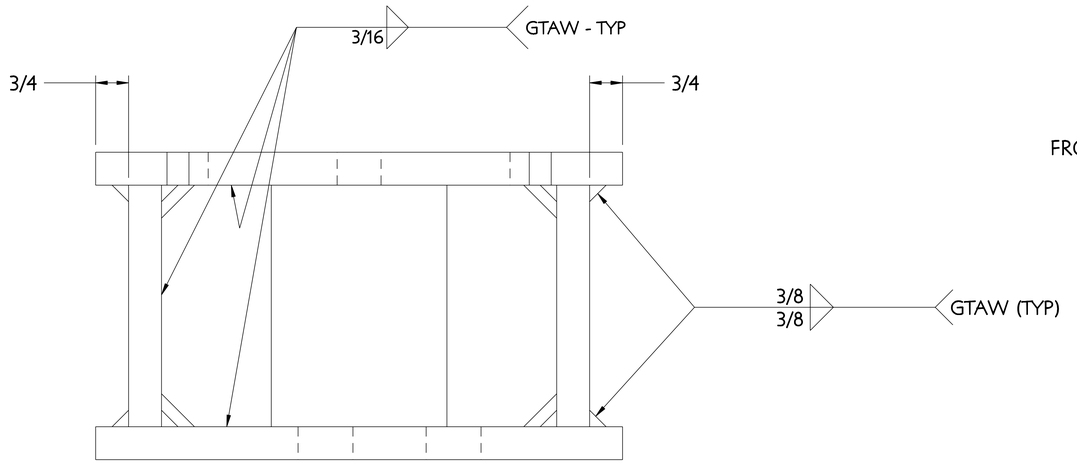
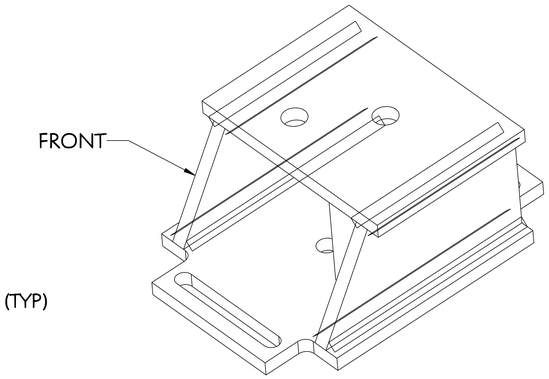
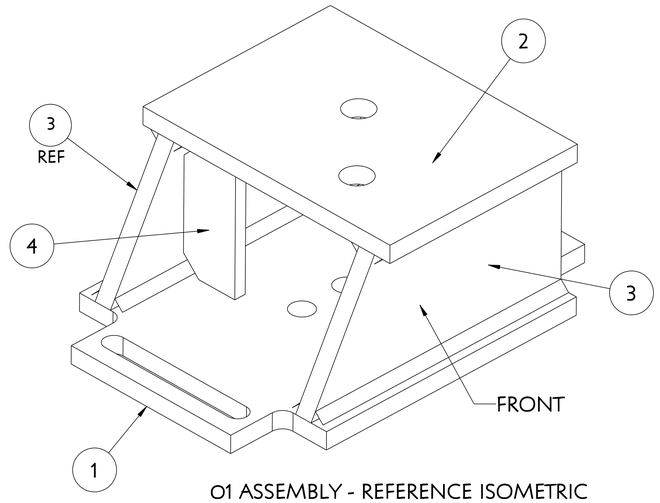
| NO. | REVISION | BY | CH | SUP | APPROVED | DATE |
|---|---|---|---|---|---|---|
| | | | | | | |

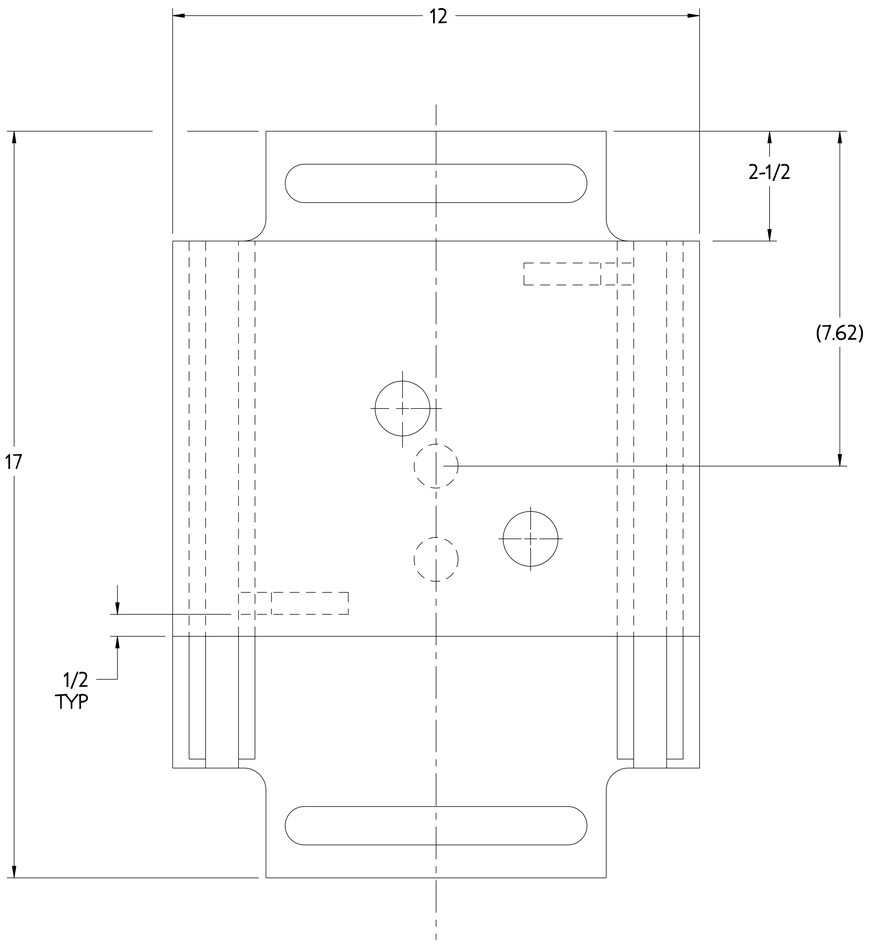


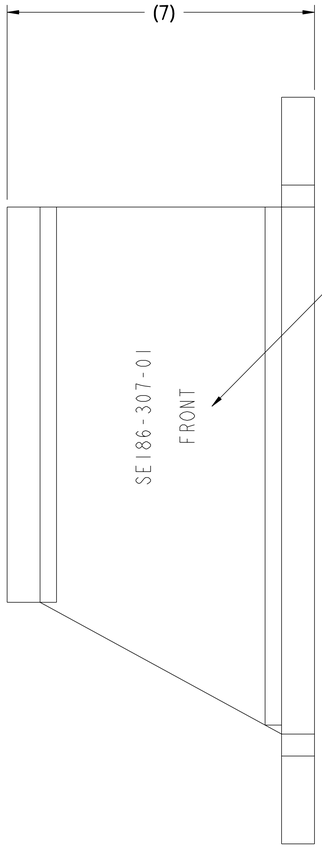




02 ASSEMBLY - REFERENCE ISOMETRIC




01 ASSEMBLY - REFERENCE ISOMETRIC




IDENTIFIER FOR 01 ASSEMBLY AS SHOWN.
IDENTIFIER FOR 02 ASSEMBLY TO BE ON OPPOSITE SIDE.
SEE NOTES.

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.

BRACKET ASSEMBLY IS TO BE STAMPED OR PERMANENTLY MARKED WITH IDENTIFIER AS INDICATED.

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

**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)**

01 ASSEMBLY - AS SHOWN- (1) REQ'D

02 ASSEMBLY - OPPOSITE - (1) REQ'D

RELEASED FOR FABRICATION / INSTALLATION
PPPL Drafting: jerome siegel
Digitally signed by jerome siegel
DN: cn=jerome siegel, o, ou, email=jsiegel@pppl.gov, c=US
Date: 2008.04.22 13:57:04 -04'00'

| PART NO. | DRAWING NO | NOMENCLATURE OR DESCRIPTION | MATERIAL | QTY REQD |
|---|---|---|---|---|
| 4 | SE186-307-4 | GUSSET SEGMENT "C" MCWF BRACKET | ASTM A36 | 2 |
| 3 | SE186-307-3 | SIDE PLATE MCWF SEGMENT "C" SUPPORT BRACKET TYPE #1 | CARBON STEEL | 2 |
| 2 | SE186-307-2 | TOP PLATE MCWF SEGMENT "C" SUPPORT BRACKET TYPE #1 | CARBON STEEL | 1 |
| 1 | SE186-307-1 | BOTTOM PLATE MCWF SEGMENT "C" SUPPORT BRACKET TYPE #1 | CARBON STEEL | 1 |

PARTS LIST

| | | | |
|---|---|---|---|
| COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED | CENTRAL FILES: UNLESS OTHERWISE SPECIFIED | PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY | NATIONAL COMPACT STELLARATOR EXPERIMENT |
| Pro E | DIMENSIONS ARE IN INCHES MACHINE SURFACES 125 | STELLARATOR CORE TOOLING DESIGN & FABRICATION | MCWF SEGMENT "C" SUPPORT BRACKET TYPE #1 WELDMENTS |
| DO NOT VERIFY INFORMATION BY SCALING DRAWING | BREAK SHARP EDGES .005/.020 | | |
| SCALE 0.750 | TOLERANCES NON-CUMULATIVE | DSN: J. RUSHINSKI 8-2-2007 | DRAWING NO: |
| NEXT ASSEMBLY | DECIMAL-INCH: .X +/-.100, .XX +/-.030, .XXX +/-.005, ANGULAR +/-0°-15' / FRACTIONS: 0°-12° +/-1/16, 12°-72° +/-1/8, 72°-120° +/-1/4, OVER 120° +/-1/2 | CHK: M. COLE 8-2-2007 | SE186-307 |
| | | ENGR: T. BROWN 8-2-2007 | |
| | | SUPV: J. SIEGEL 8-2-2007 | SHEET 1 OF 2 REV 0 |

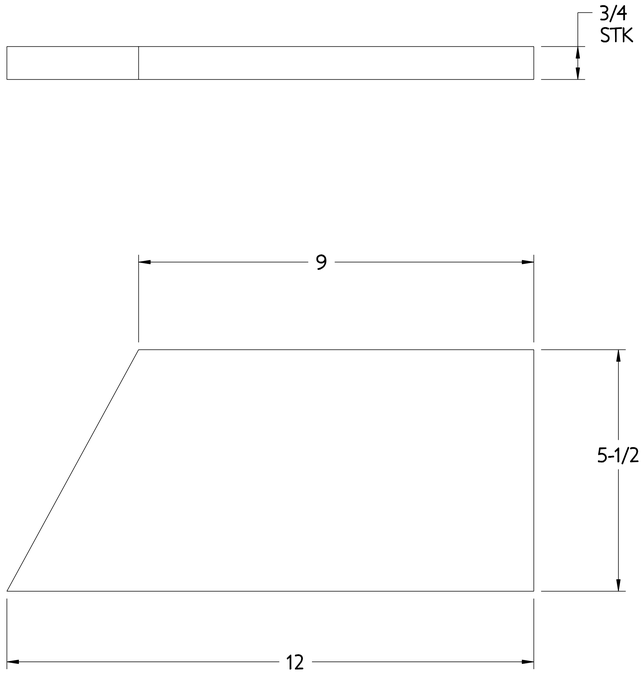
| WEIGHT | MODEL NAME | WELDING ENGINEER |
|---|---|---|
| 88.8 lbs | SE186-307-01 | G.GETTELFINGER 8-2-2007 |

RELEASE LEVEL: FABRICATION
DWG VERSION NO: 6

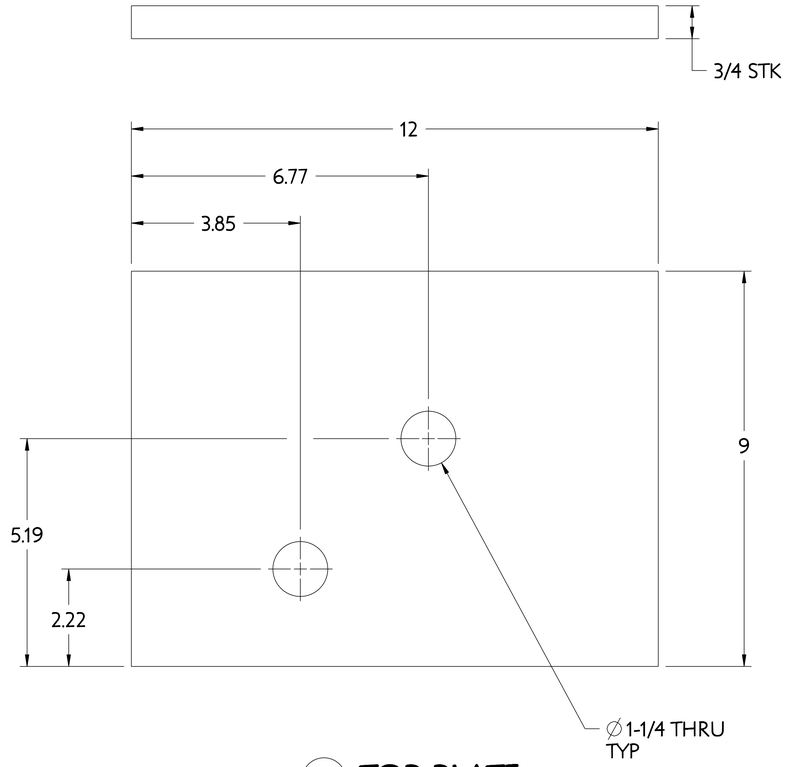
NCSX-SE186-307

NCSX_ASSY_FORMAT_E

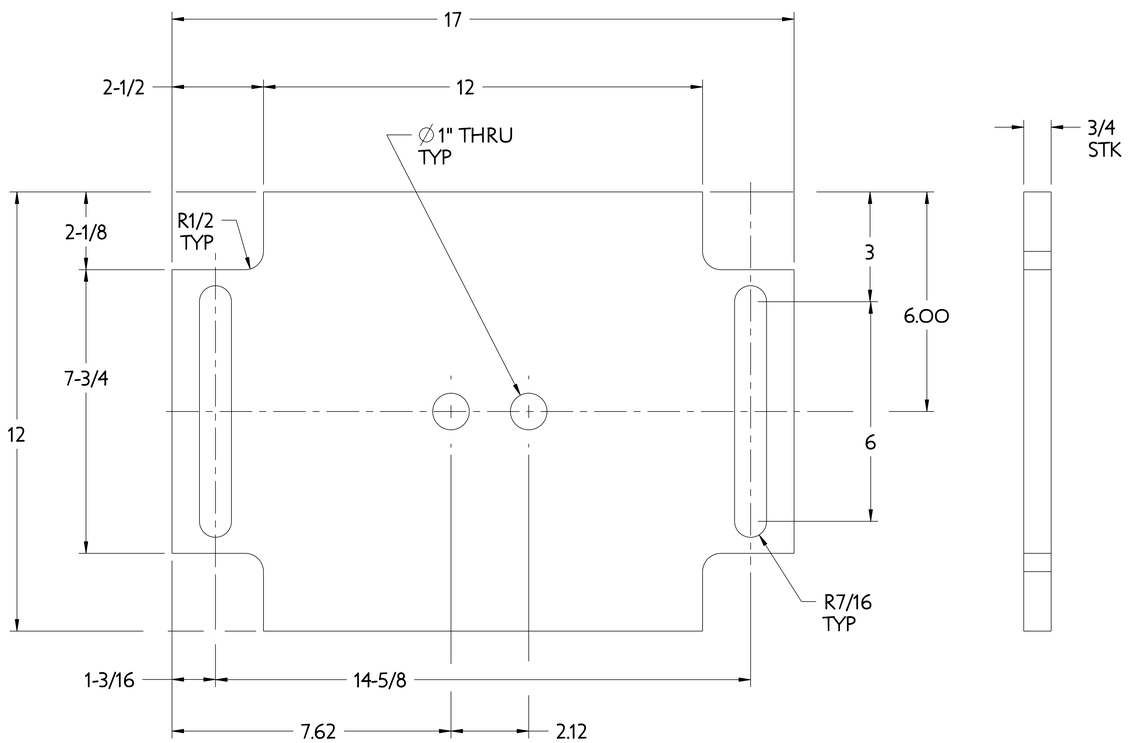
| NO. | REVISION | BY | CH | SUP | APPROVED | DATE |
|---|---|---|---|---|---|---|
| | | | | | | |



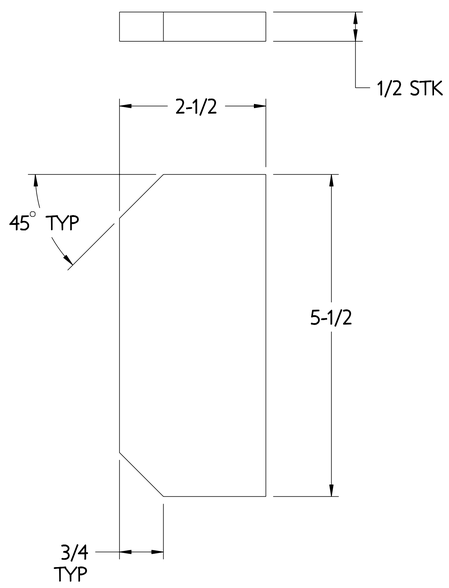

3 SIDE PLATE




2 TOP PLATE




1 BOTTOM PLATE




4 GUSSET

**RELEASED FOR FABRICATION / INSTALLATION**
PPPL Drafting: jerome siegel
Digitally signed by jerome siegel
DN: cn=jerome siegel, o, ou, email=siegel@pppl.gov, c=US
Date: 2008.04.22 13:57:04 -04'00'

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

| | | | |
|---|---|---|---|
| WEIGHT 88.8 lbs | COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED | CENTRAL FILES: UNLESS OTHERWISE SPECIFIED | PRINCETON PLASMA PHYSICS LABORATORY, PRINCETON UNIVERSITY, NATIONAL COMPACT STELLARATOR EXPERIMENT |
| MODEL NAME SE186-307-01 | Pro E | DIMENSIONS ARE IN INCHES, MACHINE SURFACES 63 | STELLARATOR CORE TOOLING DESIGN & FABRICATION |
| | DO NOT VERIFY INFORMATION BY SCALING DRAWING | BREAK SHARP EDGES .005/.020 | MCWF SEGMENT "C" SUPPORT BRACKET TYPE #1 WELDMENTS |
| | | TOLERANCES NON-CUMULATIVE | DSN: J. RUSHINSKI 8-2-2007 DRAWING NO: |
| | NEXT ASSEMBLY | DECIMAL-INCH: .X +/-.100, .XX +/-.030, .XXX +/-.005, ANGULAR +/-0°-15'; FRACTIONS: 0°-12" +/-1/16, 12°-72" +/-1/8, 72°-120" +/-1/4, OVER 120" +/-1/2 | CHK: M. COLE 8-2-2007 SE186-307 |
| | | | ENGR: T. BROWN 8-2-2007 |
| | | | SUPV: J. SIEGEL 8-2-2007 SHEET 2 OF 2 REV D.6 |
| RELEASE LEVEL: FABRICATION | WELDING ENGINEER | | |
| DWG VERSION NO: 6 | | | |

NCSX-SE186-307

NCSX_ASSY_FORMAT_E