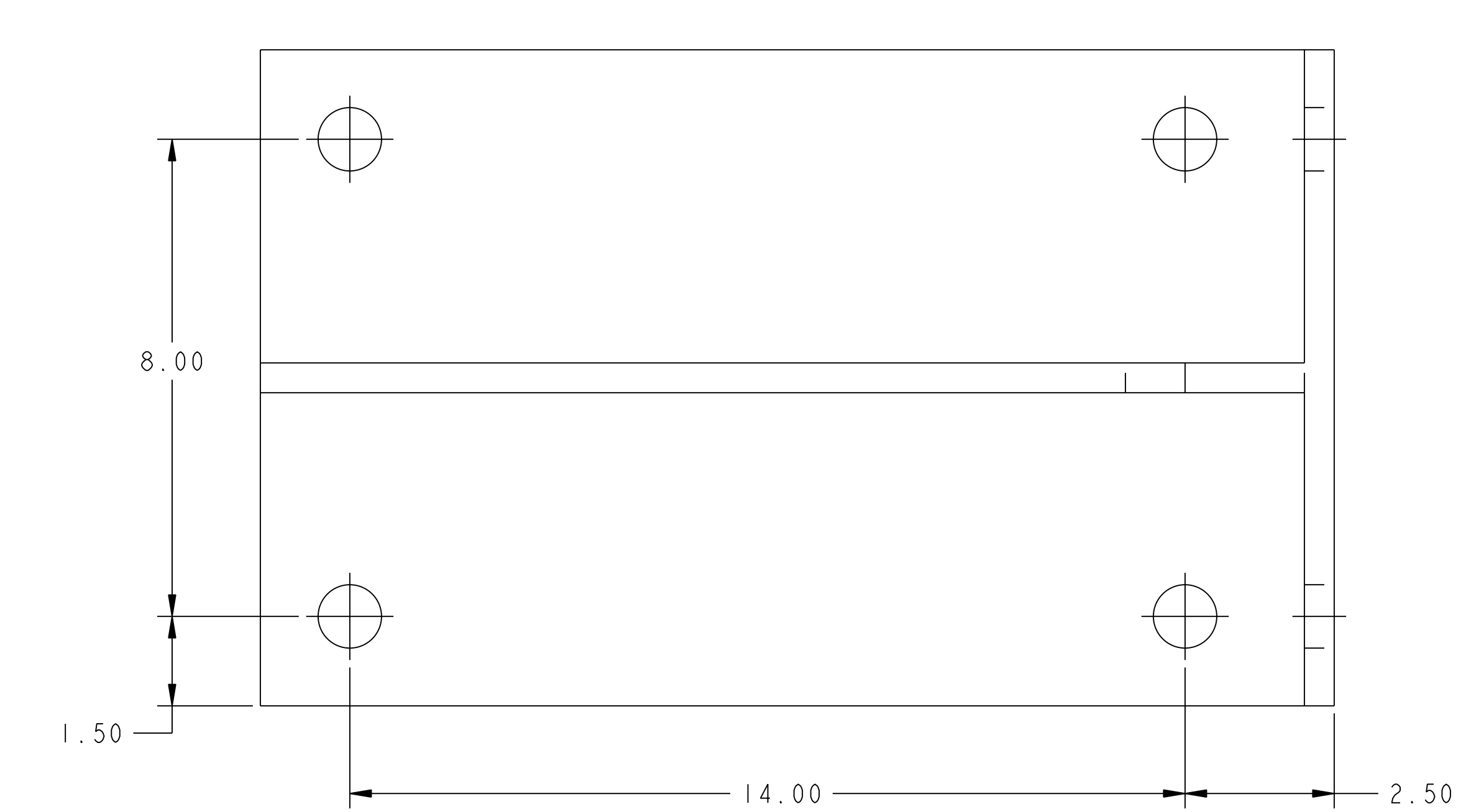
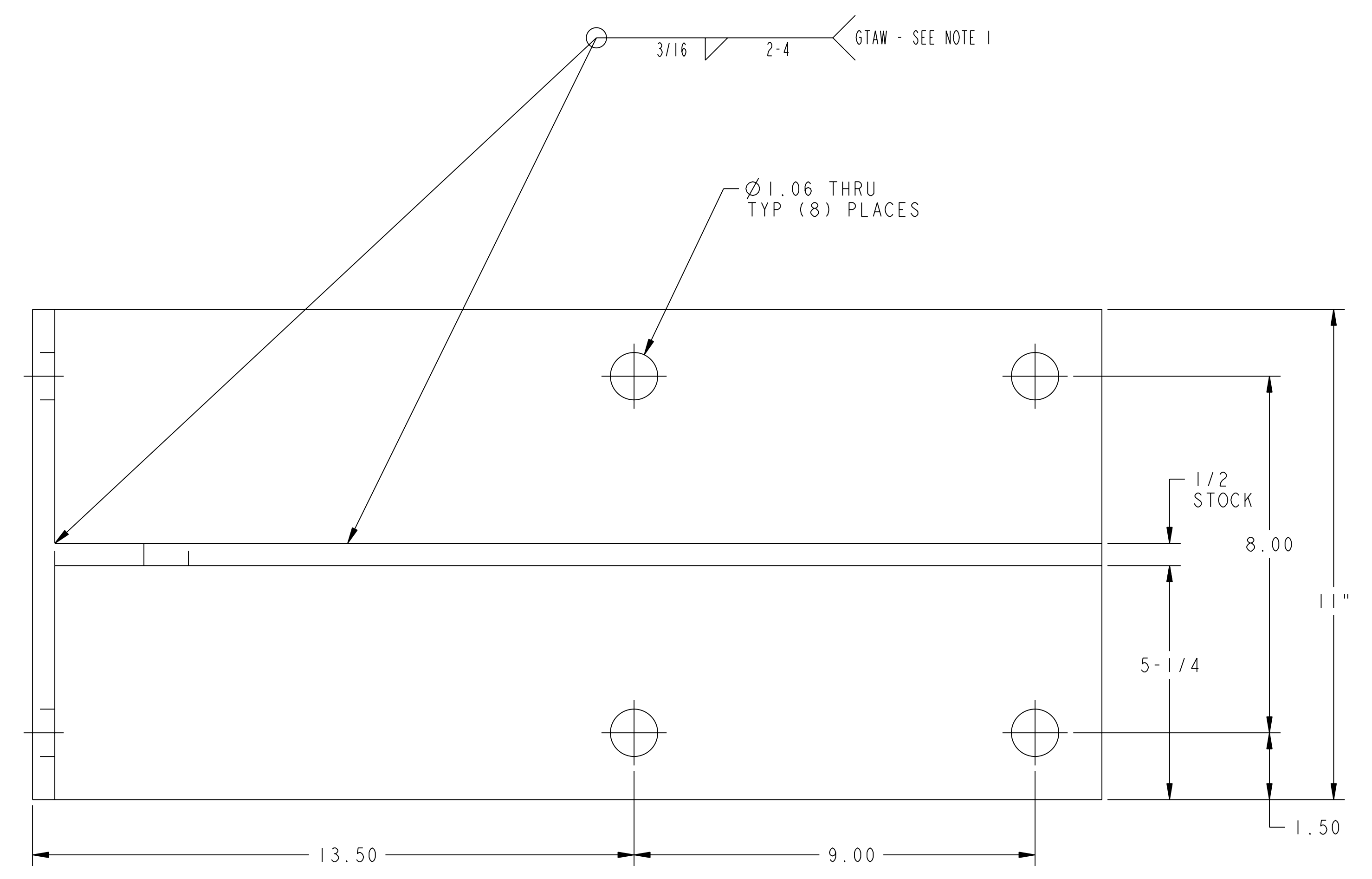


NO.	REVISION	BY	CH	SUP	APPROVED	DATE

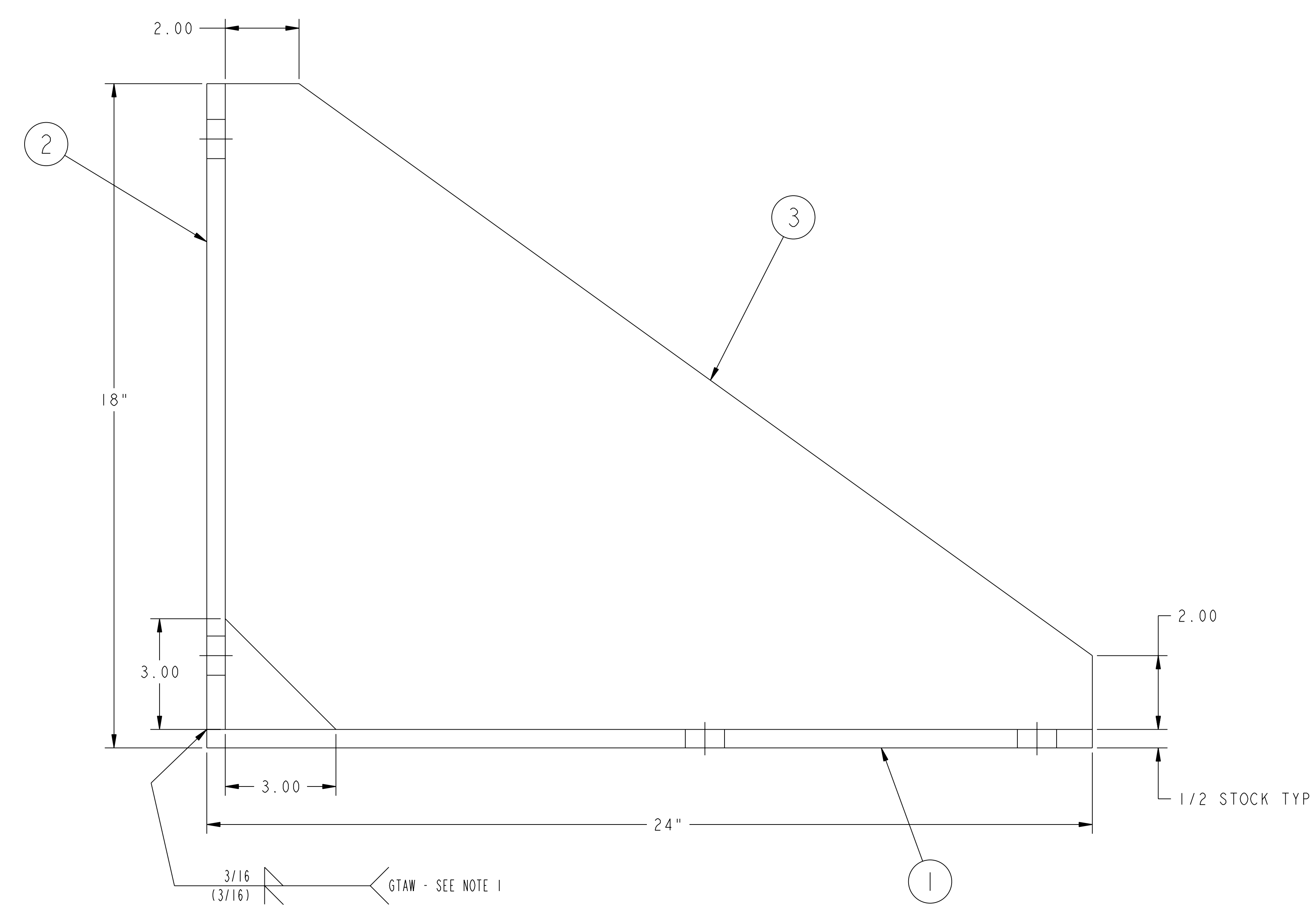


RFD-18-004 replaced either "GMAW or GTAW" welds with either "GMAW or FCAW" welds wherever appearing on this drawing. See RFD-18-004 for details)

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.

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01 ASSEMBLY
(1) REQ'D

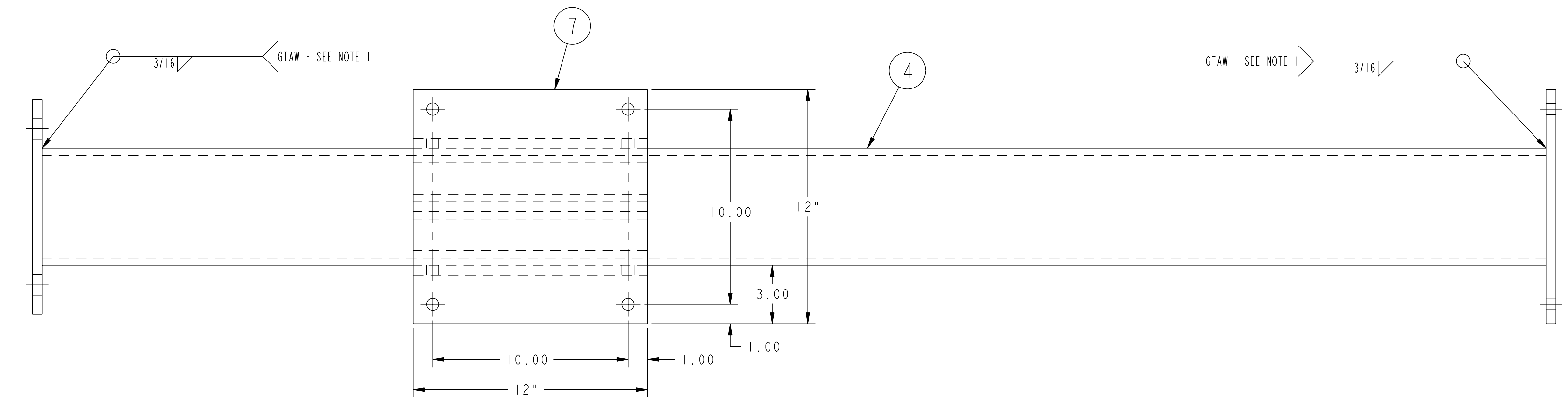
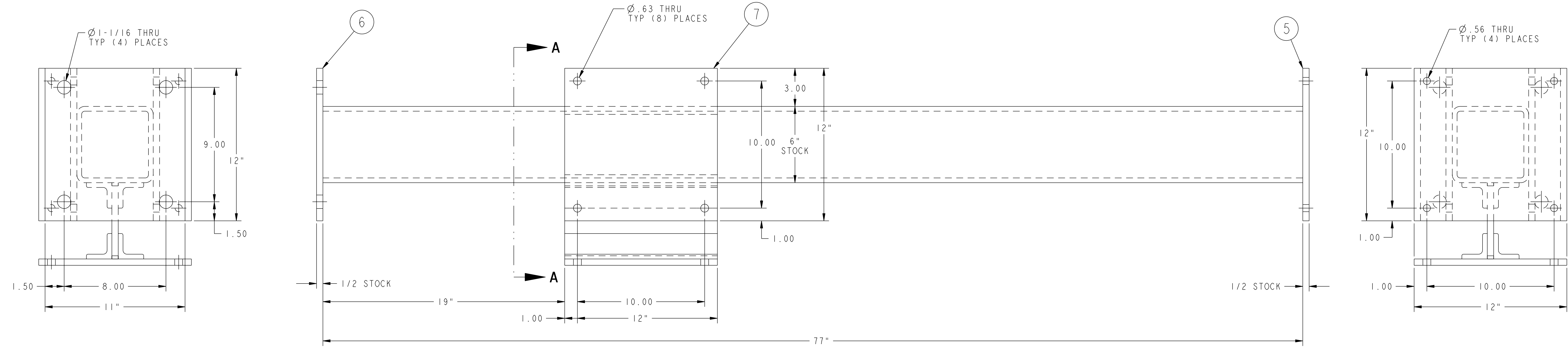
REV	NO.	DATE	DESCRIPTION	MATERIAL	QTY	RECD	
1	12		THIS DWG	OUTRIGGER TIE PLATE	ASTM A36		
1	11		THIS DWG	FOOT PLATE	ASTM A36		
1	10		THIS DWG	OUTRIGGER TUBE - 6" x 6" x 3/8 STRUCT TUBE	ASTM A36		
4	9		THIS DWG	MOUNTING CLIP ANGLE - 2 x 2 x 3/8 STRUCT ANGLE	ASTM A36		
1	8		THIS DWG	SANDWICH PLATE	ASTM A36		
2	7		THIS DWG	TIE PLATE	ASTM A36		
1	6		THIS DWG	TOP PLATE	ASTM A36		
1	5		THIS DWG	BASE PLATE	ASTM A36		
1	4		THIS DWG	VERTICAL TUBE - 6" x 6" x 3/8 STRUCT TUBE	ASTM A36		
	1	3	THIS DWG	GUSSET	ASTM A36		
	1	2	THIS DWG	VERTICAL PLATE	ASTM A36		
	1	1	THIS DWG	BASE PLATE	ASTM A36		
			THIS DWG	OUTRIGGER WELDMENT		3	
			THIS DWG	VERTICAL SUPPORT WELDMENT		1	
			THIS DWG	SUPPORT BRACKET WELDMENT		1	
03	02	01	PART NO.	DRAWING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY RECD

PARTS LIST

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 PRINCETON UNIVERSITY NATIONAL COMPACT STELLARATOR EXPERIMENT FIELD PERIOD ASSEMBLY VACUUM VESSEL SUPPORT ASSEMBLY VERTICAL SUPPORT WELDMENTS	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX ±.010 0"-12" ±.010 .XXX ±.005 12"-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: SE184-056 SHEET 1 OF 3 REV 0
WEIGHT 100.0 lbs	MODEL NAME SE184-056-01	WELDING ENGINEER G. GETTELFINGER 8-2-2007	RELEASE LEVEL: Fabrication DWG VERSION NO: 3

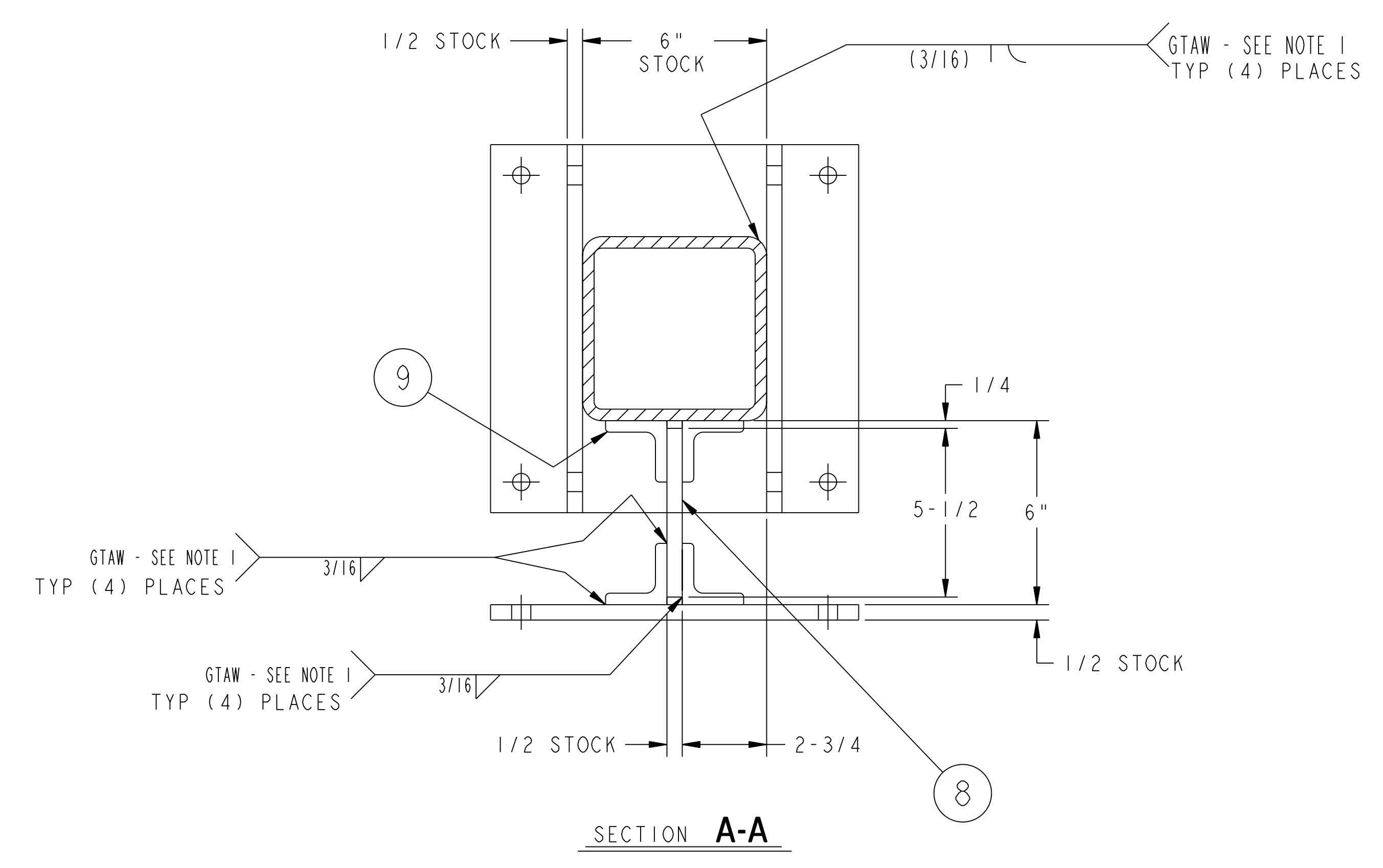
NCSX-SE184-056

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



02 ASSEMBLY

(1) REQ'D



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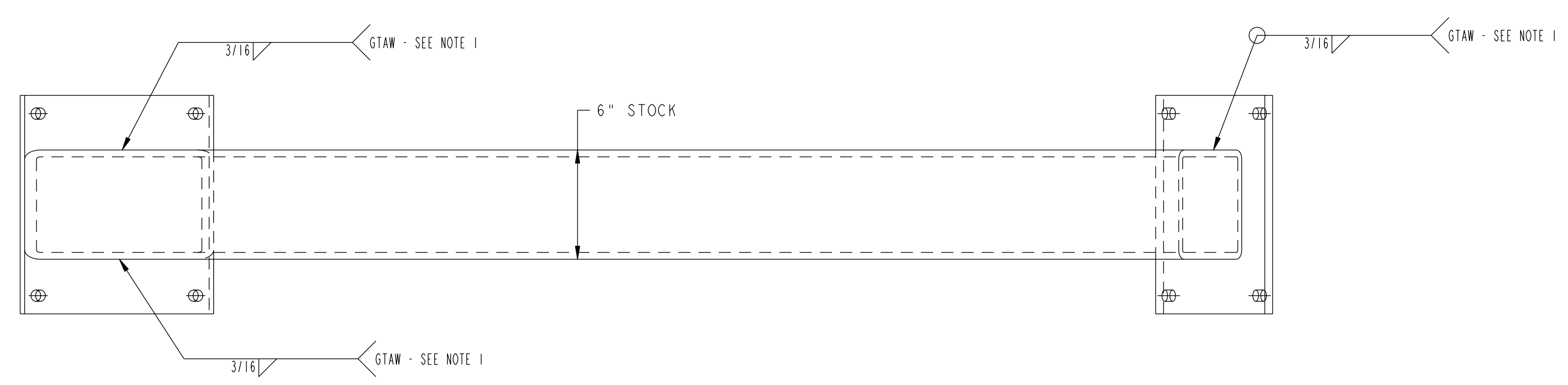
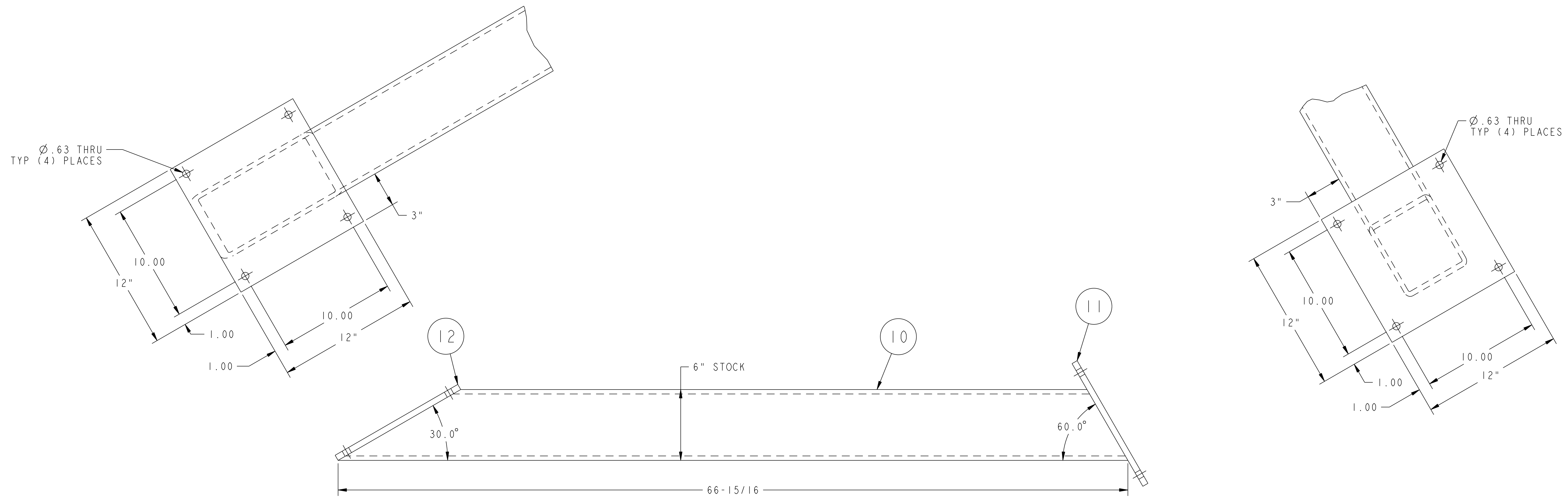
FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

COMPUTER GENERATED DRAWING CHANGES NOT PERMITTED Pro E DO NOT VERIFY INFORMATION BY SCALING DRAWING	CENTRAL FILES:	PRINCETON PLASMA PHYSICS LABORATORY	
	UNLESS OTHERWISE SPECIFIED	NATIONAL COMPACT STELLARATOR EXPERIMENT	
DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	FIELD PERIOD ASSEMBLY VACUUM VESSEL SUPPORT ASSEMBLY VERTICAL SUPPORT WELDMENTS		DRAWING NO:
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 CHK: M. COLE 8-2-2007 ENGR: T. BROWN 8-2-2007 SUPV: J. SIEGEL 8-2-2007	SE184-056 SHEET 2 OF 3 REV D, 2	

RELEASE LEVEL: Fabrication
 DWG VERSION NO: 3

WELDING ENGINEER
 G. GETTELFINGER 8-2-2007

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



03 ASSEMBLY
(3) REQ'D

**RELEASED FOR
FABRICATION / INSTALLATION**
PPPL Drafting

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES:	PRINCETON PLASMA PHYSICS LABORATORY NATIONAL COMPACT STELLARATOR EXPERIMENT			
	UNLESS OTHERWISE SPECIFIED	FIELD PERIOD ASSEMBLY VACUUM VESSEL SUPPORT ASSEMBLY VERTICAL SUPPORT WELDMENTS			
DO NOT VERIFY INFORMATION BY SCALING DRAWING	DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	DSN: L. MORRIS	8-2-2007	DRAWING NO:	
NEXT ASSEMBLY	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .X +/- .000 .XX +/- .000 .XXX +/- .005 ANGULAR +/- .05	CHK: M. COLE	8-2-2007	SE184-056	
WELDING ENGINEER: G. GETTELFINGER 8-2-2007		ENGR: T. BROWN	8-2-2007	SUPV: J. SIEGEL	8-2-2007
				SHEET 3 OF 3	REV D, 2

RELEASE LEVEL: Fabrication
DWG VERSION NO: 6

WEIGHT
312.3 lbs
MODEL NAME
SE184-056-02

NCSX-SE184-056