



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.

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

RELEASED FOR FABRICATION / INSTALLATION
PPPL Drafting

(6) ASSEMBLIES REQ'D

PART NO.	DRAWING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY REQD
4	SE186-328-5	SUPPORT POST	ASTM A36	1
3	SE186-328-3	MCWF SEGMENT TOP PLATE LARGE	ASTM A36	1
2	SE186-328-2	MCWF SEGMENT SUPPORT LOCKING PLATE	ASTM A36	2
1	SE186-328-1	MCWF SEGMENT SUPPORT GUSSET PLATE	ASTM A36	4

PARTS LIST				
COMPUTER GENERATED DRAWING	CENTRAL FILES:	PRINCETON PLASMA PHYSICS LABORATORY		
MANUAL CHANGES NOT PERMITTED	UNLESS OTHERWISE SPECIFIED	NATIONAL COMPACT STELLARATOR EXPERIMENT		
DO NOT VERIFY INFORMATION BY SCALING DRAWING	BREAK SHARP EDGES .005/.020	STELLARATOR CORE TOOLING DESIGN & FABRICATION		
SCALE 0.625	TOLERANCES NON-CUMULATIVE	DSN: J. RUSHINSKI	8-2-2007	DRAWING NO:
NEXT ASSEMBLY	DECIMAL-INCH FRACTIONS	CHK: M. COLE	8-2-2007	SE186-325
WELDING ENGINEER: G. GETTELFINGER 8-2-2007	.XX +/- .000 0°-120° +/- .010	ENGR: T. BROWN	8-2-2007	
	.XXX +/- .005 120°-120° +/- .010	SUPV: J. SIEGEL	8-2-2007	SHEET 1 OF 1
	ANGULAR +/- .0°-15° OVER 120° +/- .125			REV 0

RELEASE LEVEL: Fabrication
DWG VERSION NO: 15

NCSX-SE186-325