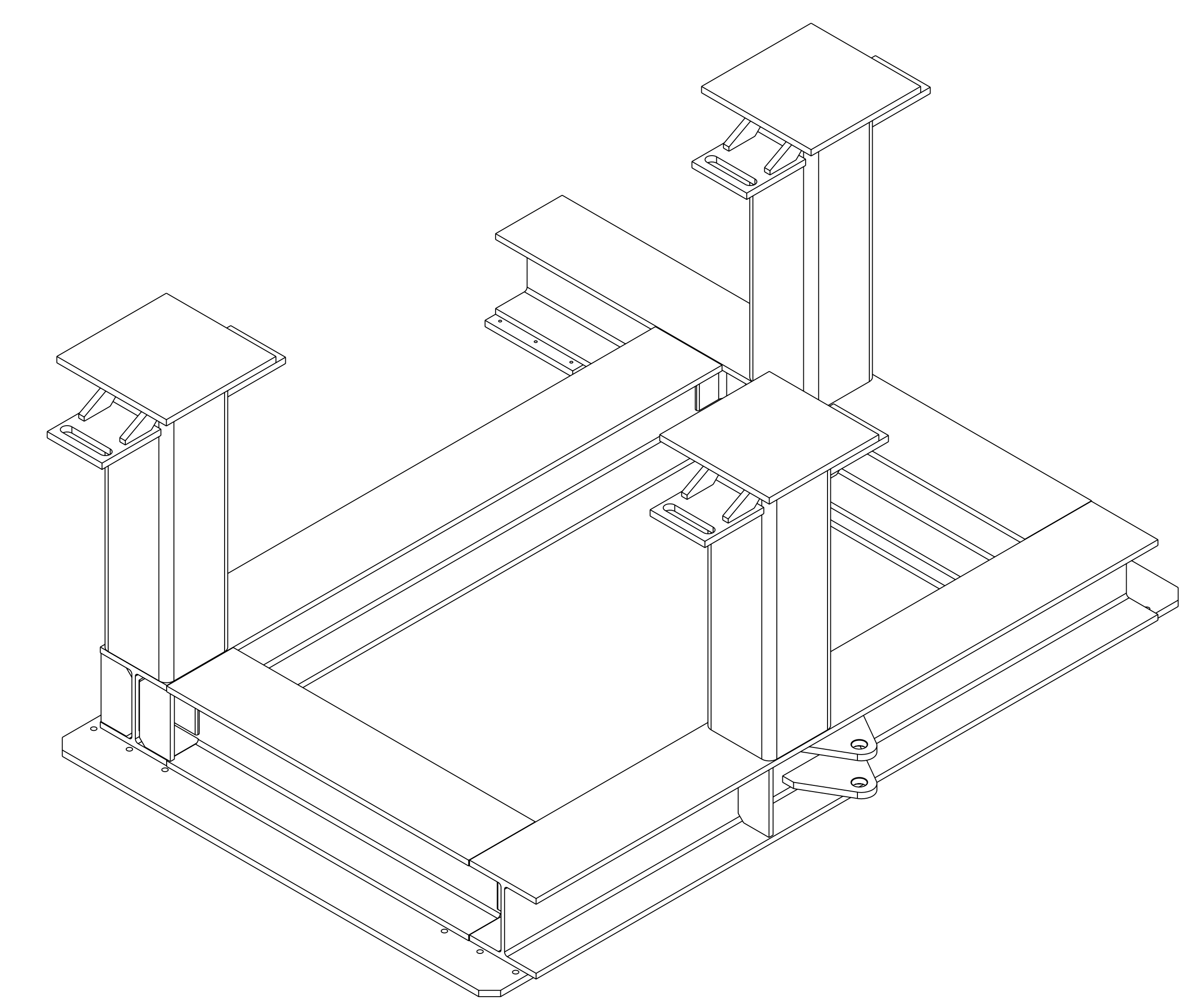
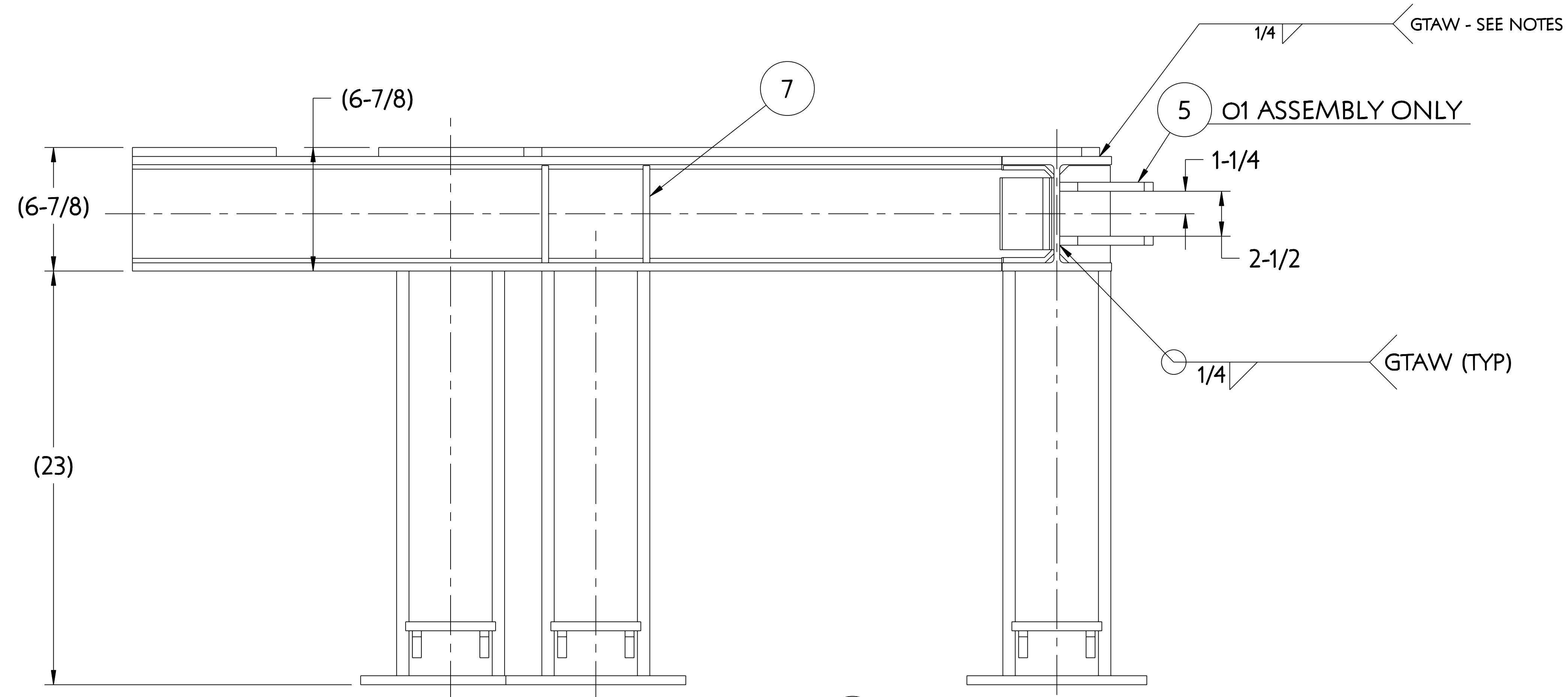


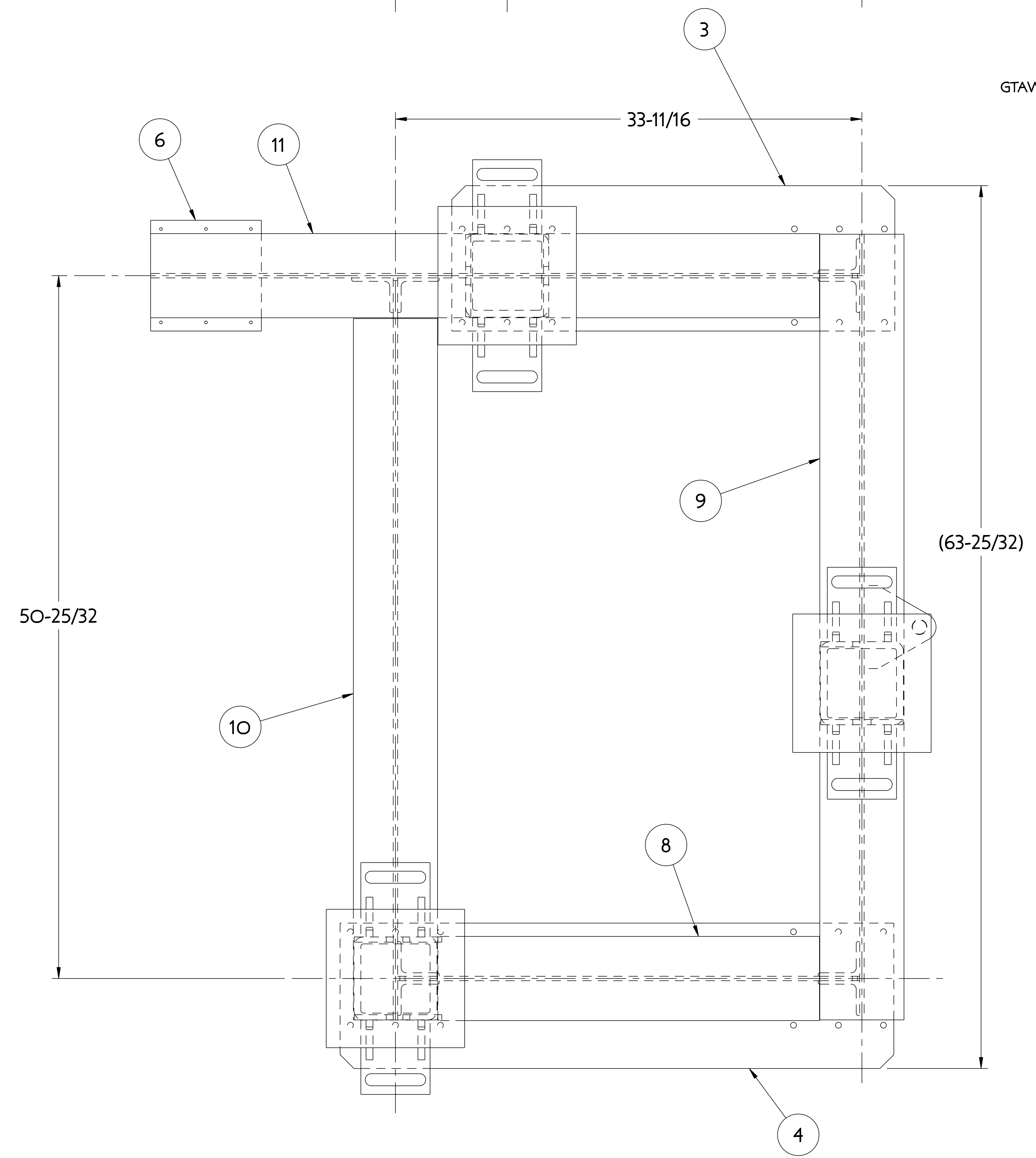
NO.	REVISION	BY	CH	SUP	APPROVED	DATE
13						
14						
15						



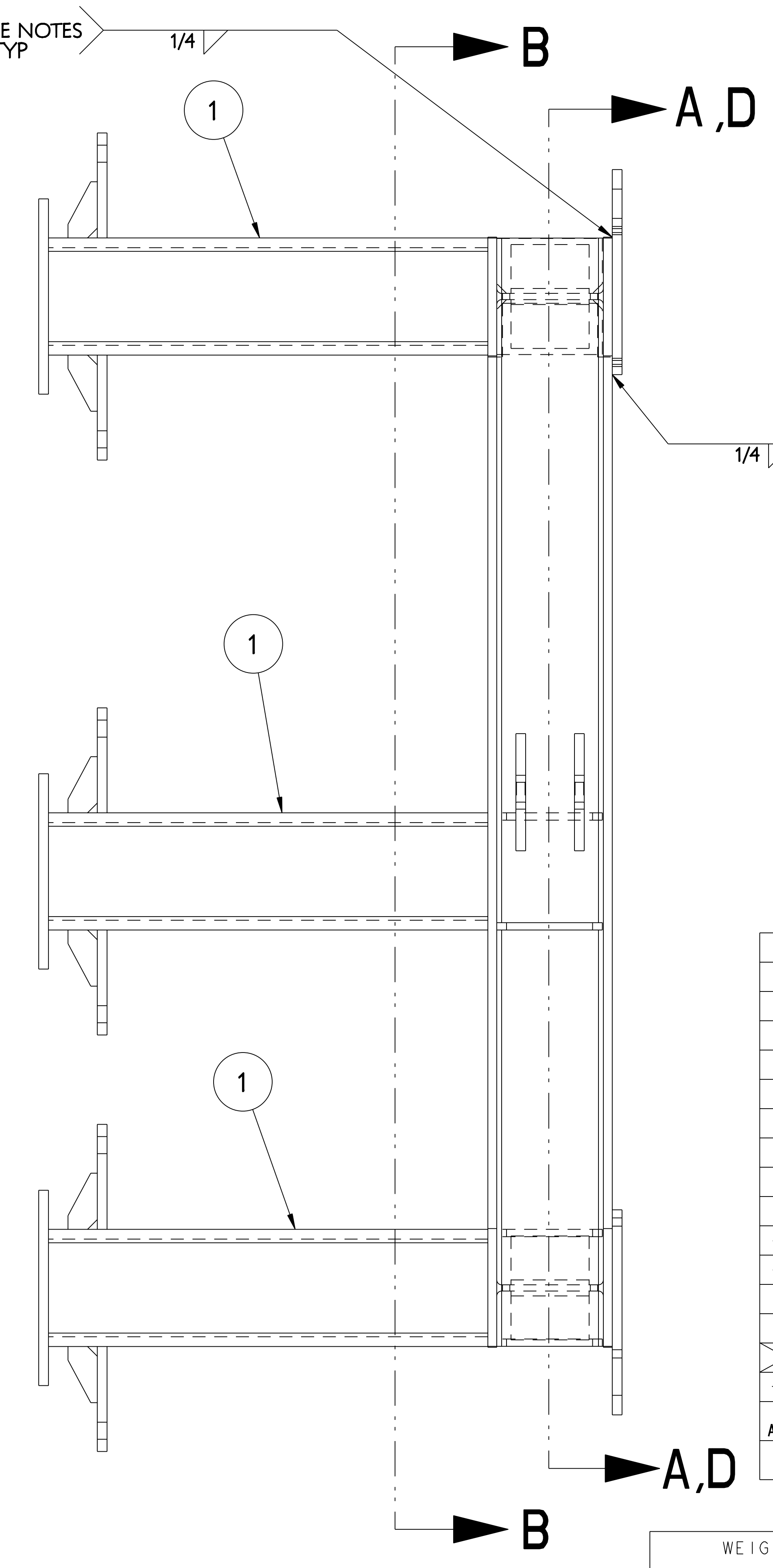
O1 ASSEMBLY  
REFERENCE ISOMETRIC

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

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O1 ASSEMBLY - RIGHT SIDE SUPPORT CART WELDMENT - AS SHOWN  
O2 ASSEMBLY - LEFT SIDE SUPPORT CART WELDMENT - OPPOSITE (SEE SHEET 3)



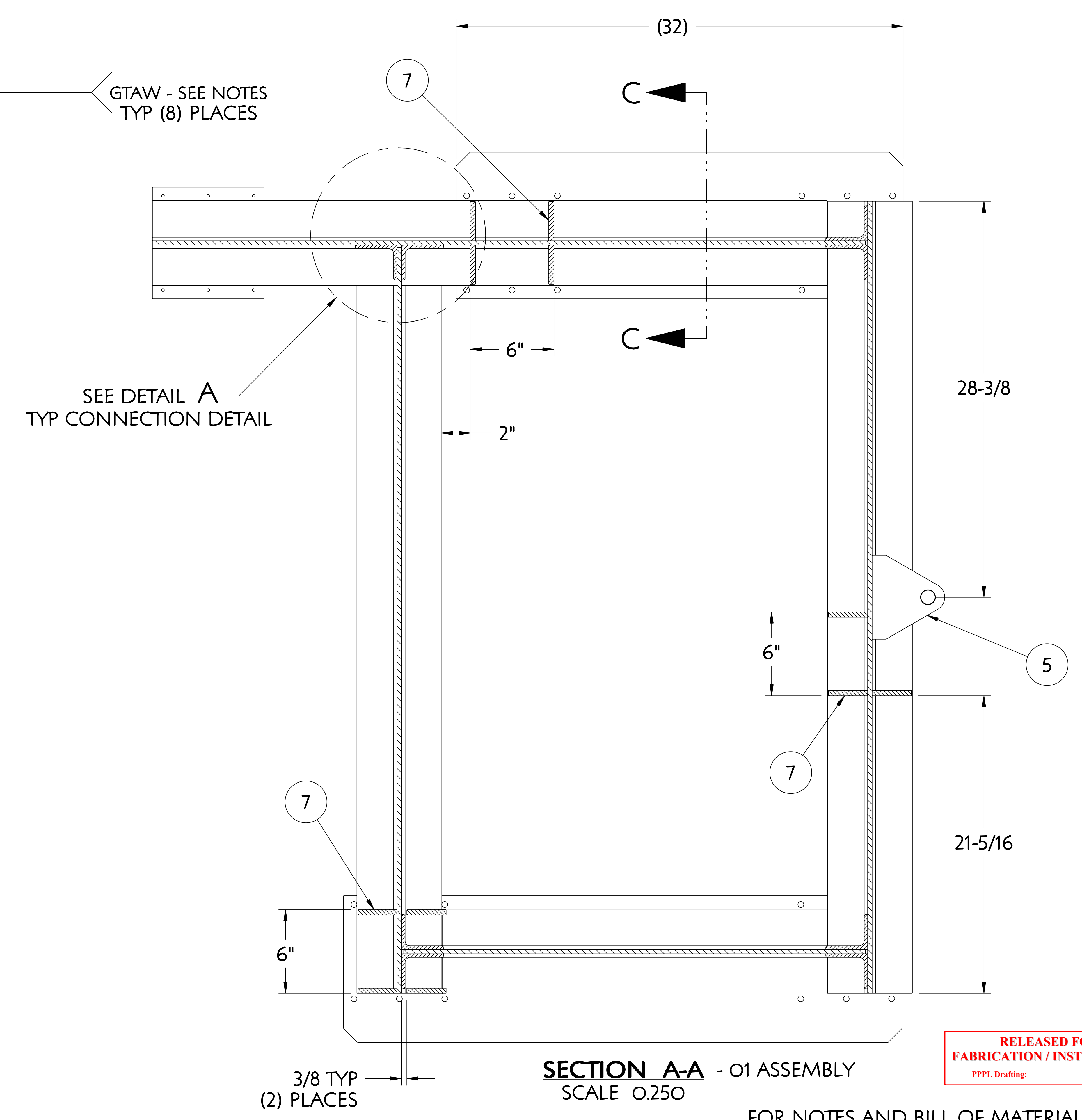
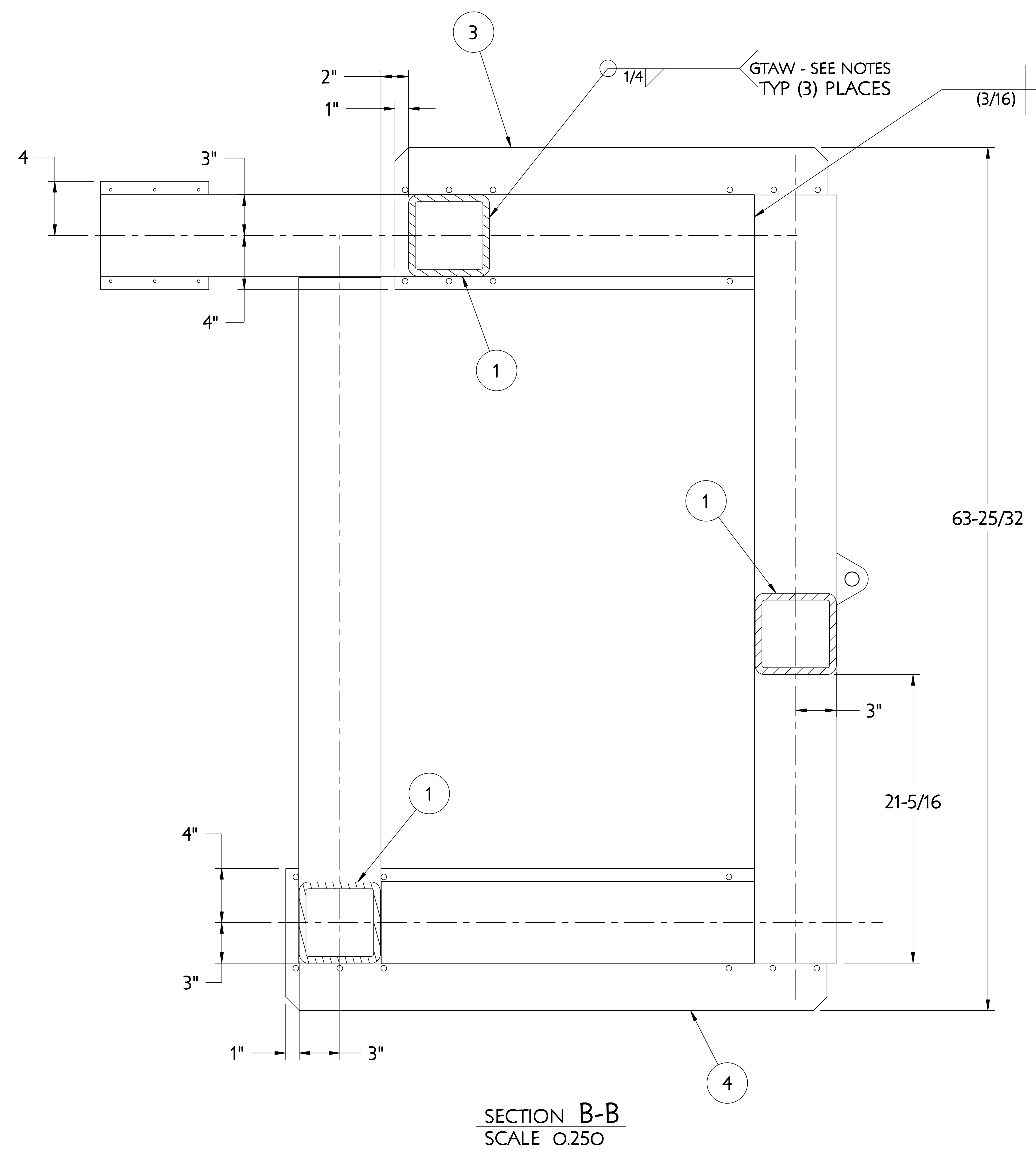
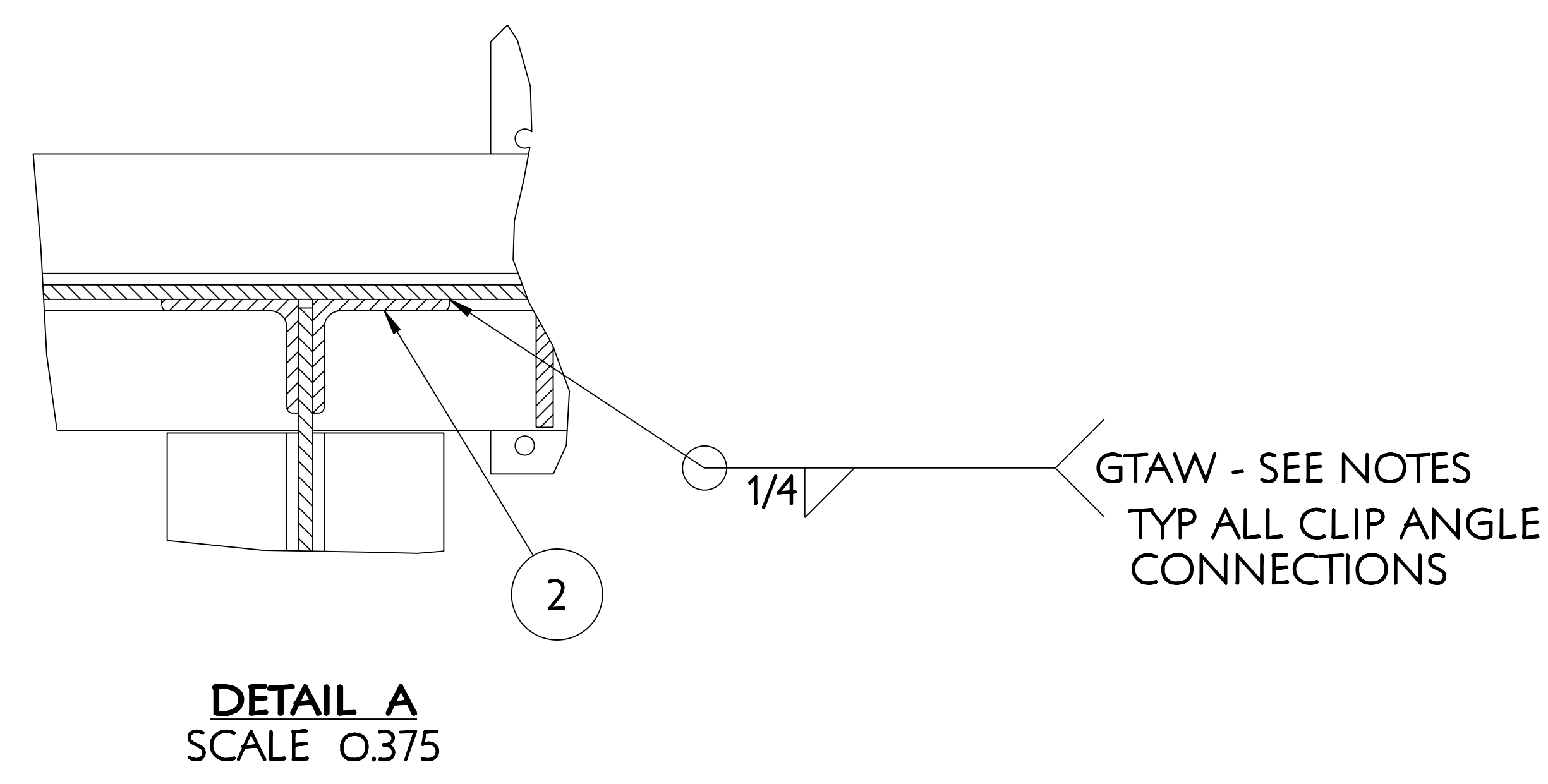
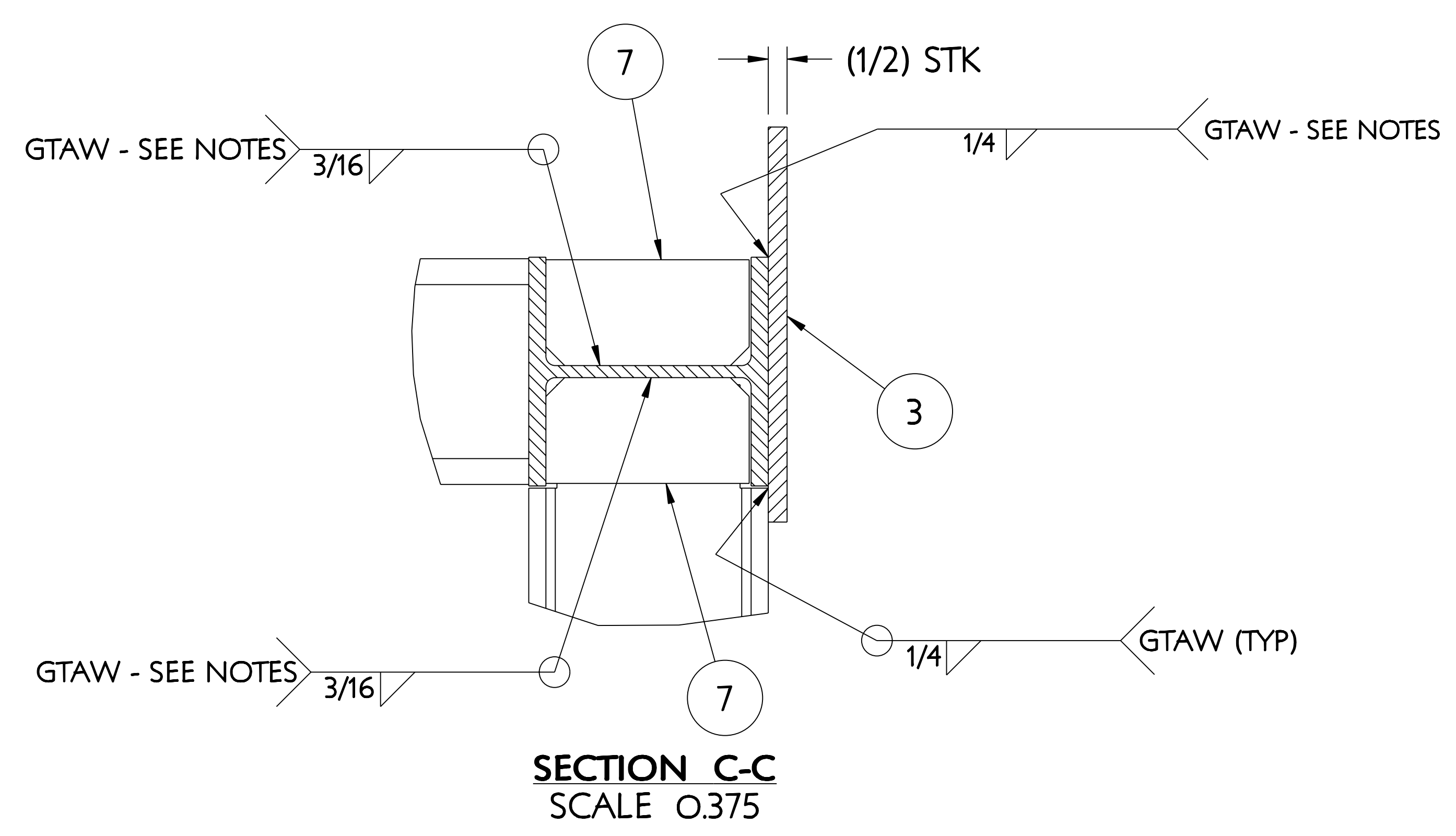
**NOTE**  
WELDING SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF AWS D1.1 OR PPPL PROCEDURE NO. ENG-37.  
VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH THE ACCEPTANCE CRITERIA OF AWS D1.1 Section 6.  
NOTE ORIENTATION OF ALL PARTS PRIOR TO WELDING.  
SAND BLAST AND APPLY 2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

QTY	PART NO.	DRAWING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY RECD
2	14	SE186-326-8	MCWF SUPPORT CART ANTI-TIP PLATE - TYPE "E"	SEE DWG	
1	13	SE186-326-7	MCWF SUPPORT CART ANTI-TIP PLATE - TYPE "D"	SEE DWG	
1	12	SE186-326-6	MCWF SUPPORT CART ANTI-TIP PLATE - TYPE "C"	SEE DWG	
1	11	SE186-341-4	FRAMING BEAM - TYPE # 4	SEE DWG	
1	10	SE186-341-3	FRAMING BEAM - TYPE # 3	SEE DWG	
1	9	SE186-341-2	FRAMING BEAM - TYPE # 2	SEE DWG	
1	8	SE186-341-1	FRAMING BEAM - TYPE # 1	SEE DWG	
12	11	7	SUPPORT GUSSET	SEE DWG	
1	6	SE186-326-5	HILMAN ROLLER MOUNTING PLATE	SEE DWG	
2	5	SE186-326-4	PULL PLATE	SEE DWG	
1	4	SE186-326-3	MCWF SUPPORT CART ANTI-TIP PLATE - TYPE "B"	SEE DWG	
1	3	SE186-326-2	MCWF SUPPORT CART ANTI-TIP PLATE - TYPE "A"	SEE DWG	
8	8	2	CLIP ANGLE	SEE DWG	
3	3	1	SE186-325	MCWF SUPPORT CART SUPPORT POST WELDMENT	SEE DWG
			THIS DWG	MCWF LEFT SIDE SUPPORT CART WELDMENT	1
			THIS DWG	MCWF RIGHT SIDE SUPPORT CART WELDMENT	1

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED		CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY	
DO NOT VERIFY INFORMATION BY SCALING DRAWING		DIMENSIONS ARE IN INCHES MACHINE SURFACES UNLESS SHOWN OTHERWISE	NATIONAL COMPACT STELLARATOR EXPERIMENT	
WEIGHT 1160.8 lbs		TOLERANCES NON-CUMULATIVE	STELLARATOR CORE TOOLING DESIGN & FABRICATION MCWF SUPPORT CART WELDMENTS	
MODEL NAME SE186-330-01		DECIMAL-INCH FRACTIONS	DRAWING NO: <b>SE186-330</b>	
WELDING ENGINEER: G. GETTLEFINGER 8-2-2007		CHK: M. COLE 8-2-2007	ENGR: T. BROWN 8-2-2007	
RELEASE LEVEL: Fabrication DWG VERSION NO: 26		ENGR: J. SIEGEL 8-2-2007	SHEET 1 OF 3	

NCSX-SE186-330

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



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FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

RELEASE LEVEL: Fabrication  
DWG VERSION NO: 26

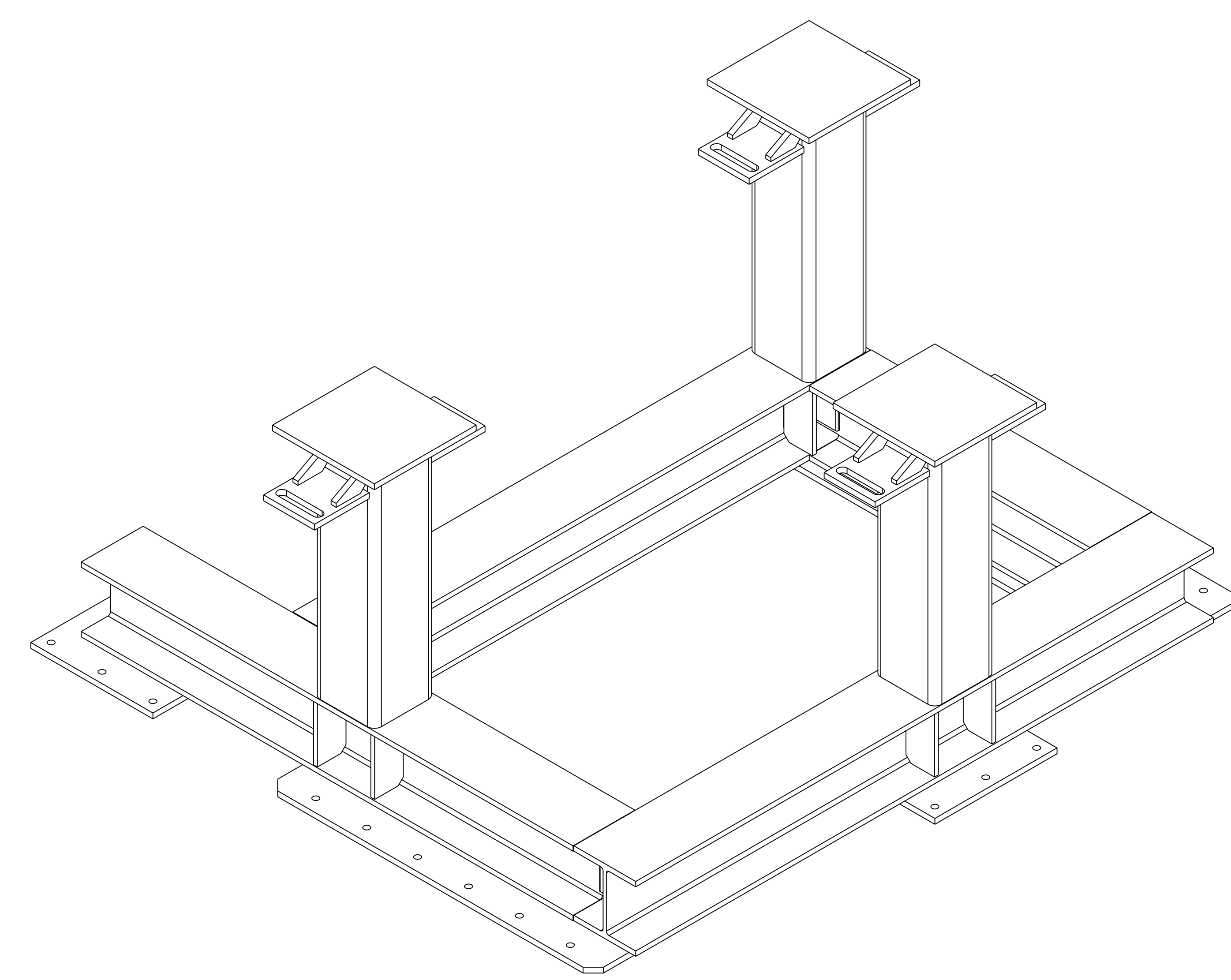
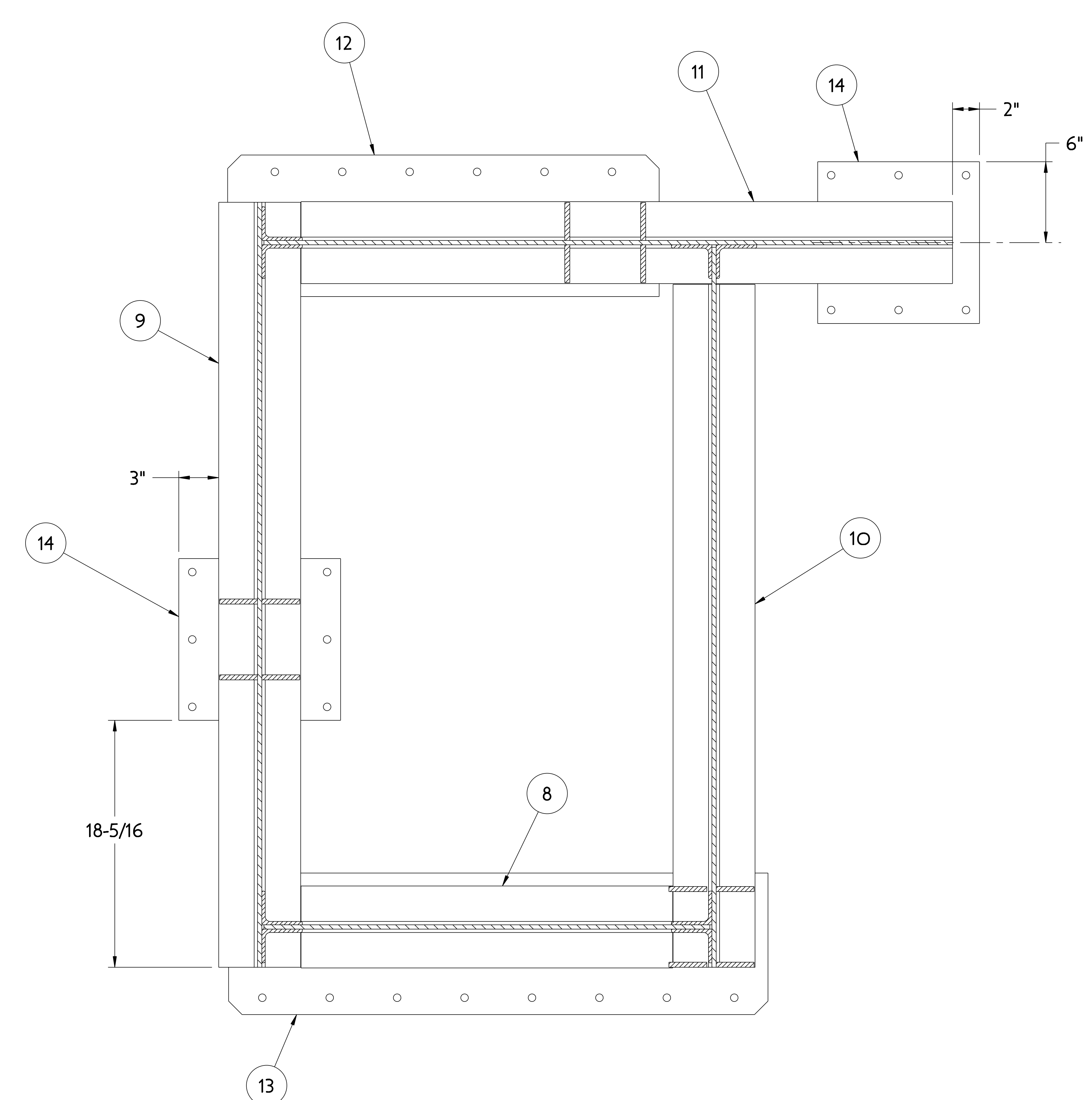
WEIGHT	1160.8 lbs
MODEL NAME	SE186-330-01
WELDING ENGINEER	

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	PRINCETON PLASMA PHYSICS LABORATORY NATIONAL COMPACT STELLARATOR EXPERIMENT STELLARATOR CORE TOOLING DESIGN & FABRICATION MCWF SUPPORT CART WELDMENTS
DO NOT VERIFY INFORMATION BY SCALING DRAWING	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX +/- .005 .XXX +/- .005 ANGULAR +/- 0°15'	DSN: J. RUSHINSKI 8-2-2007 CHK: M. COLE 8-2-2007 ENGR: T. BROWN 8-2-2007 SUPV: J. SIEGEL 8-2-2007
NEXT ASSEMBLY		DRAWING NO: <b>SE186-330</b> SHEET 2 OF 3 REV D, 10

NCSX-SE186-330



NO.	REVISION	BY	CH	SUP	APPROVED	DATE



O2 ASSEMBLY  
REFERENCE ISOMETRIC

**RELEASED FOR  
FABRICATION / INSTALLATION**  
 PPPL Drafting

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

**RELEASE LEVEL: Fabrication**  
**DWG VERSION NO: 26**

WEIGHT	1160.8 lbs
MODEL NAME	SE186-330-01
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 SUPPORT CART WELDMENTS	
TOLERANCES NON-CUMULATIVE	DECIMAL-INCH FRACTIONS	DSN: L. MORRIS	8-2-2007 DRAWING NO:
NEXT ASSEMBLY	.X +/- .100 0°-120° +/- .125 .XX +/- .030 120°-120° +/- .125 .XXX +/- .005 120°-120° +/- .125 ANGULAR +/- .0°-15° OVER 120° +/- .125	CHK: M. COLE	8-2-2007
		ENGR: T. BROWN	8-2-2007
		SUPV: J. SIEGEL	8-2-2007
			SHEET 3 OF 3
			REV D, I

NCSX-SE186-330