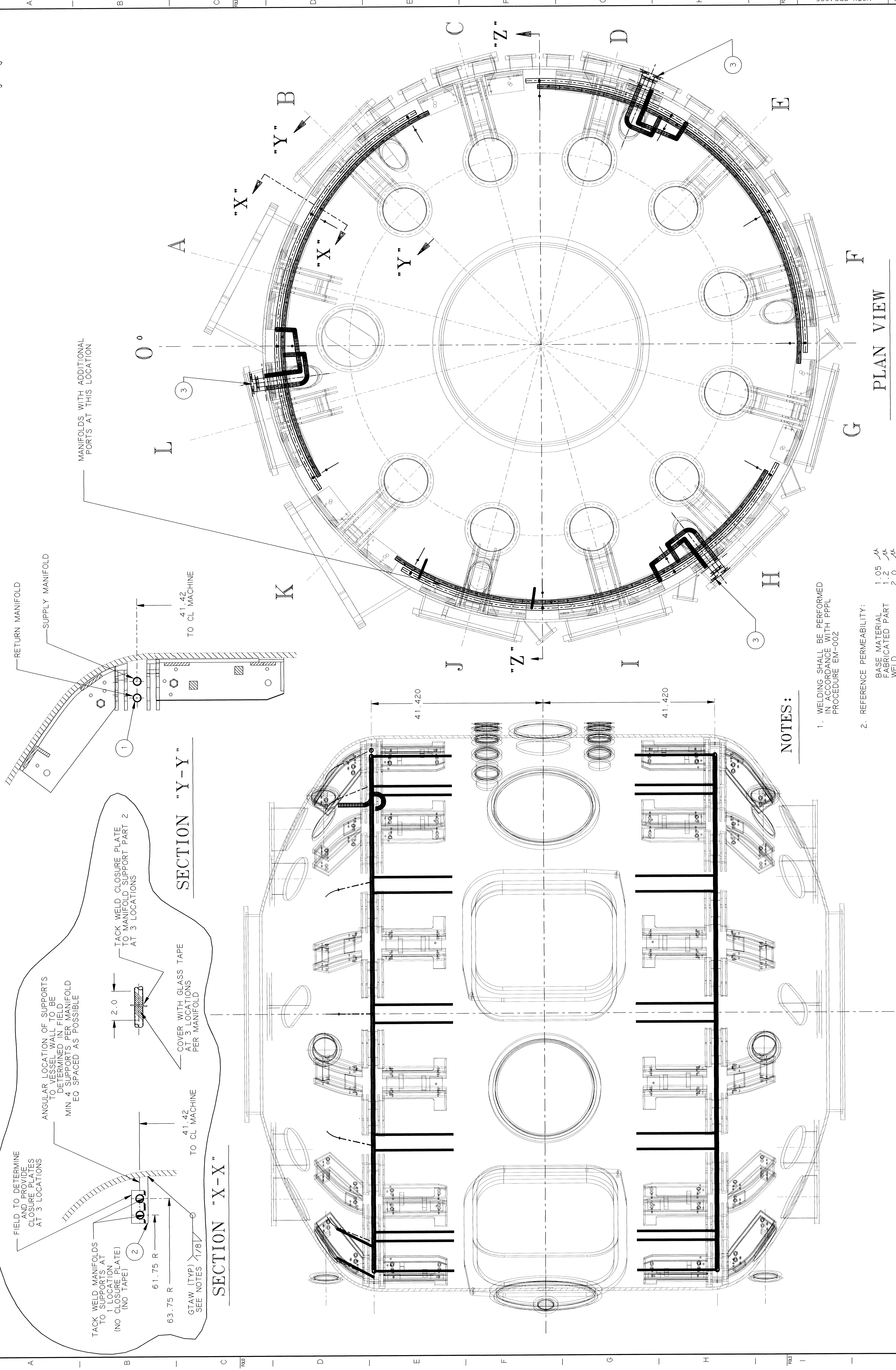


NO.	REVISION	BY	CH	SUP	APPROVED	DATE
1	REVISED PER CR-070	JDR				12/18/99



**NOTES:**

1. WELDING SHALL BE PERFORMED IN ACCORDANCE WITH PPPL PROCEDURE EM-002
2. REFERENCE PERMEABILITY:  
 BASE MATERIAL 1.05  
 FABRICATED PART 1.2  
 WELD 2.0
3. VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH ACCEPTANCE CRITERIA OF ASME B31.3 CATEGORY "D".
4. NOTE ORIENTATION OF ALL PARTS BEFORE WELDING.
5. HYDROSTATICALLY TEST MANIFOLD ASSEMBLIES AT 300 PSI FOR 15 MIN.

**PLAN VIEW**

3	H/C PORT FEED-THRU ASSEMBLY	EDB1076	SEE DT
2	MANIFOLD SUPPORT CLIP	EDB1084	SEE DT
1	MANIFOLD INSTALLATION ORIENTATION	EDB1083	SEE DT

03	02	01	
COMPUTER GENERATED CENTRAL FILES: PRINCETON PLASMA PHYSICS LABORATORY			
MANUAL CHANGES UNLESS OTHERWISE SPECIFIED: NATIONAL SPHERICAL TORUS EXPERIMENT			
DO NOT VERIFY INFORMATION FROM THIS DRAWING: TOKAMAK SYSTEMS			
PERSONAL DESIGNER: PLASMA FACING COMPONENTS			
DO NOT VERIFY INFORMATION FROM THIS DRAWING: MACHINE SURFACES: H/C MANIFOLDS INSTALLATION IN VACUUM VESSEL			
TOLERANCES: NON-DIMENSIONAL: DIV: MECH ENG DATE: 1/28/99			
DECIMAL-INCH FRACTIONS: ENG: G. BARNES			
XXX 0.005 12"-10" 0.010 10"-12" 0.015 12"-18" 0.020 18"-24" 0.030 24"-36" 0.040 36"-48" 0.050 48"-72" 0.063 72"-96" 0.080 96"-120" 0.100 120"-144" 0.125 144"-192" 0.150 192"-240" 0.1875 240"-300" 0.250 300"-360" 0.315 360"-432" 0.390 432"-516" 0.470 516"-600" 0.560 600"-720" 0.630 720"-864" 0.750 864"-1008" 0.875 1008"-1200" 1.125 1200"-1440" 1.500 1440"-1728" 2.000 1728"-2160" 2.500 2160"-2880" 3.150 2880"-3600" 4.000 3600"-4500" 5.000 4500"-5400" 6.300 5400"-6480" 8.000 6480"-7920" 10.000 7920"-9600" 12.500 9600"-11520" 16.000 11520"-13824" 20.000 13824"-16704" 25.000 16704"-20160" 31.500 20160"-24192" 40.000 24192"-28800" 50.000 28800"-34560" 63.000 34560"-41472" 80.000 41472"-49680" 100.000 49680"-59400" 125.000 59400"-70560" 157.500 70560"-83808" 200.000 83808"-99360" 251.250 99360"-117840" 315.000 117840"-139008" 396.000 139008"-163800" 495.000 163800"-192240" 622.500 192240"-224640" 787.500 224640"-269520" 990.000 269520"-318000" 1237.500 318000"-379440" 1546.875 379440"-444000" 1946.250 444000"-522240" 2432.8125 522240"-614400" 3041.250 614400"-720000" 3796.5625 720000"-839040" 4735.703125 839040"-971200" 5919.625 971200"-1127040" 7400.000 1127040"-1306560" 9225.000 1306560"-1510080" 11468.750 1510080"-1738080" 14335.9375 1738080"-1990080" 17920.000 1990080"-2267040" 22300.000 2267040"-2672640" 27762.500 2672640"-3116160" 34453.125 3116160"-3600000" 42566.40625 3600000"-4124160" 52958.000 4124160"-4688160" 65947.500 4688160"-5300160" 81934.375 5300160"-5964000" 101167.96875 5964000"-6674400" 124000.000 6674400"-7440000" 151250.000 7440000"-8364000" 183125.000 8364000"-9444000" 221406.250 9444000"-10684800" 271757.8125 10684800"-12091200" 334747.265625 12091200"-13660800" 411434.0625 13660800"-15408000" 500000.000 15408000"-17448000" 612500.000 17448000"-19680000" 753125.000 19680000"-22200000" 926406.250 22200000"-24984000" 1130000.000 24984000"-28032000" 1377500.000 28032000"-31440000" 1664375.000 31440000"-35208000" 2000000.000 35208000"-39344000" 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