

IDENTIFIER FOR O2 ASSEMBLY AS SHOWN.
IDENTIFIER FOR O1 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)

O1 ASSEMBLY - AS SHOWN - (1) REQ'D
O2 ASSEMBLY - OPPOSITE - (1) REQ'D

RELEASED FOR FABRICATION / INSTALLATION
PPPL Drafting

RELEASE LEVEL: FABRICATION
DWG VERSION NO: 4

WEIGHT	112.1 lbs
MODEL NAME	SE186-308-01
WELDING ENGINEER	G. GETTELFINGER 8-2-2007

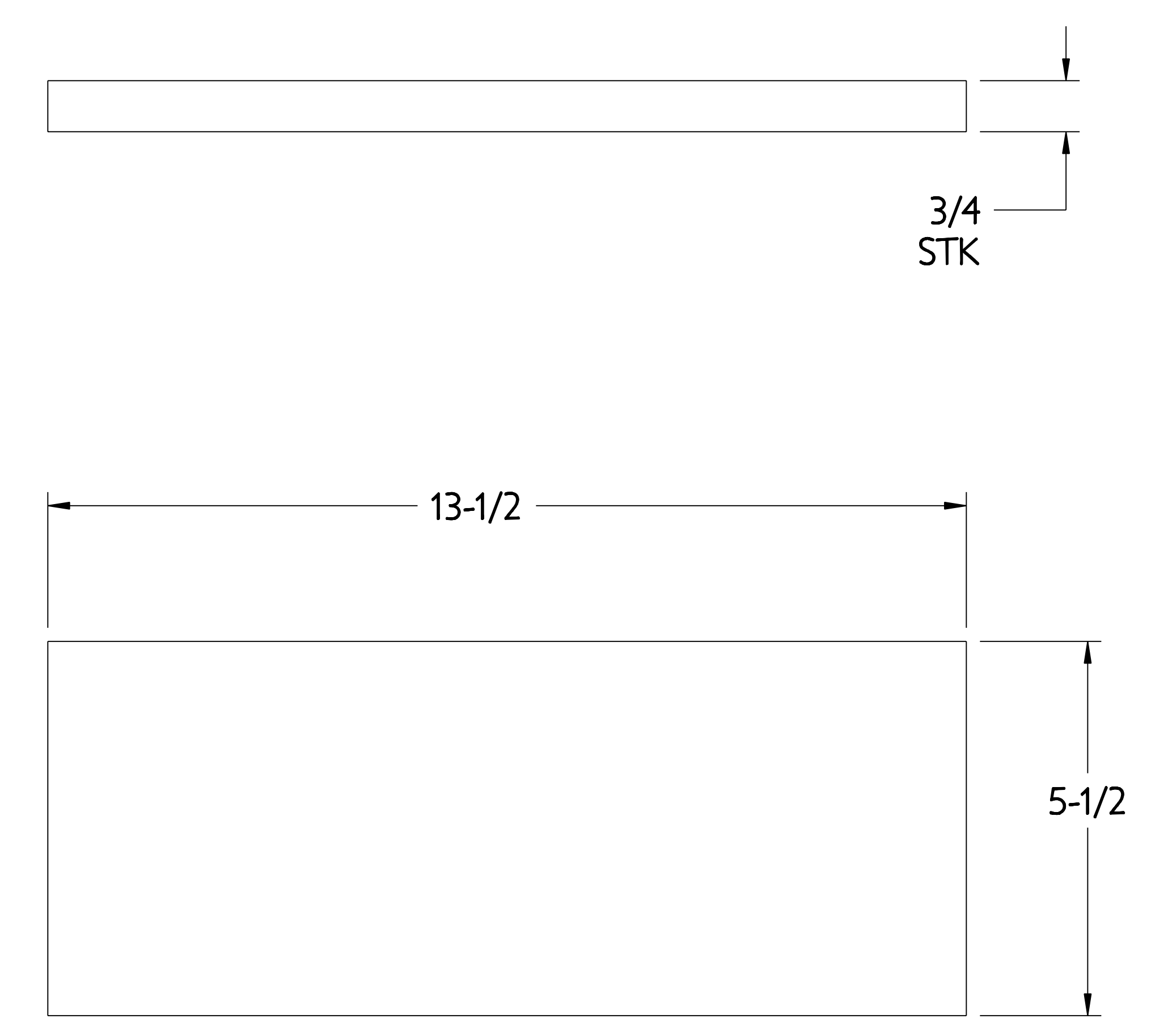
PART NO.	DRAWING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY	RECD
4	SE186-308-3	BOTTOM PLATE MCWF SEGMENT "C" SUPPORT BRACKET TYPE #2	CARBON STEEL	1	
3	SE186-308-2	TOP PLATE MCWF SEGMENT "C" SUPPORT BRACKET TYPE #2	CARBON STEEL	1	
2	SE186-308-1	SIDE PLATE MCWF SEGMENT "C" SUPPORT BRACKET TYPE #2	CARBON STEEL	2	
1	SE186-307-4	GUSSET SEGMENT "C" MCWF BRACKET	ASTM A36	2	

PARTS LIST

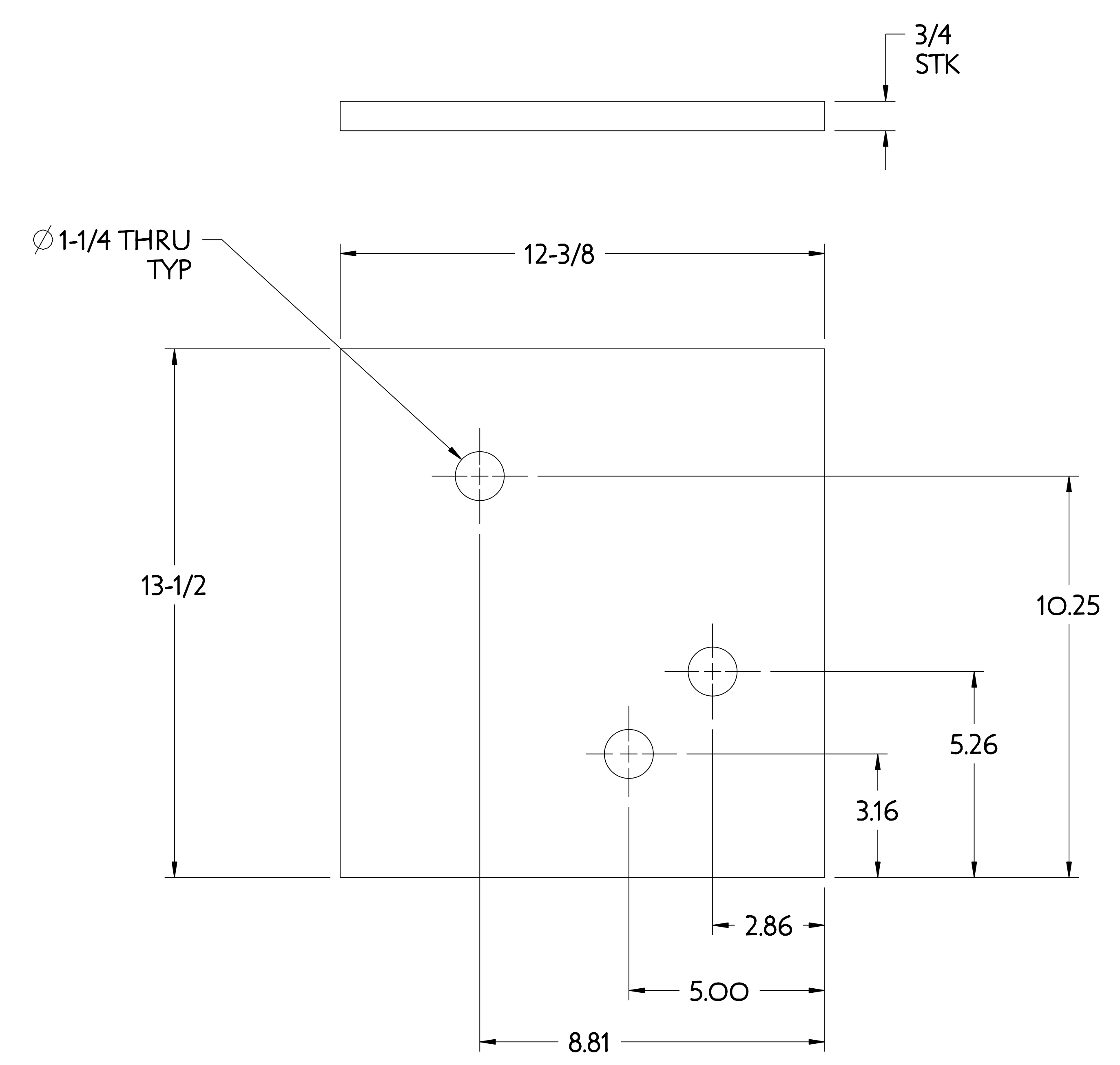
COMPUTER GENERATED DRAWING DRAWING CHANGES NOT PERMITTED	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY NATIONAL COMPACT STELLARATOR EXPERIMENT	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	STELLARATOR CORE TOOLING DESIGN & FABRICATION MCWF SEGMENT "C" SUPPORT BRACKET TYPE #2 WELDMENTS	
SCALE 0.750	TOLERANCES NON-CUMULATIVE	DSN: J. RUSHINSKI 8-2-2007	DRAWING NO:
NEXT ASSEMBLY	DECIMAL-INCH FRACTIONS	CHK: M. COLE 8-2-2007	SE186-308
	.XX +/- .000 0°-120° +/- 1.0°	ENGR: T. BROWN 8-2-2007	
	.XXX +/- .005 72°-120° +/- 1.0°	SUPV: J. SIEGEL 8-2-2007	SHEET 1 OF 2
	ANGULAR +/- 0°-15° OVER 120° +/- 1.0°		REV 0

NCSX-SE186-308

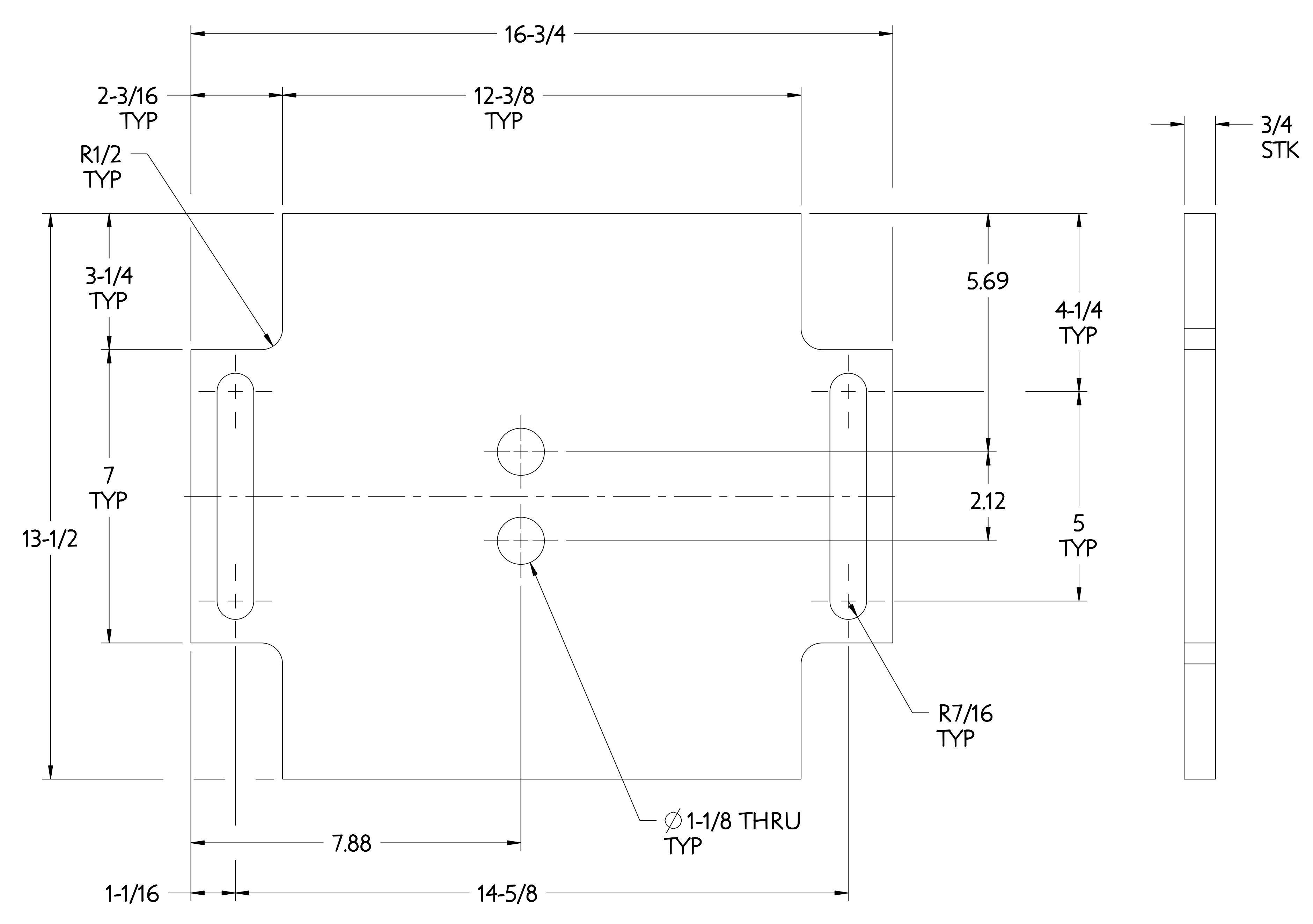
NO.	REVISION	BY	CH	SUP	APPROVED	DATE



1 SIDE PLATE



2 TOP PLATE



3 BOTTOM PLATE

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FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

COMPUTER GENERATED DRAWING MANUAL 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	
WEIGHT	DIMENSIONS ARE IN INCHES MACHINE SURFACES	STELLARATOR CORE TOOLING DESIGN & FABRICATION	
112.1 lbs	BREAK SHARP EDGES .005/.020	MCWF SEGMENT "C" SUPPORT BRACKET TYPE #2 WELDMENTS	
MODEL NAME	TOLERANCES NON-CUMULATIVE	DSN: J. RUSHINSKI	8-2-2007 DRAWING NO:
SE186-308-01	DECIMAL-INCH FRACTIONS	CHK: M. COLE	8-2-2007
WELDING ENGINEER	NEXT ASSEMBLY	ENGR: T. BROWN	8-2-2007
		SUPV: J. SIEGEL	8-2-2007
			SHEET 2 OF 2 REV 0

RELEASE LEVEL: FABRICATION
DWG VERSION NO: 4

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