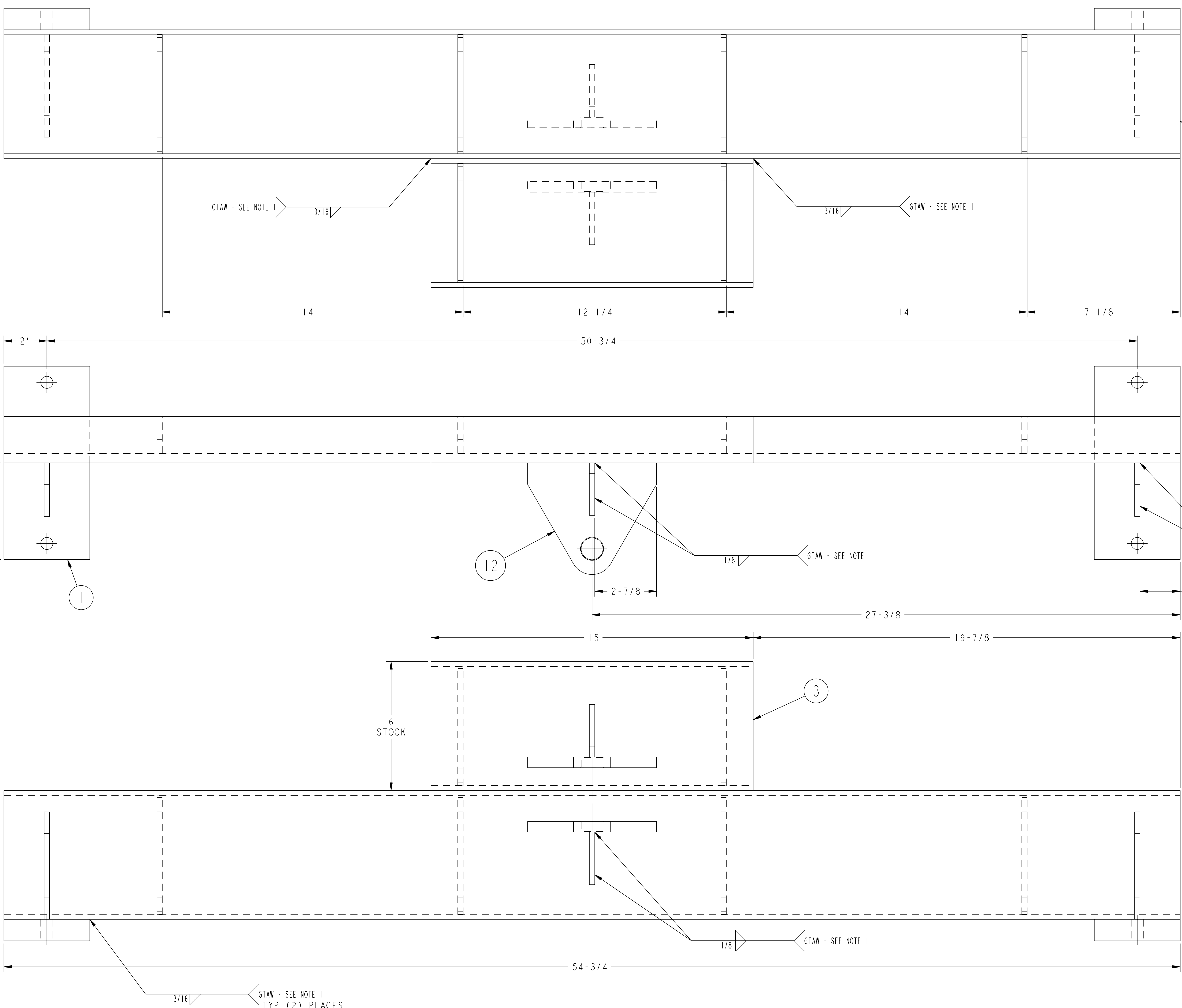
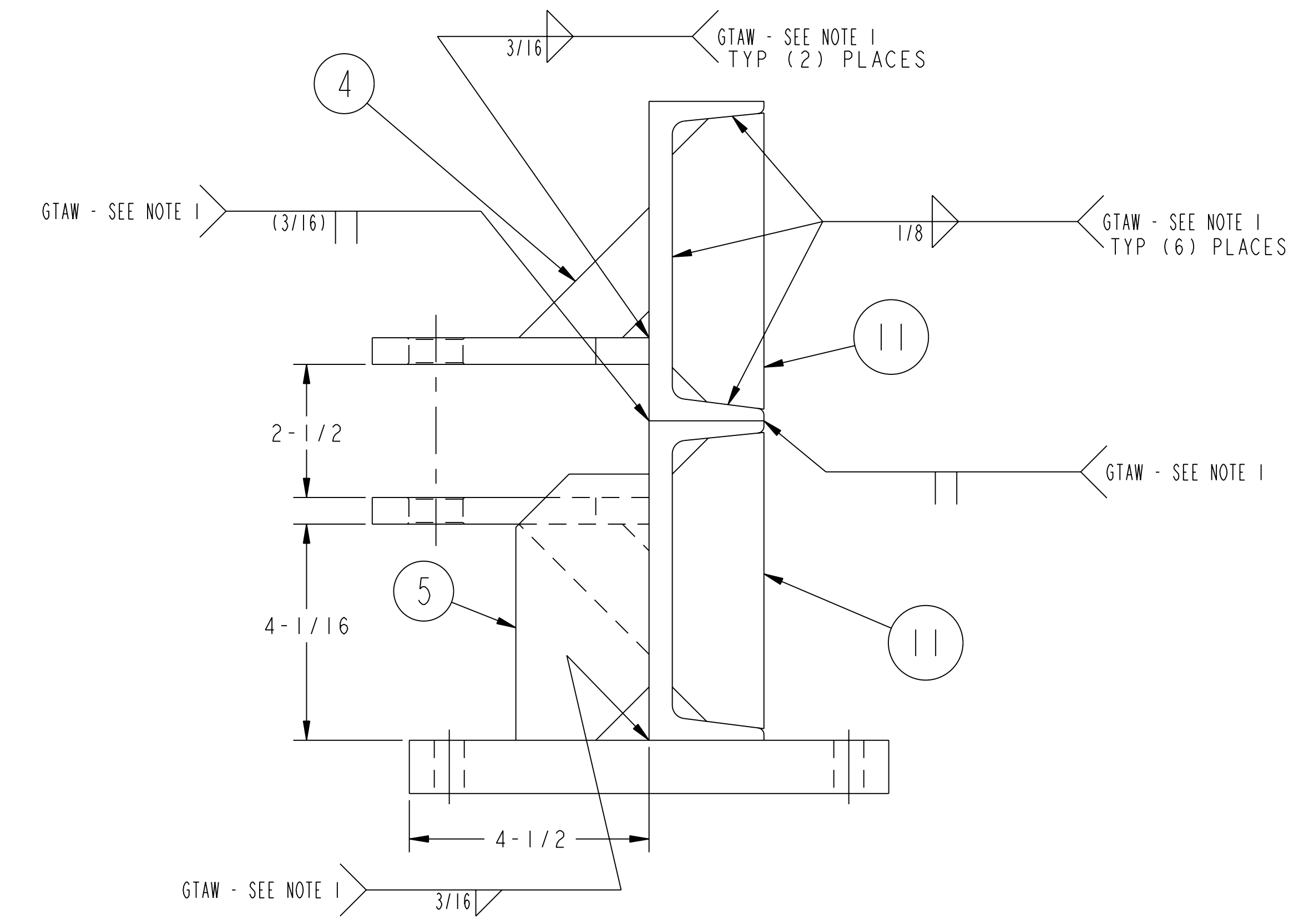


NO.	REVISION	BY	CH	SUP	APPROVED	DATE



- 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. SAND BLAST AND APPLY 2 COATS "SAFETY YELLOW" PAINT.



01 ASSEMBLY - ADJUSTER BAR SUPPORT STRUCTURE WELDMENT

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

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PPPL Drafting:

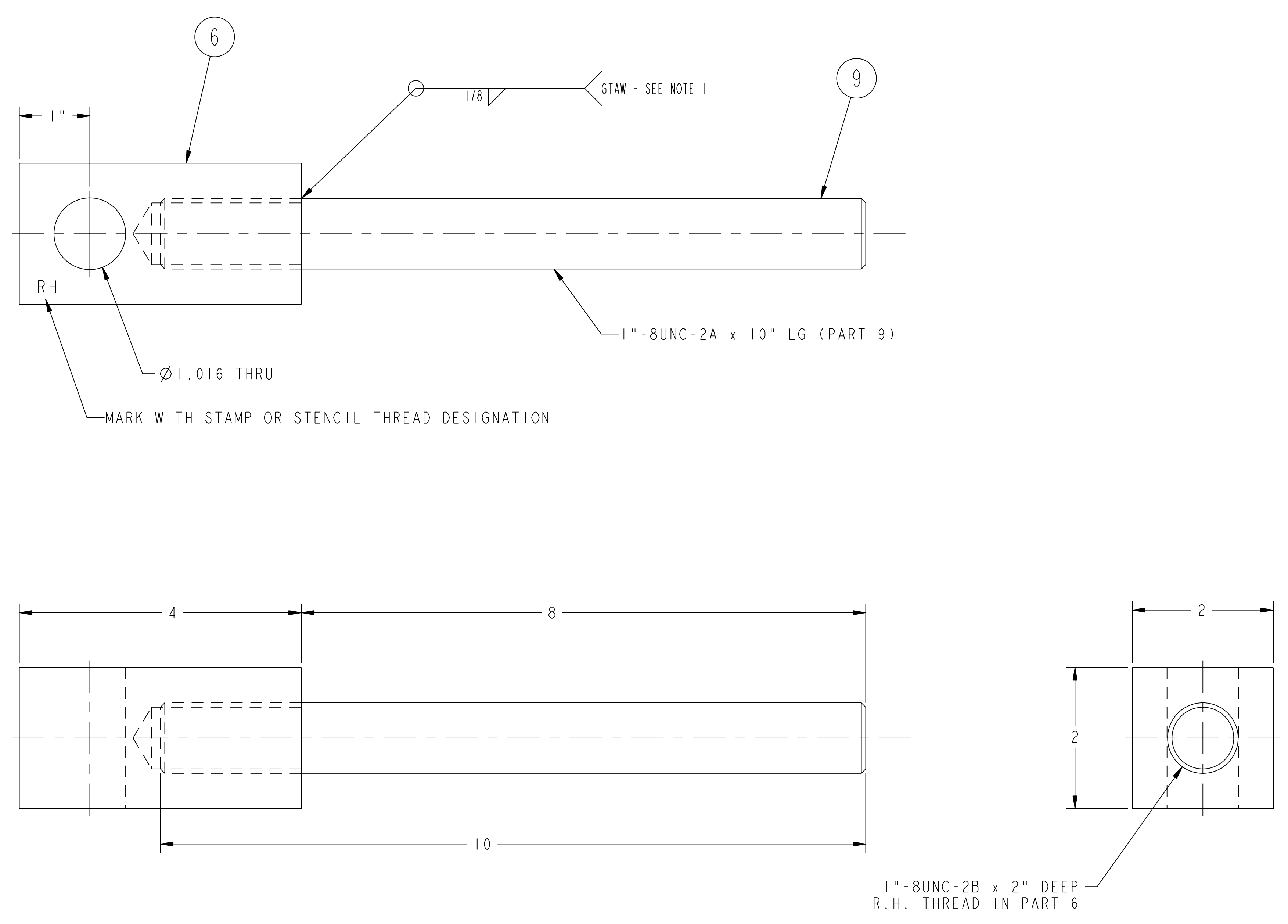
RELEASE LEVEL: Fabrication
DWG VERSION NO: 3

QTY	PART NO.	DRAWING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY REQ'D
2	12	SE186-326-3	SUPPORT CART PULL PLATE	ASTM A36	
6	11	THIS DWG	CHANNEL STIFFENER GUSSET	ASTM A36	
1	10	THIS DWG	THREADED ROD - 1"-8UNC-2A x 10" LG L.H. THREAD	ASTM A108	
1	9	THIS DWG	THREADED ROD - 1"-8UNC-2A x 10" LG R.H. THREAD	ASTM A108	
1	8	THIS DWG	ADJUSTER BLOCK - R.H. AND L.H. THREAD	ASTM A36	1
1	7	THIS DWG	ADJUSTER BAR THREADED BLOCK - L.H. THREAD	ASTM A36	
1	6	THIS DWG	ADJUSTER BAR THREADED BLOCK - R.H. THREAD	ASTM A36	
2	5	THIS DWG	STIFFENER GUSSET	ASTM A36	
2	4	THIS DWG	GUSSET	ASTM A36	
1	3	THIS DWG	PUSHER SUPPORT CHANNEL - SHORT - 6" x 25# CHANNEL	ASTM A36	
1	2	THIS DWG	PUSHER SUPPORT CHANNEL - LONG - 6" x 25# CHANNEL	ASTM A36	
2	1	THIS DWG	FOOT PLATE	ASTM A36	
			ADJUSTER BAR WELDMENT - L.H. THREAD		1
			ADJUSTER BAR WELDMENT - R.H. THREAD		1
			ADJUSTER BAR SUPPORT STRUCTURE WELDMENT		1

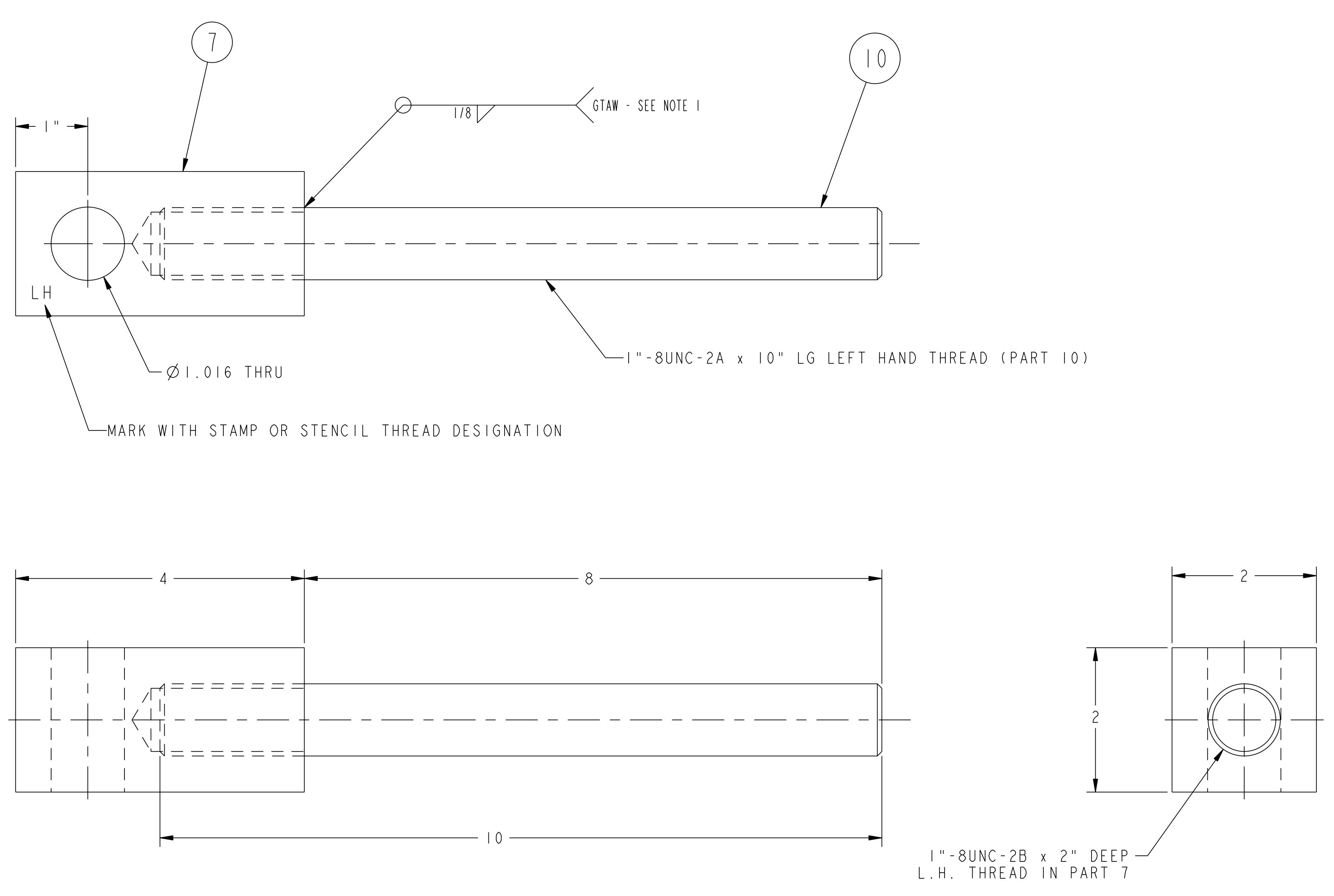
WEIGHT	MODEL NAME	WELDING ENGINEER	COMPUTER GENERATED DRAWING	CENTRAL FILES:	PRINCETON PLASMA PHYSICS LABORATORY
107.7 lbs	SE186-333-01	G. GETTELFINGER 8-2-2007	MANUAL CHANGES NOT PERMITTED	UNLESS OTHERWISE SPECIFIED	NATIONAL COMPACT STELLARATOR EXPERIMENT
			DO NOT VERIFY INFORMATION BY SCALING DRAWING	DIMENSIONS ARE IN INCHES	STELLARATOR CORE
				BREAK SHARP EDGES .005/.020	TOOLING DESIGN AND FABRICATION
				TOLERANCES NON-CUMULATIVE	ADJUSTER BAR SUPPORT STRUCTURE WELDMENTS AND DETAILS
				DECIMAL-INCH FRACTIONS	DSN: L. MORRIS 8-2-2007
				XXX .005 72"-120" 1/16"	CHK: M. COLE 8-2-2007
				ANGULAR .015" OVER 120"-112"	ENGR: T. BROWN 8-2-2007
					SUPV: J. SIEGEL 8-2-2007
					DRAWING NO: SE186-333
					SHEET 1 OF 3
					REV 0

NCSX-SE186-333

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



02 ASSEMBLY - ADJUSTER BAR WELDMENT - R.H. THREAD



03 ASSEMBLY - ADJUSTER BAR WELDMENT - L.H. THREAD

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PPPL Drafting:

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

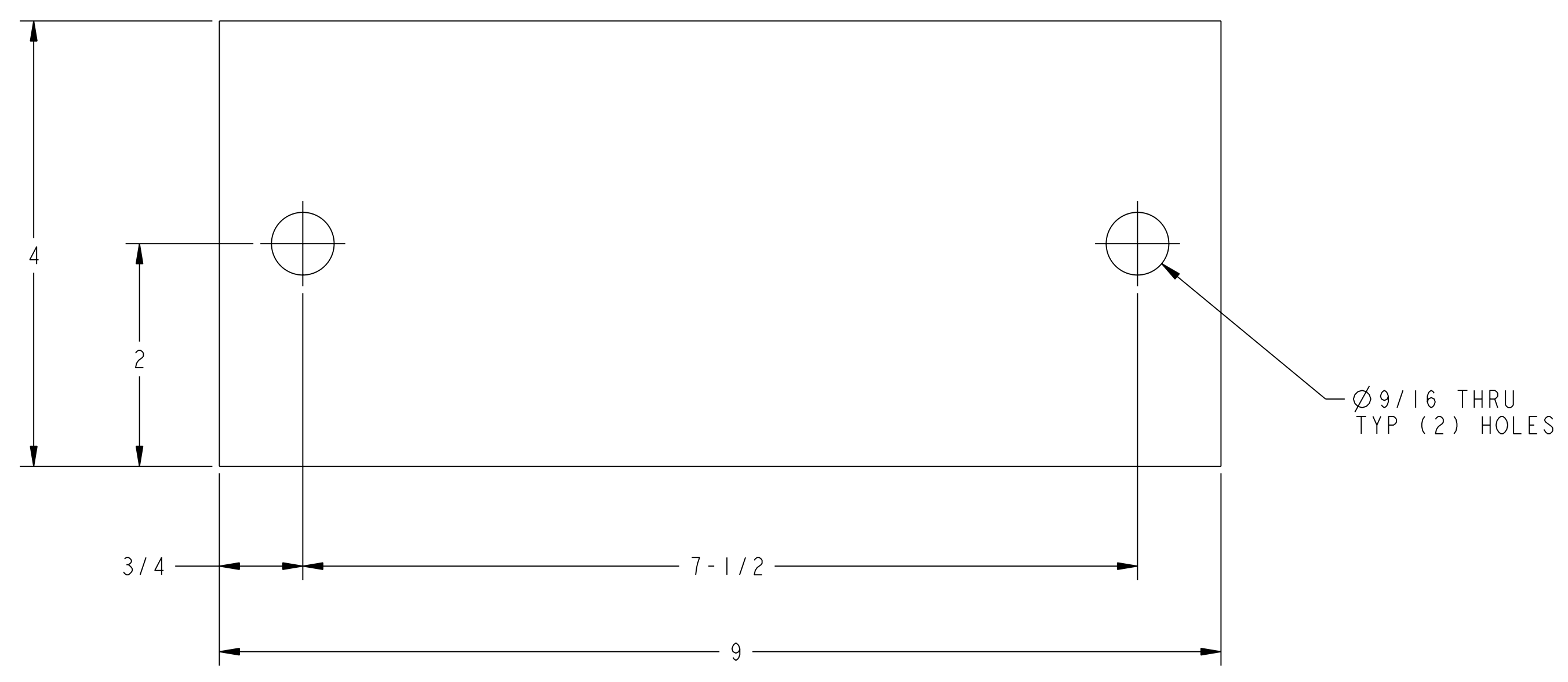
RELEASE LEVEL: Fabrication
DWG VERSION NO: 3

WEIGHT	107.7 lbs
MODEL NAME	SE186-333-01
WELDING ENGINEER	G. GETTELFINGER 8-2-2007

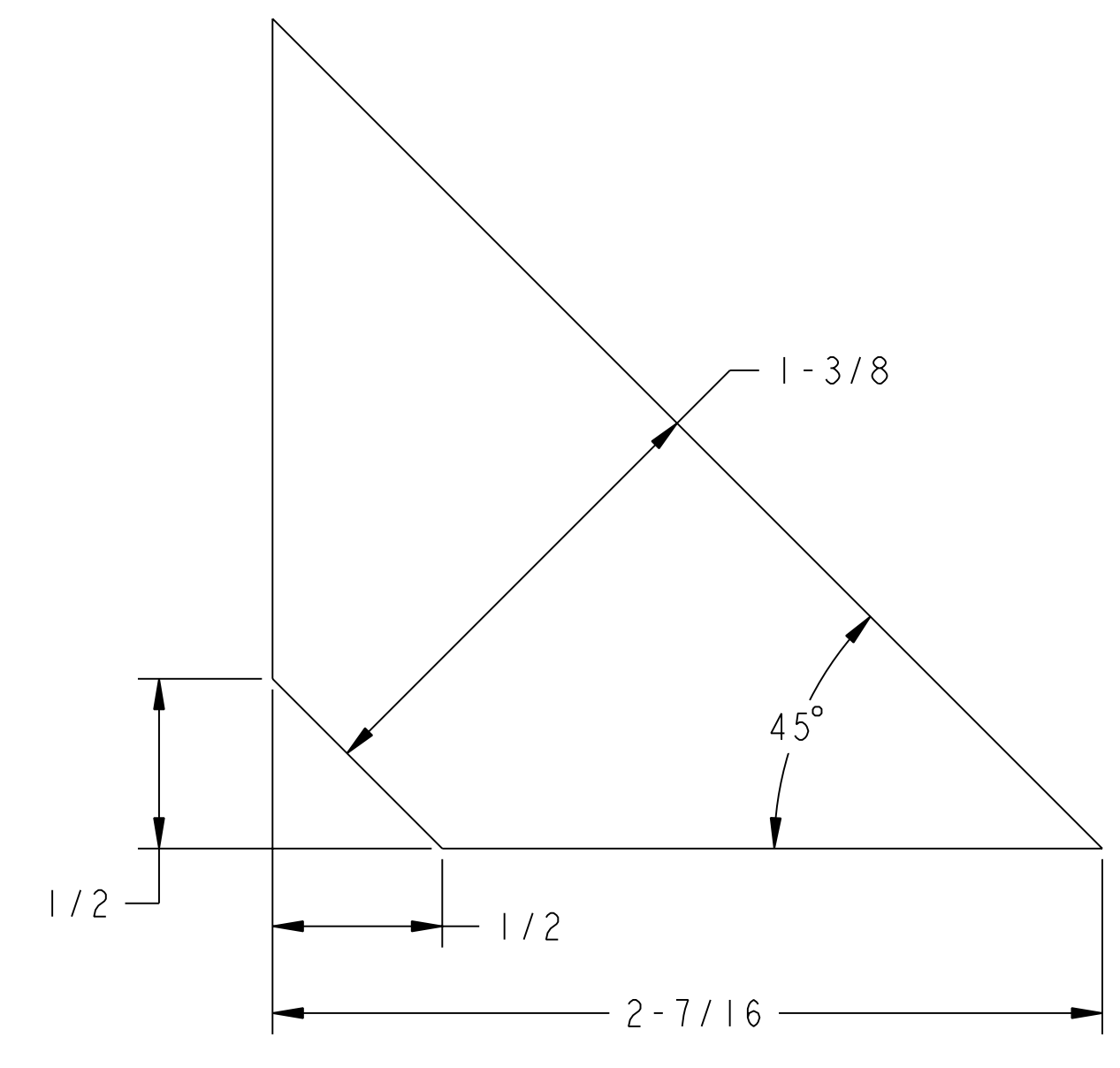
COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY NATIONAL COMPACT STELLARATOR EXPERIMENT	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	STELLARATOR CORE TOOLING DESIGN AND FABRICATION ADJUSTER BAR SUPPORT STRUCTURE WELDMENTS AND DETAILS	
NEXT ASSEMBLY	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX ±.000 .XXX ±.005 ANGULAR ±.0°-15°	DSN: L. MORRIS CHK: M. COLE ENGR: T. BROWN SUPV: J. SIEGEL	8-2-2007 8-2-2007 8-2-2007 8-2-2007
		DRAWING NO:	SE186-333
		SHEET 2 OF 3	REV D. 3

NCSX-SE186-333

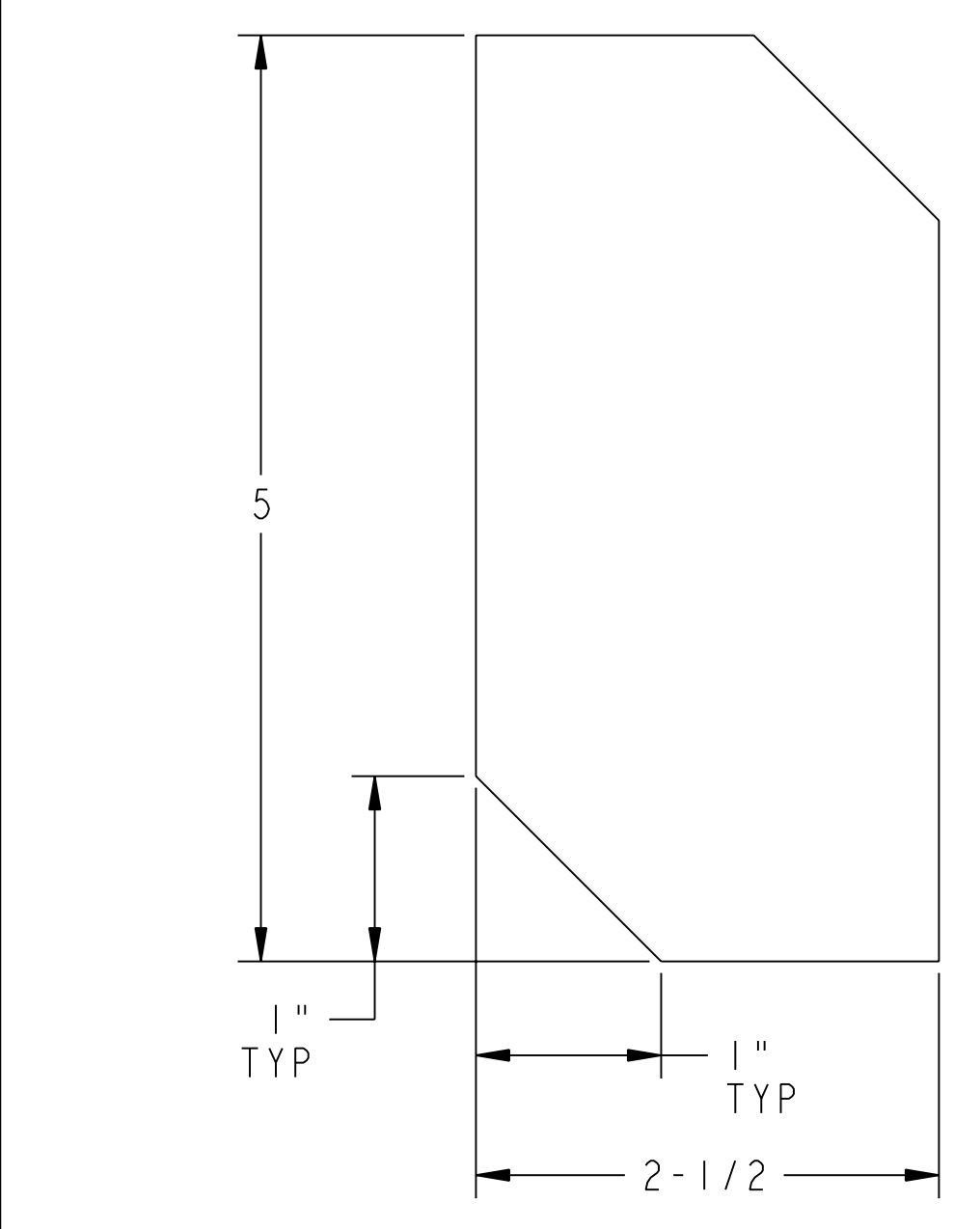
NO.	REVISION	BY	CH	SUP	APPROVED	DATE



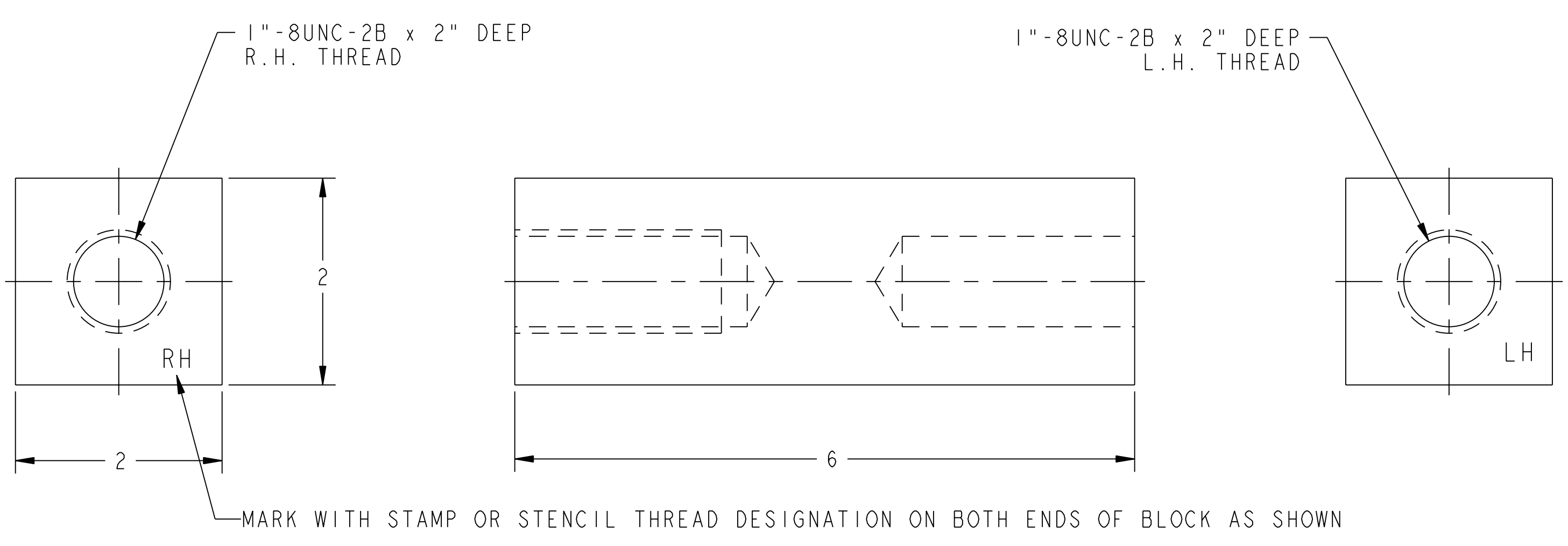
1 FOOT PLATE



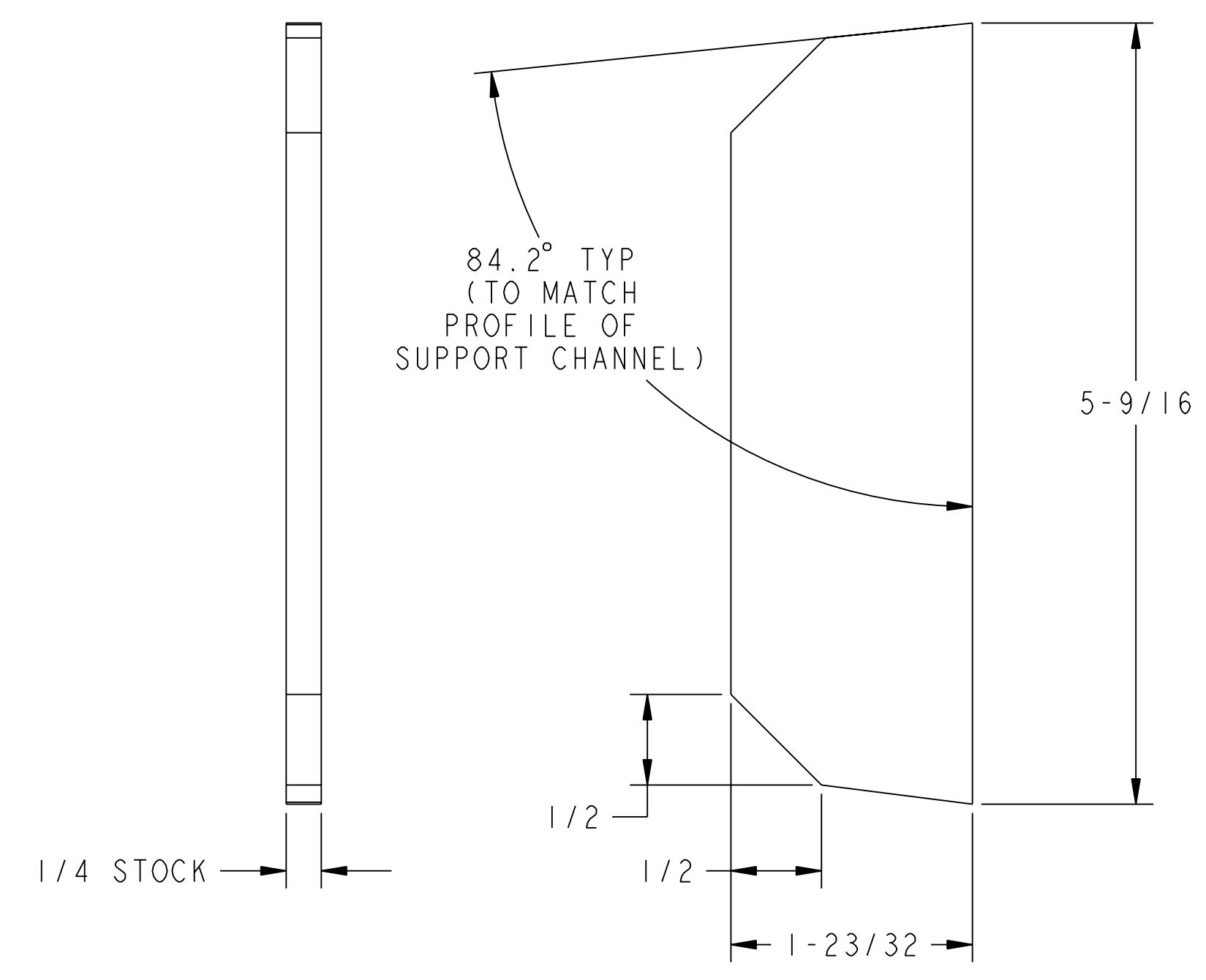
4 GUSSET



5 STIFFENER GUSSET



8 ADJUSTER BAR THREADED BLOCK - R.H. AND L.H. THREADS



11 CHANNEL STIFFENER GUSSET

RELEASED FOR FABRICATION / INSTALLATION
PPPL Drafting

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

RELEASE LEVEL: Fabrication
DWG VERSION NO: 1

WEIGHT	6.1 lbs
MODEL NAME	SE186-333-03
WELDING ENGINEER	

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY 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 AND FABRICATION ADJUSTER BAR SUPPORT STRUCTURE WELDMENTS AND DETAILS	
NEXT ASSEMBLY	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX +/- .000 0°-120° +/- .010 .XXX +/- .005 120°-120° +/- .010 ANGULAR +/- 0°-15° OVER 120° +/- .125	DSN: L. MORRIS	8-2-2007 DRAWING NO:
		CHK: M. COLE	8-2-2007
		ENGR: T. BROWN	8-2-2007
		SUPV: J. SIEGEL	8-2-2007
			SHEET 3 OF 3
			REV D. 3

NCSX-SE186-333