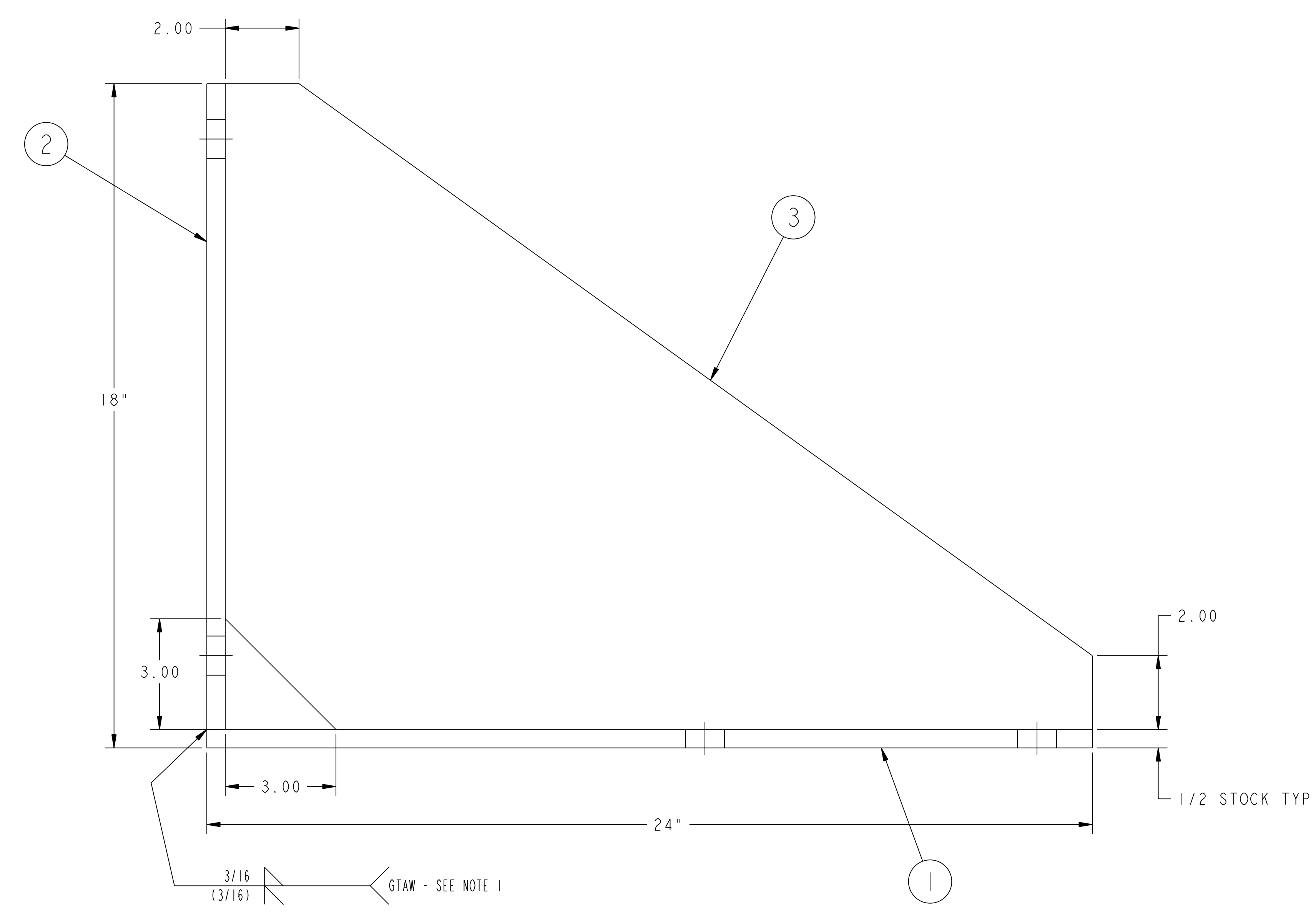
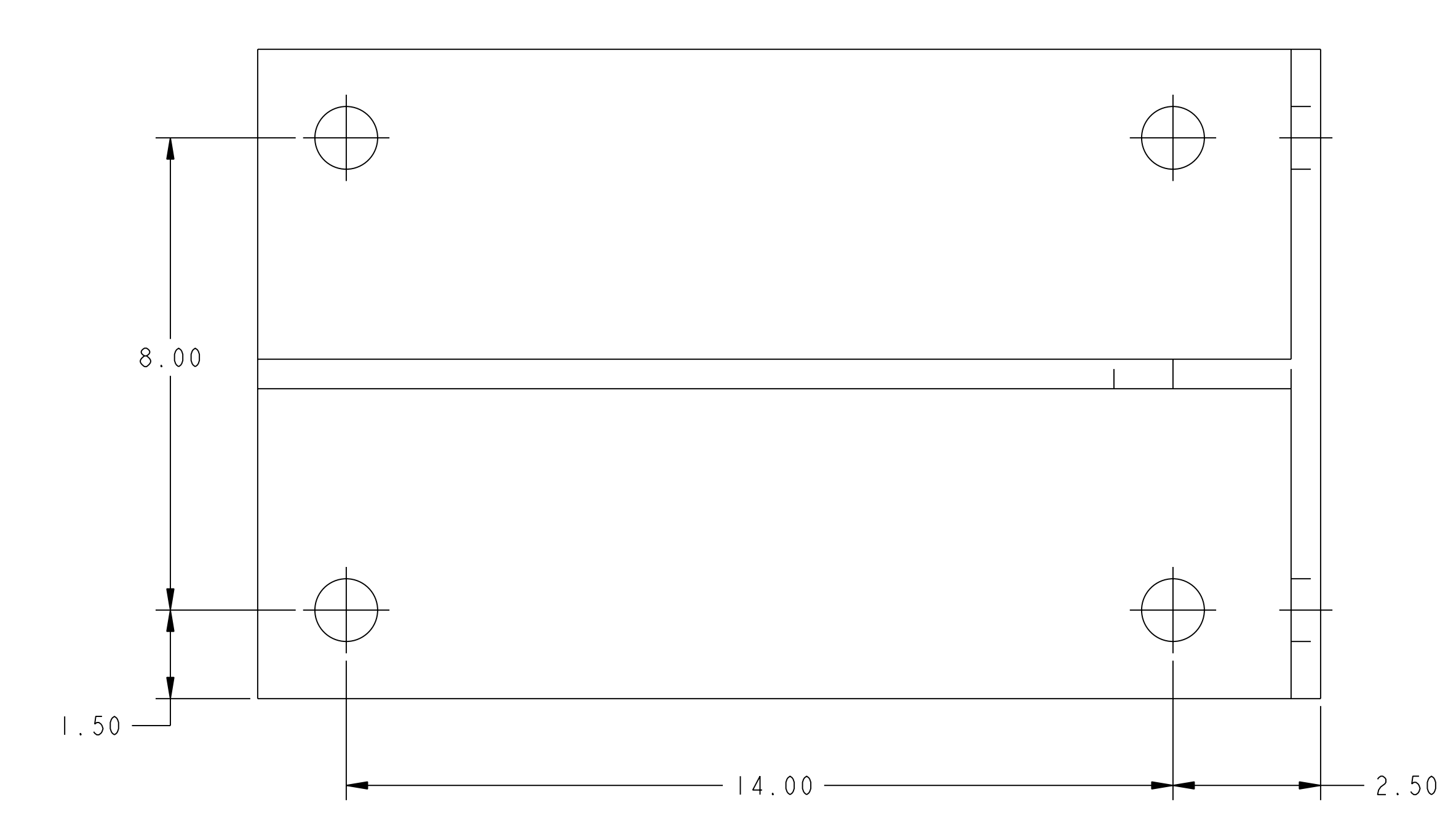
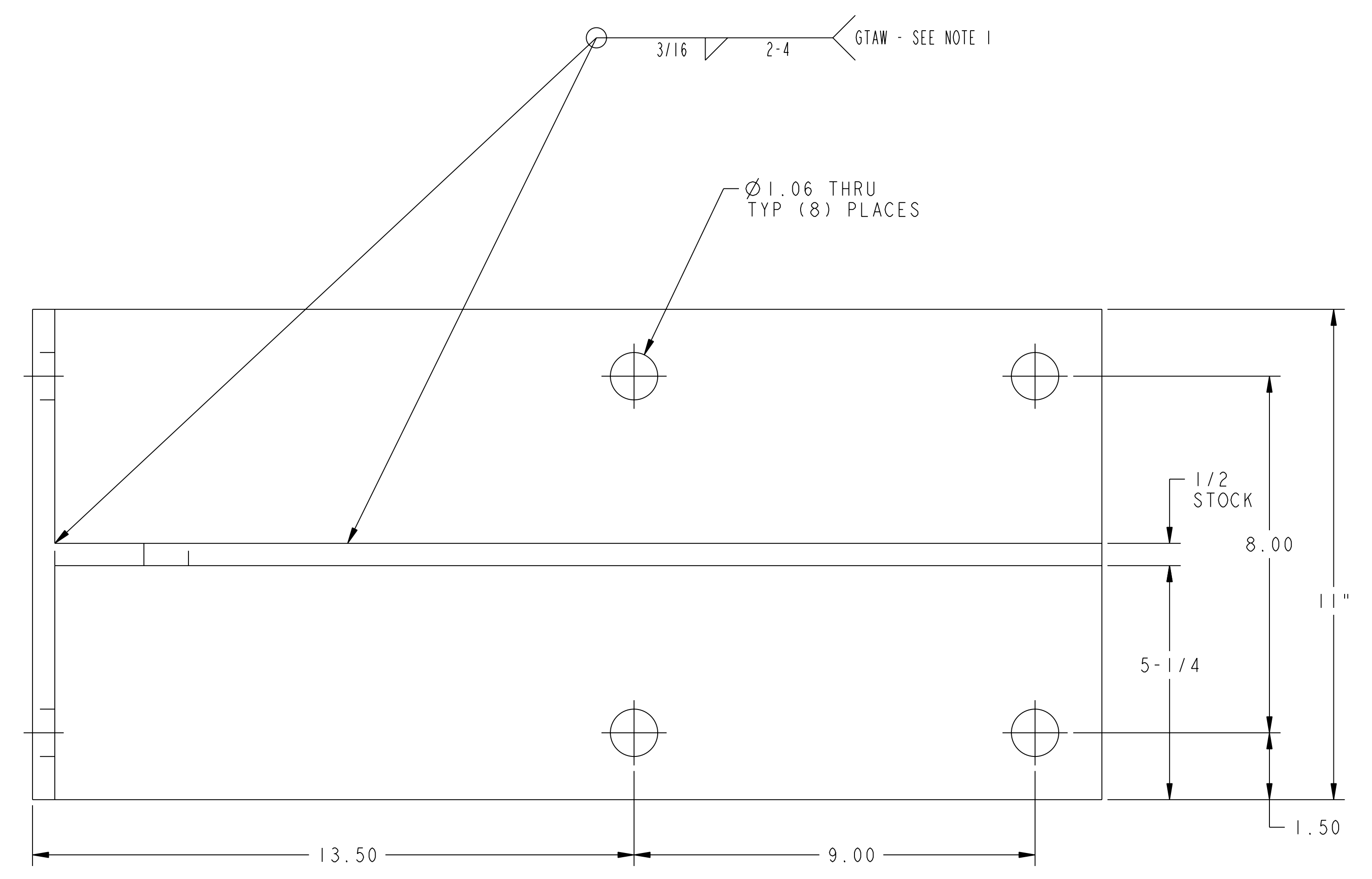


NO.	REVISION	BY	CH	SUP	APPROVED	DATE



01 ASSEMBLY
(1) REQ'D

NOTES

1. WELDING SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF AWS D1.1 OR PPPL PROCEDURE ENG-037. VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH THE ACCEPTANCE CRITERIA OF AWS D1.1 Section 6.
2. ALL HOLES TO BE MACHINED AFTER ALL WELDS ARE COMPLETE.

RFD-18-001 permitted either GTAW or GMAW welds. See RFD-18-001 for details)

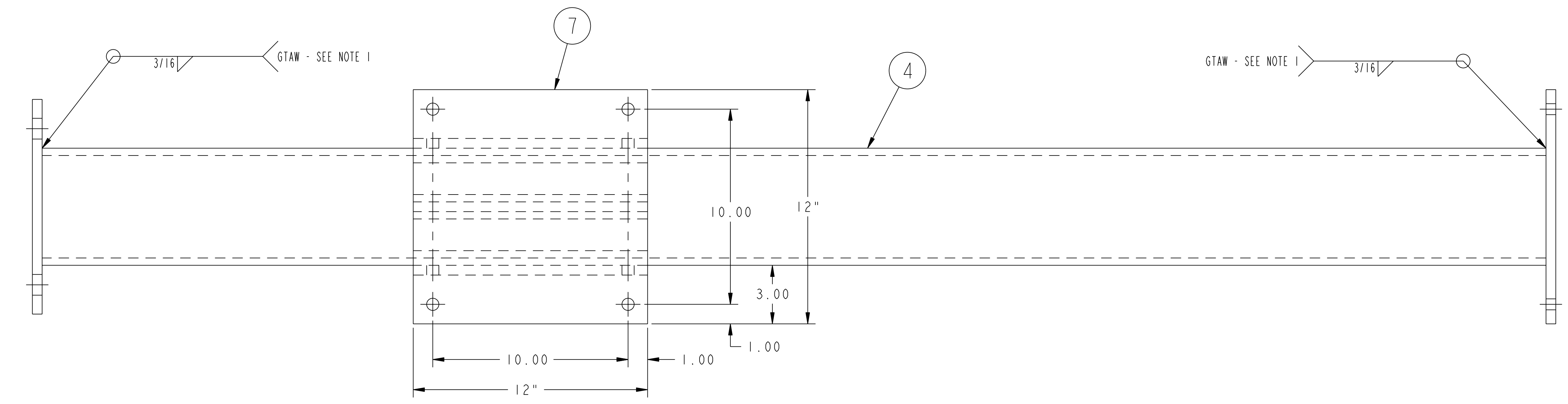
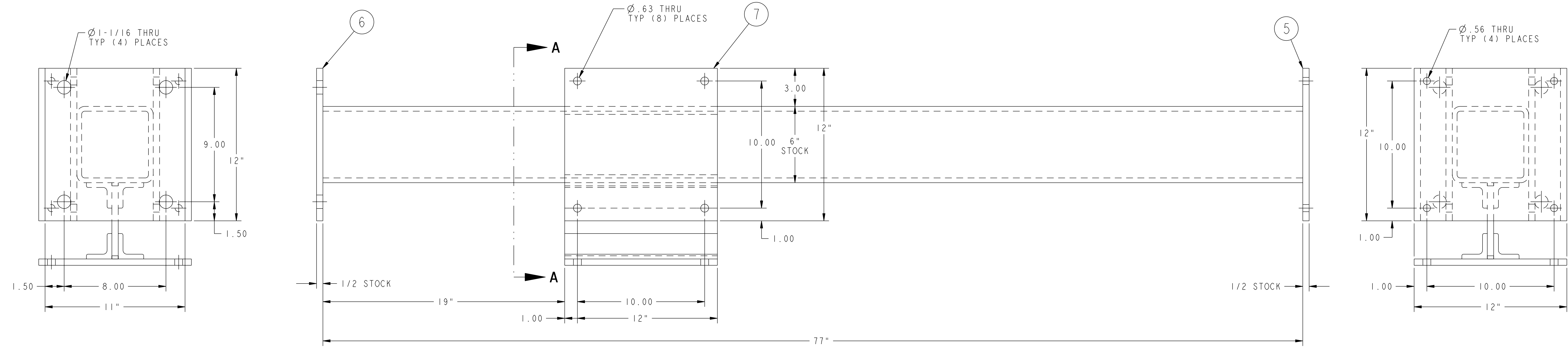
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PPPL Drafting

QTY	ASSY	PART NO.	DRAWING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY RECD
1		12	THIS DWG	OUTRIGGER TIE PLATE	ASTM A36	
1		11	THIS DWG	FOOT PLATE	ASTM A36	
1		10	THIS DWG	OUTRIGGER TUBE - 6" x 6" x 3/8 STRUCT TUBE	ASTM A36	
4		9	THIS DWG	MOUNTING CLIP ANGLE - 2 x 2 x 3/8 STRUCT ANGLE	ASTM A36	
1		8	THIS DWG	SANDWICH PLATE	ASTM A36	
2		7	THIS DWG	TIE PLATE	ASTM A36	
1		6	THIS DWG	TOP PLATE	ASTM A36	
1		5	THIS DWG	BASE PLATE	ASTM A36	
1		4	THIS DWG	VERTICAL TUBE - 6" x 6" x 3/8 STRUCT TUBE	ASTM A36	
	1	3	THIS DWG	GUSSET	ASTM A36	
	1	2	THIS DWG	VERTICAL PLATE	ASTM A36	
	1	1	THIS DWG	BASE PLATE	ASTM A36	
			THIS DWG	OUTRIGGER WELDMENT		3
			THIS DWG	VERTICAL SUPPORT WELDMENT		1
			THIS DWG	SUPPORT BRACKET WELDMENT		1

WEIGHT 100.0 lbs	COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY	
	DO NOT VERIFY INFORMATION BY SCALING DRAWING	DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	NATIONAL COMPACT STELLARATOR EXPERIMENT	
MODEL NAME SE184-056-01	NEXT ASSEMBLY	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX +/- .010 0"-12" +/- .010 .XXX +/- .005 12"-120" +/- .010 ANGULAR +/- .0°-15° OVER 120° +/- .1°	DSN: L. MORRIS 8-2-2007 CHK: M. COLE 8-2-2007 ENGR: T. BROWN 8-2-2007 SUPV: J. SIEGEL 8-2-2007	DRAWING NO: SE184-056
RELEASE LEVEL: Fabrication DWG VERSION NO: 3	WELDING ENGINEER G. GETTELFINGER 8-2-2007			SHEET 1 OF 3 REV 0

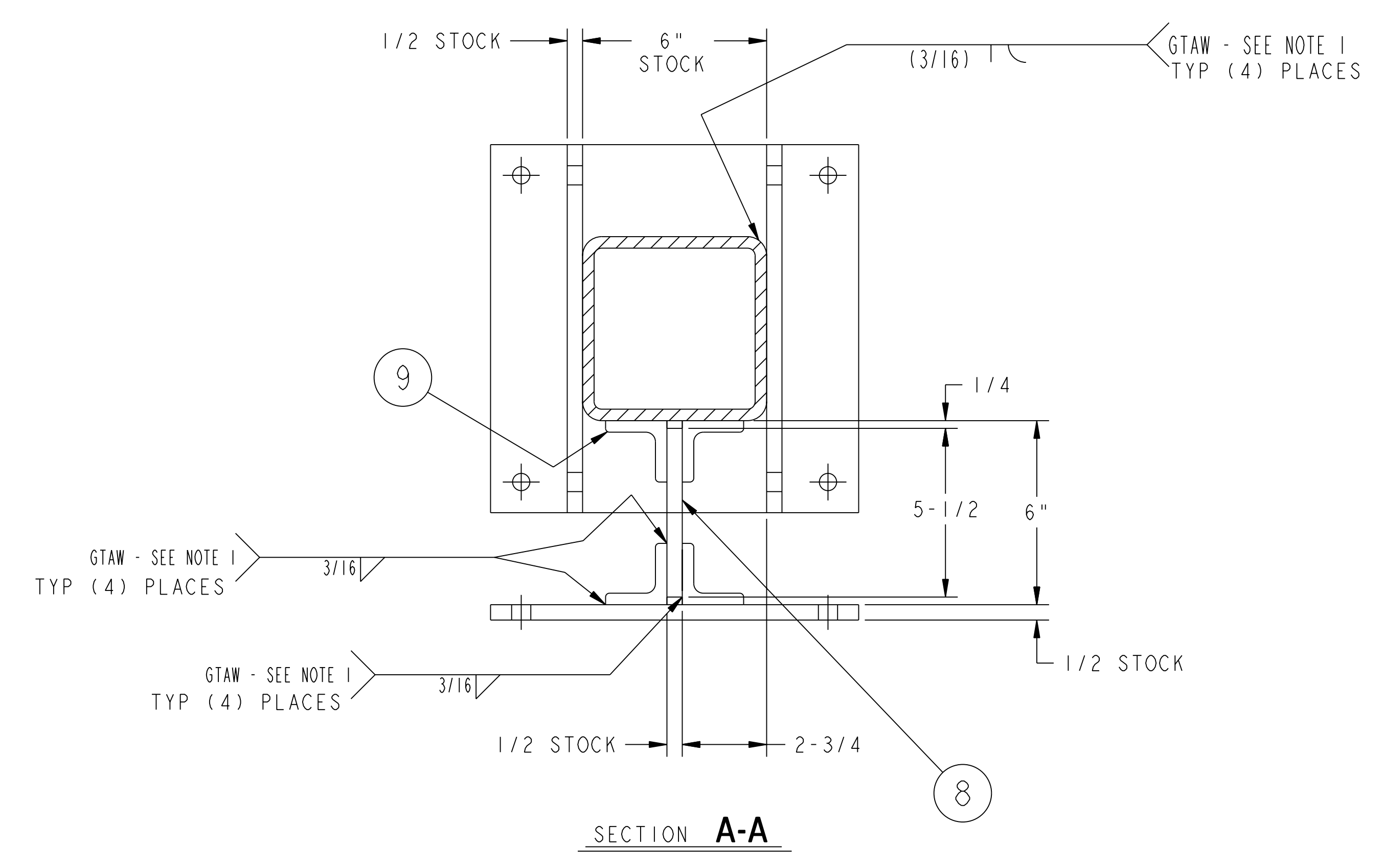
NCSX-SE184-056

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



02 ASSEMBLY

(1) REQ'D



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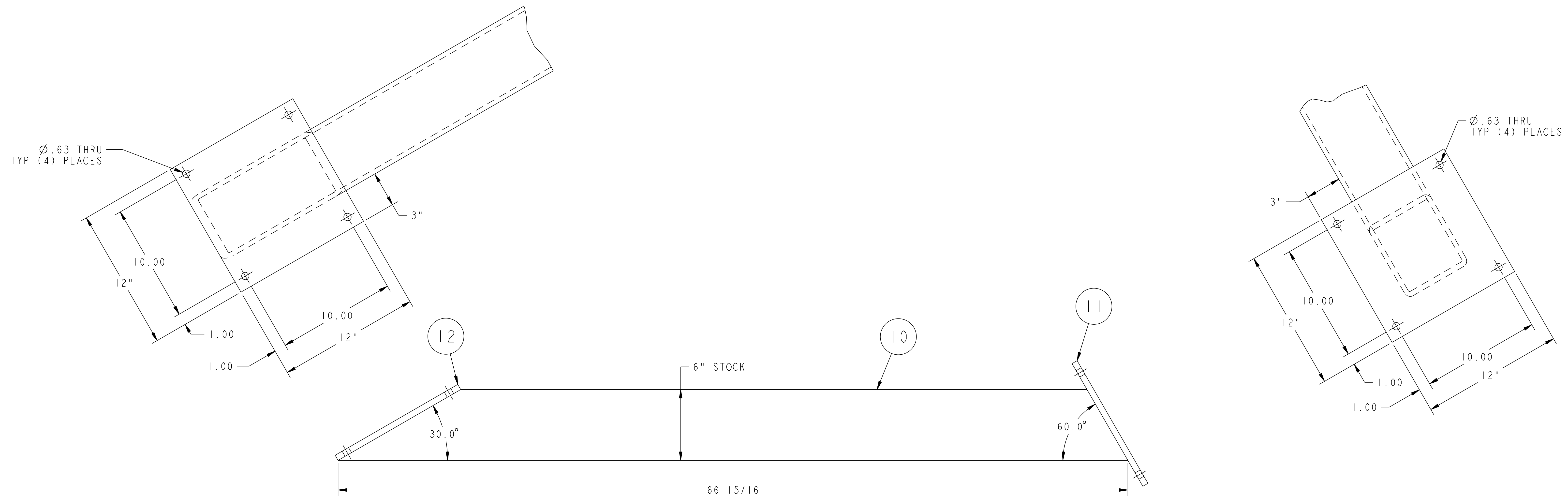
FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

COMPUTER GENERATED DRAWING CHANGES NOT PERMITTED Pro E DO NOT VERIFY INFORMATION BY SCALING DRAWING	CENTRAL FILES:	PRINCETON PLASMA PHYSICS LABORATORY	
	UNLESS OTHERWISE SPECIFIED	NATIONAL COMPACT STELLARATOR EXPERIMENT	
DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	TOLERANCES NON-CUMULATIVE	DSN: L. MORRIS	8-2-2007 DRAWING NO:
DECIMAL - INCH FRACTIONS .XX ±.000 0°-120° ±.010 .XXX ±.005 120°-120° ±.010 ANGULAR ±.0°-15° OVER 120° ±.125	NEXT ASSEMBLY WELDING ENGINEER G. GETTELFINGER 8-2-2007	CHK: M. COLE ENGR: T. BROWN SUPV: J. SIEGEL	FIELD PERIOD ASSEMBLY VACUUM VESSEL SUPPORT ASSEMBLY VERTICAL SUPPORT WELDMENTS 8-2-2007 SE184-056 8-2-2007 SHEET 2 OF 3 REV D, 2

RELEASE LEVEL: Fabrication
 DWG VERSION NO: 3

NCSX-SE184-056

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



03 ASSEMBLY
(3) REQ'D

RELEASED FOR FABRICATION / INSTALLATION
PPPL Drafting

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES:	PRINCETON PLASMA PHYSICS LABORATORY NATIONAL COMPACT STELLARATOR EXPERIMENT	
	UNLESS OTHERWISE SPECIFIED	FIELD PERIOD ASSEMBLY	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	VACUUM VESSEL SUPPORT ASSEMBLY VERTICAL SUPPORT WELDMENTS	
NEXT ASSEMBLY	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .X ±.000 0°-120° ±.010 .XX ±.030 120°-120° ±.010 .XXX ±.005 120°-120° ±.010 ANGULAR ±.0°-15° OVER 120° ±.1°	DSN: L. MORRIS 8-2-2007	DRAWING NO: SE184-056
WEIGHT 312.3 lbs	MODEL NAME SE184-056-02	CHK: M. COLE 8-2-2007	ENGR: T. BROWN 8-2-2007
WELDING ENGINEER G. GETTELFINGER 8-2-2007	RELEASE LEVEL: Fabrication DWG VERSION NO: 6	SUPV: J. SIEGEL 8-2-2007	SHEET 3 OF 3 REV D, 2

NCSX-SE184-056