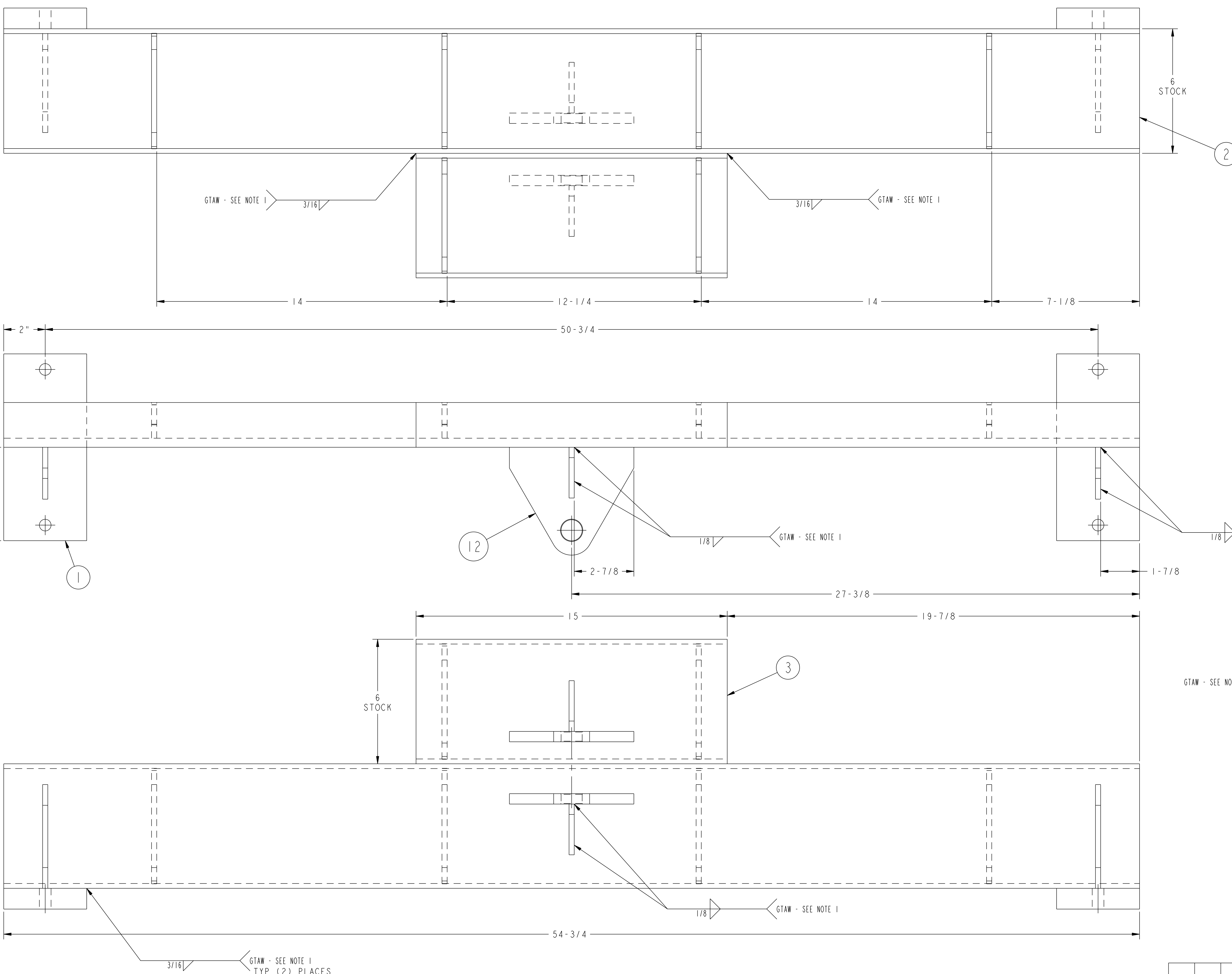
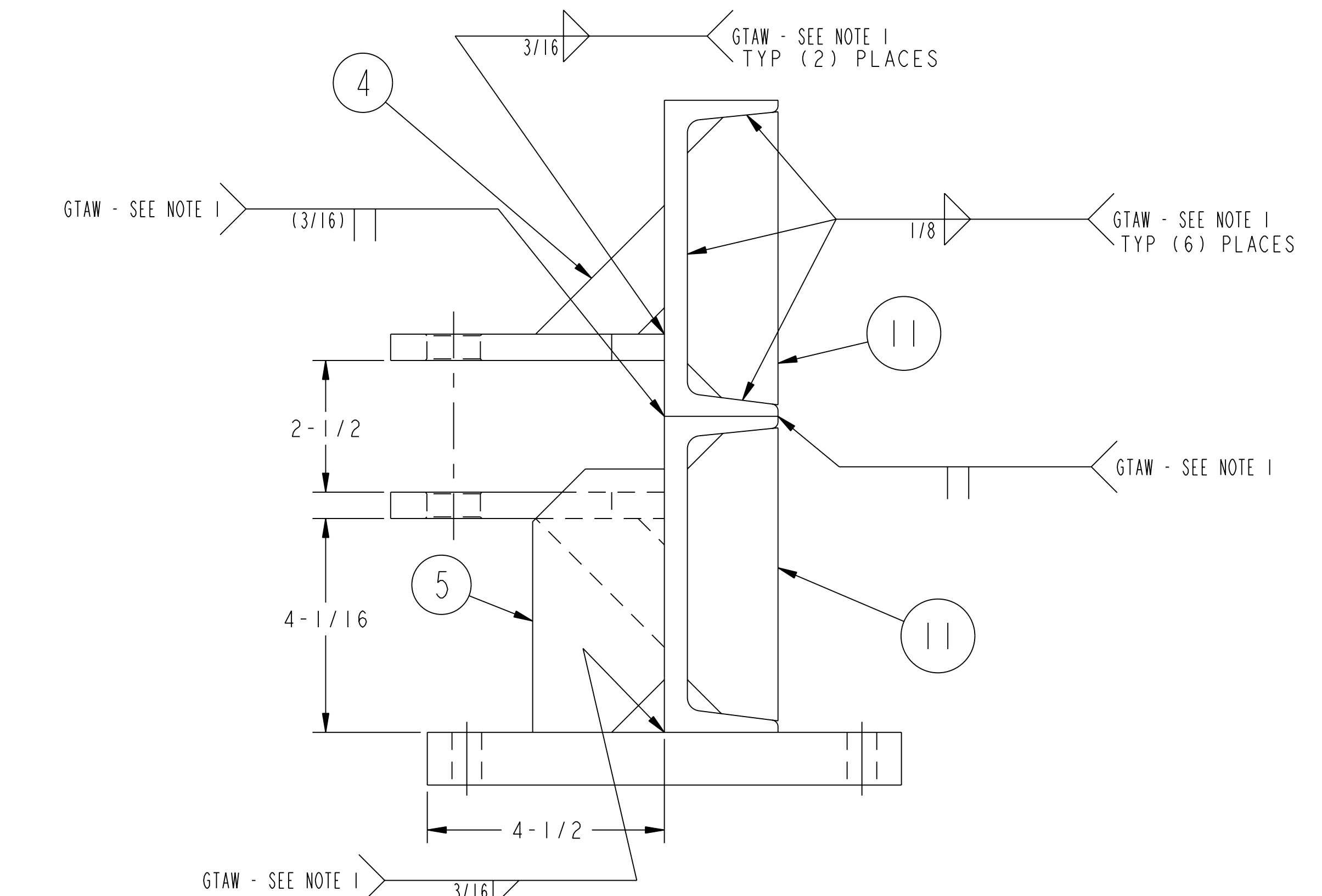


NO.	REVISION	BY	CH	SUP	APPROVED	DATE
1	REVISED PER ECN-5326	LM	TB	JS	T. BROWN	1-29-08



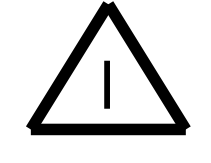
- NOTES
1. WELDING SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF AWS D1.1 OR PPPL PROCEDURE ENG-037. VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH THE ACCEPTANCE CRITERIA OF AWS D1.1 Section 6.
  2. SAND BLAST AND APPLY 2 COATS "SAFETY YELLOW" PAINT.



01 ASSEMBLY - ADJUSTER BAR SUPPORT STRUCTURE WELDMENT

QTY	PART NO.	DRAWING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY REQ'D
	2	12	SE186-326-3	SUPPORT CART PULL PLATE	ASTM A36
	6	11	THIS DWG	CHANNEL STIFFENER GUSSET	ASTM A36
1		10	THIS DWG	THREADED ROD - 1-8UNC-2A x 10" LG L.H. THREAD	ASTM A108
1		9	THIS DWG	THREADED ROD - 1"-8UNC-2A x 10" LG R.H. THREAD	ASTM A108
		8	THIS DWG	ADJUSTER BLOCK - R.H. AND L.H. THREAD	ASTM A36
1		7	THIS DWG	ADJUSTER BAR THREADED BLOCK - L.H. THREAD	ASTM A36
1		6	THIS DWG	ADJUSTER BAR THREADED BLOCK - R.H. THREAD	ASTM A36
	2	5	THIS DWG	STIFFENER GUSSET	ASTM A36
	2	4	THIS DWG	GUSSET	ASTM A36
	1	3	THIS DWG	PUSHER SUPPORT CHANNEL - SHORT - 6" x 13# CHANNEL	ASTM A36
	1	2	THIS DWG	PUSHER SUPPORT CHANNEL - LONG - 6" x 13# CHANNEL	ASTM A36
	2	1	THIS DWG	FOOT PLATE	ASTM A36
			THIS DWG	ADJUSTER BAR WELDMENT - L.H. THREAD	
			THIS DWG	ADJUSTER BAR WELDMENT - R.H. THREAD	
			THIS DWG	ADJUSTER BAR SUPPORT STRUCTURE WELDMENT	

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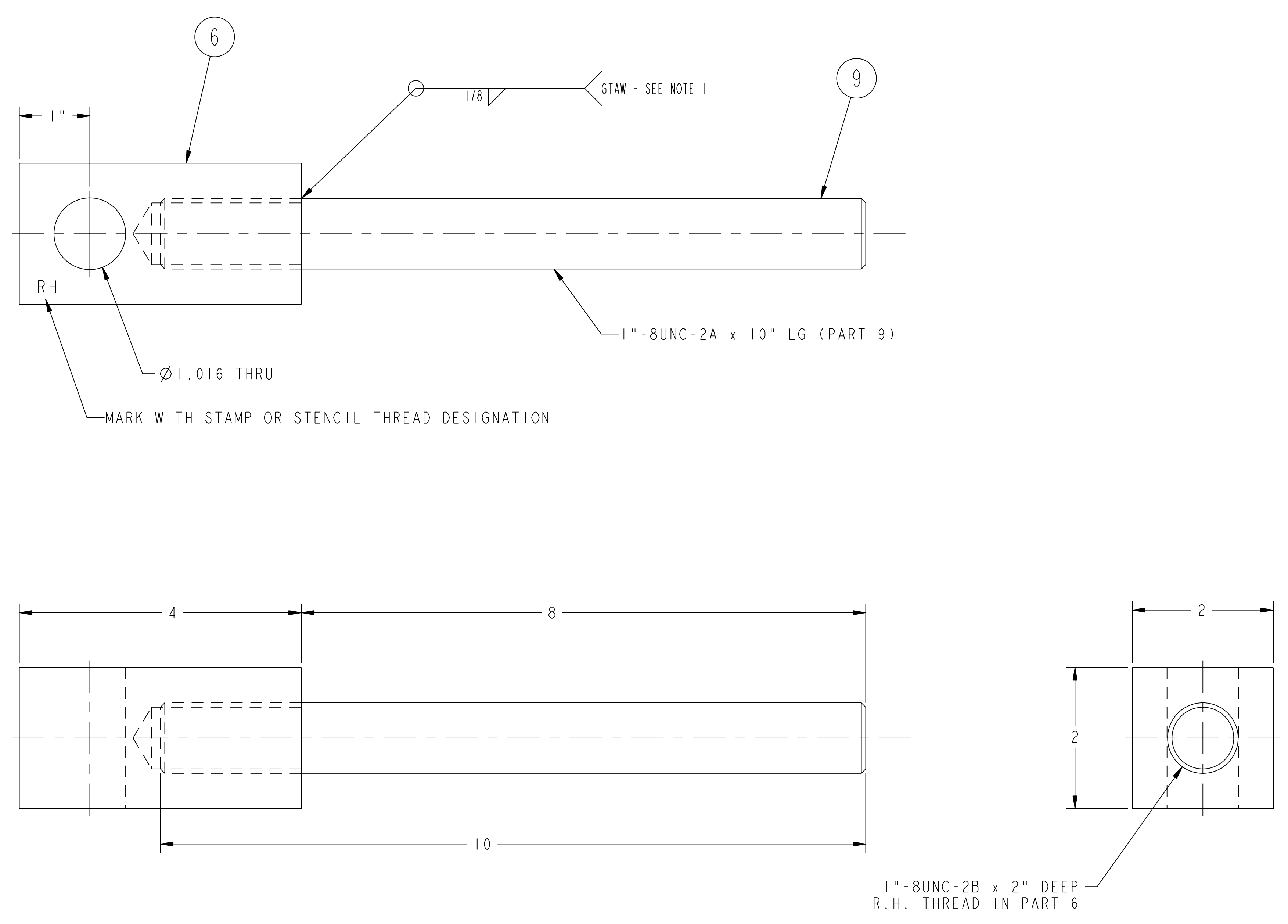


RELEASE LEVEL: Fabrication  
DWG VERSION NO: 3

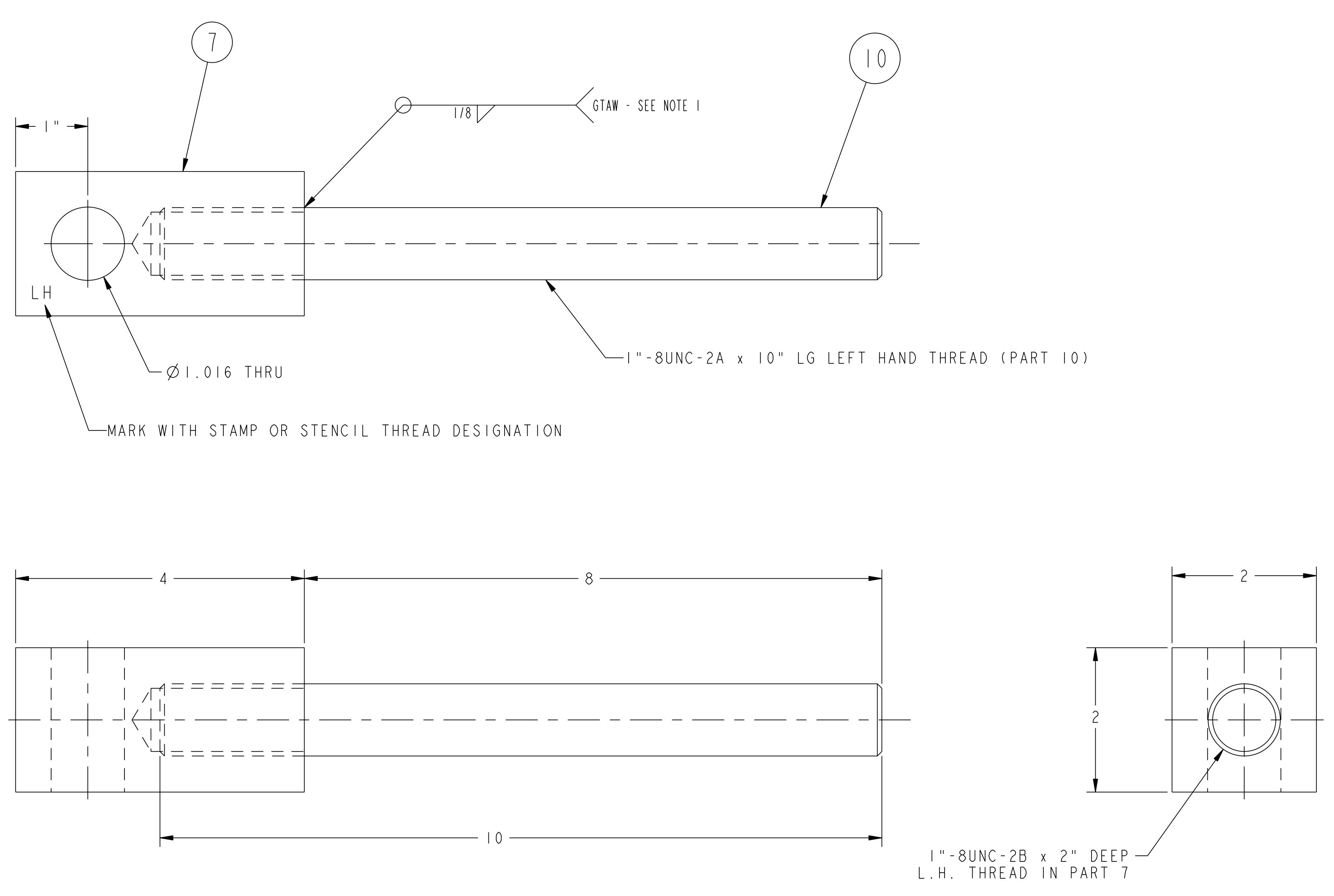
WEIGHT 107.7 lbs	MODEL NAME SE186-333-01	WELDING ENGINEER G. GETTELFINGER 8-2-2007	COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY STELLARATOR CORE TOOLING DESIGN AND FABRICATION ADJUSTER BAR SUPPORT STRUCTURE WELDMENTS AND DETAILS
			DO NOT VERIFY INFORMATION BY SCALING DRAWING	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX +/- .030 .XXX +/- .005 ANGULAR +/- .015	DSN: L. MORRIS 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: <b>SE186-333</b>
					SHEET 1 OF 3 REV I

NCSX-SE186-333

NO.	REVISION	BY	CH	SUP	APPROVED	DATE
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02 ASSEMBLY - ADJUSTER BAR WELDMENT - R.H. THREAD



03 ASSEMBLY - ADJUSTER BAR WELDMENT - L.H. THREAD

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 PPPL Drafting

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

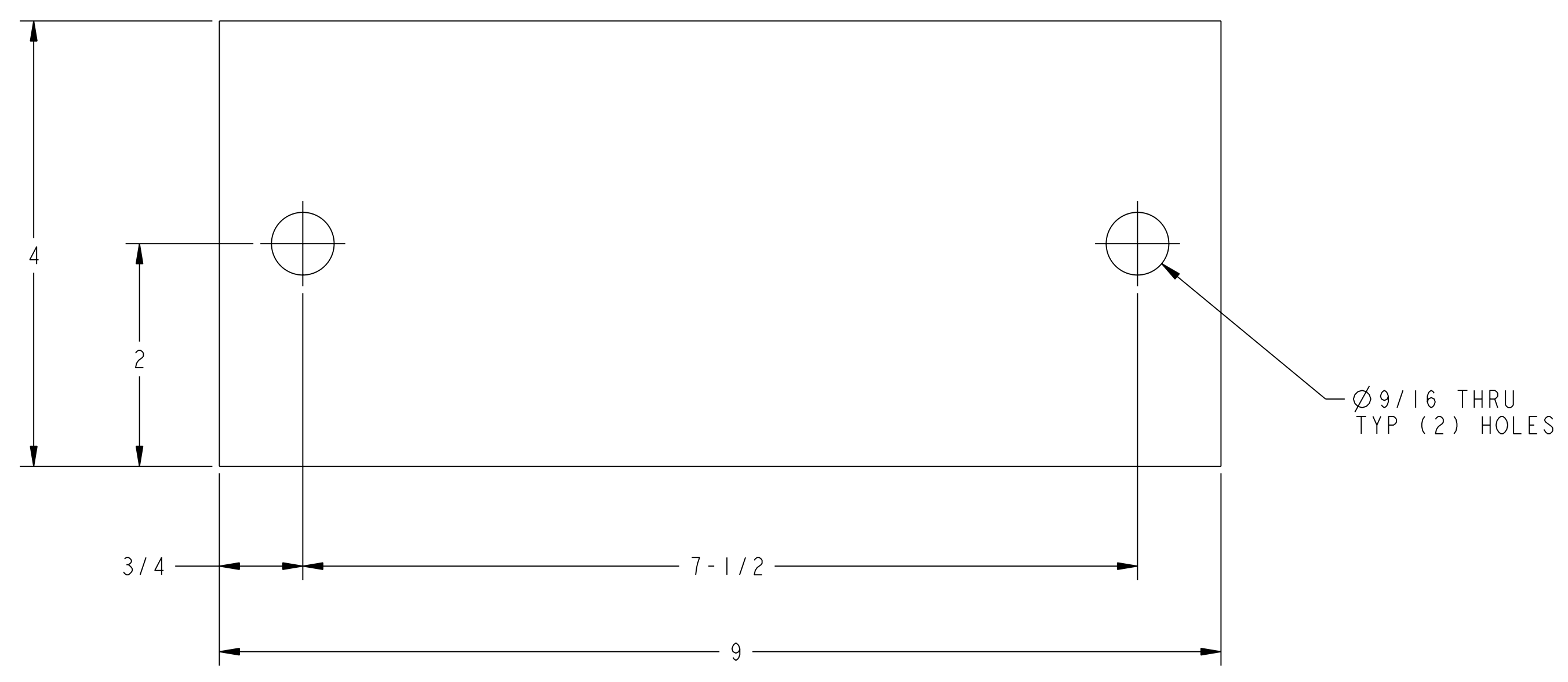
**RELEASE LEVEL: Fabrication**  
**DWG VERSION NO: 3**

WEIGHT	107.7 lbs
MODEL NAME	SE186-333-01
WELDING ENGINEER	G. GETTELFINGER 8-2-2007

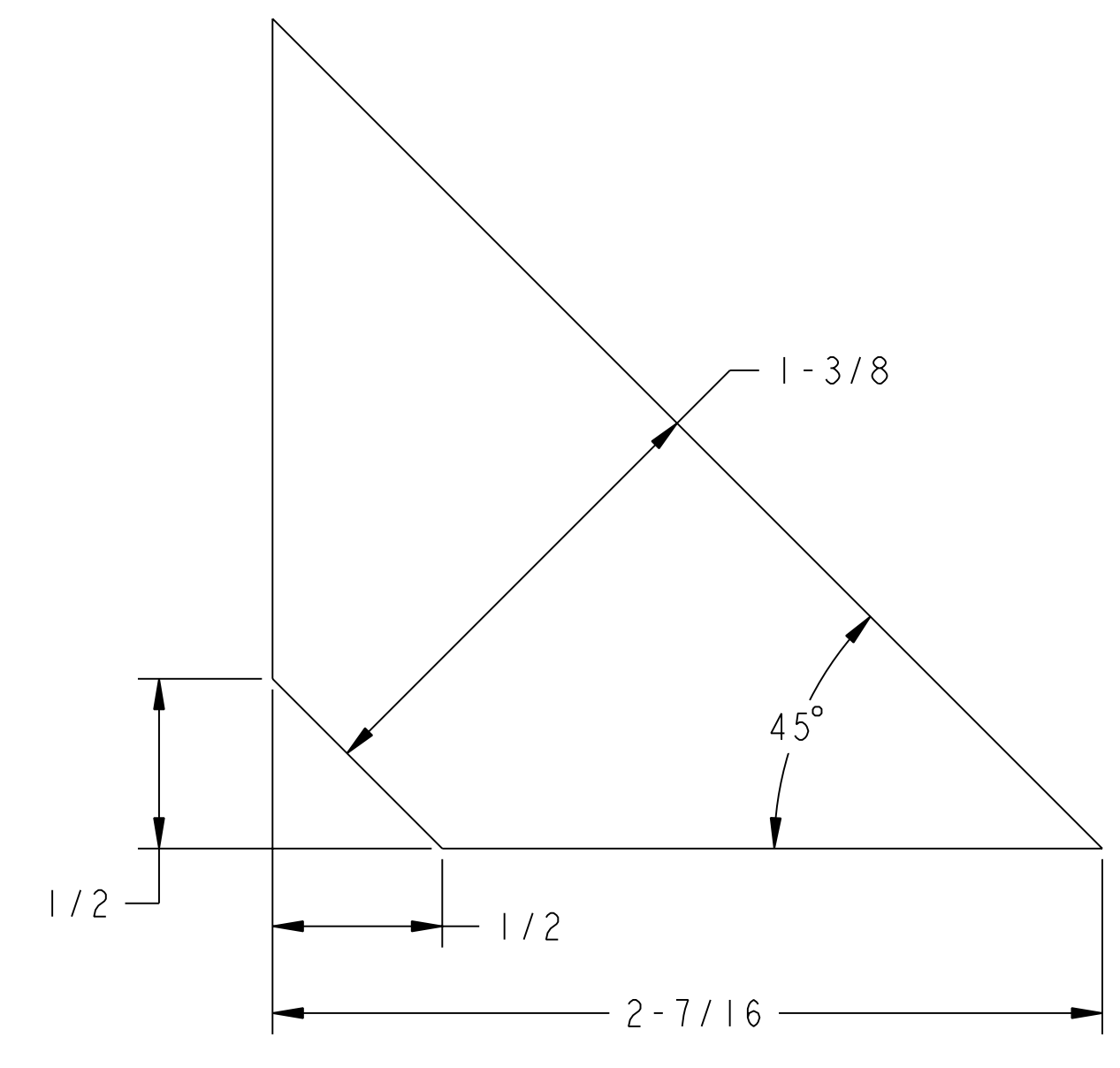
COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	NATIONAL COMPACT STELLARATOR EXPERIMENT STELLARATOR CORE TOOLING DESIGN AND FABRICATION ADJUSTER BAR SUPPORT STRUCTURE WELDMENTS AND DETAILS	
NEXT ASSEMBLY	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	DRAWING NO: SE186-333
		CHK: M. COLE 8-2-2007	
		ENGR: T. BROWN 8-2-2007	
		SUPV: J. SIEGEL 8-2-2007	SHEET 2 OF 3
			REV 1.0

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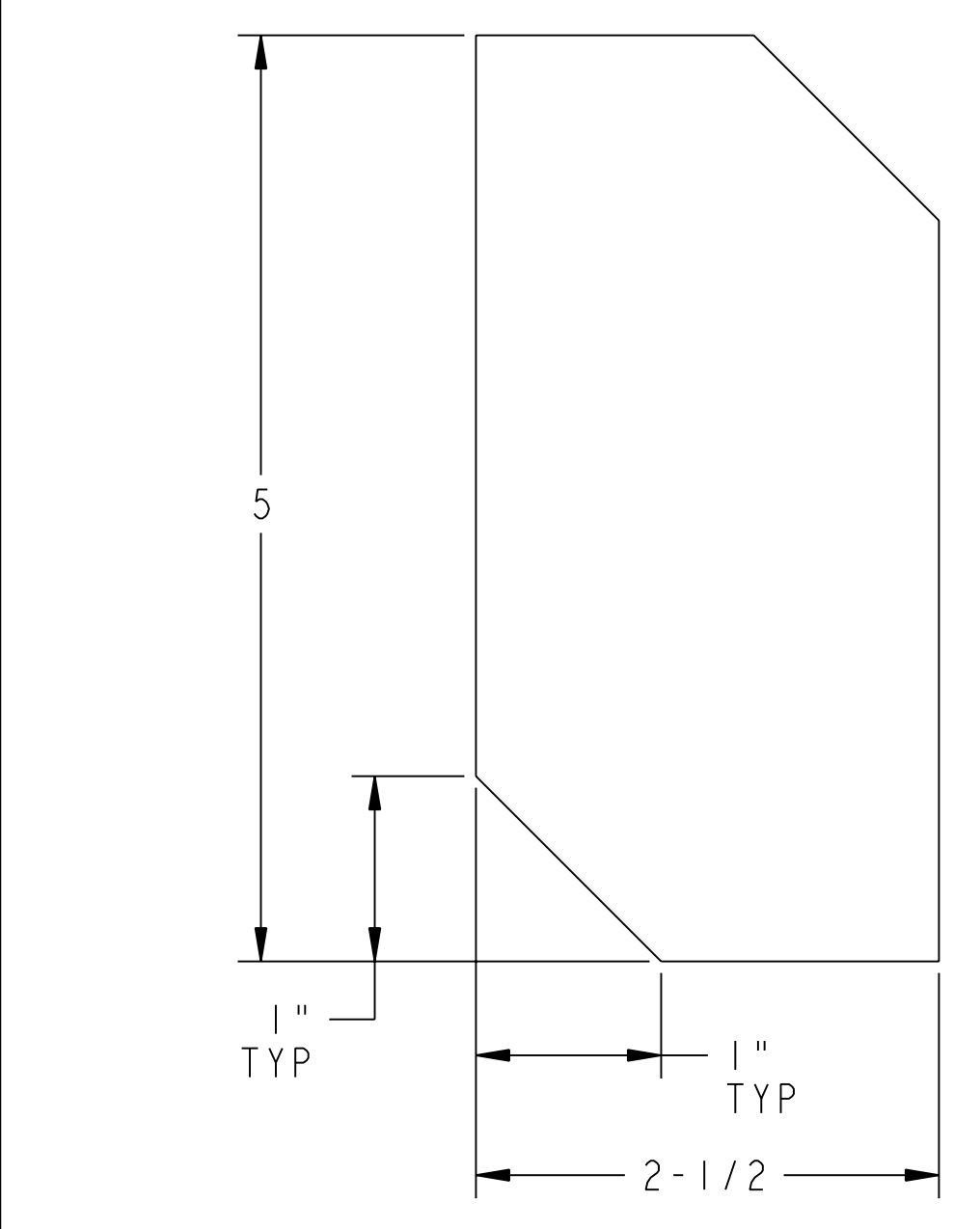
NO.	REVISION	BY	CH	SUP	APPROVED	DATE



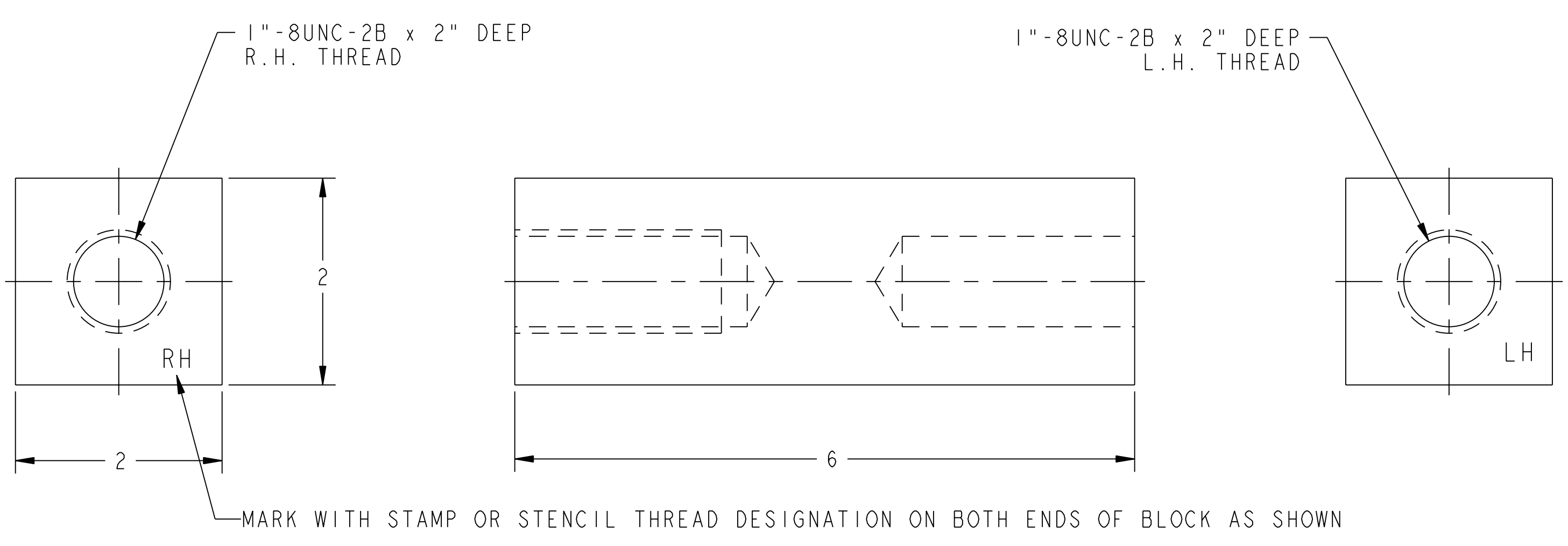
1 FOOT PLATE



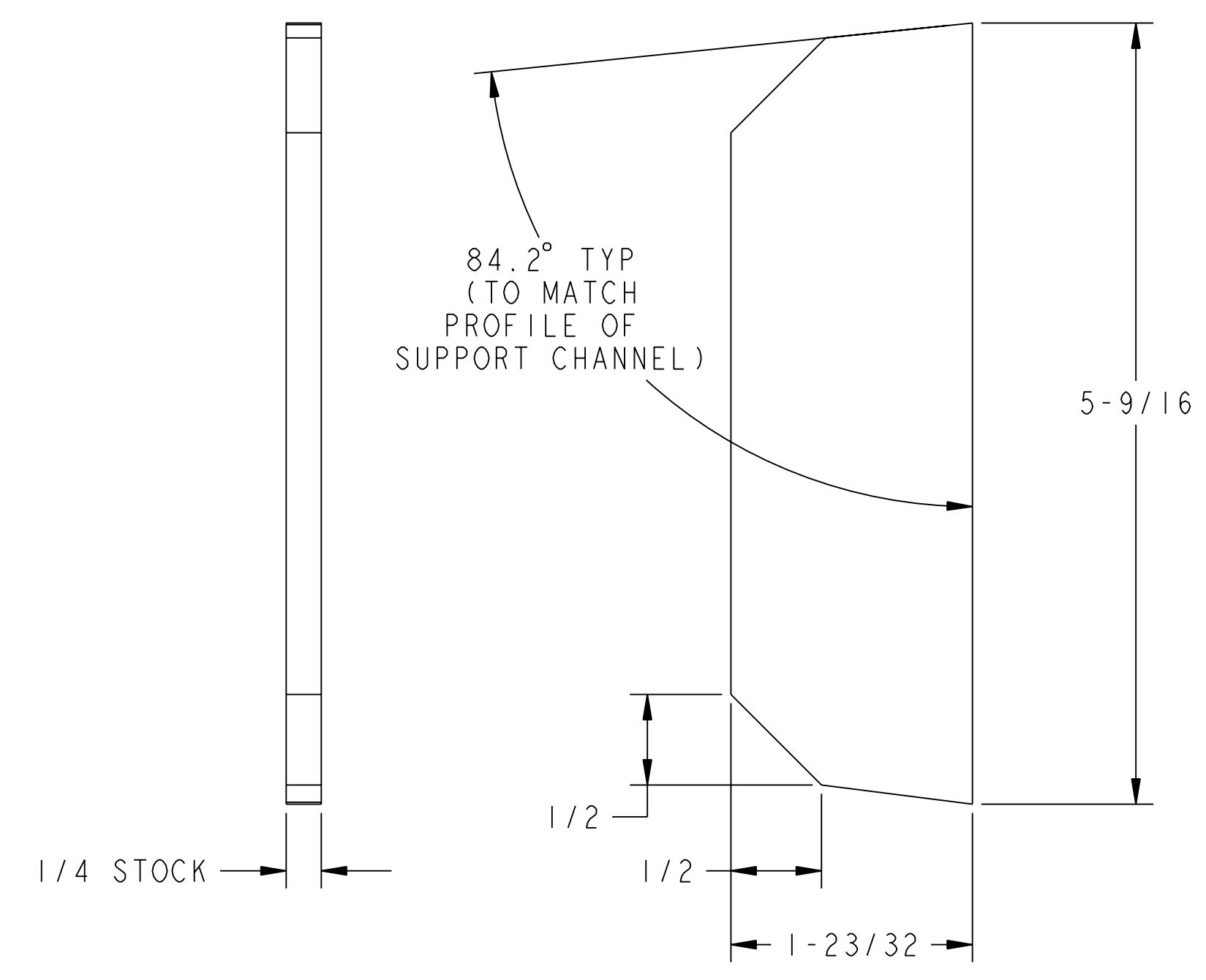
4 GUSSET



5 STIFFENER GUSSET



8 ADJUSTER BAR THREADED BLOCK - R.H. AND L.H. THREADS



11 CHANNEL STIFFENER GUSSET

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FABRICATION / INSTALLATION**  
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FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

**RELEASE LEVEL: Fabrication**  
**DWG VERSION NO: 1**

WEIGHT	6.1 lbs
MODEL NAME	SE186-333-03
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 UNLESS OTHERWISE SPECIFIED BREAK SHARP EDGES .005/.020	STELLARATOR CORE TOOLING DESIGN AND FABRICATION ADJUSTER BAR SUPPORT STRUCTURE WELDMENTS AND DETAILS	
NEXT ASSEMBLY	TOLERANCES NON-CUMULATIVE DECIMAL-INCH FRACTIONS .XX +/- .000 .XXX +/- .005 ANGULAR +/- .015	DSN: L. MORRIS CHK: M. COLE ENGR: T. BROWN SUPV: J. SIEGEL	8-2-2007 8-2-2007 8-2-2007 8-2-2007
		DRAWING NO:	SE186-333
		SHEET 3 OF 3	REV 1.0

NCSX-SE186-333