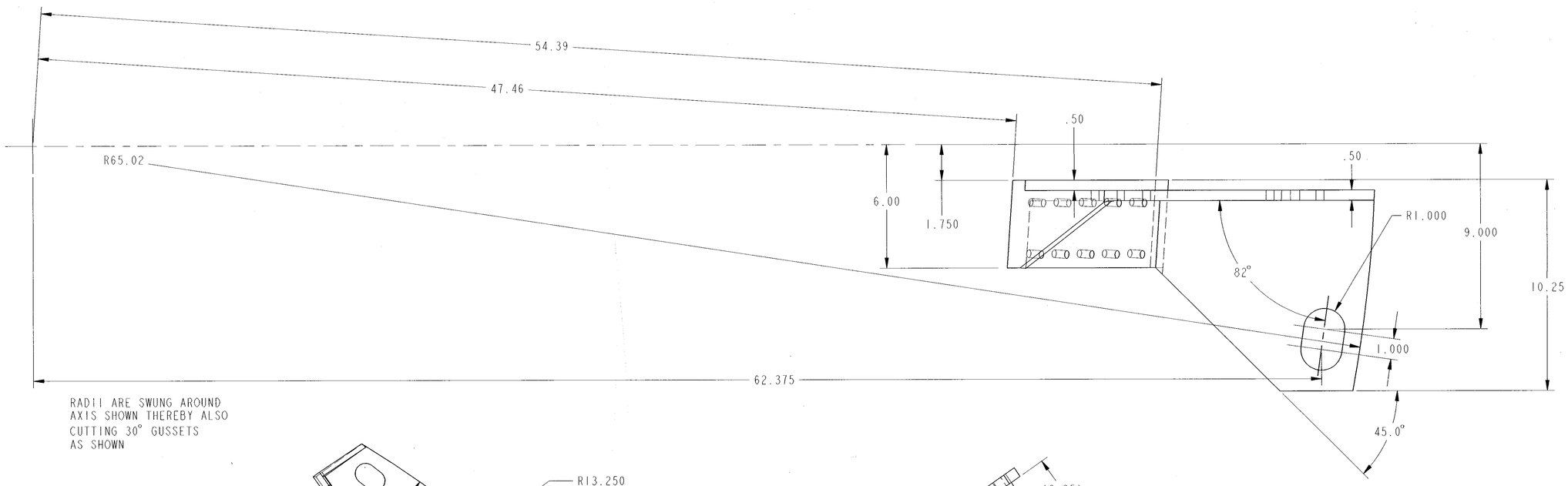
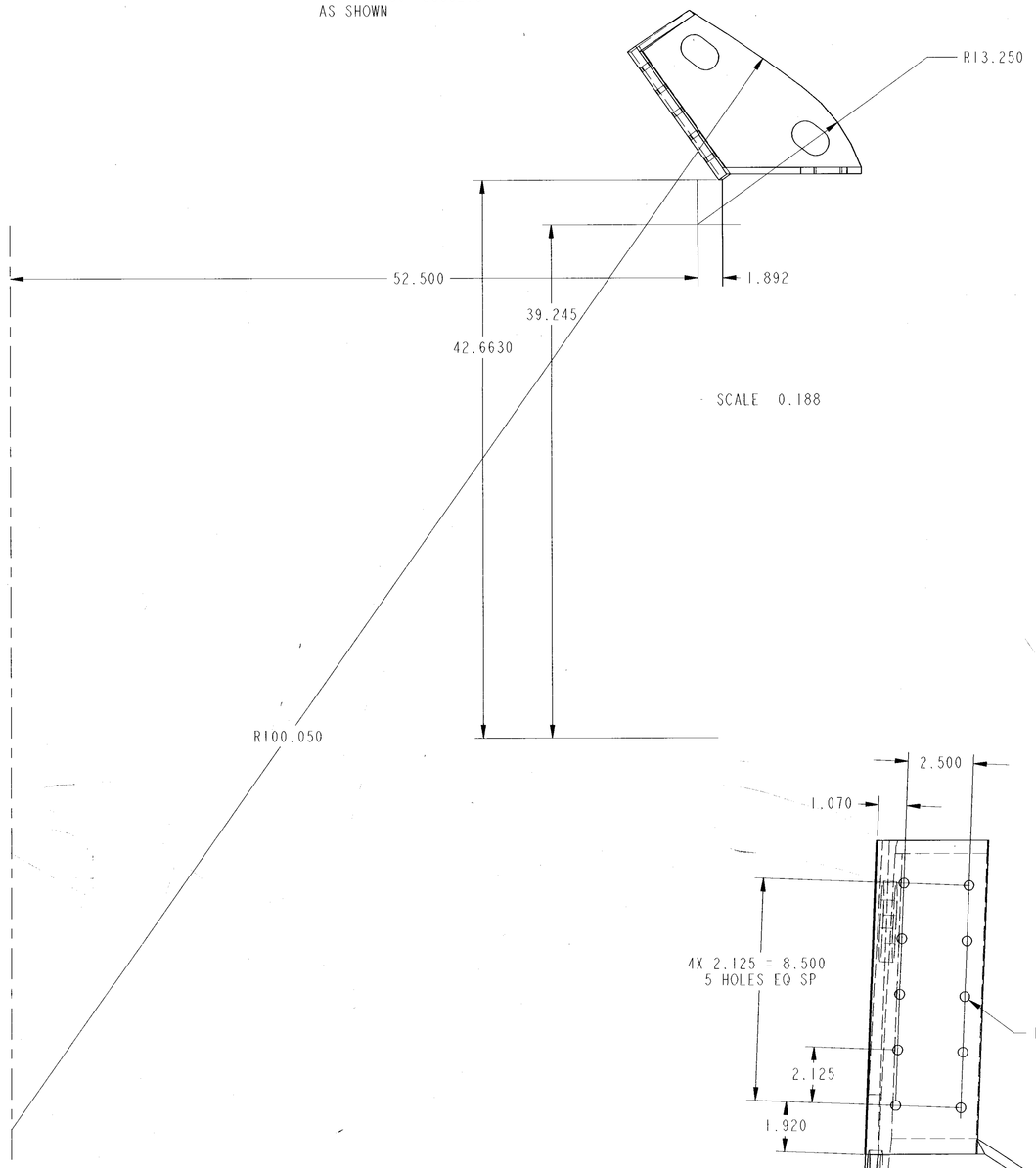
NEXT ASS'Y: | FINAL ASS'Y:

## NOTES

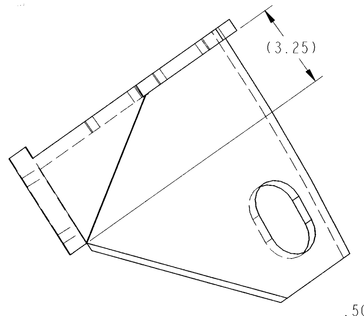
1. INTERPRET DRAWING PER MECHANICAL ENGINEERING DRAFTING STANDARD ES-3.1-2.
2. INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M.
3. DIMENSIONS ARE IN INCHES.
4. ONE PIECE CONSTRUCTION PREFERABLE. OPTIONAL WELDED CONSTRUCTION PERMISSABLE USING FULL PENETRATION CONTINUOUS BEVEL OR V-GROOVE WELDS.

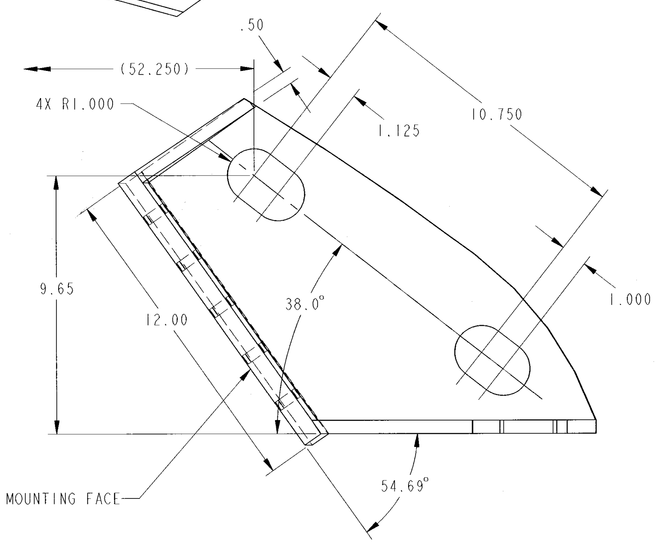


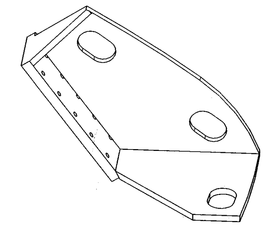

RADII ARE SWUNG AROUND AXIS SHOWN THEREBY ALSO CUTTING 30° GUSSETS AS SHOWN



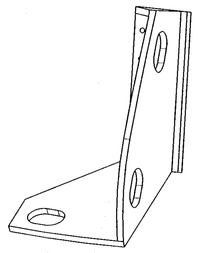

SCALE 0.188



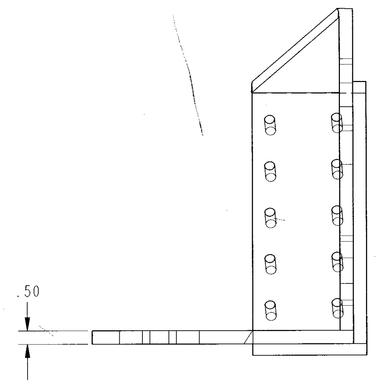



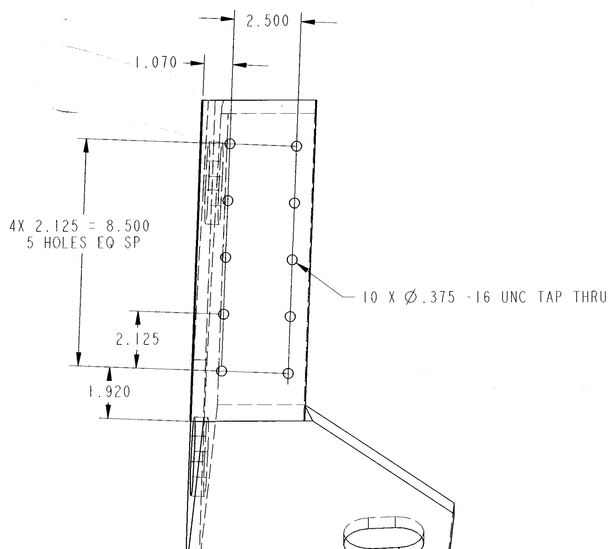



SCALE 0.188

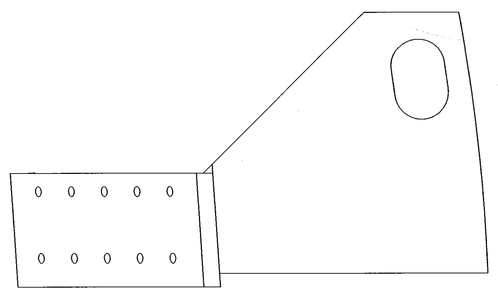


SCALE 0.188




VIEW NORMAL TO MOUNTING FACE



| AR | | -1 | SEC PASS PLT STRUCT BRKT-RIGID | SST | | |
|---|---|---|---|---|---|---|
| X3E0171104 A279 | CAGE CODE | PART OR IDENTIFYING NO | NOMENCLATURE OR DESCRIPTION | MATERIAL | SPECIFICATION | FIND NO |
| | NEXT ASSEMBLY | | PARTS LIST | | | |

### QUALITY VERIFICATION

MECHANICAL AND STRUCTURAL
REFERENCE ORNL QV-001

| QV CLAUSE | DOCUMENTS REQUIRED | APPLICABLE TO PART NO * |
|---|---|---|
| 303 | MATERIAL MILL TEST REPORT | |
| 325 | MATERIAL SELLER CERT | |
| 326 | SPECIAL MATERIAL INSPECTION REPORT | |
| 205 | MANUFACTURING, INSPECTION AND TEST PLAN | |
| 312 | FIELD INSPECTION AND TEST PLAN | |
| 321 | WELD AND BRAZE INSPECTION REPORT | |
| 322 | HEAT TREAT REPORT (W/CHART) | |
| 310 | LEAK TEST REPORT | |
| 315 | CLEANING CERT | |
| 318 | DEVIATION REQUEST | X |
| 319 | NONCONFORMANCE REPORT | X |
| 323 | DIMENSIONAL REPORT | |
| 330 | FUNCTIONAL TEST REPORT | |
| 100 | DOCUMENTTION | X |

* SYMBOL X INDICATES APPLICABLE TO ALL PARTS OR ITEMS

QA COORDINATOR — DATE 6/18/98

QPS NSTX-0008 R0 — DATE REC 6/98

PRINCETON UNIVERSITY
PLASMA PHYSICS LABORATORY
TOKAMAK FUSION TEST REACTOR

| PO ITEM | | |
|---|---|---|
| A (ENGINEER REVIEW) | NO COMMENTS, PRINT TO VENDOR | 1 |
| | COMMENTS AS NOTED, PRINT TO VENDOR | 2 |
| | DRAWING NOT APPLICABLE, PRINT TO VENDOR | 3 |
| | NO COMMENTS, NO PRINT TO VENDOR | 4 |
| | FOR INFORMATION ONLY | 5 |
| B (QUALITY PROJECT REVIEW) | NO FURTHER REPRODUCIBLE REQUIRED | 1 |
| | SUBMIT REVISED REPRODUCIBLE | 2 |
| | NO FURTHER REPRODUCIBLE REQUIRED | 3 |
| | SUBMIT REVISED REPRODUCIBLE | 4 |

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P THIS DRAWING PRODUCED ON PRO-ENGINEER

THIS DOCUMENT CONTROLLED BY
CHANGE CONTROL SYSTEM 3
ENGINEERING PROCEDURE EP-C-18

| REV | CHANGE TYPE | CHANGE CONTROL NUMBER | CHANGE NOTICE NUMBER | DESCRIPTION | A-E | BY | CHK | SECT | DEPT | DATE | PE | REQ | DATE | LM-ES | DATE | DOE | DATE | QA | CV | EC | EE | EM | IE | M | PD | SE | ST | XAD | PES |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 0 | | | | ORIGINAL ISSUE | | MTB | | | | 3/98 | | | | | | | | | | | | | | | | | | | |
| REVISION OR ISSUE PURPOSE | | | | | | | | | REVISION APPROVALS | | | | | | | | | SQUAD CHECK | | | | | | | | | | | |

SCALE .375

TOLERANCES UNLESS OTHERWISE SPECIFIED

| | |
|---|---|
| FRACTIONS | |
| XX DECIMALS | ±.01 |
| XXX DECIMALS | ±.005 |
| ANGLES | ±0°15' |
| BREAK SHARP EDGES | .06 MAX |
| FINISH | .125 UNLESS OTHERWISE SPECIFIED |

| | | |
|---|---|---|
| DES | P GORANSON | 02/98 |
| DRW | MT BROWN | 03/98 |
| CHK | | |
| SECT | | |
| DEPT | | |
| PE | | |
| CR | | |
| PJS | | |
| REQ | | |

DRAWING APPROVALS — DATE

LOCKHEED MARTIN — LOCKHEED MARTIN ENERGY SYSTEMS, INC.
operated for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT contract DE-AC-05-84OR21400
Oak Ridge, Tennessee . Paducah, Kentucky

PROJECT NAME: NSTX

# SECONDARY PASSIVE PLATE RIGHT BRACKET WELDMENT

| 1 | 48 | 49 | 50 | PLANT | BLDG | FL | SHT | OF | TYPE | CLASS |
|---|---|---|---|---|---|---|---|---|---|---|
| 3 | M | E | U | Y-12 | FEDC | 1 | 1 | 1 | S | U |
| 51 | | 52 | | 53 | X3E0171104A293 | | | | | REV 0 |

X3E0171104A293