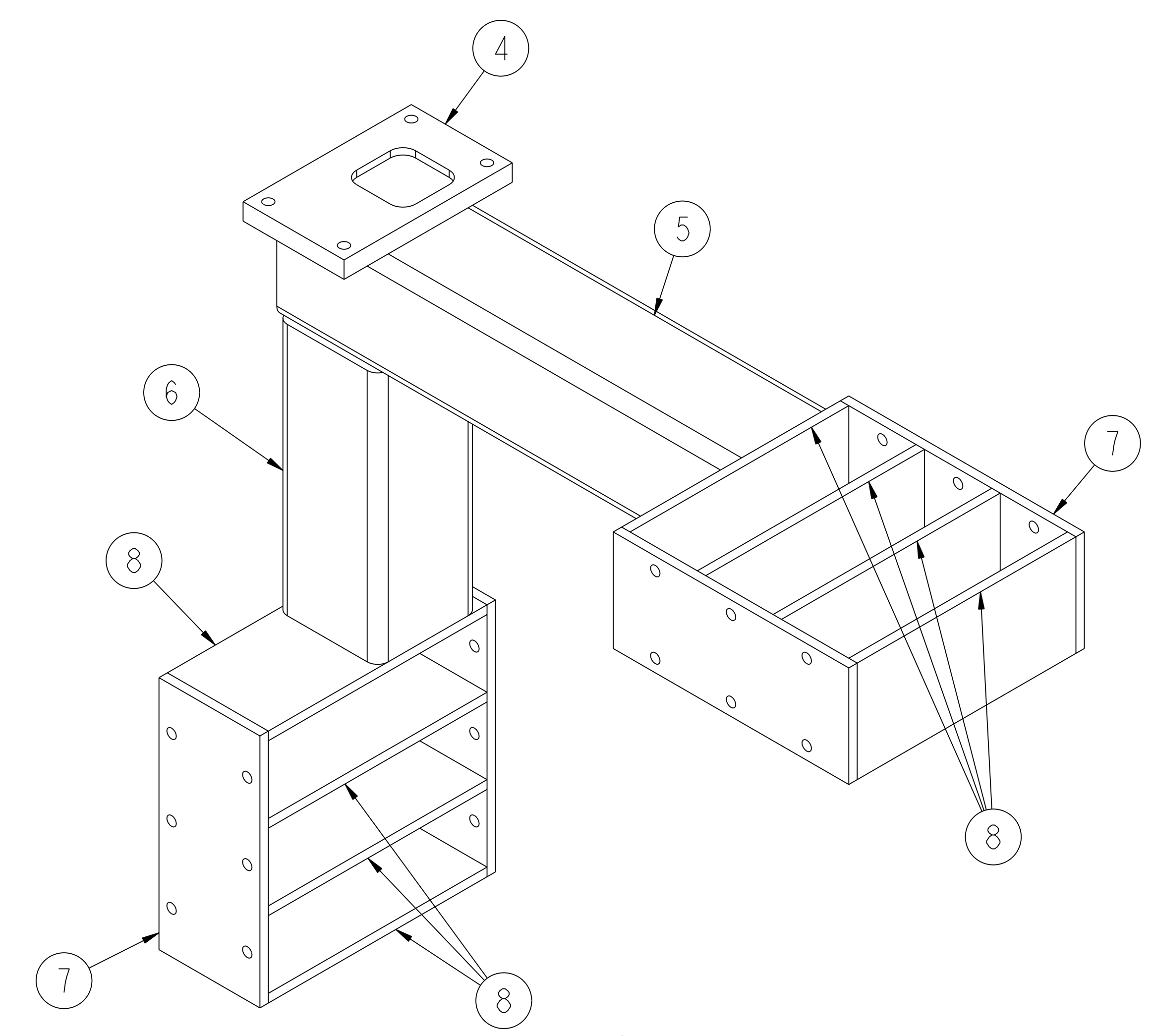
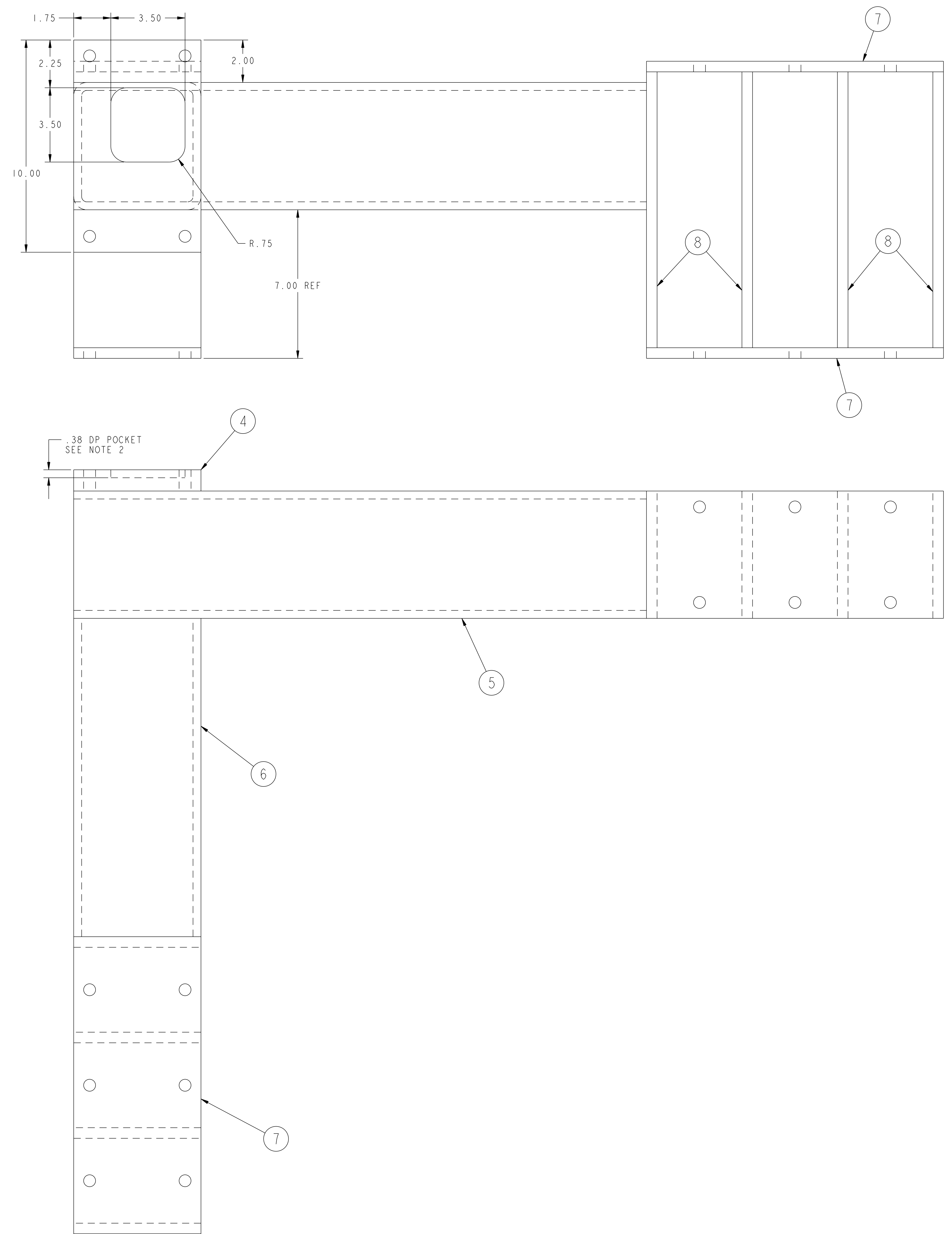
03 ASSEMBLY - TWISTED RACETRACK CASTING SUPPORT WELDMENT - TYPE C

RELEASE LEVEL: Fabrication
DWG VERSION NO: 1

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES:	PRINCETON PLASMA PHYSICS LABORATORY NATIONAL COMPACT STELLARATOR EXPERIMENT	
	UNLESS OTHERWISE SPECIFIED	DIMENSIONS ARE IN INCHES MACHINE SURFACES	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	BREAK SHARP EDGES .005/.020	TOLERANCES NON-CUMULATIVE	DSN: L. MORRIS
NEXT ASSEMBLY	DECIMAL-INCH FRACTIONS	CHK: S. RAFTOPOULOS	DRAWING NO:
	.X +/- .100 0°-12° +/- .125	ENGR: J. CHRZANOWSKI	SE144-201
	.XX +/- .030 12°-12° +/- .125	SUPV: J. SIEGEL	SHEET 3 OF 4
	.XXX +/- .005 12°-120° +/- .125		REV 0
	ANGULAR +/- .0°-15° OVER 120° +/- .125		

NCSX-SE144-201

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



REFERENCE ISOMETRIC

NOTE:
THIS WELDMENT IS IDENTICAL TO WELDMENT - TYPE A SHOWN ON SHEET 1 EXCEPT AS INDICATED HEREON.

04 ASSEMBLY - TWISTED RACETRACK CASTING SUPPORT WELDMENT - TYPE D

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

RELEASE LEVEL: Fabrication
DWG VERSION NO: 1

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES:	PRINCETON PLASMA PHYSICS LABORATORY NATIONAL COMPACT STELLARATOR EXPERIMENT	
	UNLESS OTHERWISE SPECIFIED	MODULAR COIL WINDING FACILITY TWISTED RACETRACK WINDING TWISTED RACETRACK CASTING SUPPORT WELDMENTS	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	DIMENSIONS ARE IN INCHES MACHINE SURFACES	BREAK SHARP EDGES .005/.020	DSN: L. MORRIS
NEXT ASSEMBLY	TOLERANCES NON-CUMULATIVE	DECIMAL-INCH FRACTIONS	CHK: S. RAFTOPOULOS
WEIGHT 244.9 lbs	.XX +/- .030 .XXX +/- .005 ANGULAR +/- .0°-15°	0°-12° +/- .124 12°-12° +/- .118 12°-120° +/- .114 OVER 120° +/- .112	ENGR: J. CHRZANOWSKI
MODEL NAME SE144-201	WELDING ENGINEER		SUPV: J. SIEGEL
			DRAWING NO: SE144-201
			SHEET 4 OF 4
			REV 0