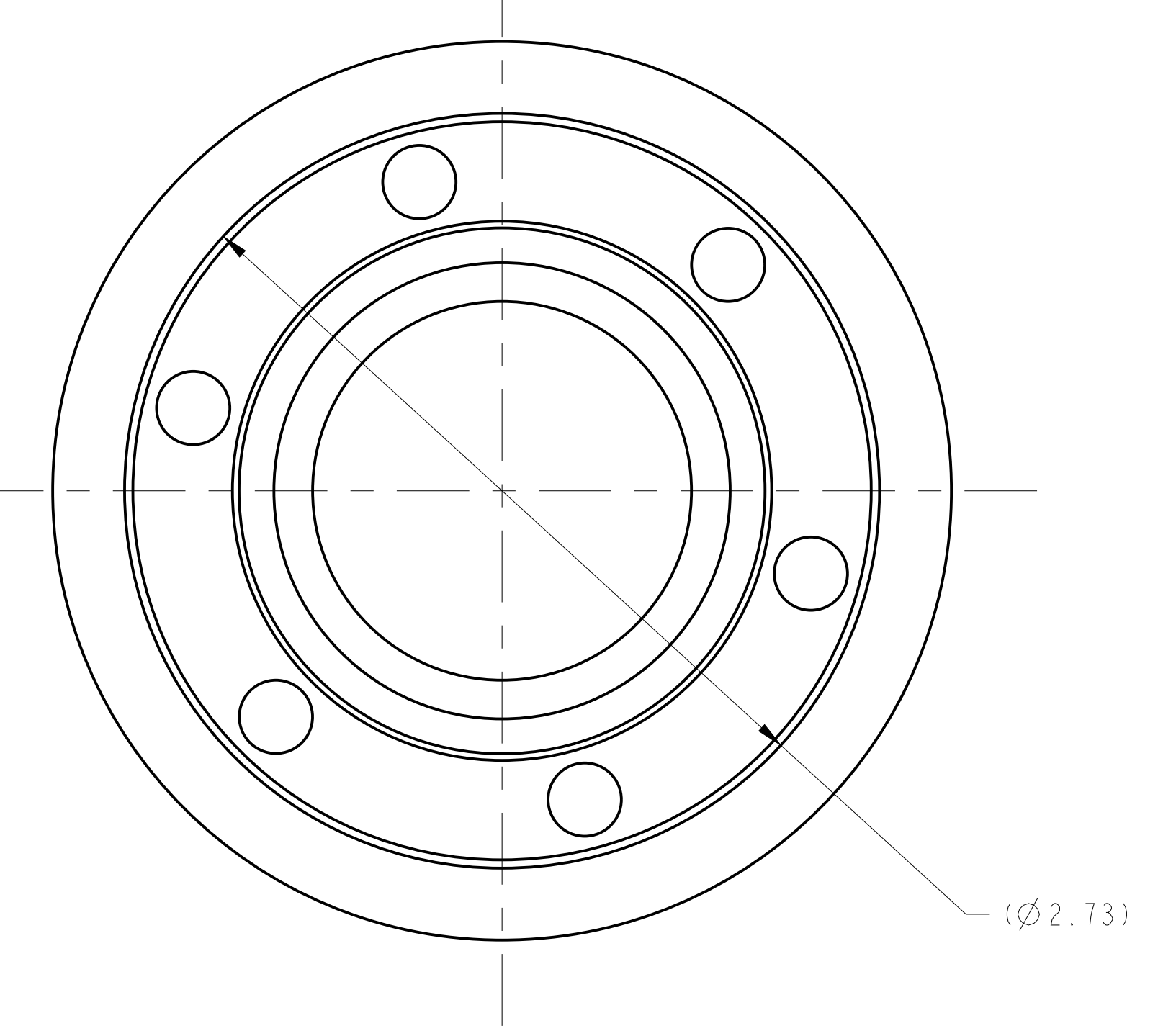
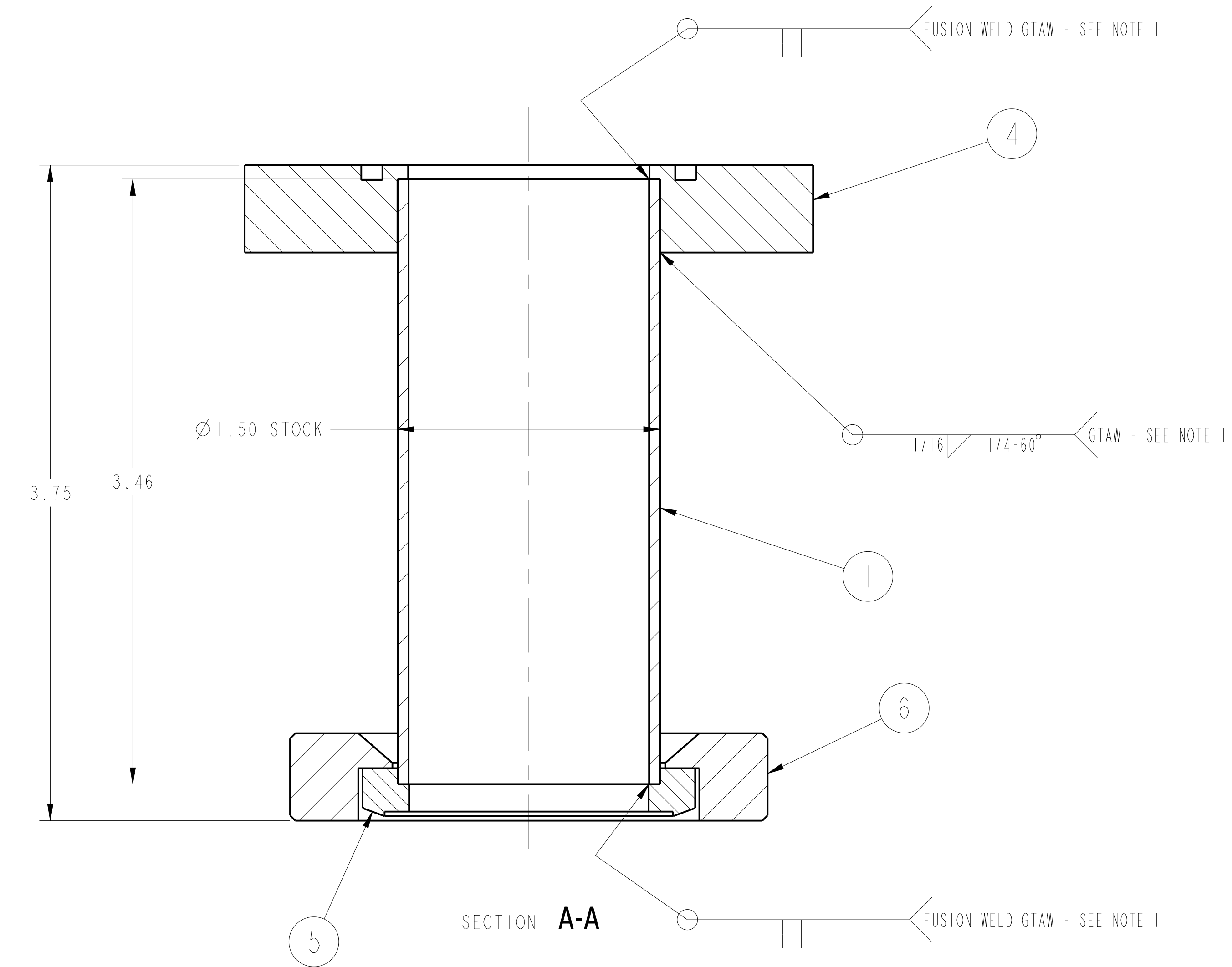
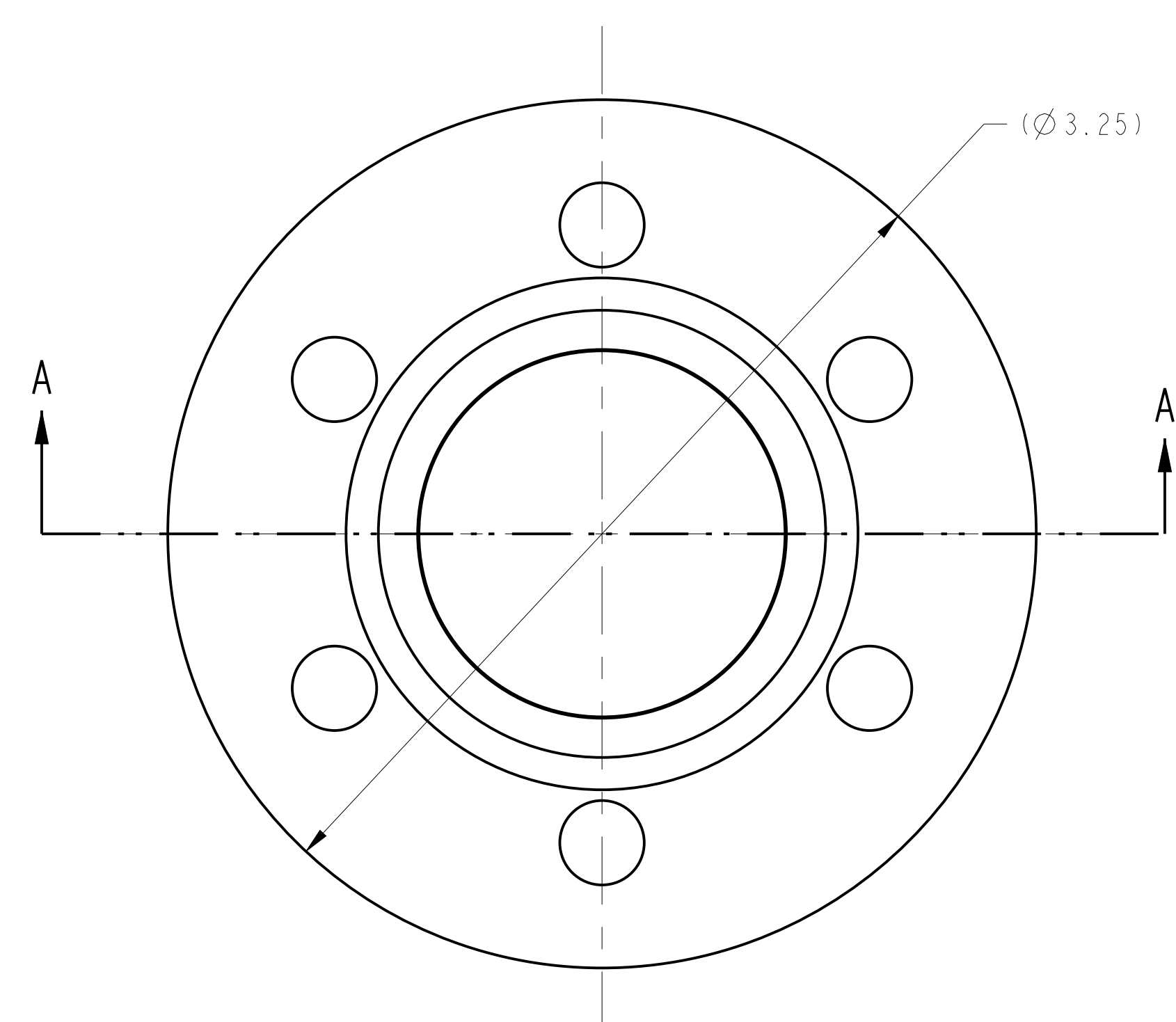


NO.	REVISION	WP NO.	BY	CH	SUP	APPROVED	DATE
1	REVISED PER ECN-7634	2165	LM	NA	LM	N. ALLEN	2/23/2016



-01 ASSEMBLY - MGI VALVE ADAPTER SPOOL PIECE WELDMENT

NOTES

1. WELDING SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF ASME B31.3. WELDING PERFORMED ONSITE SHALL ALSO MEET THE REQUIREMENTS OF PPPL PROCEDURE ENG-037. VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH THE ACCEPTANCE CRITERIA OF ASME B31.3 CATEGORY D.
2. MAGNETIC PERMEABILITY AS DETERMINED WITH A SEVERN GAUGE SHALL NOT EXCEED THE FOLLOWING:
 BASE MATERIAL: 1.04 mu
 MACHINED: 1.20 mu
 WELDED: 2.0 mu

QTY	ITEM NO.	DRAWING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL	QTY REQD
1	8	NS151553	1.33 O.D. ROT. INNER RING x 1/2 TUBE	304 S/S	
1	7	NS151540	1.33 O.D. MINI-CF FLG ROT. NON-TAPPED OUTER RING	304 S/S	
1	6	NS151550	2 3/4 O.D. CF FLG ROTATABLE NON-TAPPED OUTER RING	304 S/S	
1	5	NS151511	2.75 ROTATABLE INNER RING 1 1/2 TUBE	304 S/S	
1	4	A-EA3507-1	CUSTOM FLANGE (FOR MGI VALVE)	316 S/S	
1	3	E-EA3506-3	MGI VALVE PUMPOUT TUBE	316 S/S	
1	2	E-EA3506-2	SPECIAL SPOOL PIECE - TYPE "B"	316 S/S	
1	1	E-EA3506-1	SPECIAL SPOOL PIECE - TYPE "A"	304 S/S	
2		E-EA3506-02	MGI VALVE ADAPTER SPOOL PIECE W/PUMPOUT WELDMENT		2
1		E-EA3506-01	MGI VALVE ADAPTER SPOOL PIECE WELDMENT		1

PARTS LIST

GENERAL NOTES

1. PPPL APPROVED DRAWINGS TAKE PRECEDENCE OVER MODEL DIMENSIONS.
2. WHEN MODELS ARE PROVIDED, VENDOR MUST VERIFY THAT MODEL DIMENSIONS CONFORM WITH PPPL APPROVED DRAWINGS PRIOR TO FABRICATION.

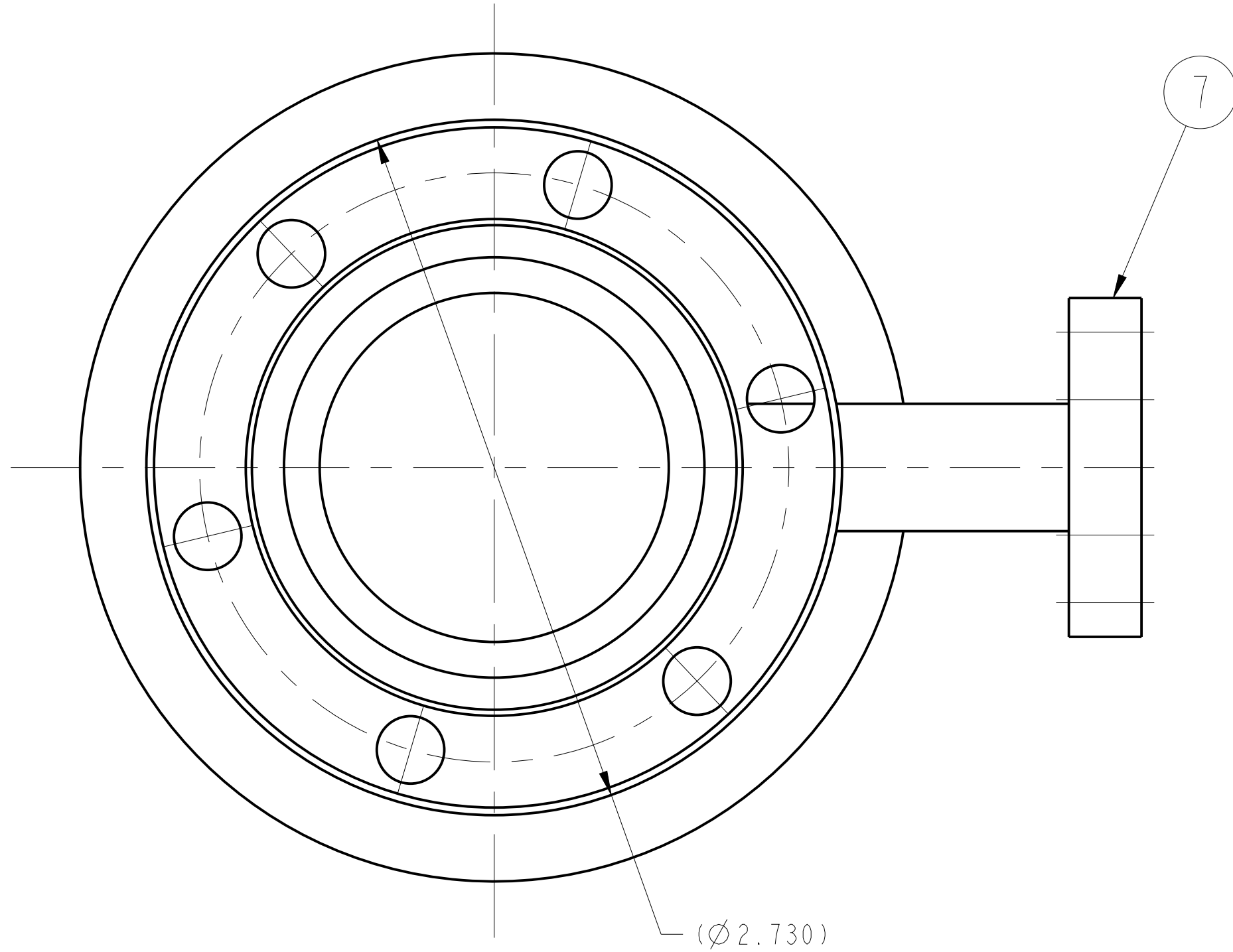
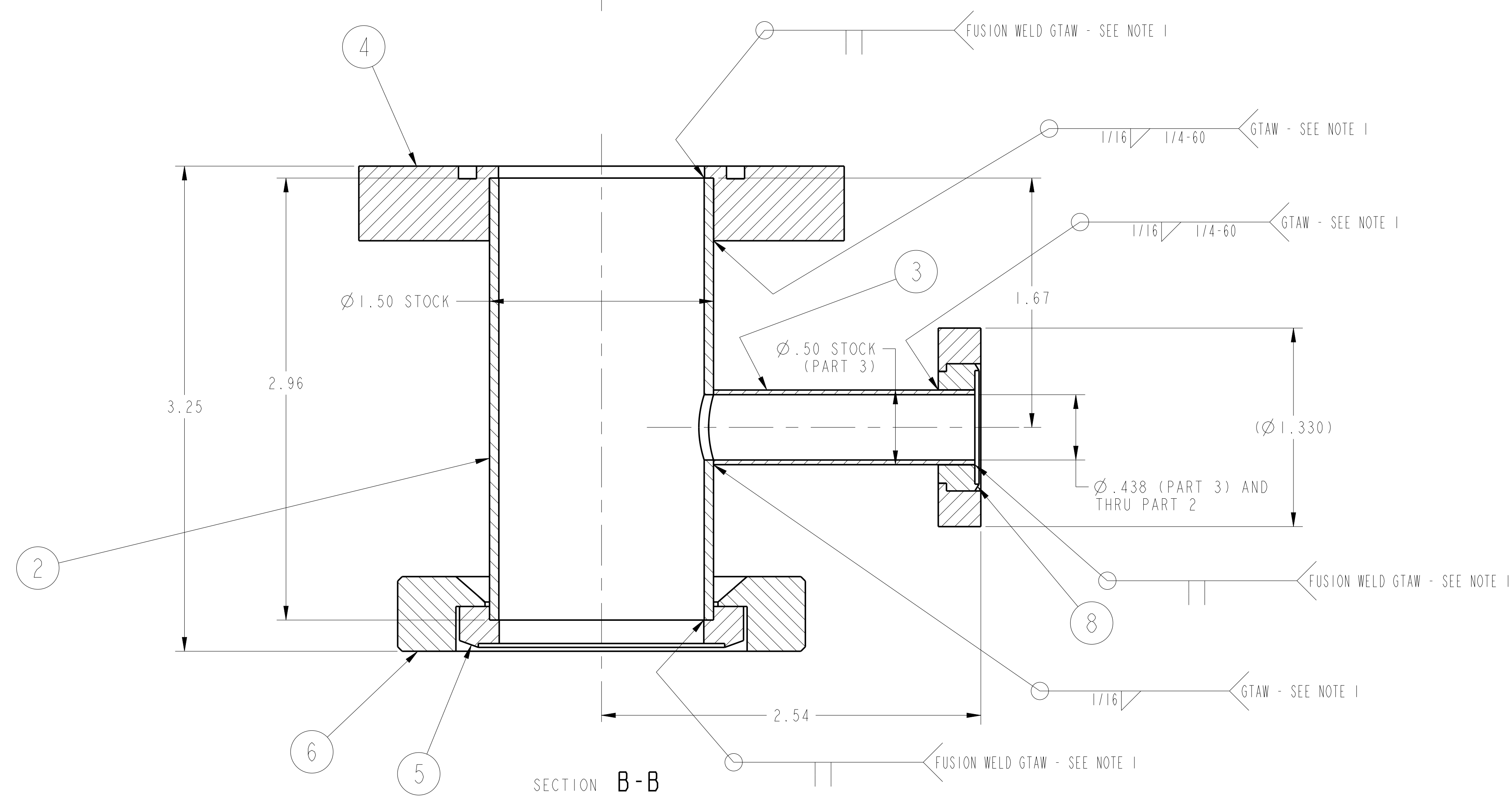
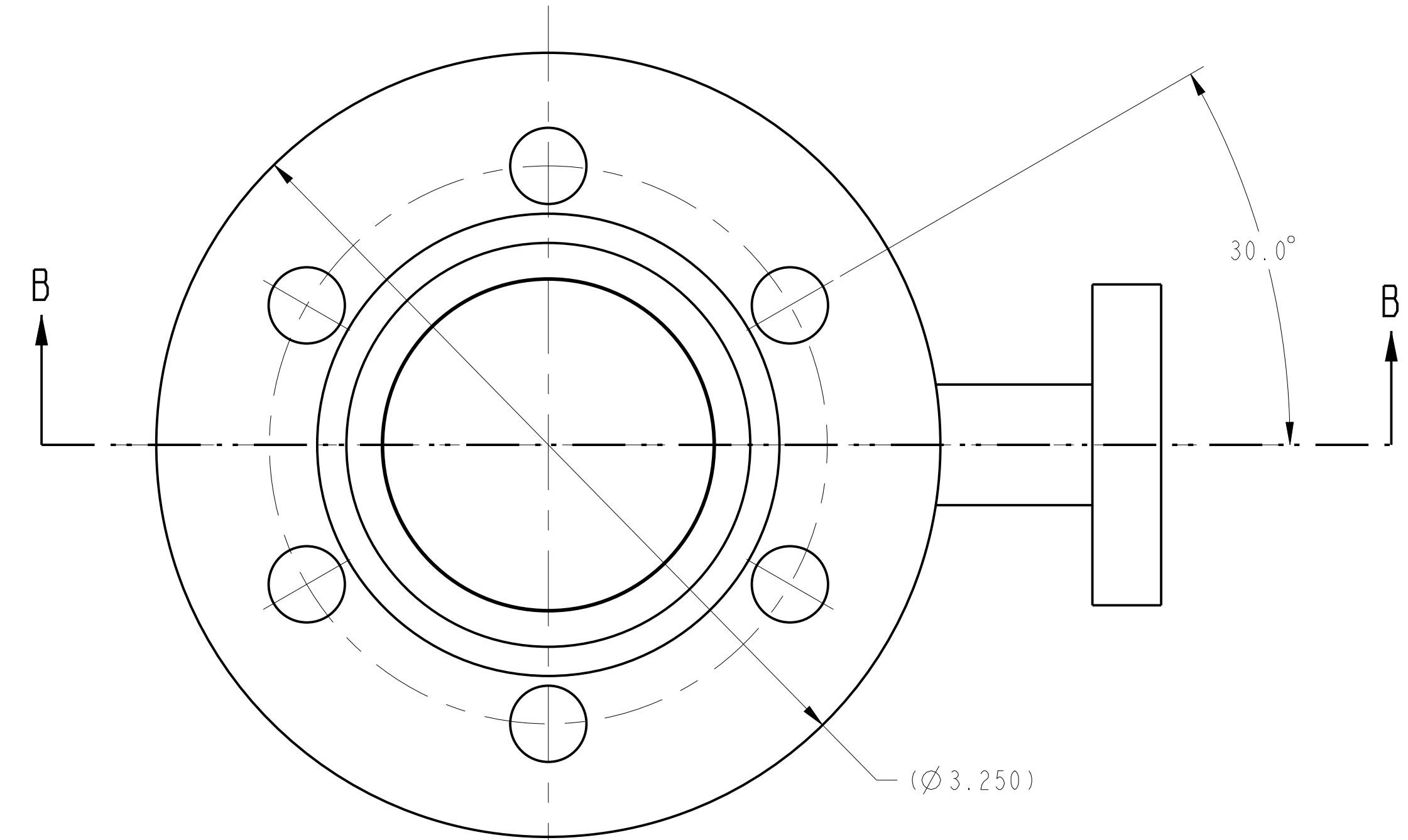
MAGNETIC PERMEABILITY REQUIREMENT (SEE NOTES)	
YES	<input checked="" type="checkbox"/>
NO	<input type="checkbox"/>

RELEASE LEVEL: WIP
 DWG VERSION NO: 1.0

WELDING ENGINEER
 APPVD: W. STYER DATE: 2/5/2014

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES: (UNLESS OTHERWISE SPECIFIED) DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .055/.020	PRINCETON PLASMA PHYSICS LABORATORY NATIONAL SPHERICAL TORUS EXPERIMENT GAS INJECTION SYSTEM MASSIVE GAS INJECTION SYSTEM MGI VALVE ADAPTER SPOOL PIECE WELDMENTS
SCALE: 2X	TOLERANCES - NON-CUMULATIVE DECIMAL-INCH FRACTIONS XX ±.000 01"-12" ±.010 XXX ±.010 12"-120" ±.014 ANGULAR ±0°-15' 00°-120' ±12'	DIV: MECH. ENG. DATE: 9/4/2014 ENG: W. BLANCHARD DSN: L. MORRIS W. BLANCHARD CHK: W. BLANCHARD
NEXT ASSEMBLY		APPROVED E-EA3506
		SHEET 1 OF 2 REV 1

NO.	REVISION	WP NO.	BY	CH	SUP	APPROVED	DATE



-02 ASSEMBLY - MGI VALVE ADAPTER SPOOL PIECE W/PUMPOUT WELDMENT

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

GENERAL NOTES

- PPPL APPROVED DRAWINGS TAKE PRECEDENCE OVER MODEL DIMENSIONS.
- WHEN MODELS ARE PROVIDED, VENDOR MUST VERIFY THAT MODEL DIMENSIONS CONFORM WITH PPPL APPROVED DRAWINGS PRIOR TO FABRICATION.

MAGNETIC PERMEABILITY REQUIREMENT (SEE NOTES)	
YES	NO

RELEASE LEVEL: WIP
DWG VERSION NO: 1.0

WELDING ENGINEER
APPVD: _____ DATE: _____

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY NATIONAL SPHERICAL TORUS EXPERIMENT
DO NOT VERIFY INFORMATION BY SCALING DRAWING	BREAK SHARP EDGES .005/.020	GAS INJECTION SYSTEM MASSIVE GAS INJECTION SYSTEM MGI VALVE ADAPTER SPOOL PIECE WELDMENTS
SCALE: 2X	TOLERANCES - NON-CUMULATIVE	DIV: MECH. ENG. DATE: 2/22/2016
NEXT ASSEMBLY	DECIMAL - INCH FRACTIONS	ENG: N. ALLEN DSN: L. MORRIS CHK: N. ALLEN
	XXX 0.100 01"=12" 0.174 XXX 0.030 12"=12" 0.174 XXX 0.010 72"=120" 0.174 ANGLR 00°-15' 000°-120' 0.174	APPROVED E-EA3506
		CH: N. ALLEN SUPV: LW SHEET 2 OF 2 REV 1

INSTX-E-EA3506