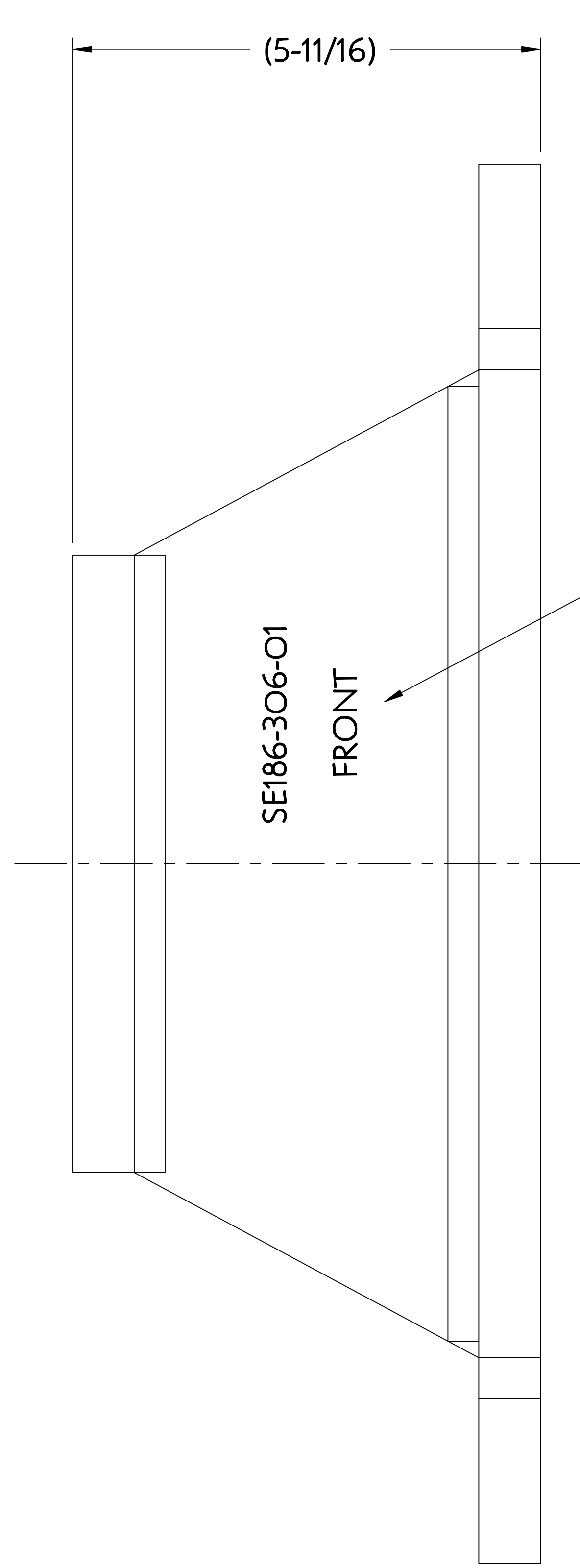
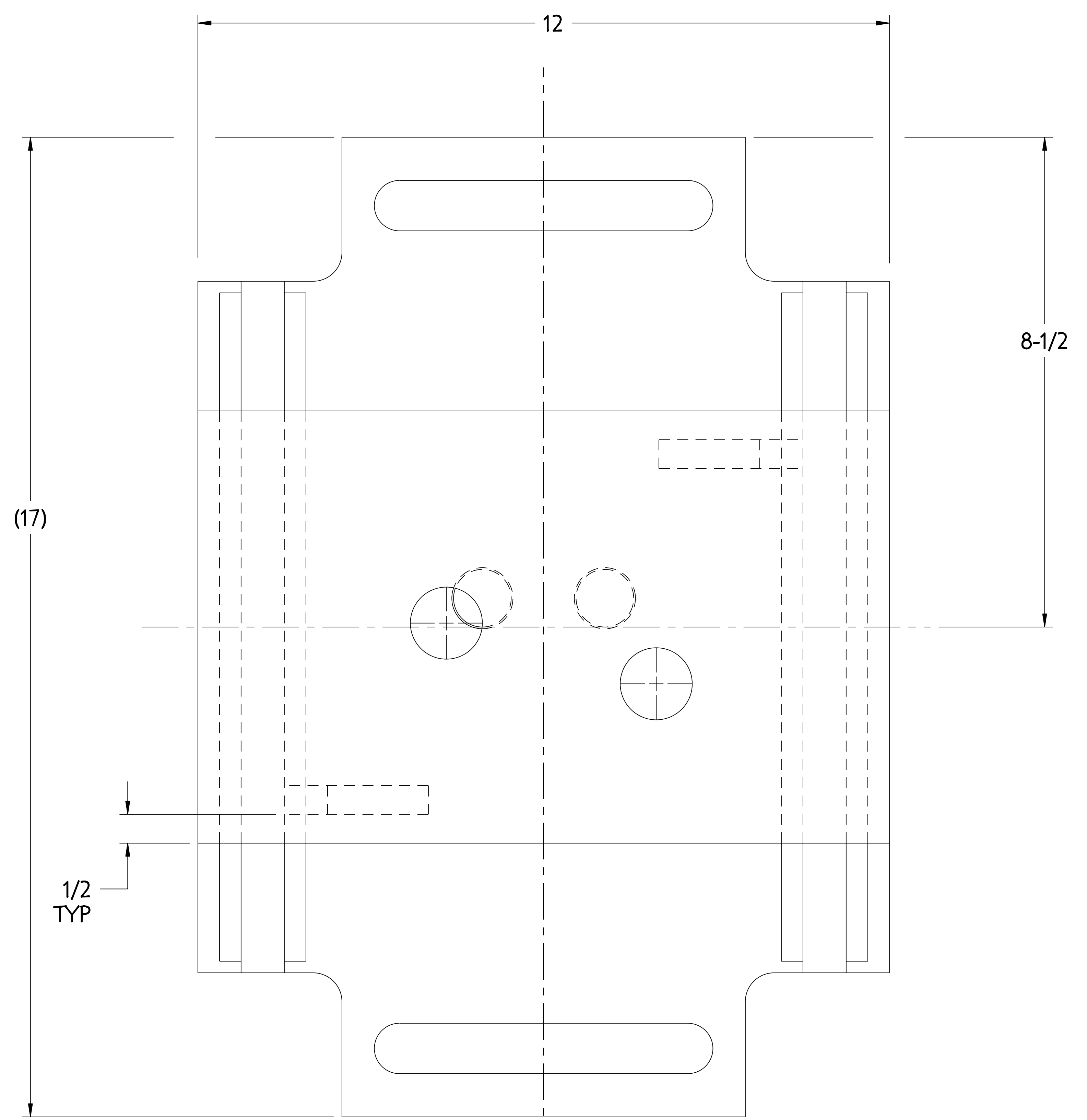
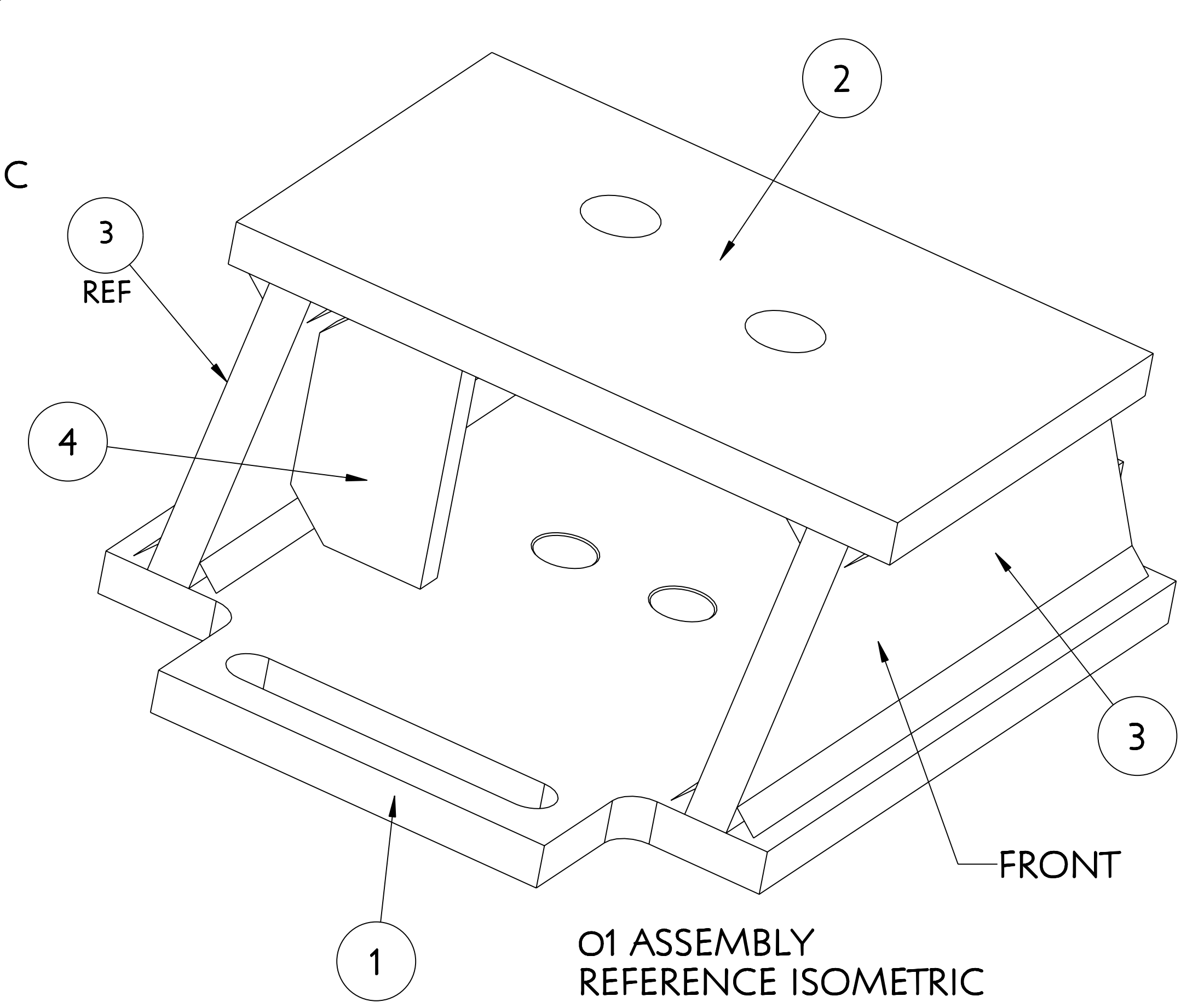
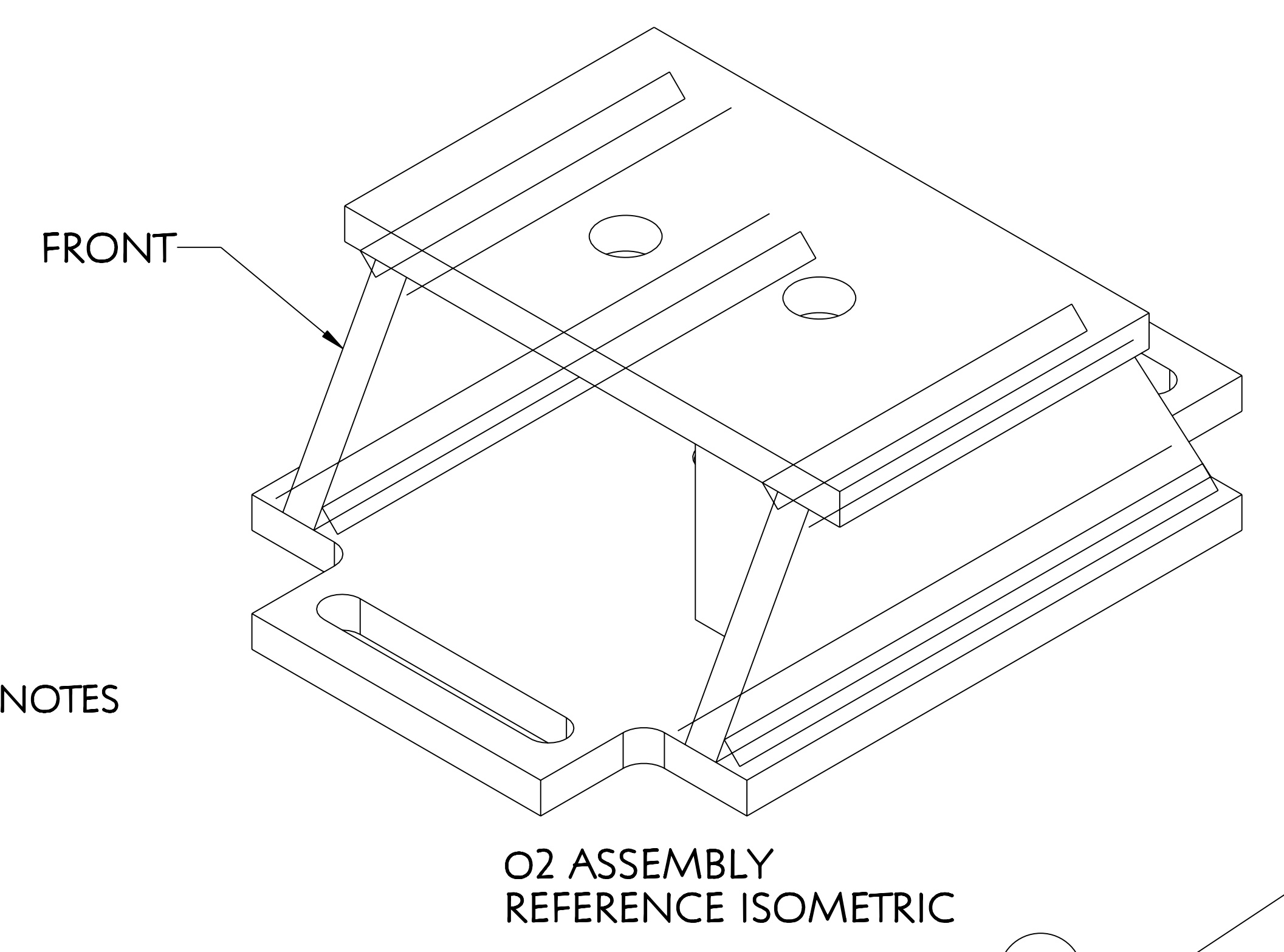
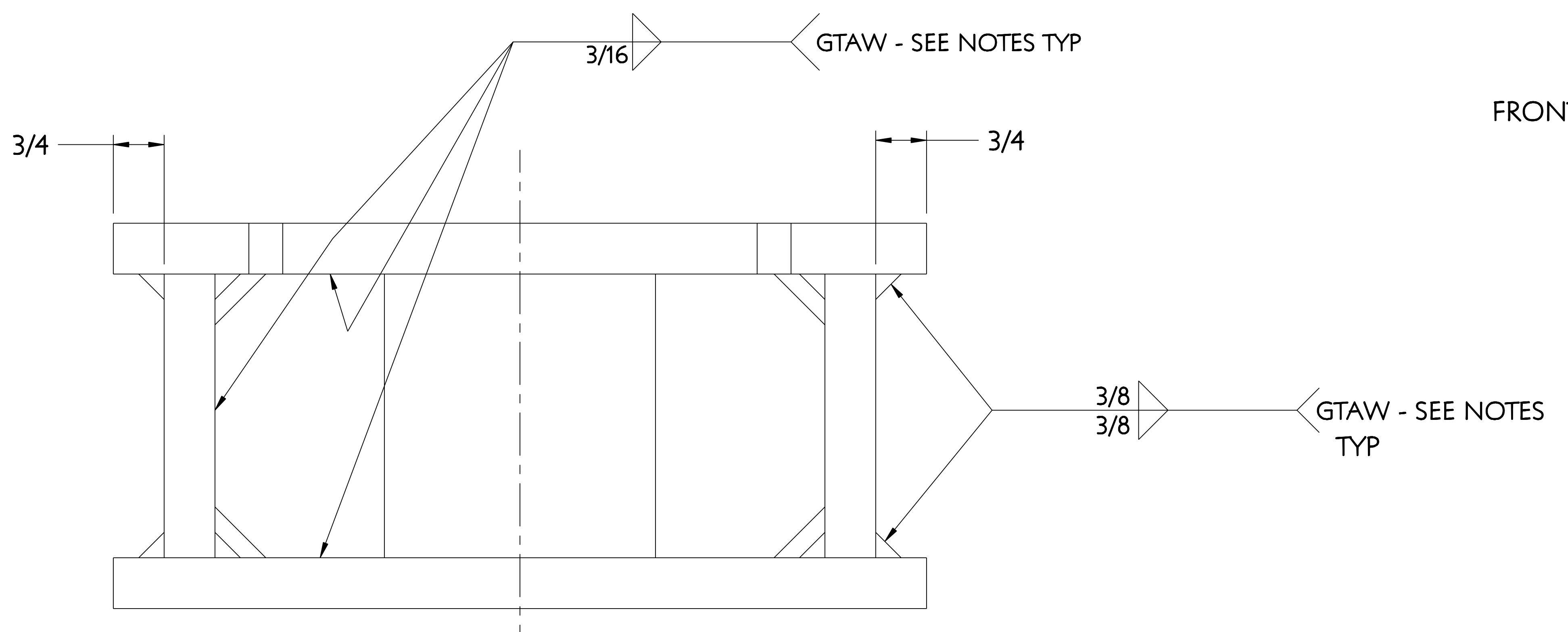


NO.	REVISION	BY	CH	SUP	APPROVED	DATE



IDENTIFIER FOR O1 ASSEMBLY AS SHOWN.  
IDENTIFIER FOR O2 ASSEMBLY TO BE ON OPPOSITE SIDE.  
SEE NOTES.

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

**NOTE**  
WELDING SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF AWS D1.1 OR PPPL PROCEDURE NO. ENG-37.  
VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH THE ACCEPTANCE CRITERIA OF AWS D1.1 Section 6.  
NOTE ORIENTATION OF ALL PARTS PRIOR TO WELDING.  
BRACKET ASSEMBLY IS TO BE STAMPED OR PERMANENTLY MARKED WITH IDENTIFIER AS INDICATED.  
SAND BLAST AND APPLY 2 COATS "SAFETY YELLOW" PAINT.

O1 ASSEMBLY - AS SHOWN - (1) REQ'D  
O2 ASSEMBLY - OPPOSITE - (1) REQ'D

**RELEASED FOR FABRICATION / INSTALLATION**  
PPPL Drafting:

RELEASE LEVEL: FABRICATION  
DWG VERSION NO: 6

WEIGHT	76.1 lbs
MODEL NAME	SE186-306-01
WELDING ENGINEER	G. GETTELFINGER 8-2-2007

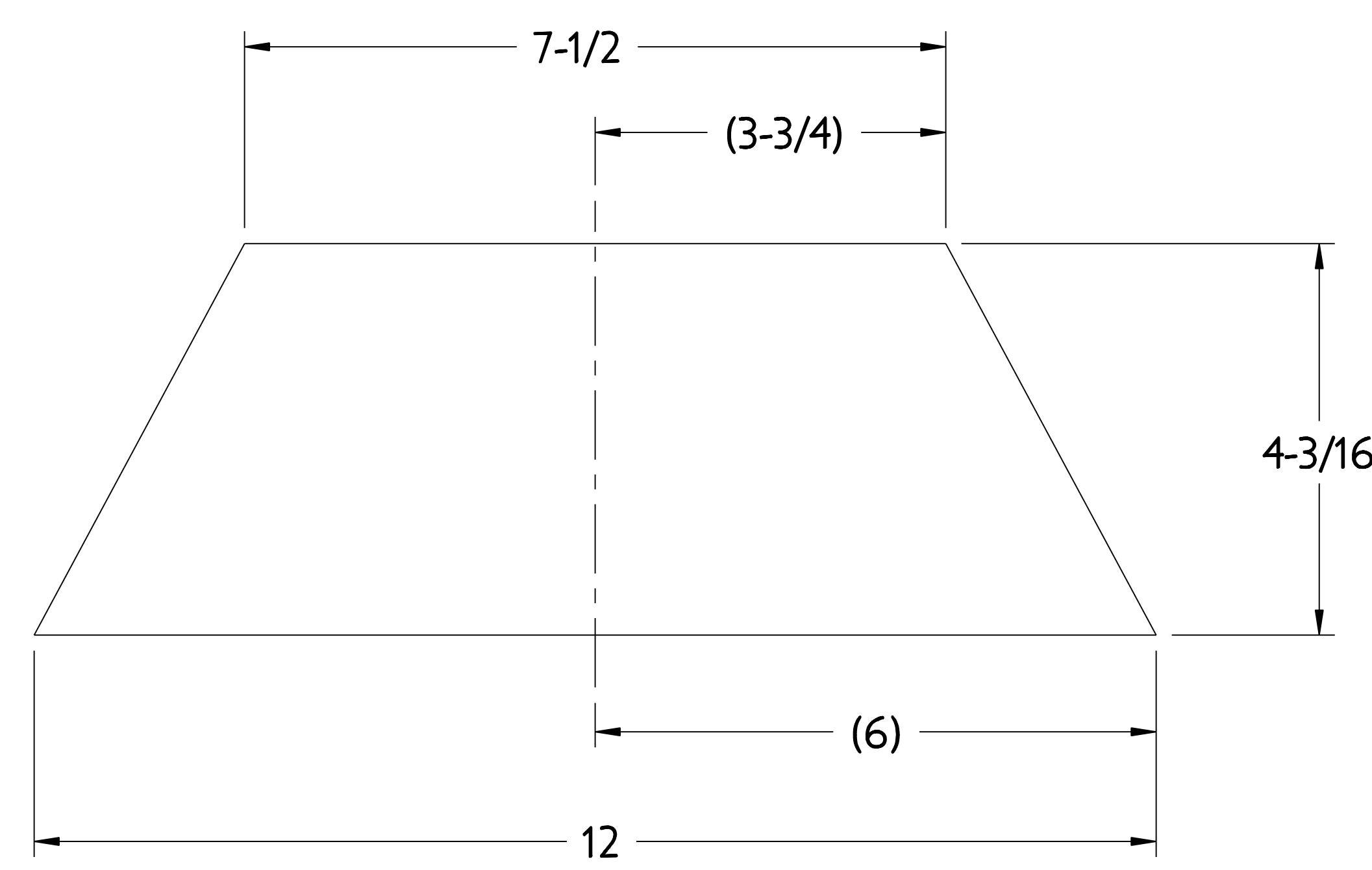
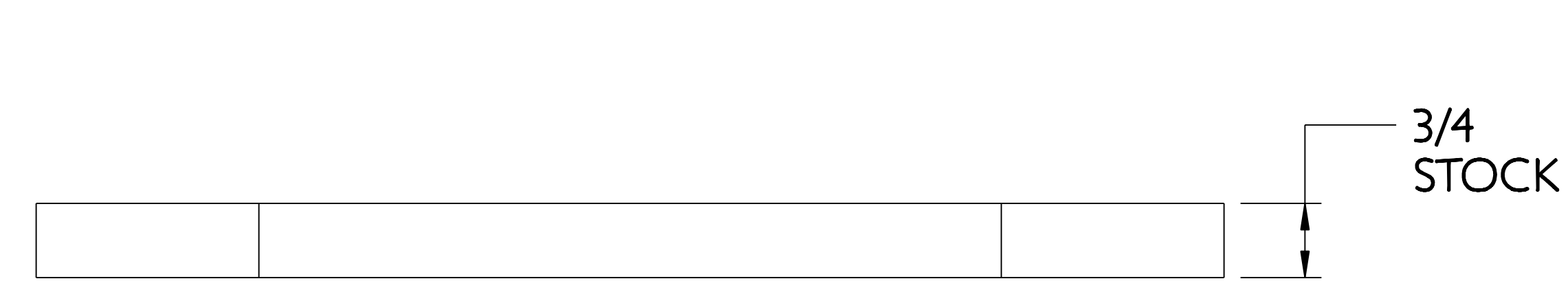
PART NO.	DRAWING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY REQD
4	SE186-306-4	GUSSET SEGMENT "A" MCWF BRACKET	ASTM A36	2
3	SE186-306-3	SIDE PLATE SEGMENT "A" MCWF BRACKET	CARBON STEEL	2
2	SE186-306-2	TOP PLATE SEGMENT "A" MCWF BRACKET	CARBON STEEL	1
1	SE186-306-1	BASE PLATE SEGMENT "A" MCWF BRACKET	CARBON STEEL	1

PPPL Drafting:

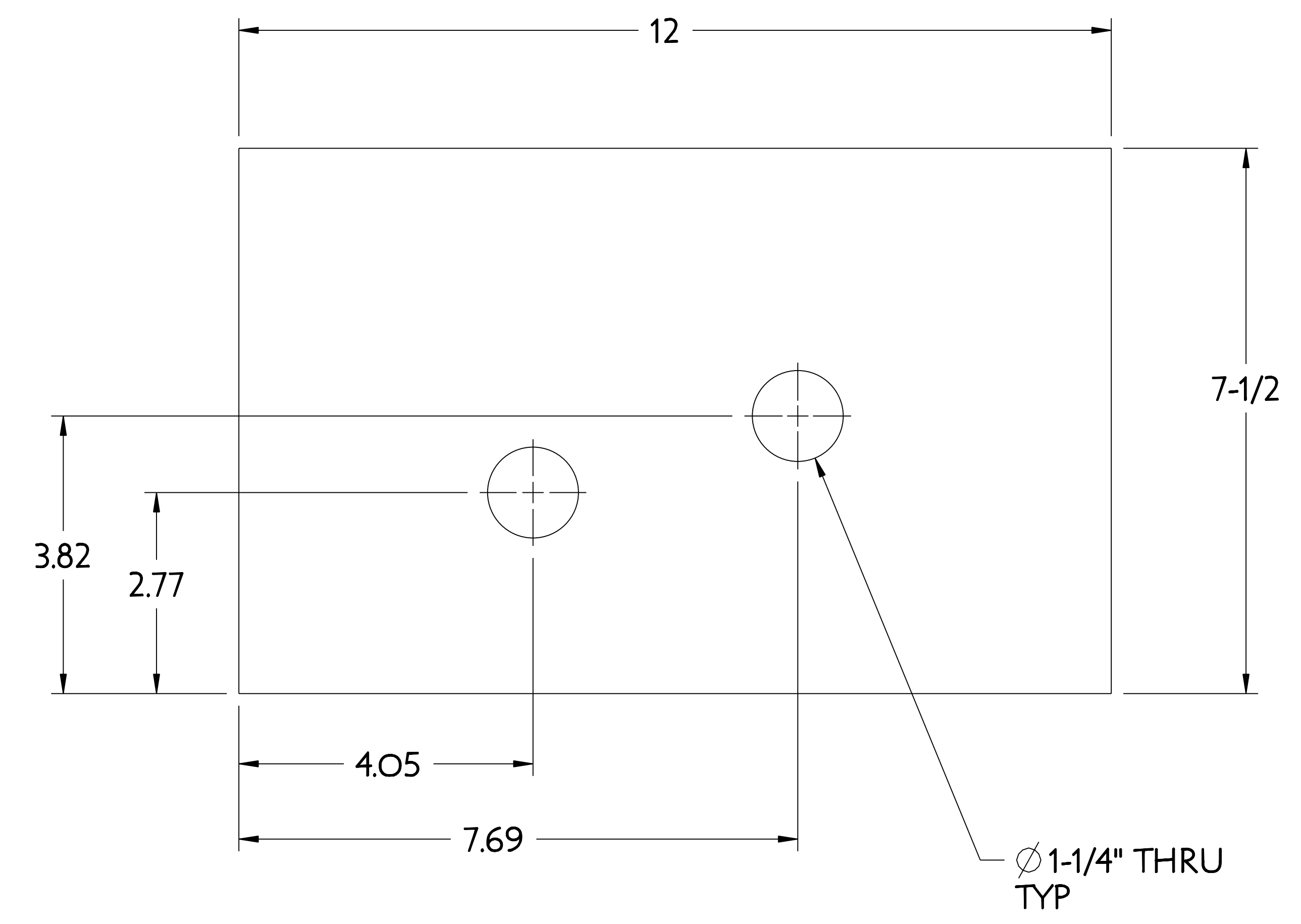
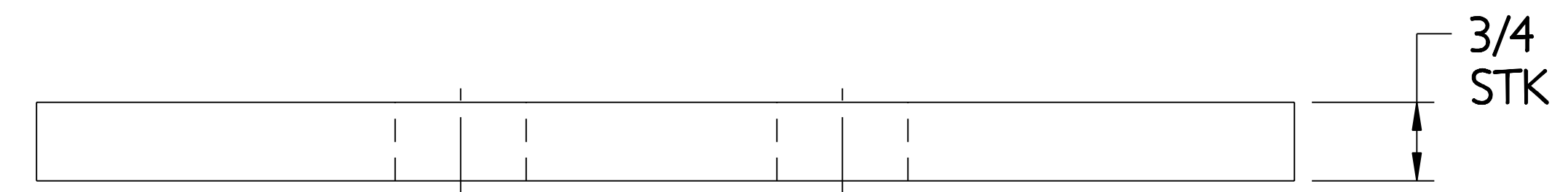
COMPUTER GENERATED DRAWING DRAWING CHANGES NOT PERMITTED	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY NATIONAL COMPACT STELLARATOR EXPERIMENT
DO NOT VERIFY INFORMATION BY SCALING DRAWING	SCALE 0.875	STELLARATOR CORE TOOLING DESIGN & FABRICATION MCWF SEGMENT "A" SUPPORT BRACKET WELDMENTS
PROJ: SE186-306-01	TOLERANCES NON-CUMULATIVE	DSN: J. RUSHINSKI 8-2-2007 DRAWING NO:
NEXT ASSEMBLY	DECIMAL-INCH FRACTIONS	CHK: M. COLE 8-2-2007
	.XX +/- .030 12°-12° +/- 1/8°	ENGR: T. BROWN 8-2-2007
	.XXX +/- .005 72°-120° +/- 1/4°	SUPV: J. SIEGEL 8-2-2007
	ANGULAR +/- 0°-15°	OVER: 120° +/- 1/2°

NCSX-SE186-306

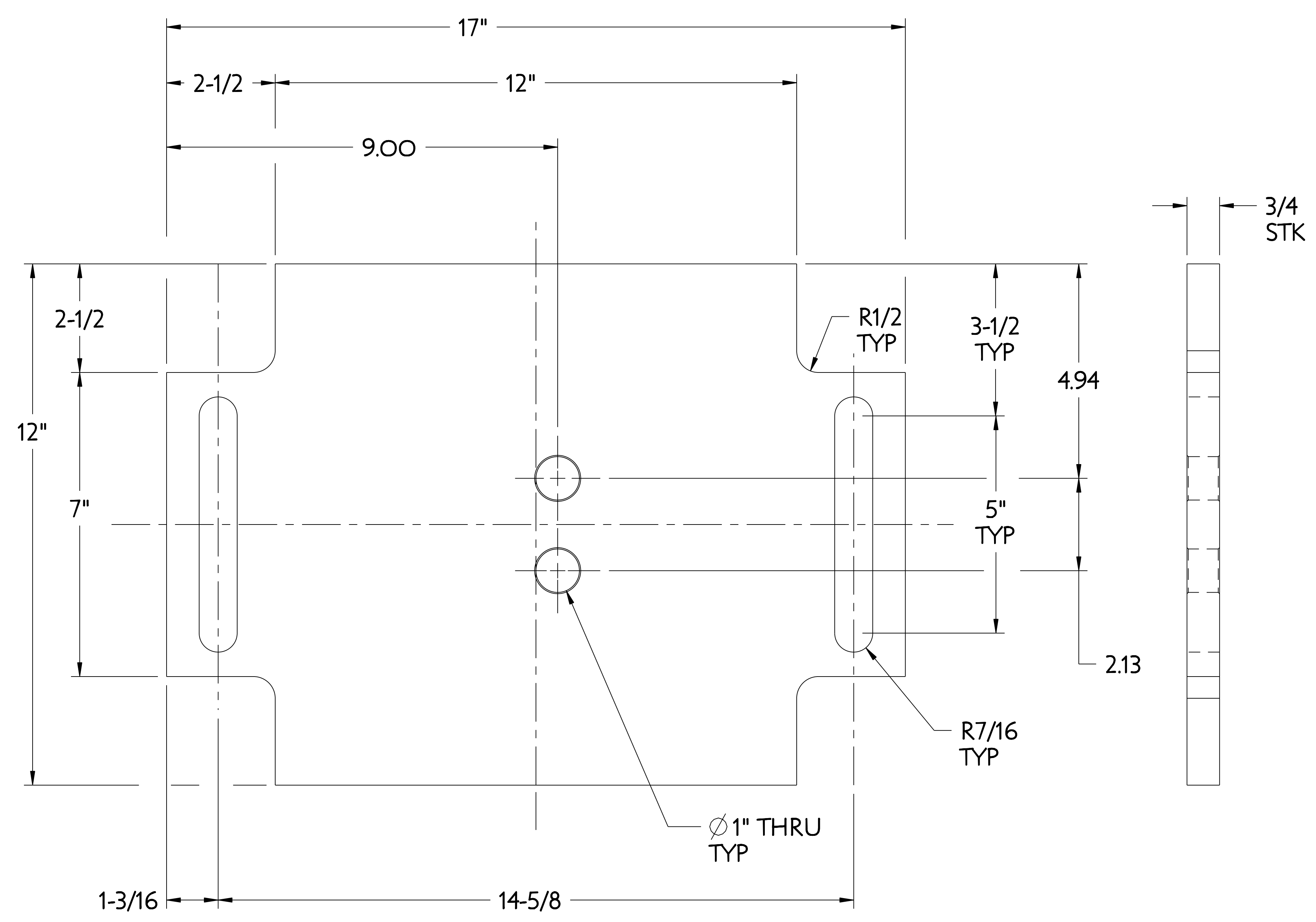
NO.	REVISION	BY	CH	SUP	APPROVED	DATE



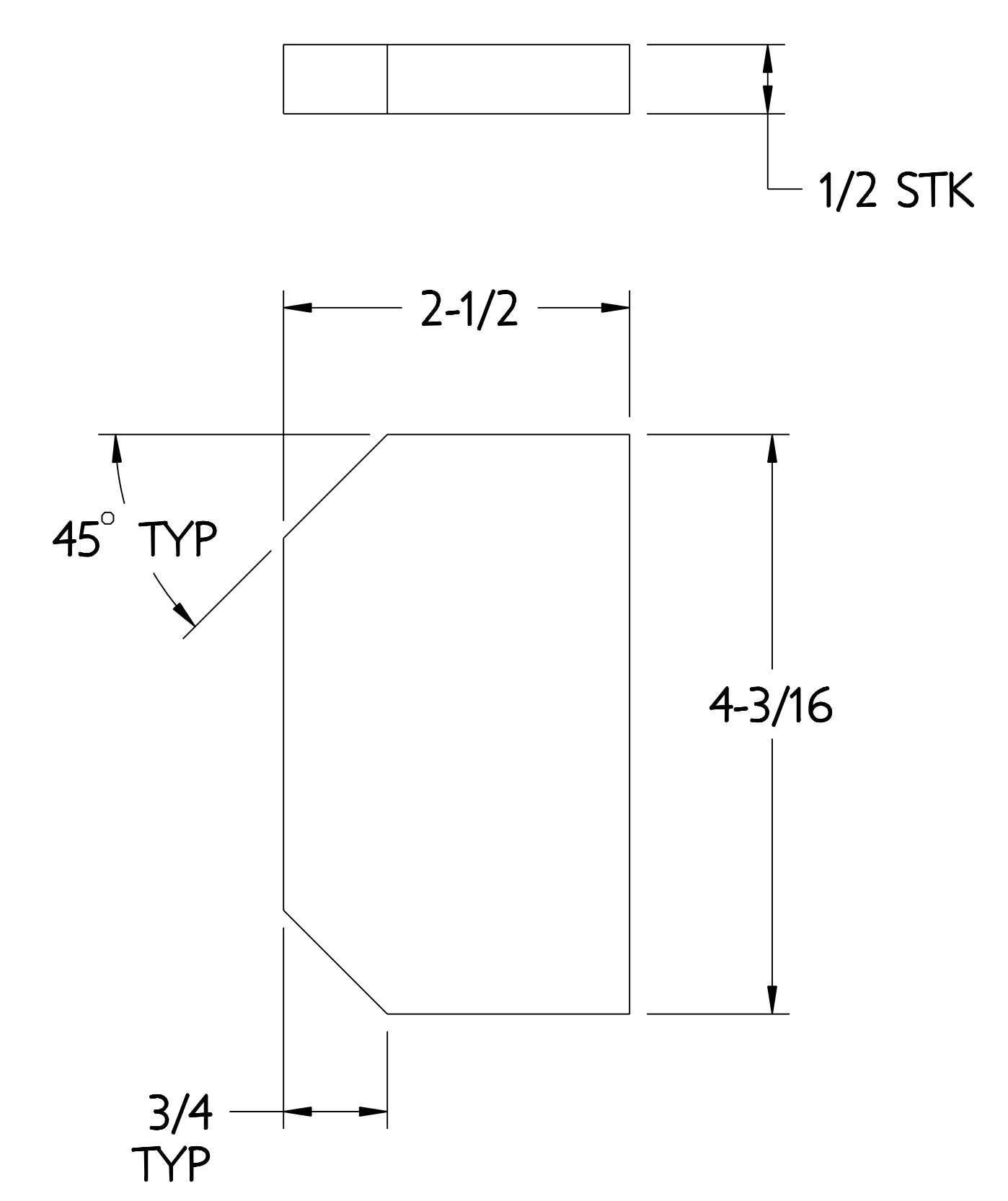
3 SIDE PLATE



2 TOP PLATE



1 BASE PLATE



4 GUSSET

**RELEASED FOR  
FABRICATION / INSTALLATION**  
 PPPL Drafting

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

RELEASE LEVEL: FABRICATION  
DWG VERSION NO: 6

WEIGHT	76.1 lbs
MODEL NAME	SE186-306-01
WELDING ENGINEER	

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 TOOLING DESIGN & FABRICATION MCWF SEGMENT "A" SUPPORT BRACKET DETAILS	
NEXT ASSEMBLY	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .X ±.000 .XX ±.005 ANGULAR ±.0°-15° OVER 120° ±.1°	DSN: J. RUSHINSKI CHK: M. COLE ENGR: T. BROWN SUPV: J. SIEGEL	8-2-2007 8-2-2007 8-2-2007 8-2-2007
DRAWING NO: SE186-306		SHEET 2 OF 2	

NCSX-SE186-306