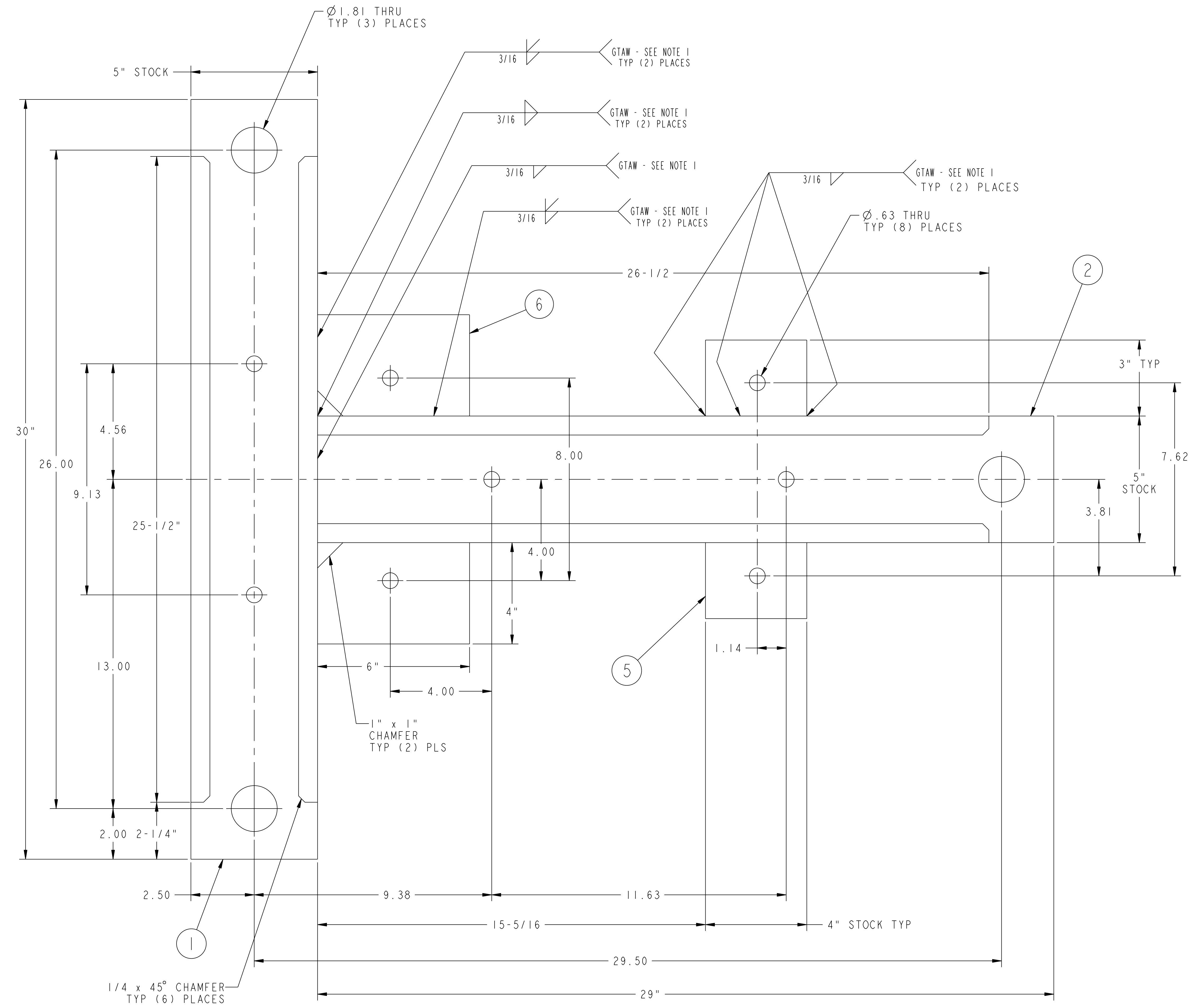
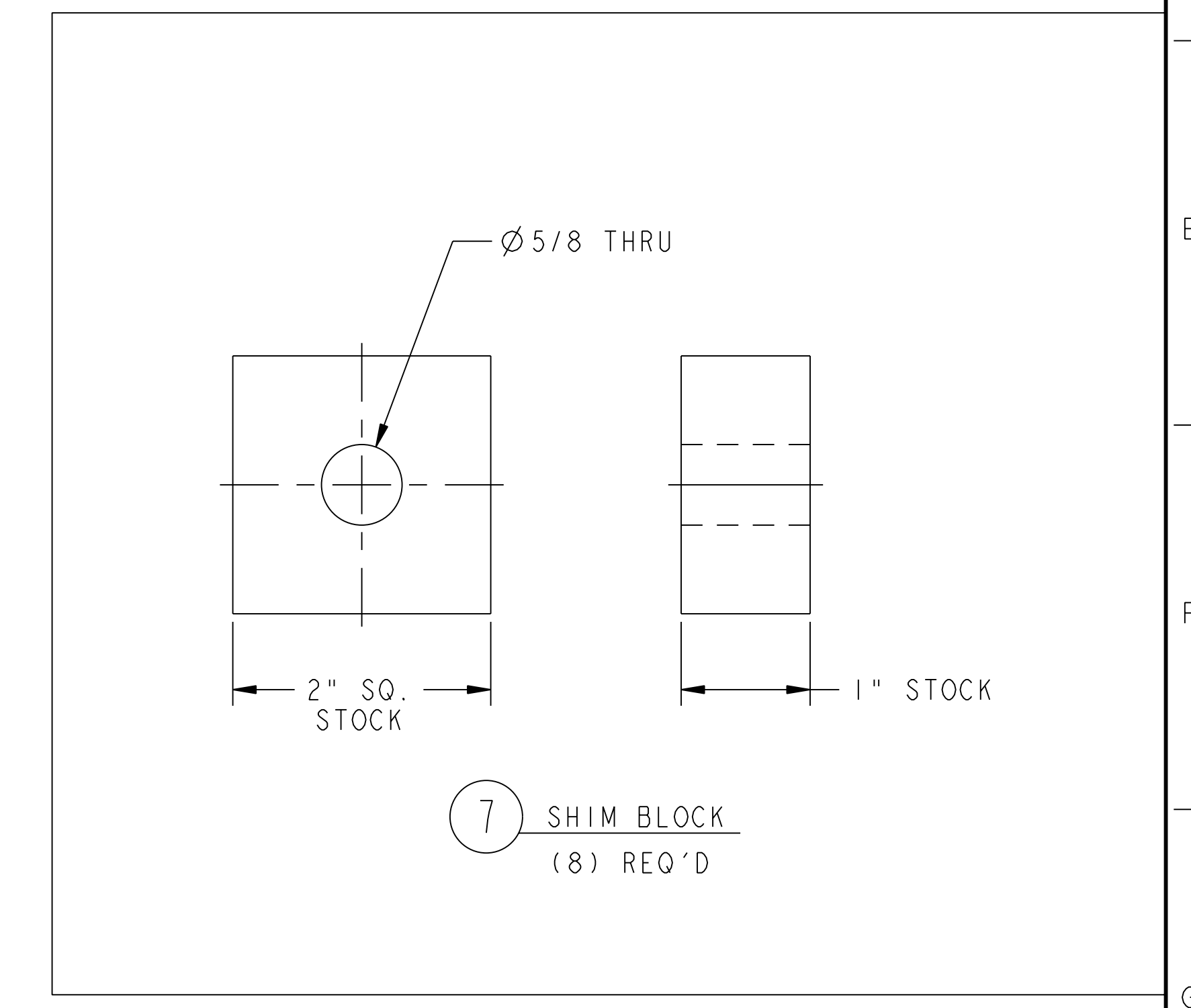


NO.	REVISION	BY	CH	SUP	APPROVED	DATE



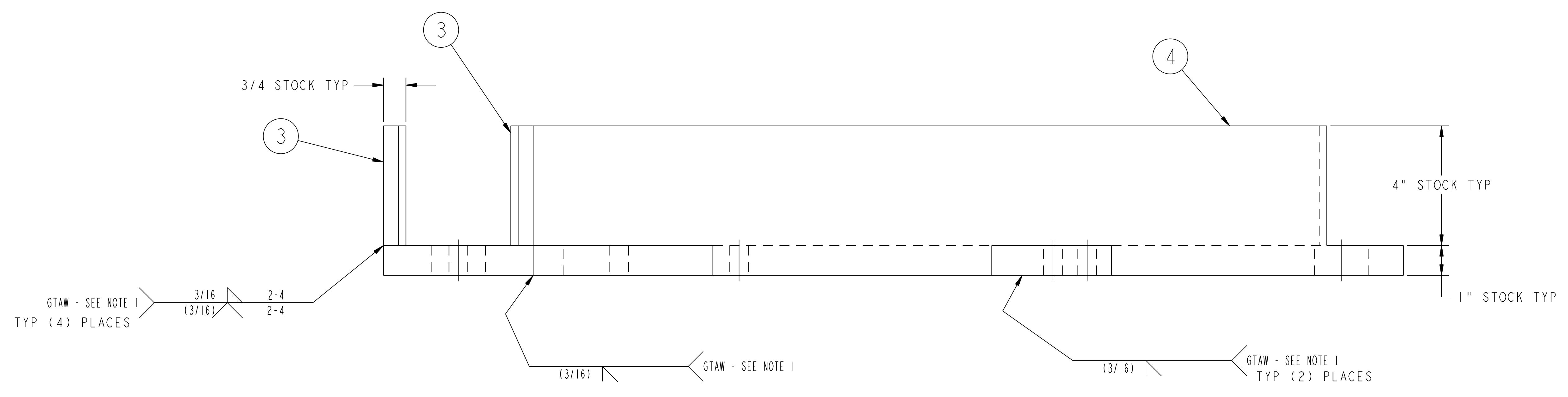
NOTES

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. ALL HOLES TO BE MACHINED AFTER ALL WELDS ARE COMPLETE.



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

RELEASED FOR FABRICATION / INSTALLATION
PPPL Drafting



QTY	PART NO.	DRAWING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY REQD
—	7	THIS DWG	SHIM BLOCK	ASTM A36	8
2	6	THIS DWG	SUPPORT BLOCK	ASTM A36	
2	5	THIS DWG	SUPPORT WING	ASTM A36	
2	4	THIS DWG	REINFORCING BAR - LONG	ASTM A36	
2	3	THIS DWG	REINFORCING BAR - SHORT	ASTM A36	
1	2	THIS DWG	BASE BAR - LONG	ASTM A36	
1	1	THIS DWG	BASE BAR - SHORT	ASTM A36	
—	—	THIS DWG	SUPPORT "TEE" BAR WELDMENT		1

COMPUTER GENERATED DRAWING DRAWING 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 PRINCETON UNIVERSITY NATIONAL COMPACT STELLARATOR EXPERIMENT FIELD PERIOD ASSEMBLY VACUUM VESSEL SUPPORT ASSEMBLY SUPPORT "TEE" BAR WELDMENT	
WEIGHT 194.7 lbs	MODEL NAME SE184-052-01	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX ±.010 0°-120° ±.010 .XX ±.030 120°-120° ±.010 .XXX ±.005 120°-120° ±.010 ANGULAR ±.0°-15° OVER 120° ±.1°	DSN: L. MORRIS 8-2-2007 CHK: M. COLE 8-2-2007 ENGR: T. BROWN 8-2-2007 SUPV: J. SIEGEL 8-2-2007	DRAWING NO: SE184-052 SHEET 1 OF 1 REV 0

RELEASE LEVEL: Fabrication
DWG VERSION NO: 11

NCSX-SE184-052