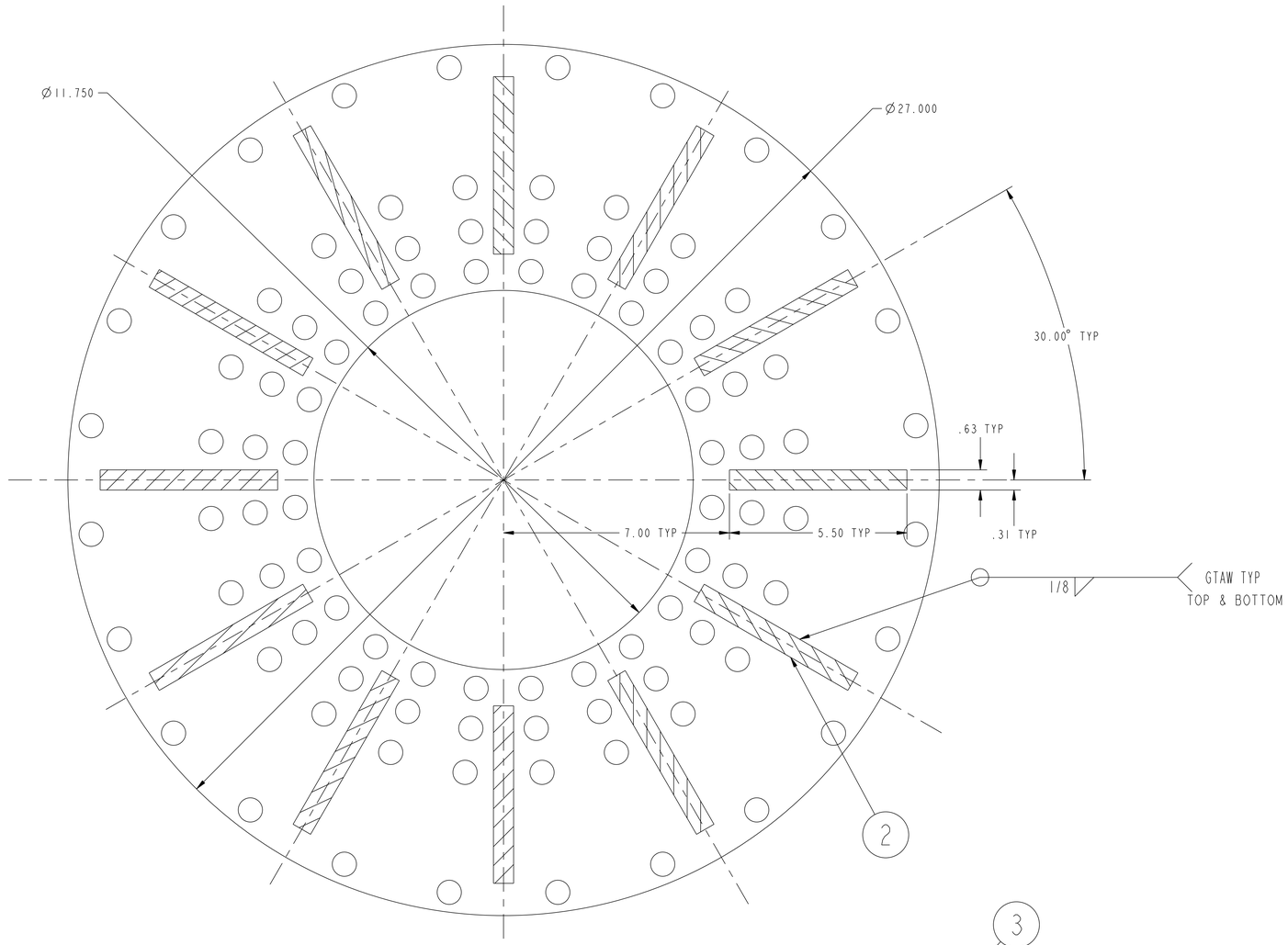
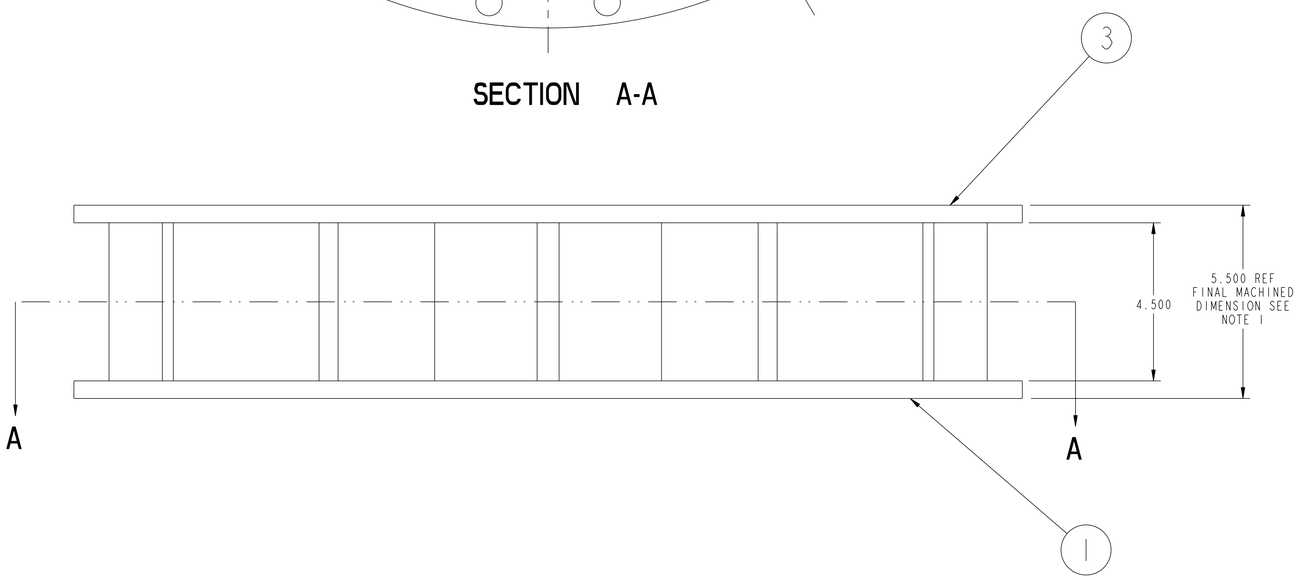
NO.	REVISION	BY	CH	SUP	APPROVED	DATE



SECTION A-A



NOTES:

1. TOP AND BOTTOM PLATES TO BE 5/8"TH'K MATERIAL FOR WELDING. FINAL MACHING TO BE DONE PER SHEET 2 OF THIS DRAWING.
2. WELDING SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF ASME B31.3 AND PPPL PROCEDURE NO. EM-002. VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH THE ACCEPTANCE CRITERIA OF ASME B31.3 CATEGORY D

03	02	01	PART NO.	DRAWING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL
		1	3	THIS DWG	CENTER HUB PLATE 5/8" TH'K X Ø27.000	304SS
		12	2	THIS DWG	RIB PLATE 5/8"TH'K X 4.500 WD X 5 1/2" LG	304SS
		1	1	THIS DWG	CENTER HUB PLATE 5/8" TH'K X Ø27.000	304SS
		X	----	THIS DWG	CENTER HUB WELDMENT/FINAL MACHINING	304SS

ASSY QTY — PARTS LIST

COMPUTER GENERATED DRAWING
MANUAL CHANGES NOT PERMITTED

Pro E

DO NOT VERIFY INFORMATION BY SCALING DRAWING

CENTRAL FILES:

UNLESS OTHERWISE SPECIFIED

DIMENSIONS ARE IN INCHES
MACHINE SURFACES: 125

BREAK SHARP EDGES .005/.020

TOLERANCES NON-CUMULATIVE

NEXT ASSEMBLY

DECIMAL-INCH		FRACTIONS	
.X	±.100	0°-12°	±1/16
.XX	±.030	12°-72°	±1/8
.XXX	±.005	72°-120°	±1/4
ANGULAR	±0°-15'	OVER 120°	±1/2

PRINCETON PLASMA PHYSICS LABORATORY
PRINCETON UNIVERSITY
NATIONAL SPHERICAL TORUS EXPERIMENT

TF CORE
CENTER HUB WELDMENT
AND FINAL MACHINING

DIV: MECH. ENG. | DATE: 7/23/03 | CADD FILE: E-DC1295 .DRW

ENG: J.CHRZANOWSKI | APPROVED J.CHRZANOWSKI

DSN: B.PAUL

CHK: M. KALISH | CHK MK | SUPV JS

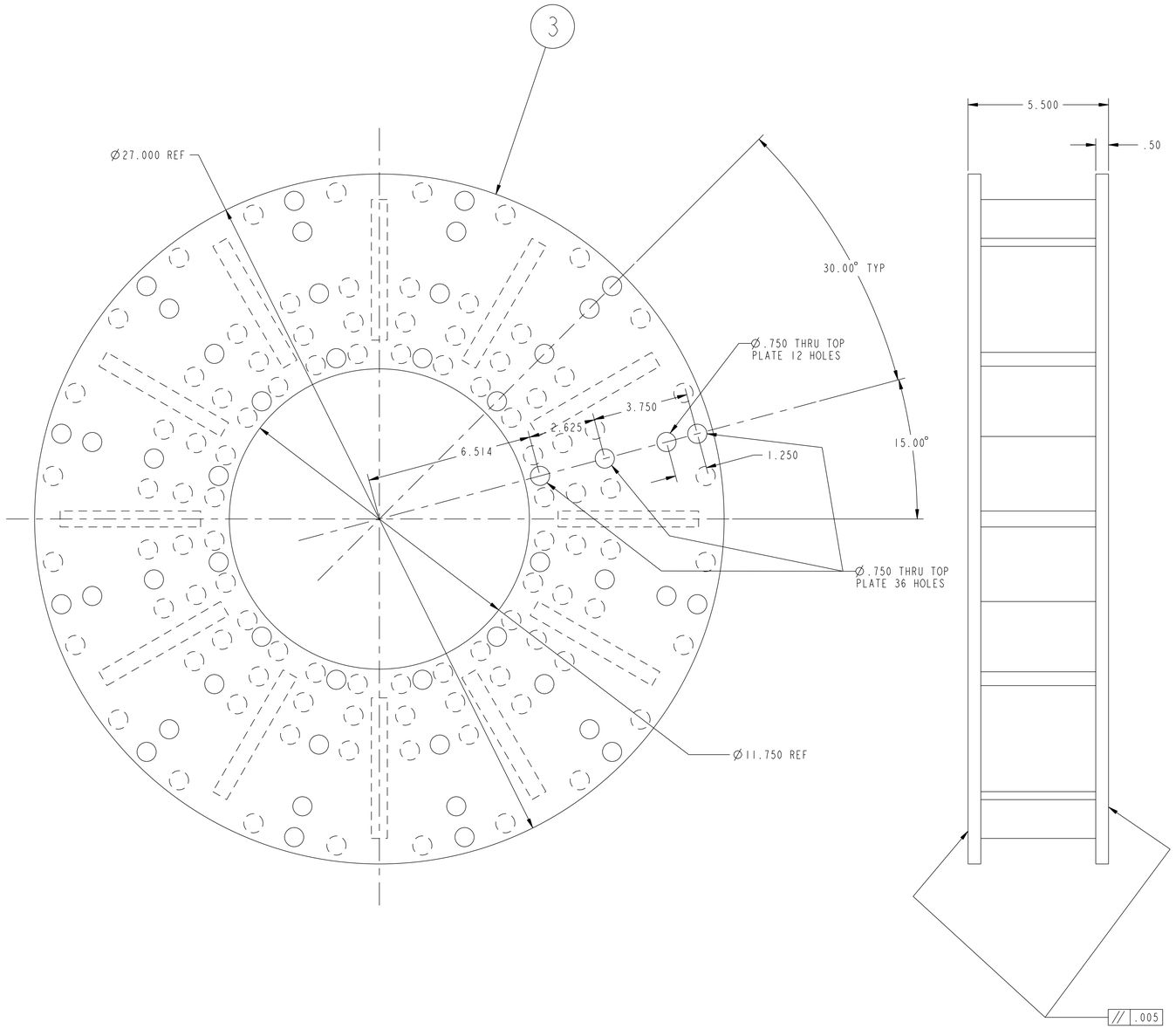
E-DC1295

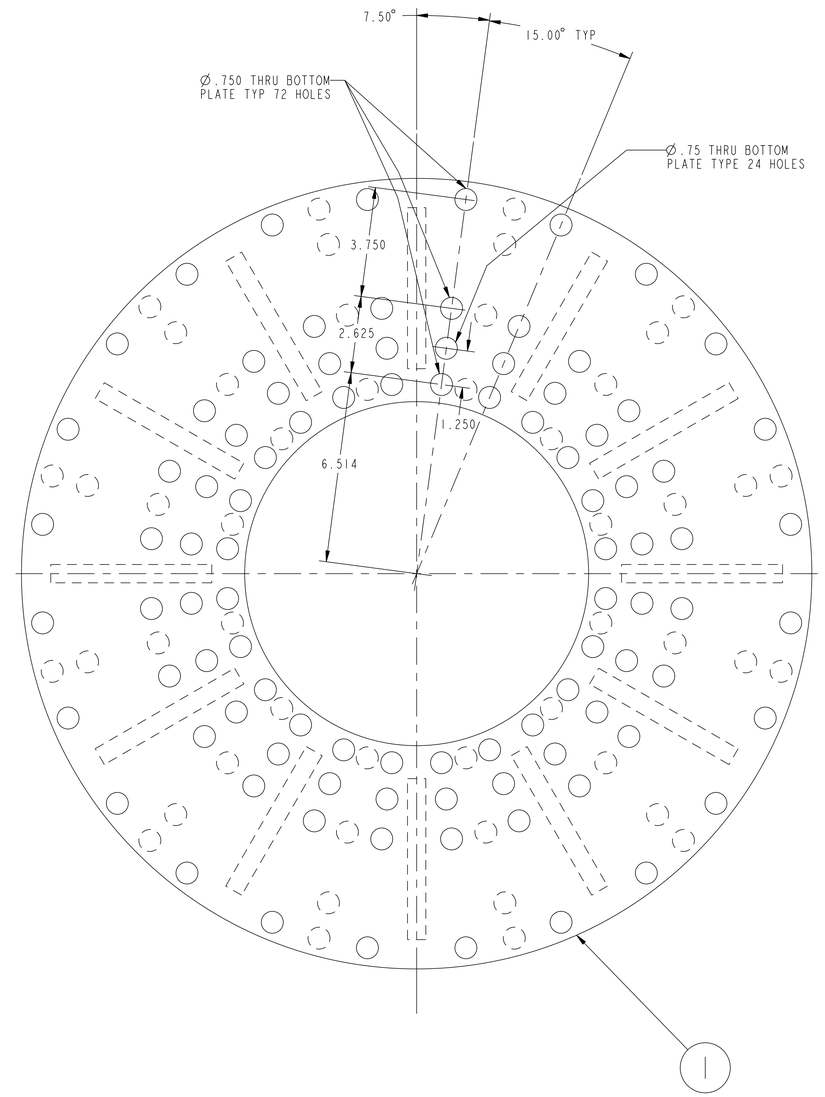
SHEET 1 OF 2 | REV 0

WELDING ENGINEER
APPVD: R.PARSELLS DATE 7/23/03

NSTX-E-DC1295

NO.	REVISION	BY	CH	SUP	APPROVED	DATE





CENTER HUB FINAL MACHINING

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY NATIONAL SPHERICAL TORUS EXPERIMENT	
Pro E	DIMENSIONS ARE IN INCHES MACHINE SURFACES 125	TF CORE CENTER HUB WELDMENT AND FINAL MACHINING	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	BREAK SHARP EDGES .005/.020		
	TOLERANCES NON-CUMULATIVE	DIV: MECH. ENG. / DATE: 7/23/03	CADD FILE: E-DC1295 .DRW
NEXT ASSEMBLY	DECIMAL-INCH: .X ±.100; .XX ±.030; .XXX ±.005; ANGULAR ±0°-15' FRACTIONS: 0°-12° ±1/16; 12°-72° ±1/8; 72°-120° ±1/4; OVER 120° ±1/2	ENG: J.CHRZANOWSKI / APPROVED J.CHRZANOWSKI	E-DC1295
		DSN: B.PAUL	
		CHK: M. KALISH / CHK MK / SUPV JS	SHEET 2 OF 2 / REV 0

WELDING ENGINEER
APPVD: _____ DATE

EMI

NSTX-E-DC1295