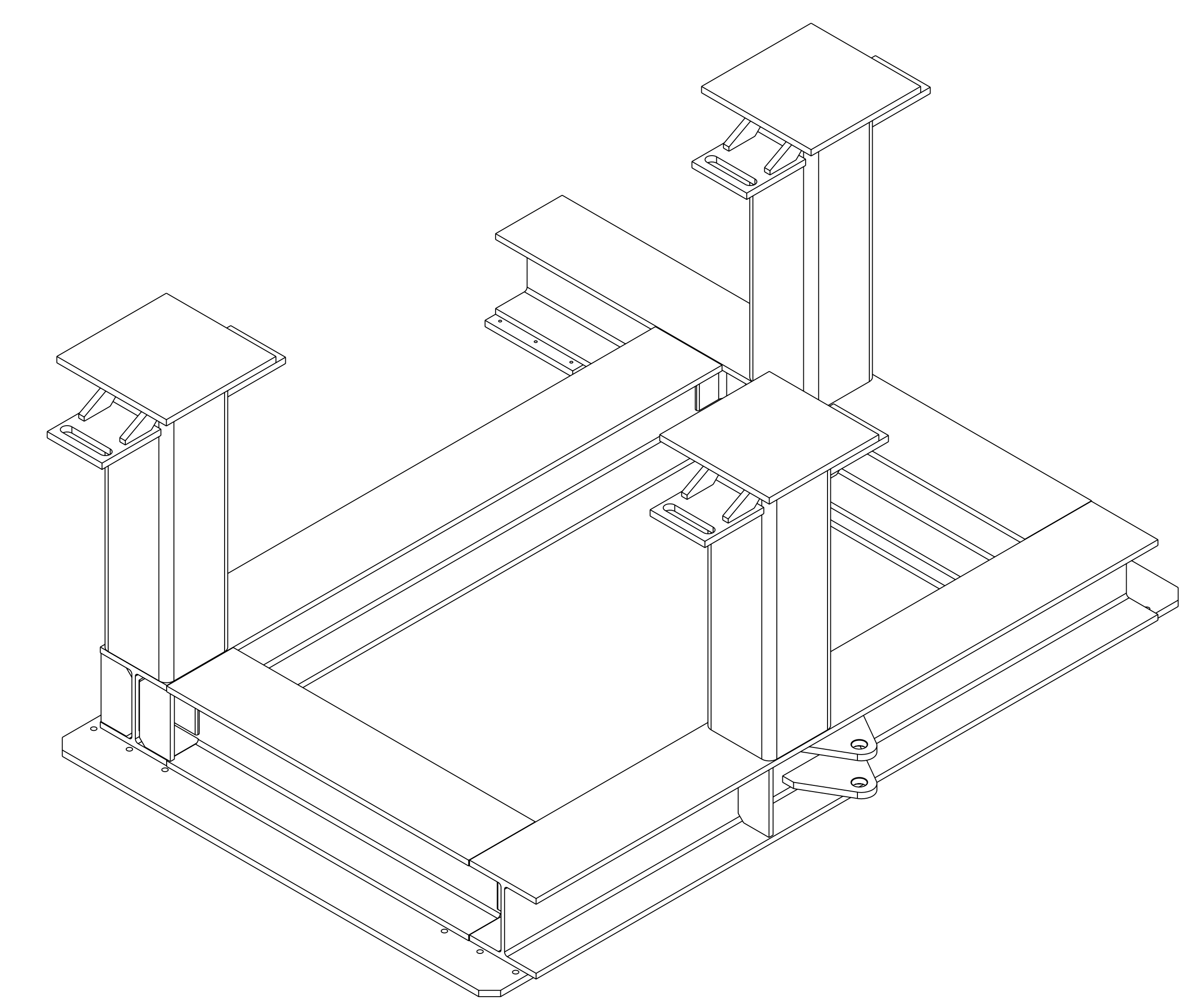
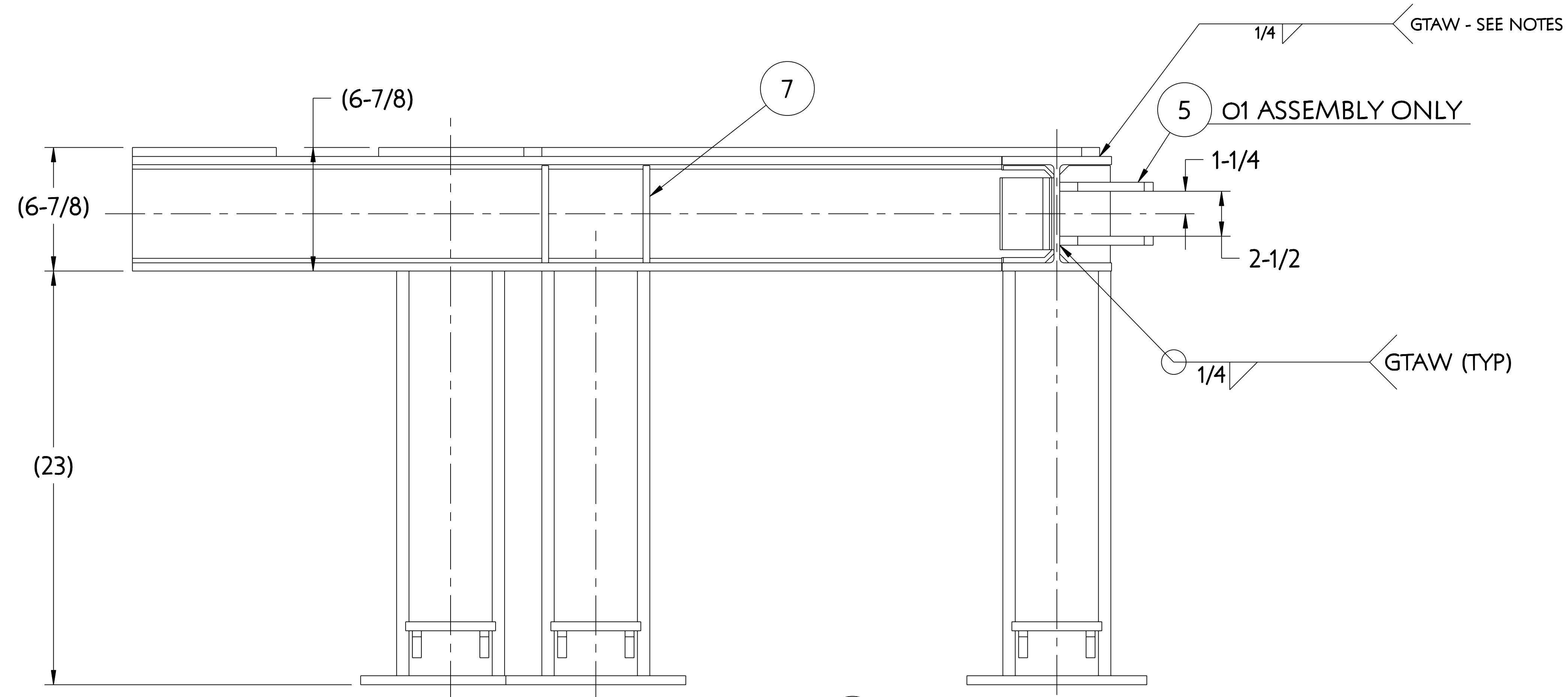


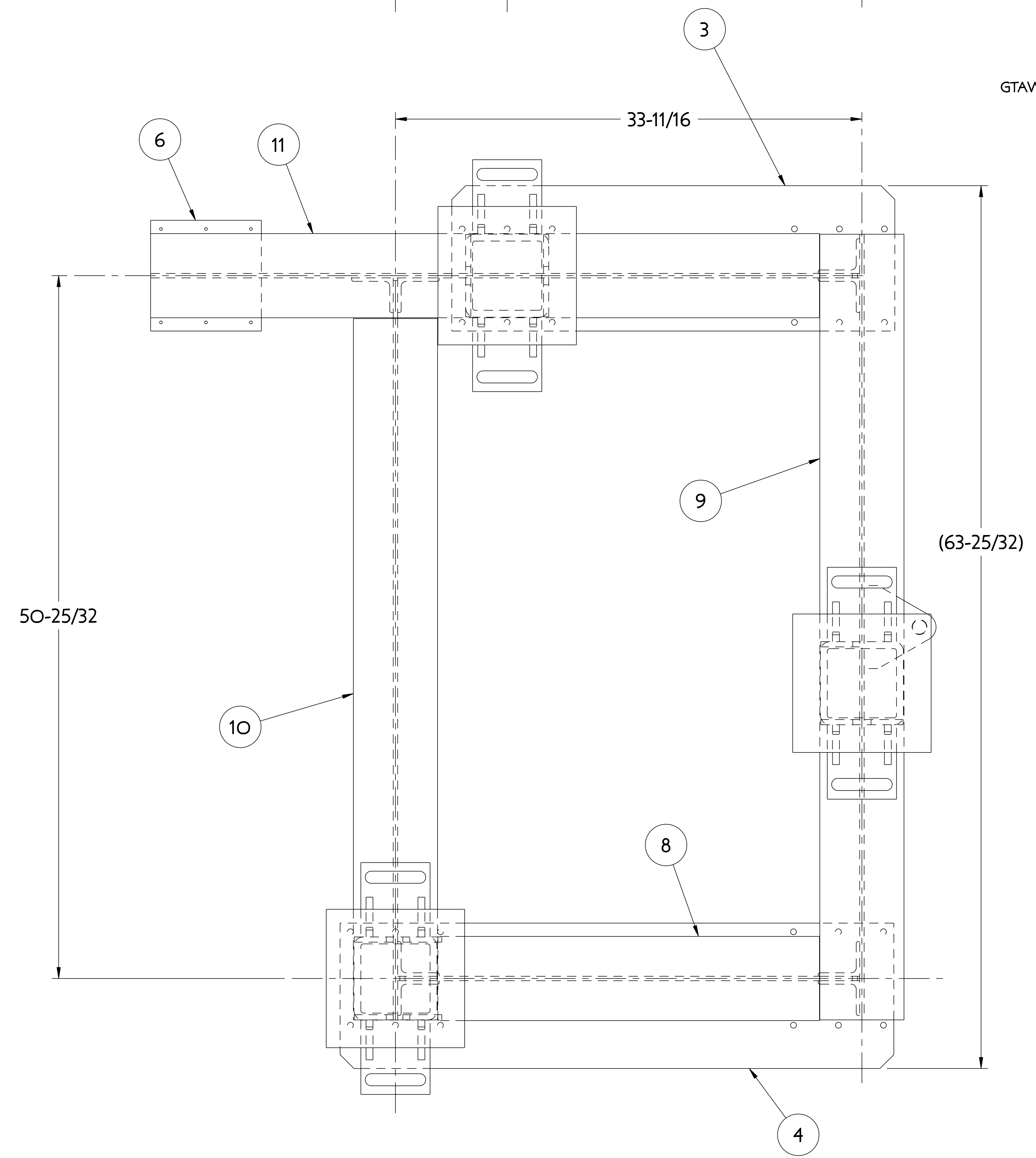
NO.	REVISION	BY	CH	SUP	APPROVED	DATE
13						
14						
15						



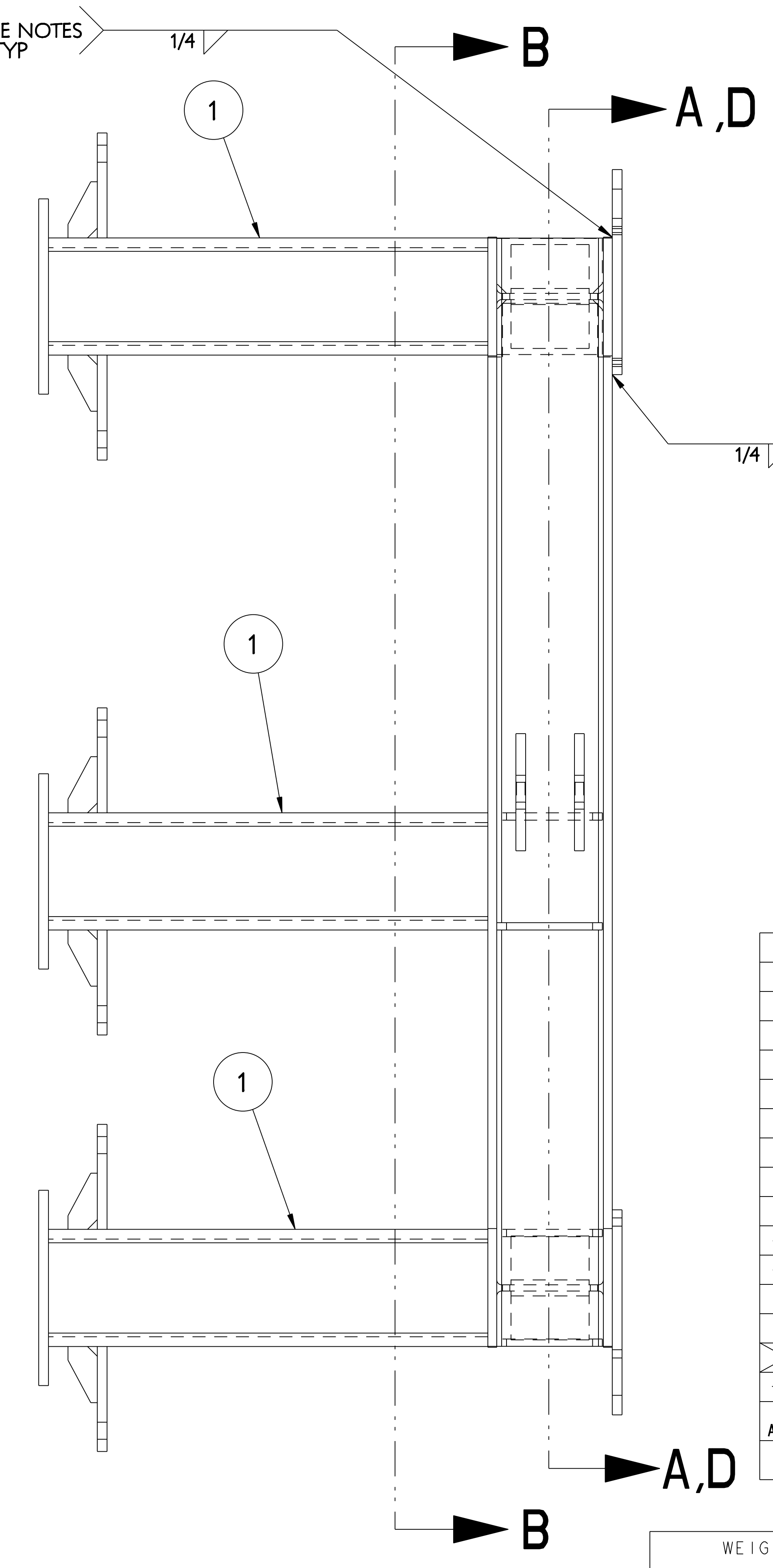
O1 ASSEMBLY
REFERENCE ISOMETRIC

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

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O1 ASSEMBLY - RIGHT SIDE SUPPORT CART WELDMENT - AS SHOWN
O2 ASSEMBLY - LEFT SIDE SUPPORT CART WELDMENT - OPPOSITE (SEE SHEET 3)



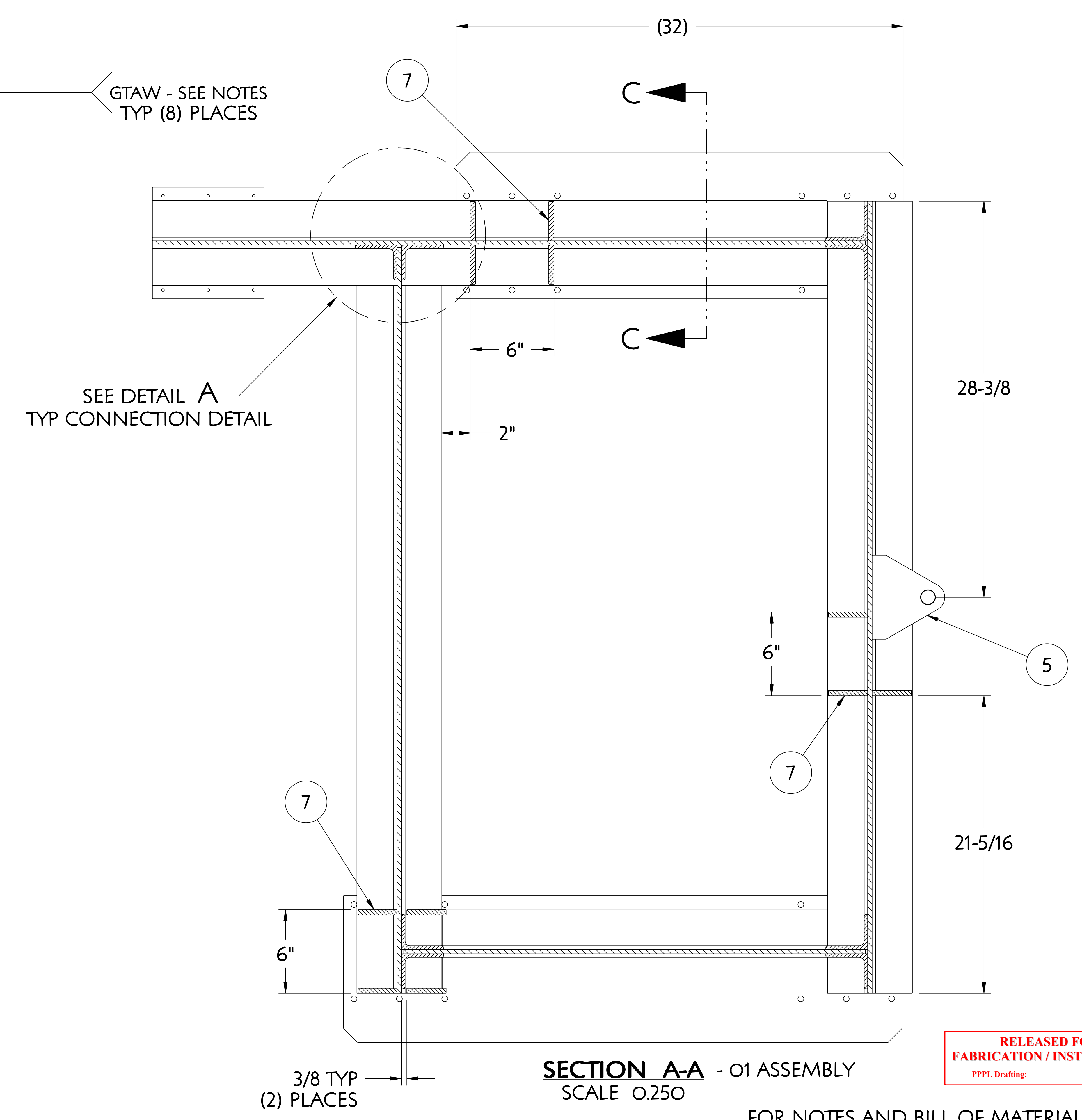
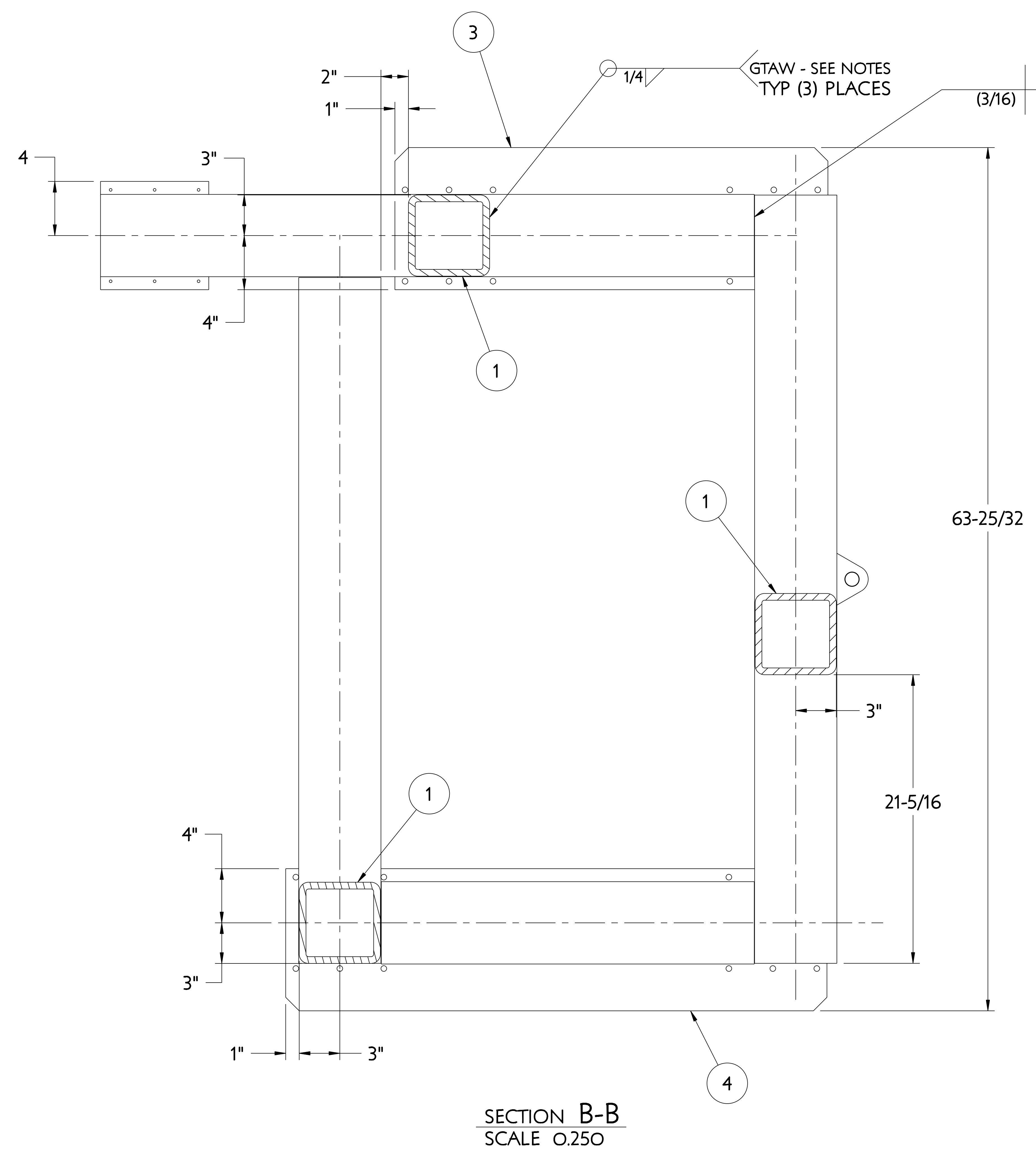
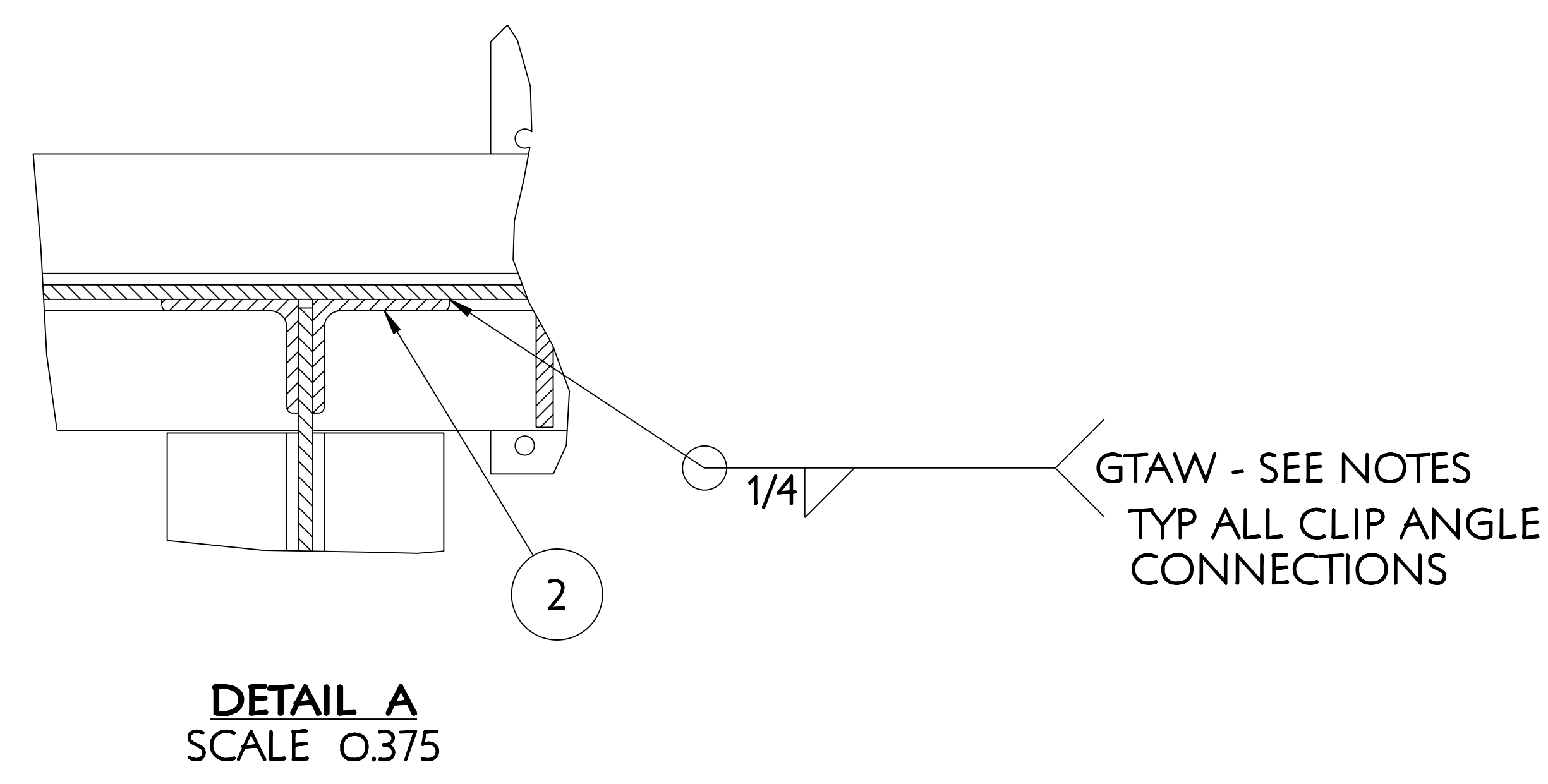
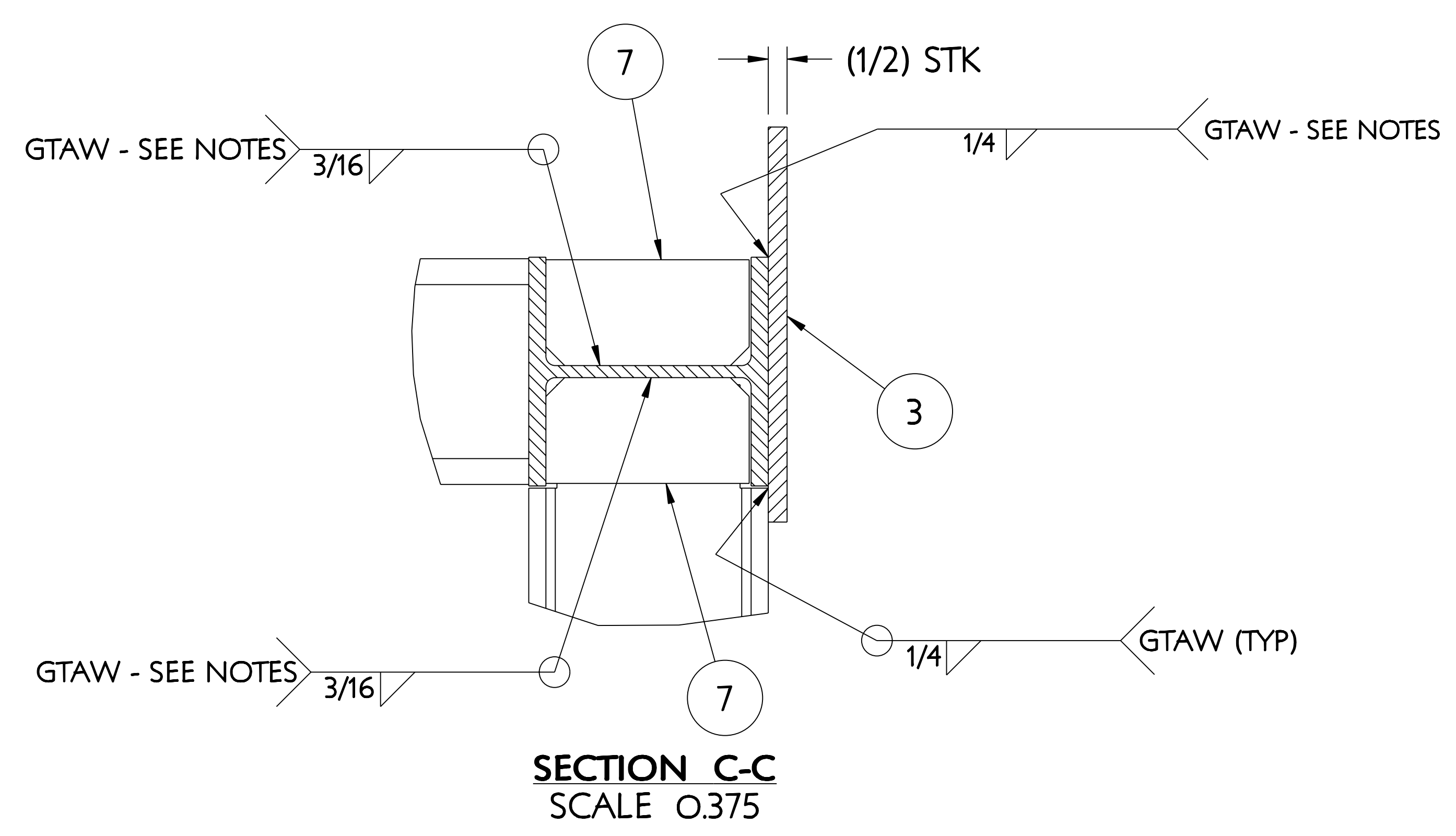
NOTE
WELDING SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF AWS D1.1 OR PPPL PROCEDURE NO. ENG-37.
VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH THE ACCEPTANCE CRITERIA OF AWS D1.1 Section 6.
NOTE ORIENTATION OF ALL PARTS PRIOR TO WELDING.
SAND BLAST AND APPLY 2 COATS "SAFETY YELLOW" PAINT

QTY	REV	PART NO.	DRAWING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY RECD
2	14	SE186-326-8	MCWF SUPPORT CART ANTI-TIP PLATE - TYPE "E"	SEE DWG		
1	13	SE186-326-7	MCWF SUPPORT CART ANTI-TIP PLATE - TYPE "D"	SEE DWG		
1	12	SE186-326-6	MCWF SUPPORT CART ANTI-TIP PLATE - TYPE "C"	SEE DWG		
1	11	SE186-341-4	FRAMING BEAM - TYPE # 4	SEE DWG		
1	10	SE186-341-3	FRAMING BEAM - TYPE # 3	SEE DWG		
1	9	SE186-341-2	FRAMING BEAM - TYPE # 2	SEE DWG		
1	8	SE186-341-1	FRAMING BEAM - TYPE # 1	SEE DWG		
12	11	7	SE186-331-6	SUPPORT GUSSET	SEE DWG	
1	6	SE186-326-5	HILMAN ROLLER MOUNTING PLATE	SEE DWG		
2	5	SE186-326-4	PULL PLATE	SEE DWG		
1	4	SE186-326-3	MCWF SUPPORT CART ANTI-TIP PLATE - TYPE "B"	SEE DWG		
1	3	SE186-326-2	MCWF SUPPORT CART ANTI-TIP PLATE - TYPE "A"	SEE DWG		
8	8	2	SE186-326-1	CLIP ANGLE	SEE DWG	
3	3	1	SE186-325	MCWF SUPPORT CART SUPPORT POST WELDMENT	SEE DWG	
			THIS DWG	MCWF LEFT SIDE SUPPORT CART WELDMENT		1
			THIS DWG	MCWF RIGHT SIDE SUPPORT CART WELDMENT		1

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY	
Pro E	DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/ .020	NATIONAL COMPACT STELLARATOR EXPERIMENT	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	TOLERANCES NON-CUMULATIVE	DSN: J. RUSHINSKI	8-2-2007
SCALE 0:250	DECIMAL-INCH FRACTIONS	CHK: M. COLE	8-2-2007
NEXT ASSEMBLY	.XX .XX .005 12"=12" .XX=12" .XX .XX .005 12"=12" .XX=12" .XX .XX .005 12"=12" .XX=12"	ENGR: T. BROWN	8-2-2007
WELDING ENGINEER: G. GETTLEFINGER 8-2-2007	ANGLER: 120° ± 15'	SUPV: J. SIEGEL	8-2-2007
WEIGHT: 1160.8 lbs		DRAWING NO: SE186-330	
MODEL NAME: SE186-330-01		SHEET 1 OF 3	
RELEASE LEVEL: Fabrication DWG VERSION NO: 26		REV 0	

NCSX-SE186-330

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



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FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

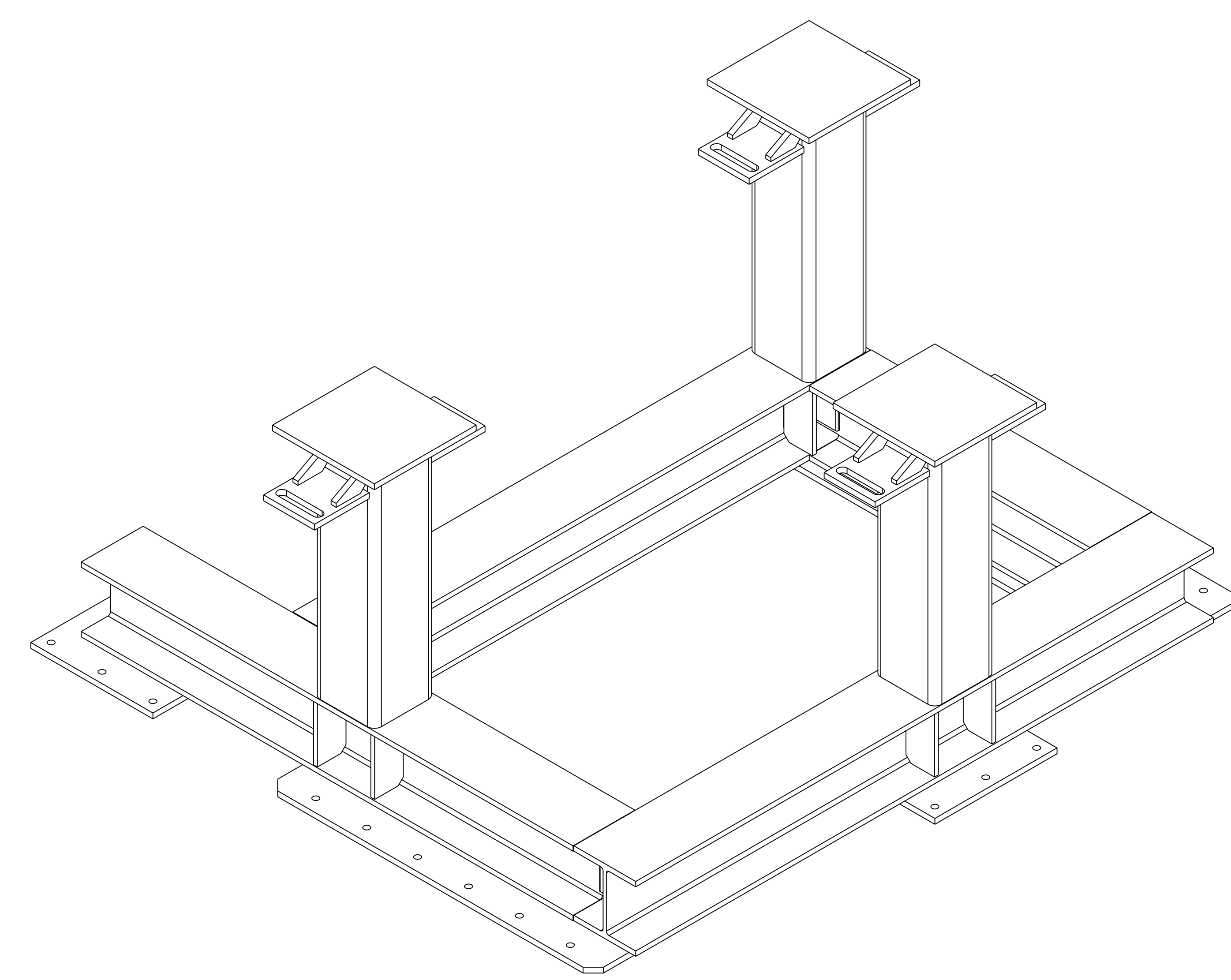
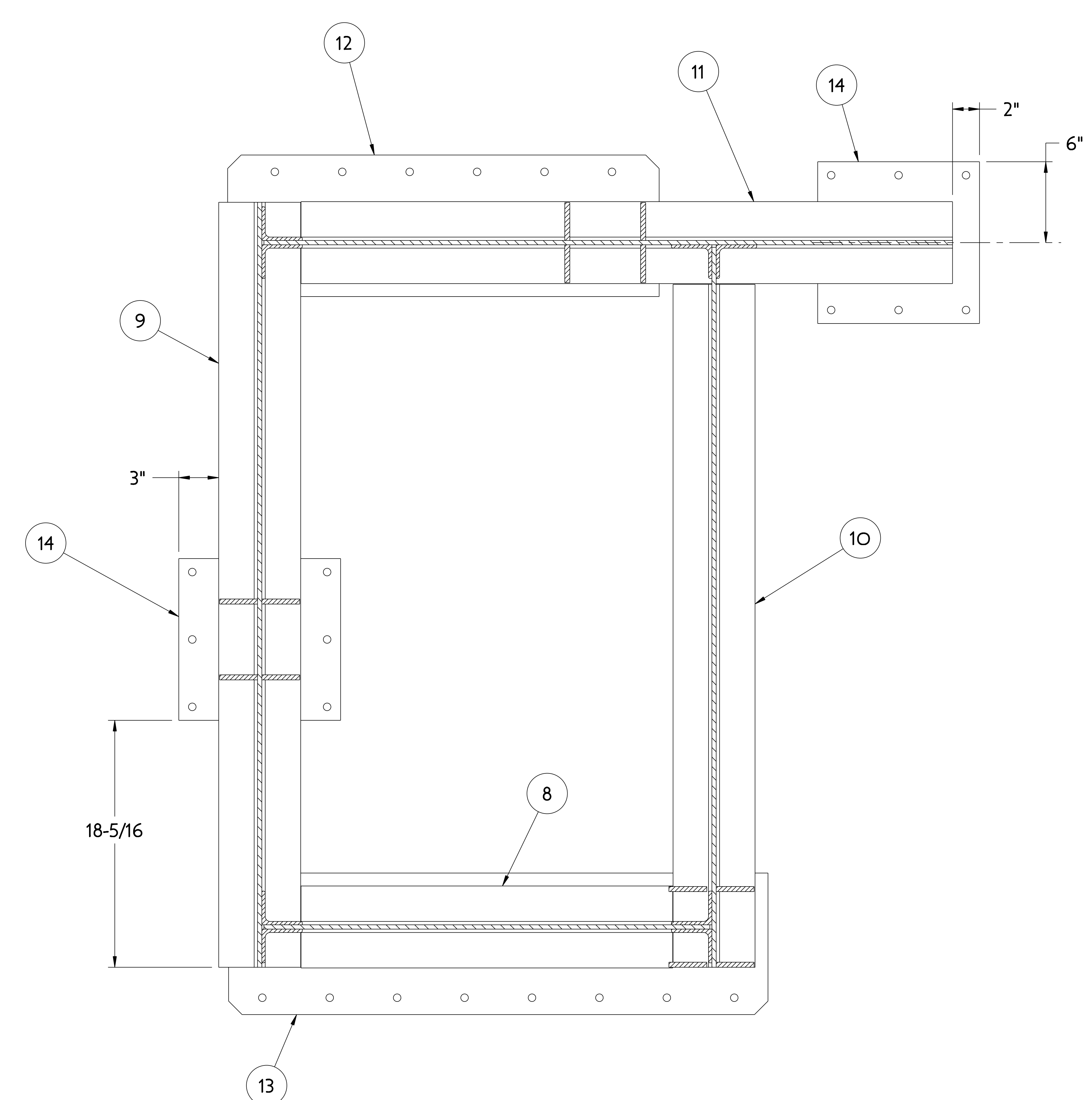
RELEASE LEVEL: Fabrication
DWG VERSION NO: 26

WEIGHT	1160.8 lbs
MODEL NAME	SE186-330-01
WELDING ENGINEER	

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 NATIONAL COMPACT STELLARATOR EXPERIMENT STELLARATOR CORE TOOLING DESIGN & FABRICATION MCWF SUPPORT CART WELDMENTS
DO NOT VERIFY INFORMATION BY SCALING DRAWING	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX +/- .030 .XXX +/- .005 ANGULAR +/- .05	DSN: J. RUSHINSKI 8-2-2007 CHK: M. COLE 8-2-2007 ENGR: T. BROWN 8-2-2007 SUPV: J. SIEGEL 8-2-2007
NEXT ASSEMBLY		DRAWING NO: SE186-330 SHEET 2 OF 3

NCSX-SE186-330

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



O2 ASSEMBLY
REFERENCE ISOMETRIC

**RELEASED FOR
FABRICATION / INSTALLATION**
 PPPL Drafting

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

RELEASE LEVEL: Fabrication
DWG VERSION NO: 26

WEIGHT	1160.8 lbs
MODEL NAME	SE186-330-01
WELDING ENGINEER	

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY 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 SUPPORT CART WELDMENTS	
TOLERANCES NON-CUMULATIVE	DECIMAL-INCH FRACTIONS	DSN: L. MORRIS	8-2-2007 DRAWING NO:
NEXT ASSEMBLY	.X +/- .100 0°-120° +/- .125 .XX +/- .030 120°-120° +/- .125 .XXX +/- .005 120°-120° +/- .125 ANGULAR +/- .0°-15° OVER 120° +/- .125	CHK: M. COLE	8-2-2007
		ENGR: T. BROWN	8-2-2007
		SUPV: J. SIEGEL	8-2-2007
			SHEET 3 OF 3
			REV D, I

NCSX-SE186-330