



**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.

**RELEASED FOR FABRICATION/INSTALLATION**  
PPPL Drafting

PART NO.	DRAWING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY	RECD
5	SE186-352-6	WEDGE FORKLIFT BLOCK	ASTM A36	2	
4	SE186-352-5	WEDGE TOP	ASTM A36	1	
3	SE186-352-4	WEDGE SIDE, 20 DEGREES	ASTM A36	2	
2	SE186-352-3	WEDGE BOTTOM	ASTM A36	1	
1	SE186-352-2	WEDGE BACK, 20 DEGREES	ASTM A36	1	

COMPUTER GENERATED DRAWING		CENTRAL FILES:		PRINCETON PLASMA PHYSICS LABORATORY	
DRAWING CHANGES NOT PERMITTED		UNLESS OTHERWISE SPECIFIED		NATIONAL COMPACT STELLARATOR EXPERIMENT	
Pro E		DIMENSIONS ARE IN INCHES		TOOLING DESIGN AND FABRICATION	
DO NOT VERIFY INFORMATION BY SCALING DRAWING		MACHINE SURFACES		FIELD PERIOD ASSEMBLY FIXTURE	
NEXT ASSEMBLY		BREAK SHARP EDGES .005/.020		20 DEGREE WEDGE FIXTURE WELDMENT	
WEIGHT		TOLERANCES NON-CUMULATIVE		DSN: R. UPCAVALA 2/26/2008 DRAWING NO:	
6.851 lbs		DECIMAL-INCH FRACTIONS		CHK: M. VIOLA 2/26/2008	
MODEL NAME		.XX ±.000 .125-.125 ±.000		ENGR: B. SANDS 2/26/2008	
SE186-352-01		.XXX ±.005 .75-.125 ±.005		SUPV: J. SIEGEL 2/26/2008	
WELDING ENGINEER L. DUDEK 2/26/2008		ANGULAR ±.015 .125-.125 ±.005		SHEET 1 OF 1 REV 0	

RELEASE LEVEL: Fabrication  
 DWG VERSION NO: 4

NCSX-SE186-352