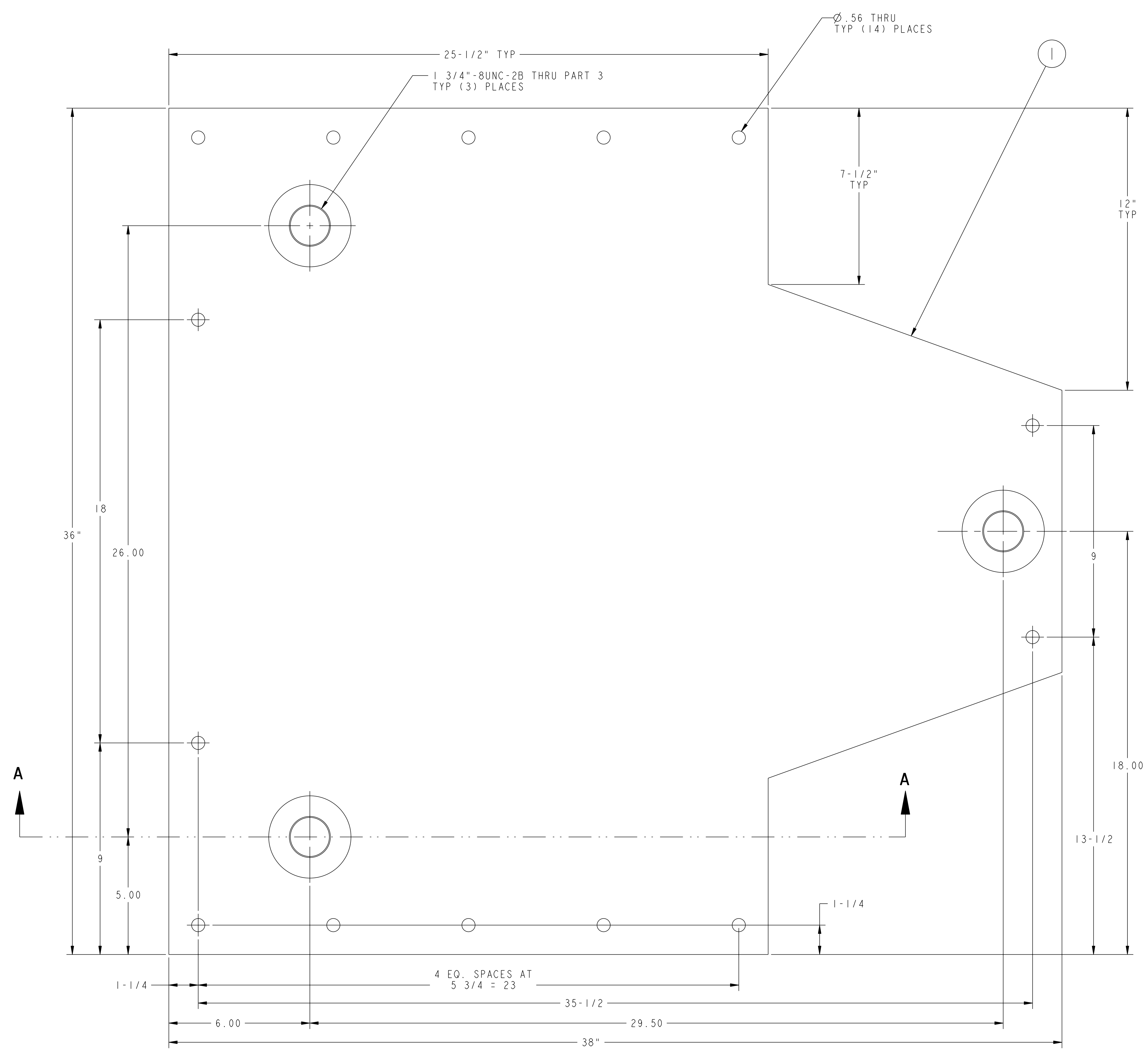


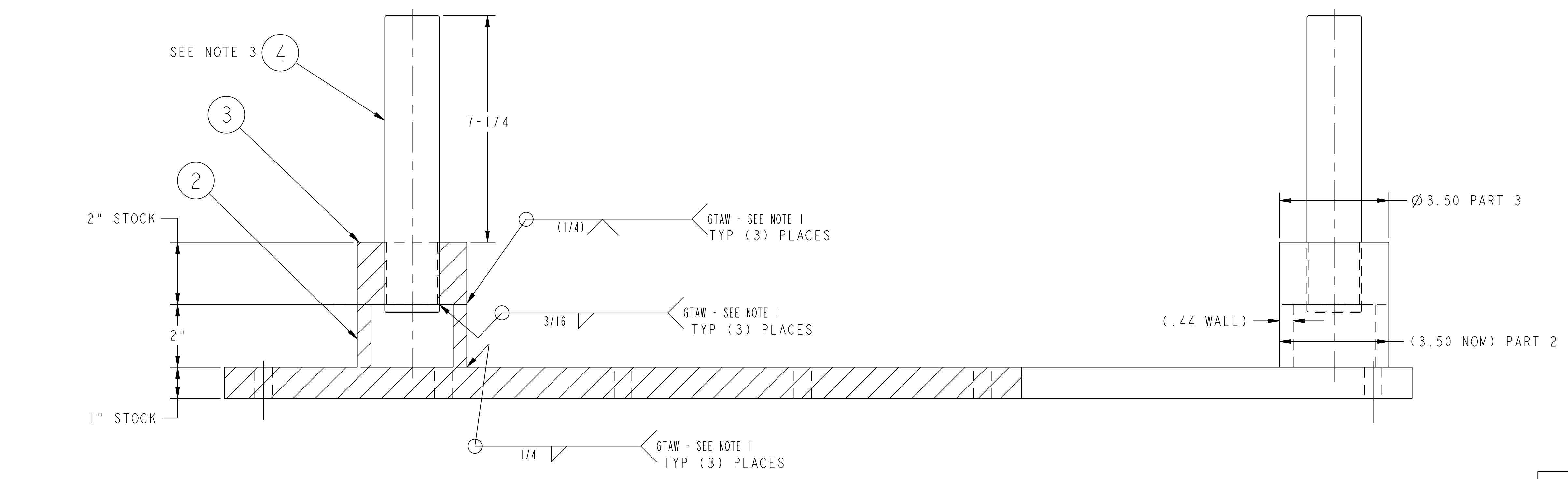
NO.	REVISION	BY	CH	SUP	APPROVED	DATE
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NOTES

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.
3. PART 4, THREADED ROD, TO BE MADE FROM McMASTER-CARR #98957A660 (3 FT. LENGTH) OR EQUIVALENT. MUST MEET ASTM A193 GRADE B7 REQUIREMENTS OR BETTER.

RFD-18-004 replaced either "GMAW or GTAW" welds with either "GMAW or FCAW" welds wherever appearing on this drawing. See RFD-18-004 for details)



RELEASED FOR FABRICATION / INSTALLATION
PPPL Drafting

Q1 ASSY	PART NO.	DRAWING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY REQD
	3	4	THIS DWG	1 3/4"-8UNC-2A x 9 1/2" LG THREADED ROD	ASTM A193 GRADE B7
	3	3	THIS DWG	PIPE TOP PLATE	ASTM A36
	3	2	THIS DWG	SUPPORT PIPE - 3" PIPE SCHEDULE 160	ASTM A120
	1	1	THIS DWG	BASE SUPPORT PLATE	ASTM A36
			THIS DWG	BASE SUPPORT WELDMENT	

PARTS LIST

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 UNLESS OTHERWISE SPECIFIED BREAK SHARP EDGES .005/.020		NATIONAL COMPACT STELLARATOR EXPERIMENT	
WEIGHT 366.0 lbs		TOLERANCES NON-CUMULATIVE		FIELD PERIOD ASSEMBLY VACUUM VESSEL SUPPORT ASSEMBLY BASE SUPPORT WELDMENT	
MODEL NAME SE184-051-01		DECIMAL-INCH FRACTIONS		DRAWING NO: SE184-051	
WELDING ENGINEER G. GETTELFINGER 8-2-2007		.XX +/- .000 .XXX +/- .005 ANGULAR +/- 0°-15'		DSN: L. MORRIS 8-2-2007 CHK: M. COLE 8-2-2007 ENGR: T. BROWN 8-2-2007 SUPV: J. SIEGEL 8-2-2007	
RELEASE LEVEL: Fabrication DWG VERSION NO: 10		NEXT ASSEMBLY		SHEET 1 OF 1 REV 0	

SECTION A-A

NCSX-SE184-051