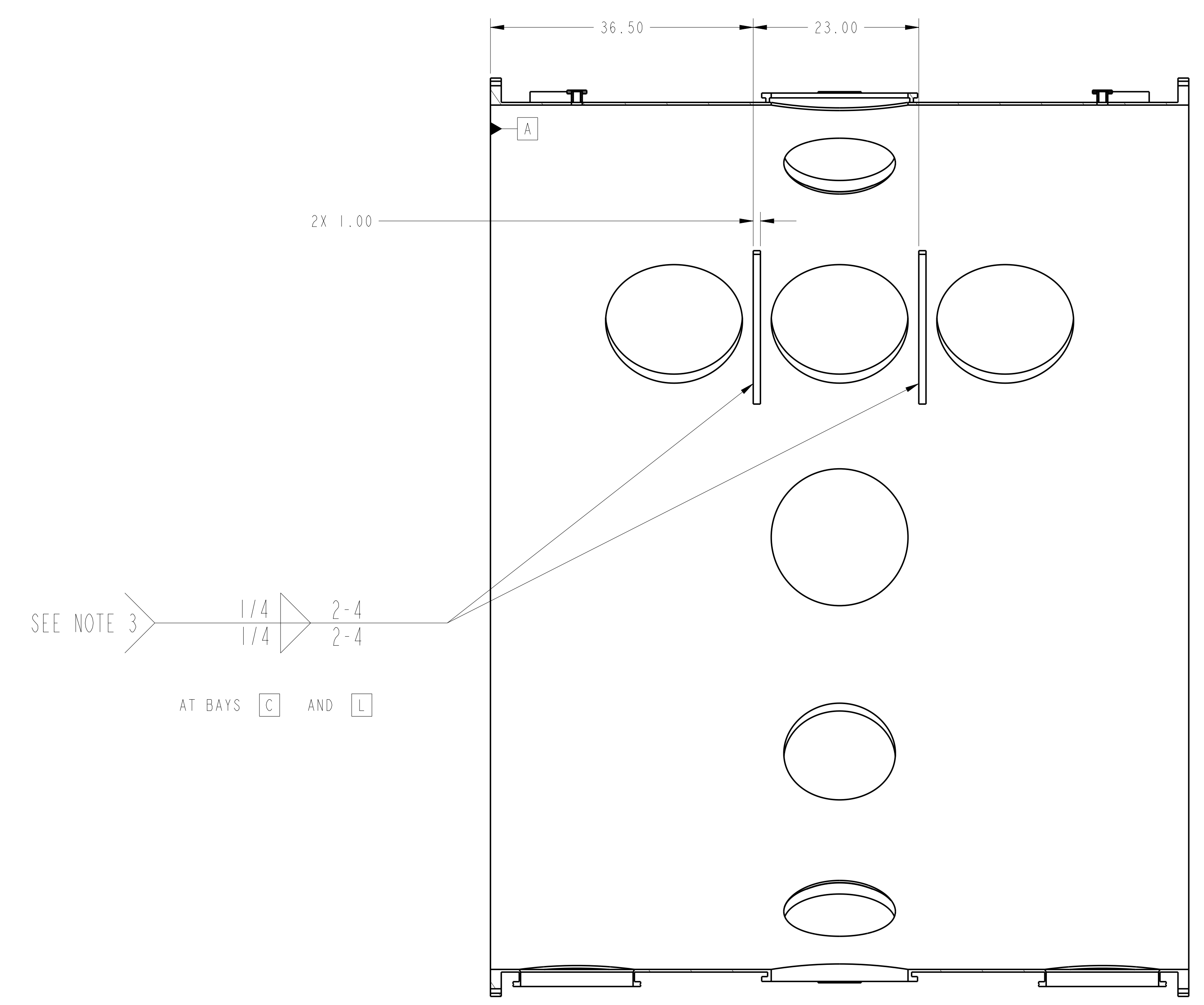
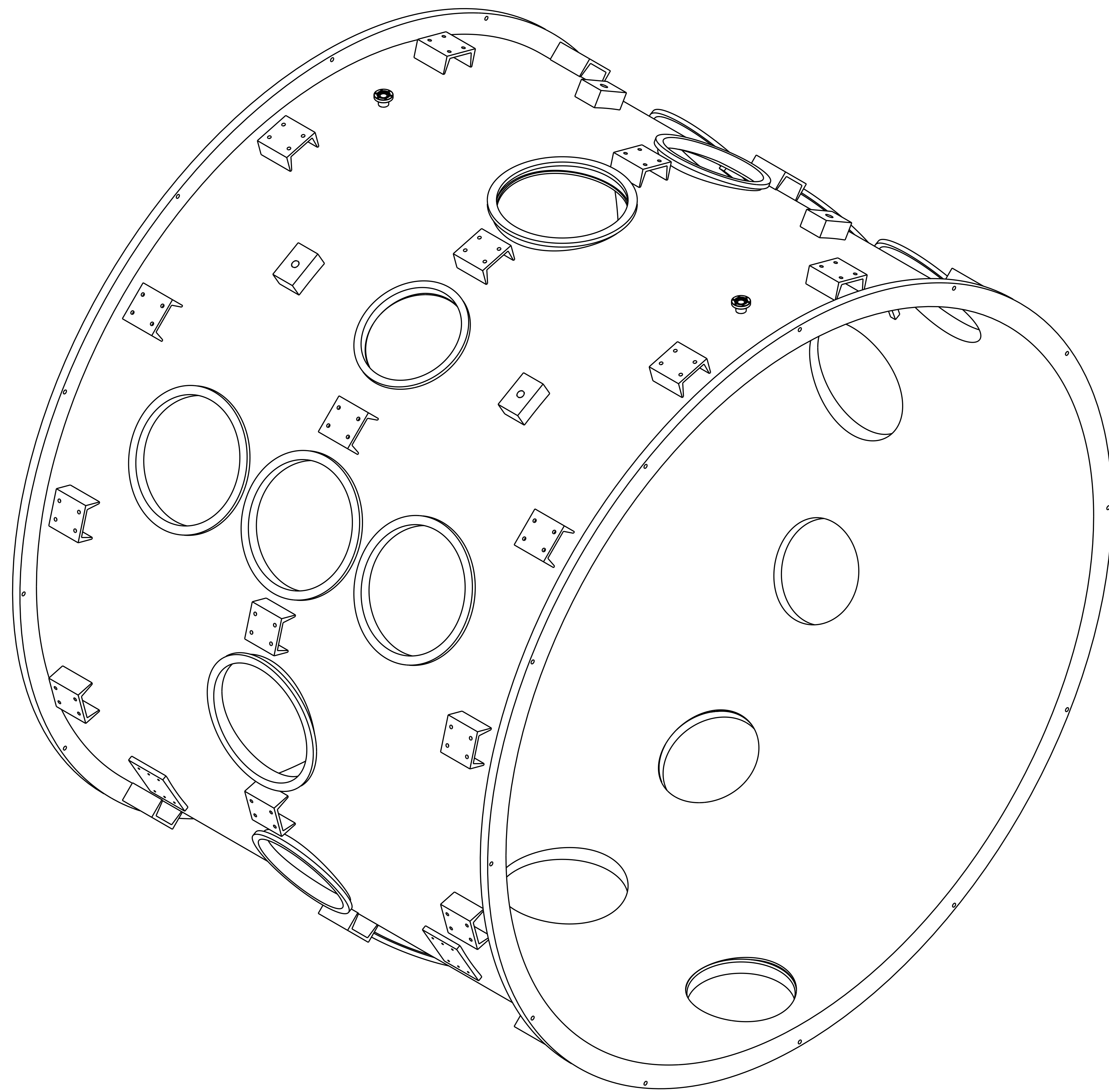


NO.	REVISION	BY	CH	SUP	APPROVED	DATE



SEE NOTE 3 $\frac{1}{4}$ $\frac{2-4}{1/4}$ $\frac{2-4}{2-4}$
AT BAYS **C** AND **L**

SECTION G-G
TYPICAL BOTH SIDES
INSIDE VESSEL
SCALE 0.100

- NOTES:
- ALL ASPECTS OF FABRICATION OF THIS ASSEMBLY (MATERIALS, WELDING, FINISHING, ETC.) SHALL BE PERFORMED IN ACCORDANCE WITH PPPL SPECIFICATION FLARE-SPEC-04.
 - BAY DESIGNATIONS ARE INDICATED BY **A**
EXAMPLE: **A** = BAY "A"
 - WELDING SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF ASME B31.3. WELDING PERFORMED ONSITE SHALL ALSO MEET THE REQUIREMENTS OF PPPL PROCEDURE NO. ENG-037. VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH THE ACCEPTANCE CRITERIA OF ASME B31.3, CATEGORY D.
 - FLANGES AT BAYS "B", "E", "F", "J" & "M" ARE 15.500 INSIDE DIAMETER FLANGES (MDC PART NO 820005 OR EQUIV). ALL OTHER FLANGES ARE 19.000 DIAMETER (MDC PART NO. 820007 OR EQUIV) EXCEPT 2 OUTER FLANGES AT BAY "G" (MDC PART NO. 820004).
 - MATERIAL TO BE 304 SS UNLESS OTHERWISE SPECIFIED.
 - FULL PENETRATION SEAM WELD AS SHOWN IN APPROX. LOCATION.
 - SURFACE FINISH TO BE CIRCUMFERENCIAL FOR VACUUM SEALING.

QTY	PART NO	DRAWING NO	NOMENCLATURE OR DESCRIPTION	MAT'L	QTY REQD
6	5	COMM	NW250 FLANGE - MDC PART NO. 8200004 OR EQUIV	304 SS	
2	4	NS151457	FLANGE, CONFLAT	304 SS	
5	3	COMM	NW320 FLANGE - MDC PART NO. 820005 OR EQUIV	304 SS	
11	2	COMM	NW500 FLANGE - MDC PART NO. 820007 OR EQUIV	304 SS	
1	1	E-FL300-002-1	VACUUM VESSEL	304 SS	
-01			THIS DRAWING		
			FLARE VACUUM VESSEL WELDMENT		

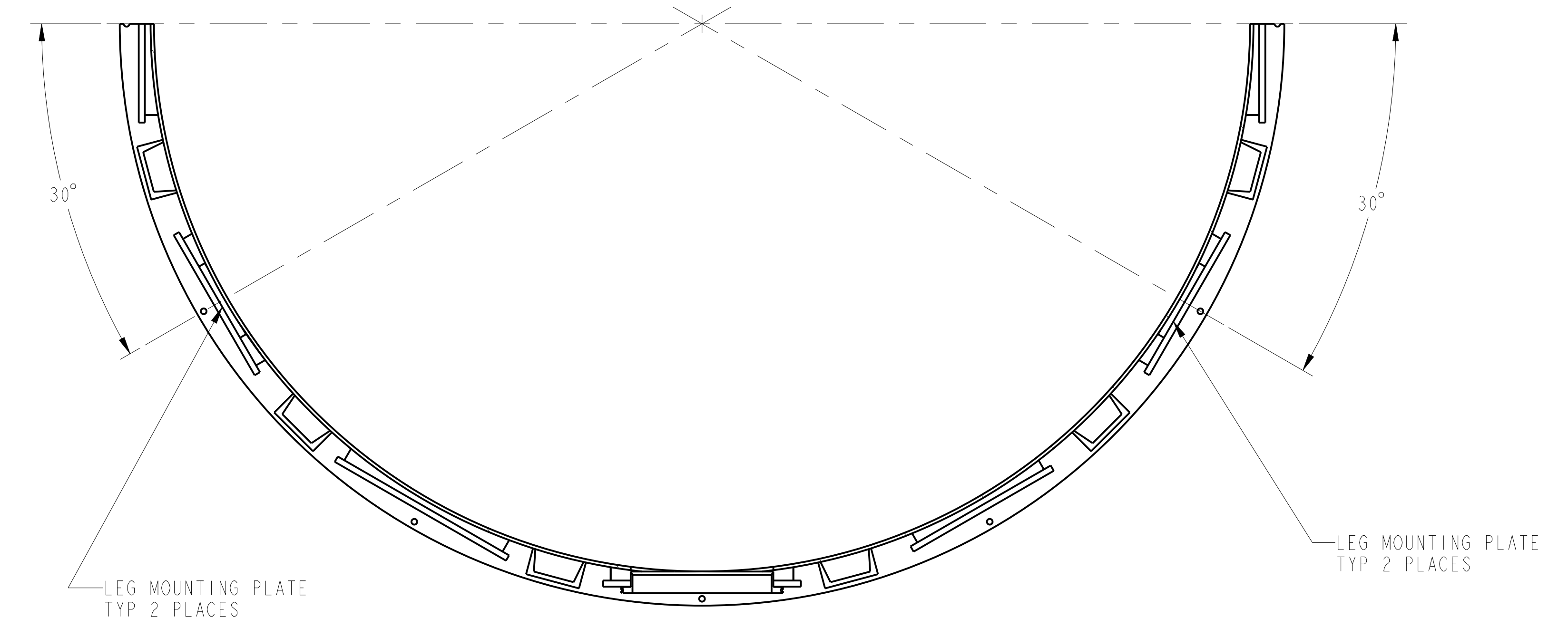
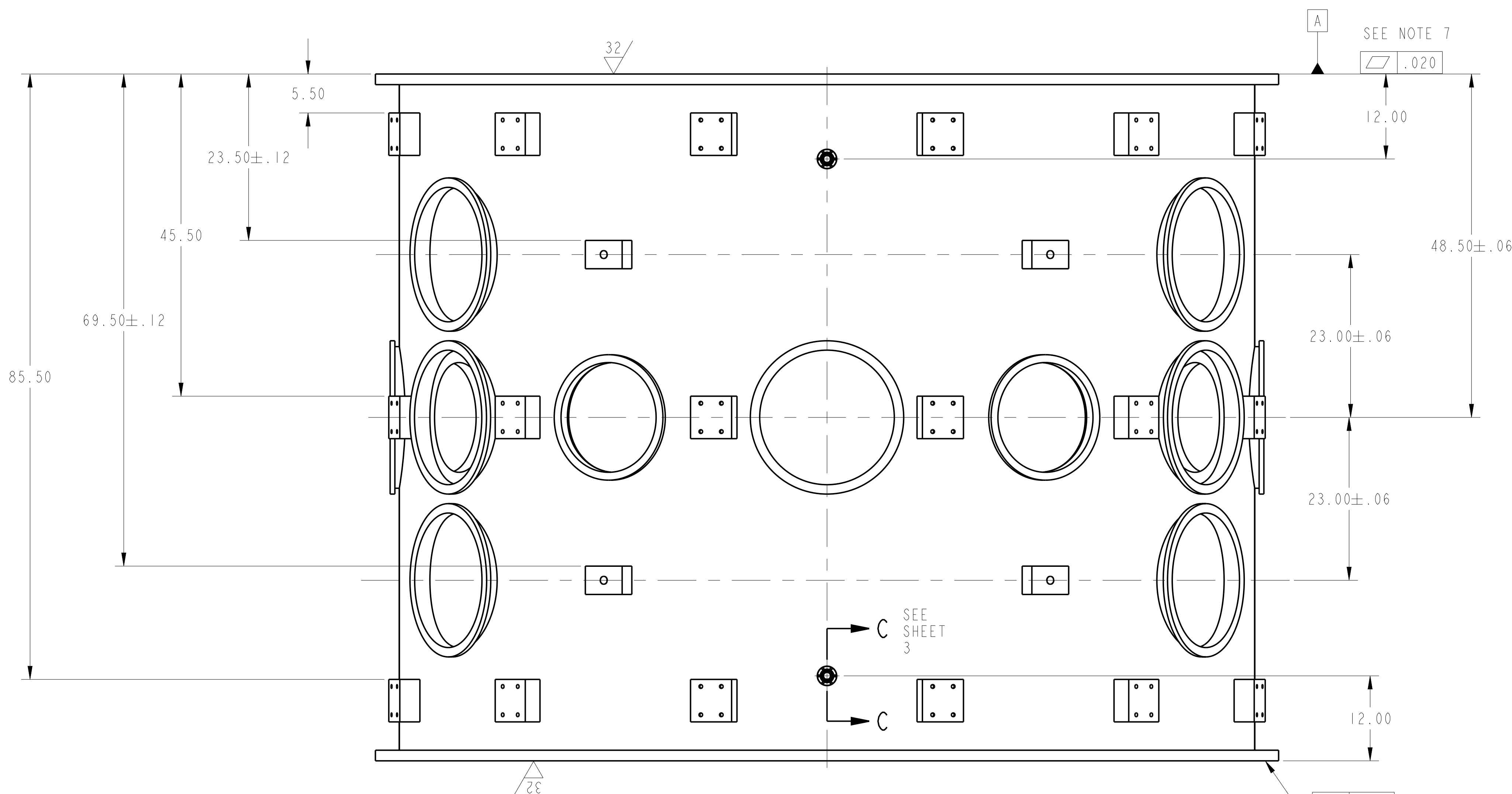
PARTS LIST

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY FLARE VACUUM VESSEL WELDMENT
DO NOT VERIFY INFORMATION BY SCALING DRAWING	TOLERANCES - NON-CUMULATIVE DECIMAL-INCH FRACTIONS XX 0.100 01'-12" 01/16 XX 0.030 12'-12" 01/16 XXX 0.010 12'-120" 01/16 ANGULAR 00'-15 00'-120' 01/2	DIV: MECH. ENG. DATE: 5/5/2015 ENG: M KALISH DSN: J MITCHELL CHK: M KALISH
SCALE:	NEXT ASSEMBLY E-FL600-001	APPROVED M KALISH SHEET 1 OF 4 REV 0

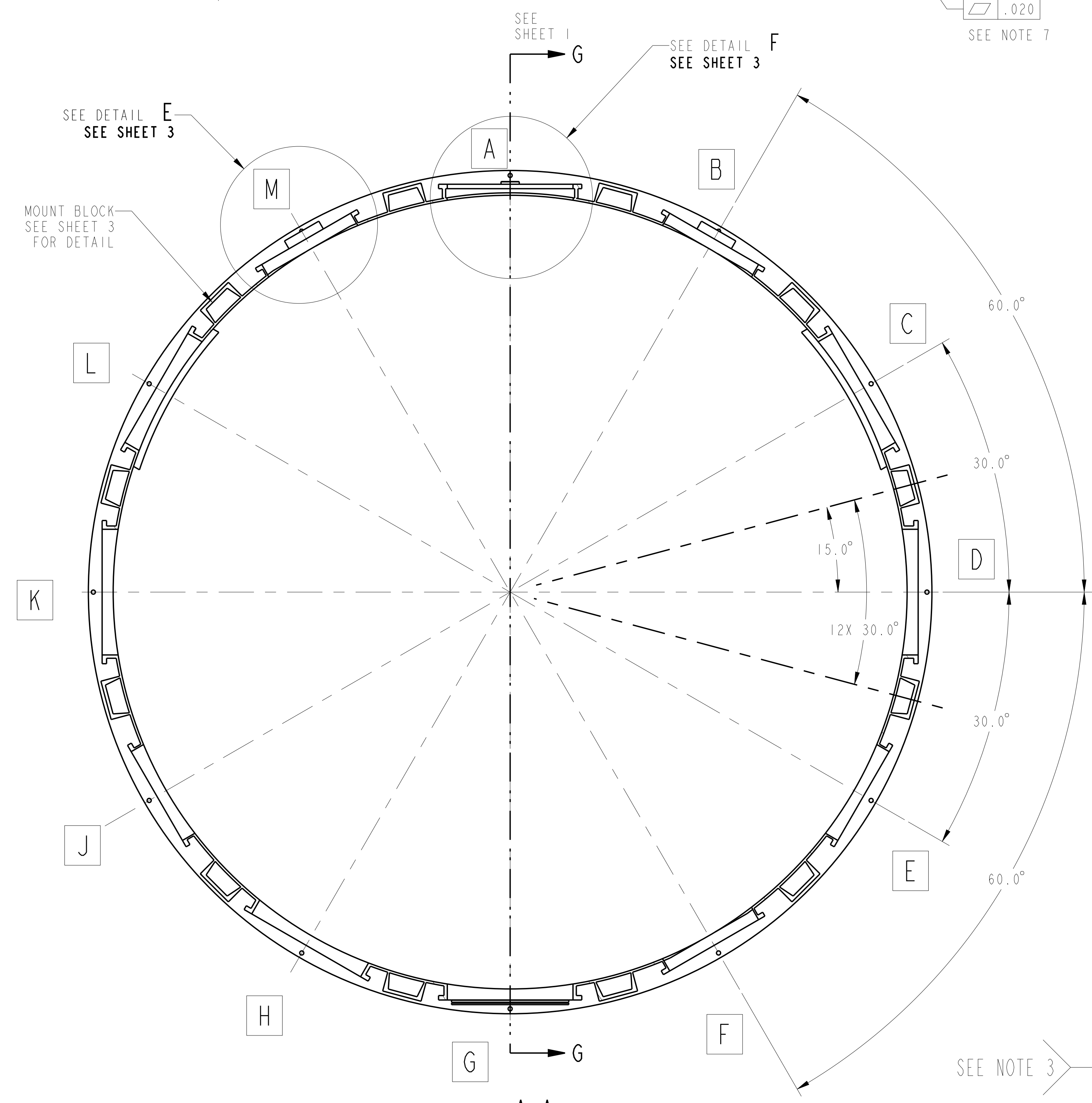
RELEASED FOR FABRICATION / INSTALLATION
PPPL Drafting

RELEASE LEVEL: Fabrication	WELDING ENGINEER
DWG VERSION NO: 1.18	APPROVED: DATE:

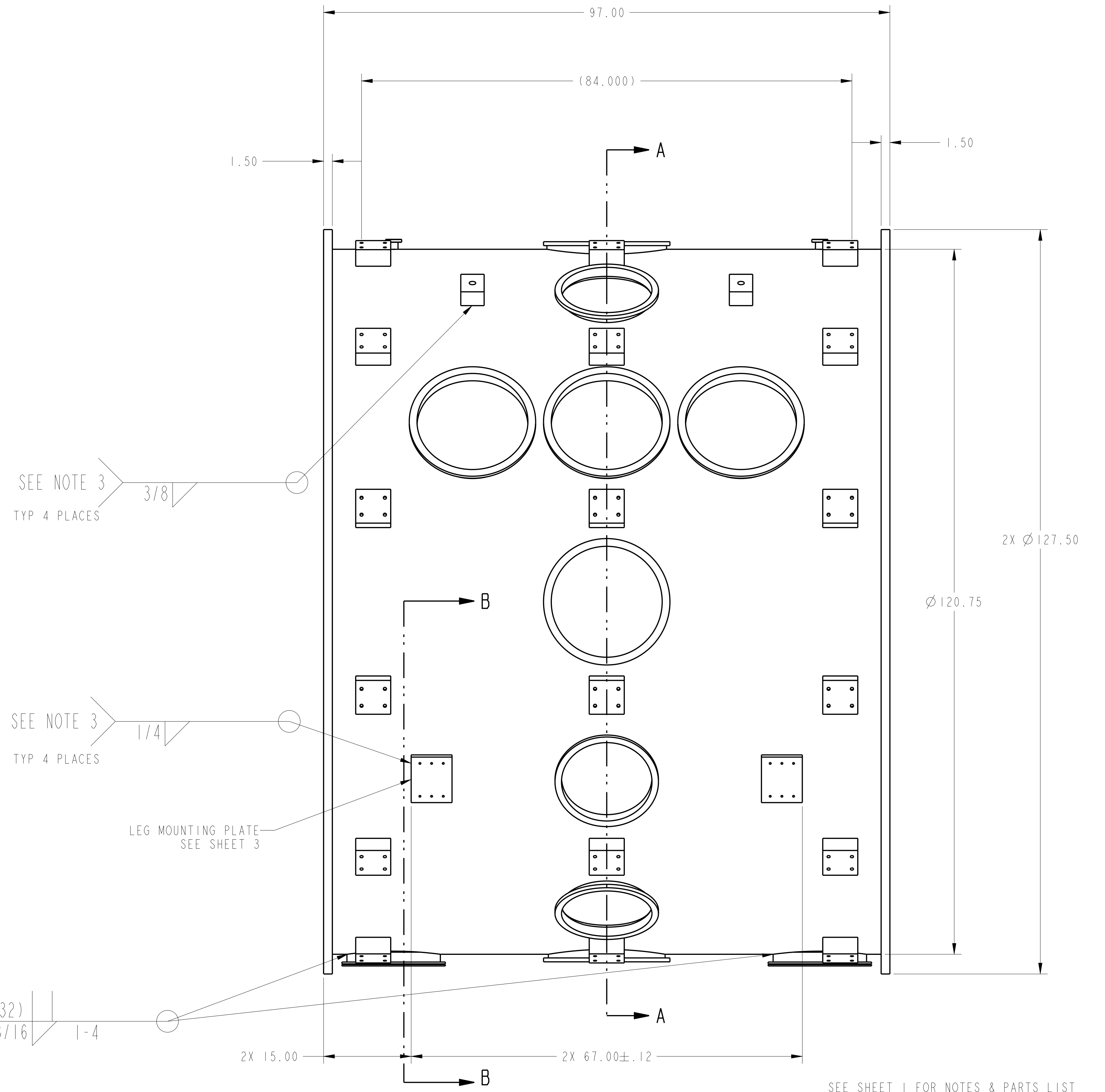
GENERAL NOTES		MAGNETIC PERMEABILITY REQUIREMENT (SEE NOTES)	
1. PPPL APPROVED DRAWINGS TAKE PRECEDENCE OVER MODEL DIMENSIONS.		YES	<input checked="" type="checkbox"/>
2. WHEN MODELS ARE PROVIDED, VENDOR MUST VERIFY THAT MODEL DIMENSIONS CONFORM WITH PPPL APPROVED DRAWINGS PRIOR TO FABRICATION.		NO	<input type="checkbox"/>



SECTION B-B
SCALE 0.100



SECTION A-A
SCALE 0.100



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

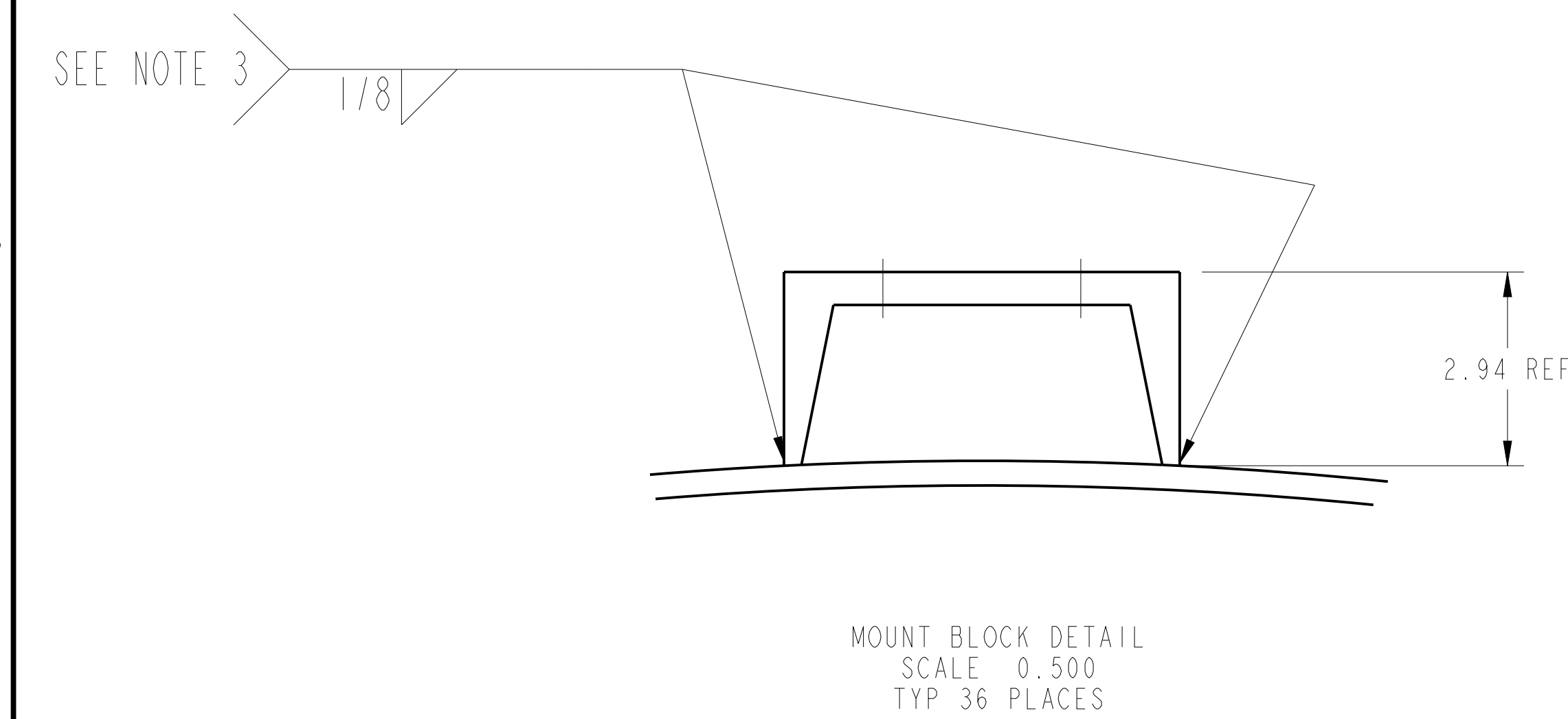
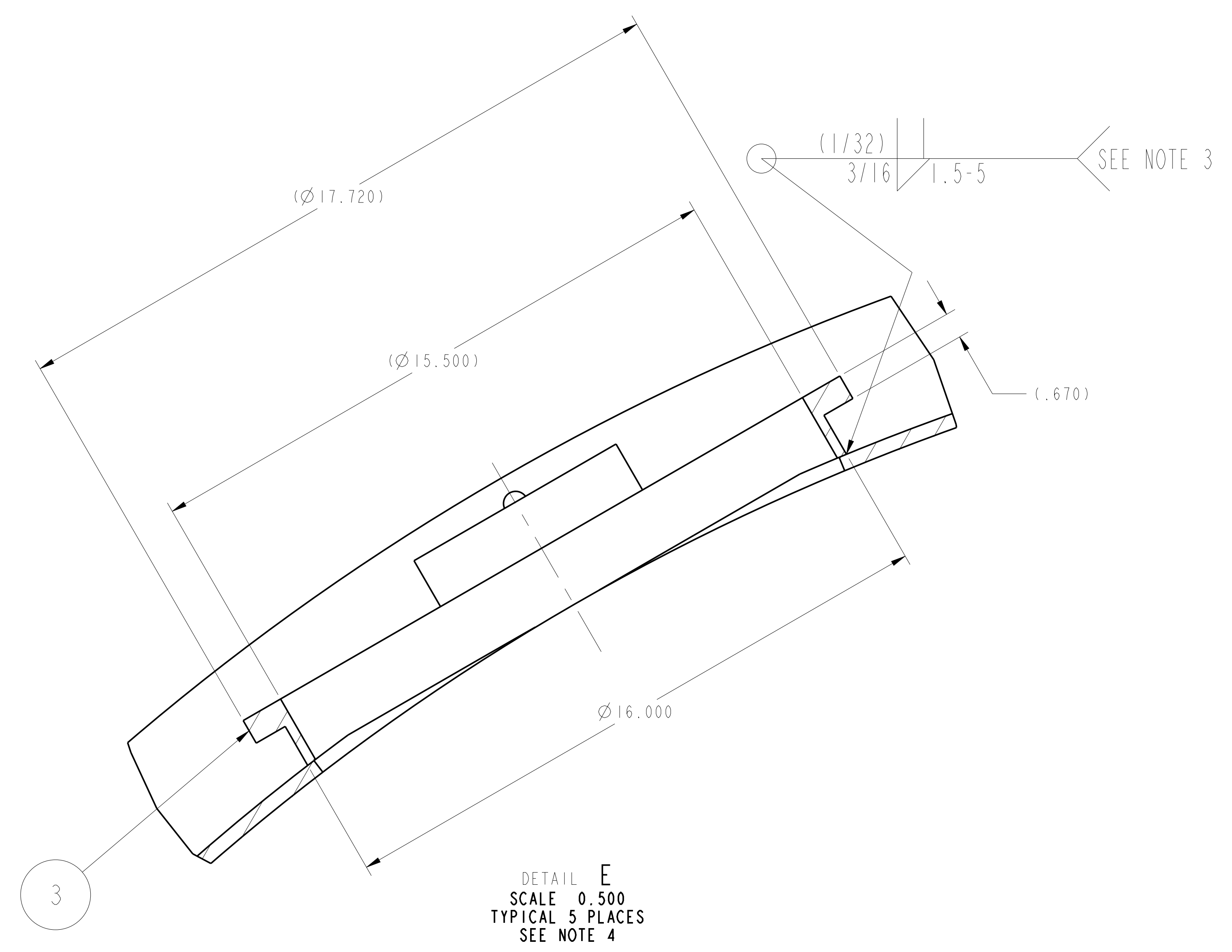
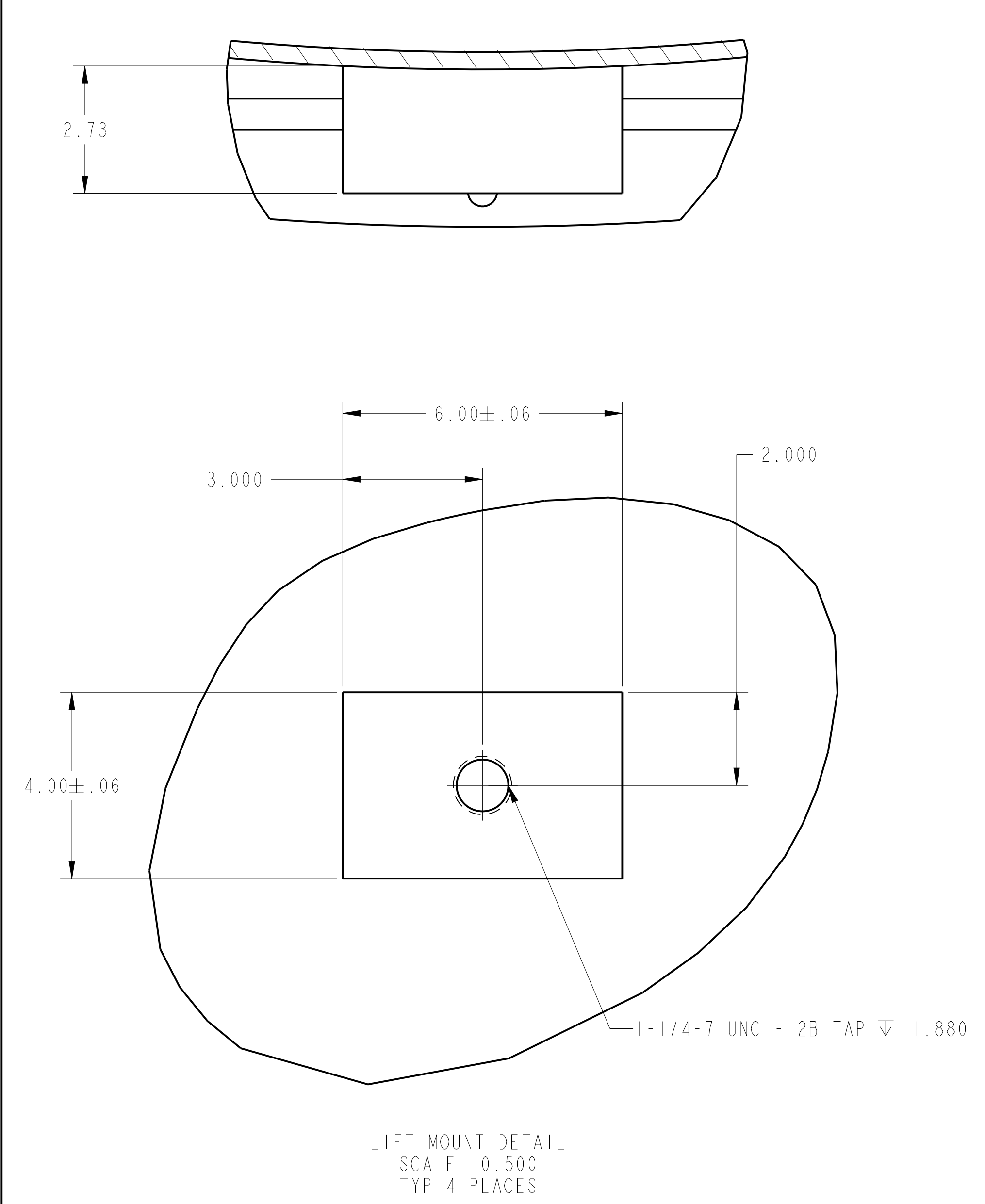
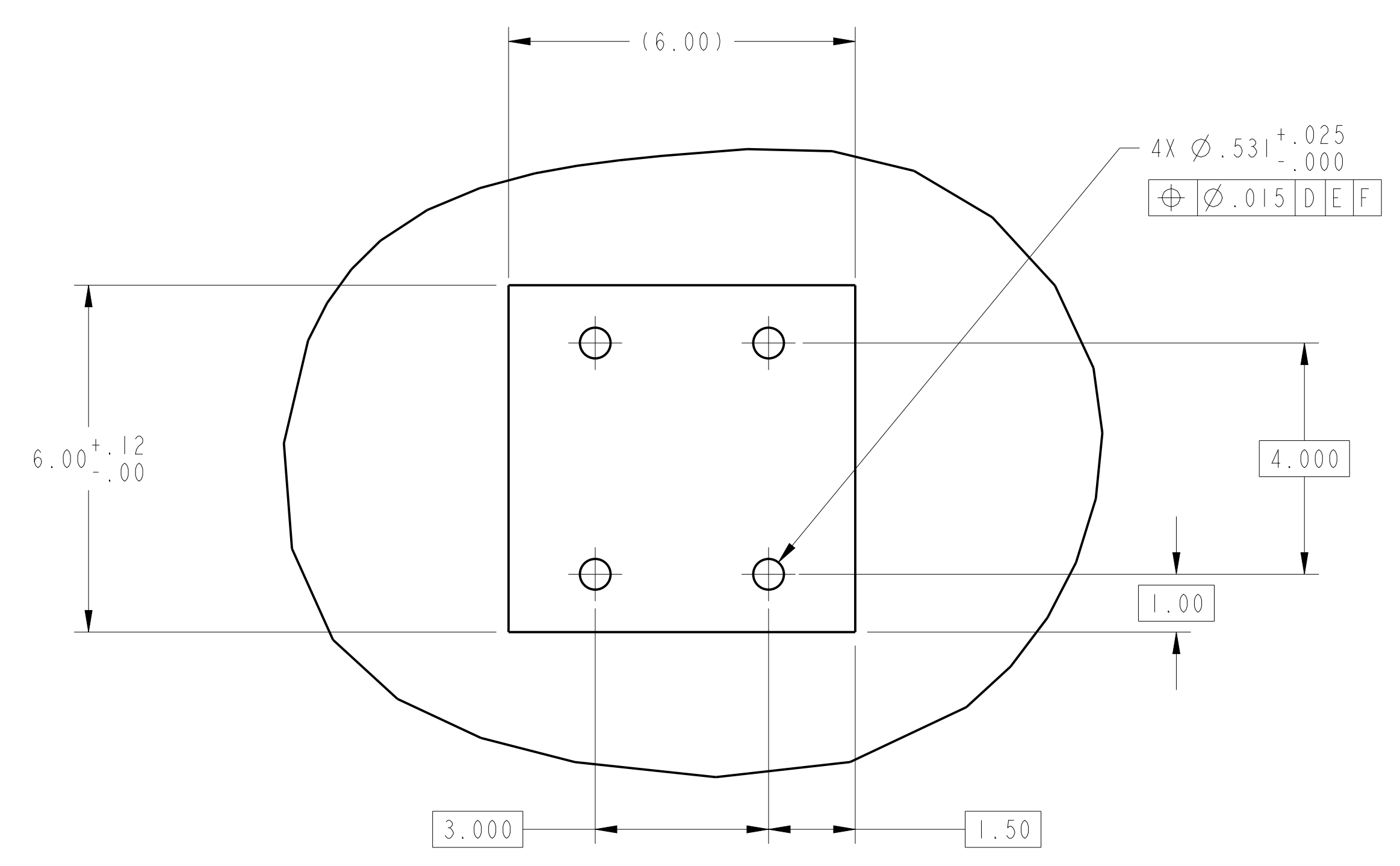
RELEASED FOR FABRICATION / INSTALLATION
PPPL Drafting

RELEASE LEVEL: Fabrication
DWG VERSION NO: 1.18

WELDING ENGINEER
APPROVED: M. Styer DATE: 6/10/15

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	PRINCETON PLASMA PHYSICS LABORATORY FACILITY FOR LABORATORY RECONNECTION EXPERIMENT FLARE VACUUM VESSEL WELDMENT
DO NOT VERIFY INFORMATION BY SCALING DRAWING	TOLERANCES NON-CUMULATIVE	DIV: MECH. ENG. DATE: 5/5/2015
SCALE:	DECIMAL-INCH FRACTIONS	ENG: M KALISH APPROVED
NEXT ASSEMBLY	1/4 3/8 1/2 3/4 1 1 1/4 1 1/2 2 2 1/2 3 3 1/2 4 4 1/2 5 5 1/2 6 6 1/2 7 7 1/2 8 8 1/2 9 9 1/2 10 10 1/2 11 11 1/2 12 12 1/2 13 13 1/2 14 14 1/2 15 15 1/2 16 16 1/2 17 17 1/2 18 18 1/2 19 19 1/2 20 20 1/2 21 21 1/2 22 22 1/2 23 23 1/2 24 24 1/2 25 25 1/2 26 26 1/2 27 27 1/2 28 28 1/2 29 29 1/2 30 30 1/2 31 31 1/2 32 32 1/2 33 33 1/2 34 34 1/2 35 35 1/2 36 36 1/2 37 37 1/2 38 38 1/2 39 39 1/2 40 40 1/2 41 41 1/2 42 42 1/2 43 43 1/2 44 44 1/2 45 45 1/2 46 46 1/2 47 47 1/2 48 48 1/2 49 49 1/2 50 50 1/2 51 51 1/2 52 52 1/2 53 53 1/2 54 54 1/2 55 55 1/2 56 56 1/2 57 57 1/2 58 58 1/2 59 59 1/2 60 60 1/2 61 61 1/2 62 62 1/2 63 63 1/2 64 64 1/2 65 65 1/2 66 66 1/2 67 67 1/2 68 68 1/2 69 69 1/2 70 70 1/2 71 71 1/2 72 72 1/2 73 73 1/2 74 74 1/2 75 75 1/2 76 76 1/2 77 77 1/2 78 78 1/2 79 79 1/2 80 80 1/2 81 81 1/2 82 82 1/2 83 83 1/2 84 84 1/2 85 85 1/2 86 86 1/2 87 87 1/2 88 88 1/2 89 89 1/2 90 90 1/2 91 91 1/2 92 92 1/2 93 93 1/2 94 94 1/2 95 95 1/2 96 96 1/2 97 97 1/2 98 98 1/2 99 99 1/2 100 100 1/2 101 101 1/2 102 102 1/2 103 103 1/2 104 104 1/2 105 105 1/2 106 106 1/2 107 107 1/2 108 108 1/2 109 109 1/2 110 110 1/2 111 111 1/2 112 112 1/2 113 113 1/2 114 114 1/2 115 115 1/2 116 116 1/2 117 117 1/2 118 118 1/2 119 119 1/2 120 120 1/2 121 121 1/2 122 122 1/2 123 123 1/2 124 124 1/2 125 125 1/2 126 126 1/2 127 127 1/2 128 128 1/2 129 129 1/2 130 130 1/2 131 131 1/2 132 132 1/2 133 133 1/2 134 134 1/2 135 135 1/2 136 136 1/2 137 137 1/2 138 138 1/2 139 139 1/2 140 140 1/2 141 141 1/2 142 142 1/2 143 143 1/2 144 144 1/2 145 145 1/2 146 146 1/2 147 147 1/2 148 148 1/2 149 149 1/2 150 150 1/2 151 151 1/2 152 152 1/2 153 153 1/2 154 154 1/2 155 155 1/2 156 156 1/2 157 157 1/2 158 158 1/2 159 159 1/2 160 160 1/2 161 161 1/2 162 162 1/2 163 163 1/2 164 164 1/2 165 165 1/2 166 166 1/2 167 167 1/2 168 168 1/2 169 169 1/2 170 170 1/2 171 171 1/2 172 172 1/2 173 173 1/2 174 174 1/2 175 175 1/2 176 176 1/2 177 177 1/2 178 178 1/2 179 179 1/2 180 180 1/2 181 181 1/2 182 182 1/2 183 183 1/2 184 184 1/2 185 185 1/2 186 186 1/2 187 187 1/2 188 188 1/2 189 189 1/2 190 190 1/2 191 191 1/2 192 192 1/2 193 193 1/2 194 194 1/2 195 195 1/2 196 196 1/2 197 197 1/2 198 198 1/2 199 199 1/2 200 200 1/2 201 201 1/2 202 202 1/2 203 203 1/2 204 204 1/2 205 205 1/2 206 206 1/2 207 207 1/2 208 208 1/2 209 209 1/2 210 210 1/2 211 211 1/2 212 212 1/2 213 213 1/2 214 214 1/2 215 215 1/2 216 216 1/2 217 217 1/2 218 218 1/2 219 219 1/2 220 220 1/2 221 221 1/2 222 222 1/2 223 223 1/2 224 224 1/2 225 225 1/2 226 226 1/2 227 227 1/2 228 228 1/2 229 229 1/2 230 230 1/2 231 231 1/2 232 232 1/2 233 233 1/2 234 234 1/2 235 235 1/2 236 236 1/2 237 237 1/2 238 238 1/2 239 239 1/2 240 240 1/2 241 241 1/2 242 242 1/2 243 243 1/2 244 244 1/2 245 245 1/2 246 246 1/2 247 247 1/2 248 248 1/2 249 249 1/2 250 250 1/2 251 251 1/2 252 252 1/2 253 253 1/2 254 254 1/2 255 255 1/2 256 256 1/2 257 257 1/2 258 258 1/2 259 259 1/2 260 260 1/2 261 261 1/2 262 262 1/2 263 263 1/2 264 264 1/2 265 265 1/2 266 266 1/2 267 267 1/2 268 268 1/2 269 269 1/2 270 270 1/2 271 271 1/2 272 272 1/2 273 273 1/2 274 274 1/2 275 275 1/2 276 276 1/2 277 277 1/2 278 278 1/2 279 279 1/2 280 280 1/2 281 281 1/2 282 282 1/2 283 283 1/2 284 284 1/2 285 285 1/2 286 286 1/2 287 287 1/2 288 288 1/2 289 289 1/2 290 290 1/2 291 291 1/2 292 292 1/2 293 293 1/2 294 294 1/2 295 295 1/2 296 296 1/2 297 297 1/2 298 298 1/2 299 299 1/2 300 300 1/2 301 301 1/2 302 302 1/2 303 303 1/2 304 304 1/2 305 305 1/2 306 306 1/2 307 307 1/2 308 308 1/2 309 309 1/2 310 310 1/2 311 311 1/2 312 312 1/2 313 313 1/2 314 314 1/2 315 315 1/2 316 316 1/2 317 317 1/2 318 318 1/2 319 319 1/2 320 320 1/2 321 321 1/2 322 322 1/2 323 323 1/2 324 324 1/2 325 325 1/2 326 326 1/2 327 327 1/2 328 328 1/2 329 329 1/2 330 330 1/2 331 331 1/2 332 332 1/2 333 333 1/2 334 334 1/2 335 335 1/2 336 336 1/2 337 337 1/2 338 338 1/2 339 339 1/2 340 340 1/2 341 341 1/2 342 342 1/2 343 343 1/2 344 344 1/2 345 345 1/2 346 346 1/2 347 347 1/2 348 348 1/2 349 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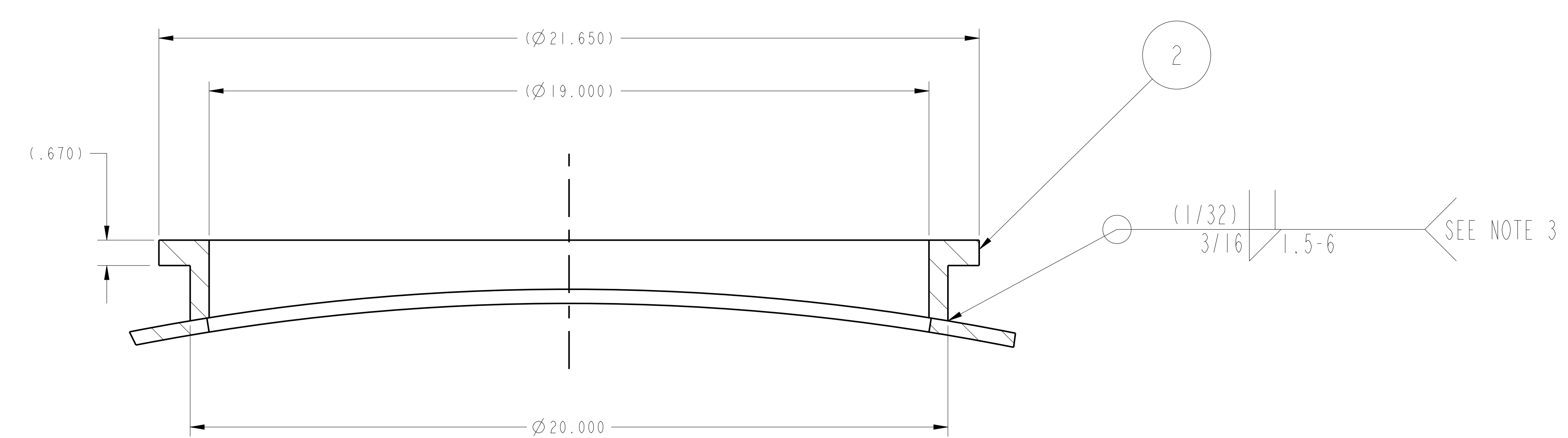
NO.	REVISION	BY	CH	SUP	APPROVED	DATE



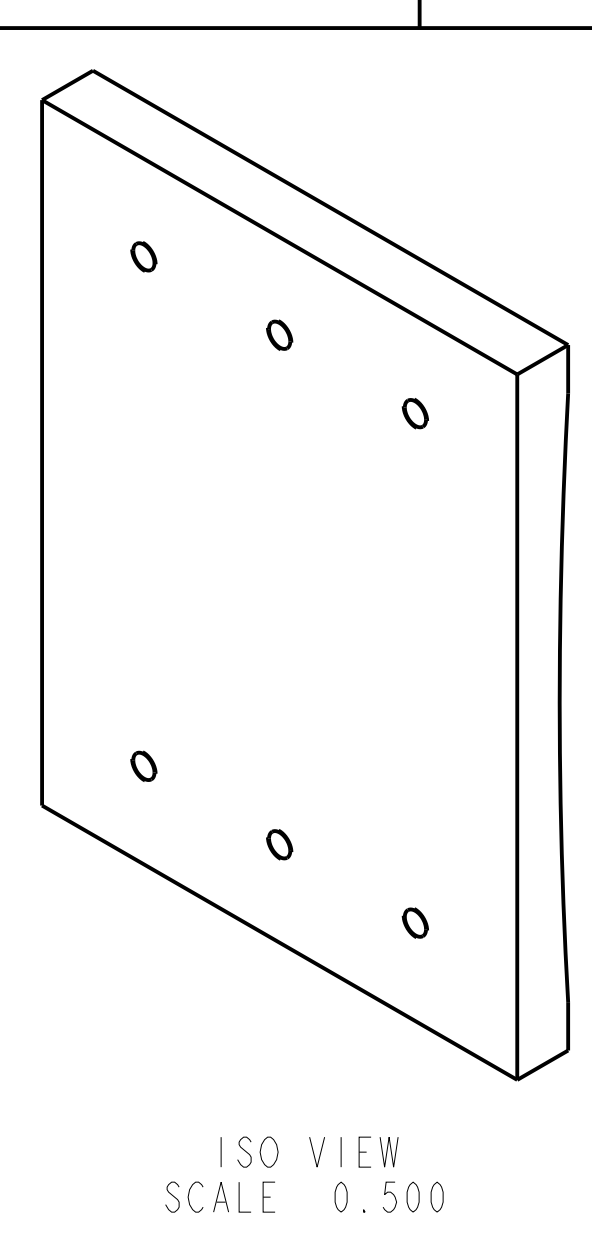
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SCALE 0.500
TYP 36 PLACES

LIFT MOUNT DETAIL
SCALE 0.500
TYP 4 PLACES

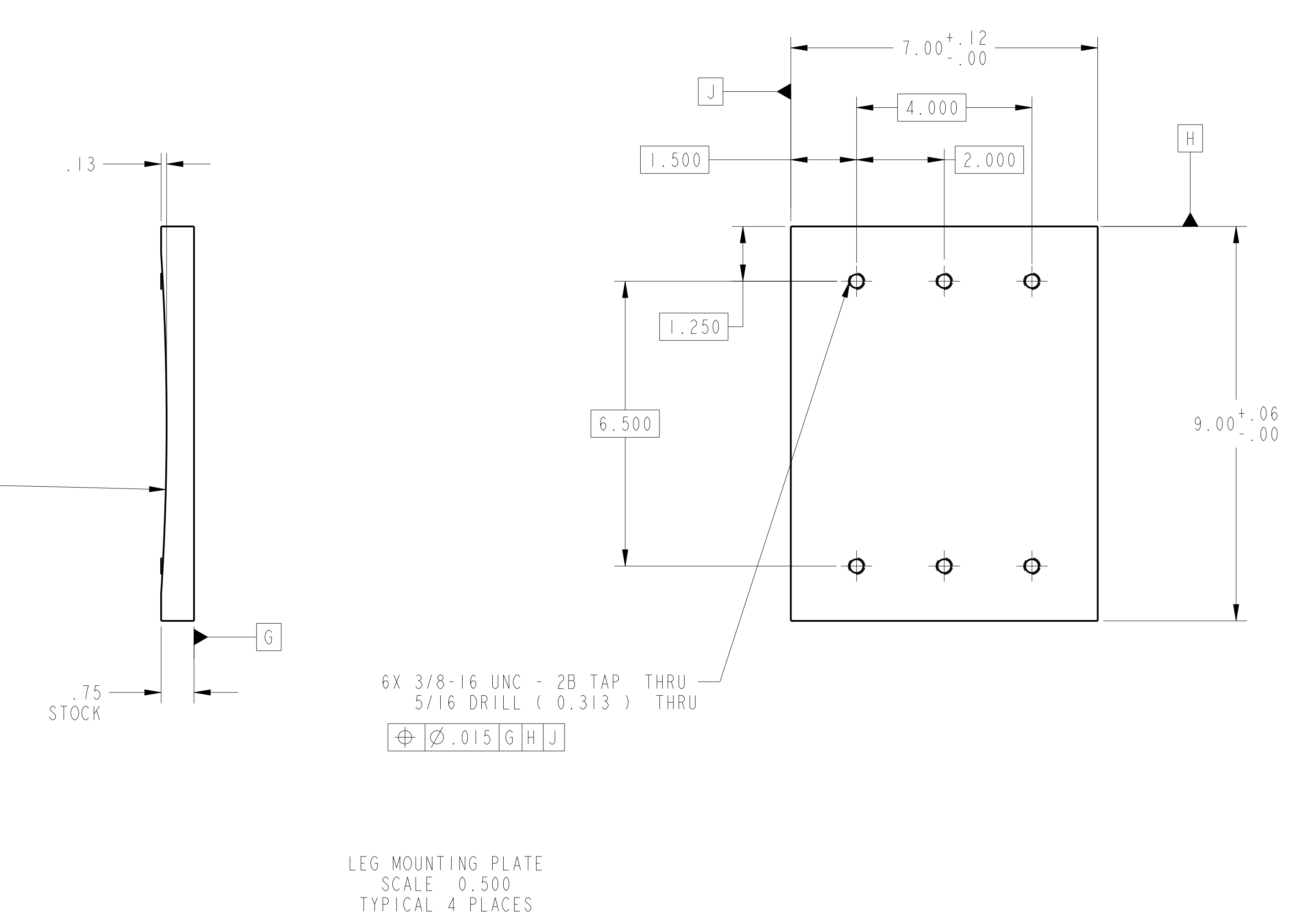
DETAIL E
SCALE 0.500
TYPICAL 5 PLACES
SEE NOTE 4



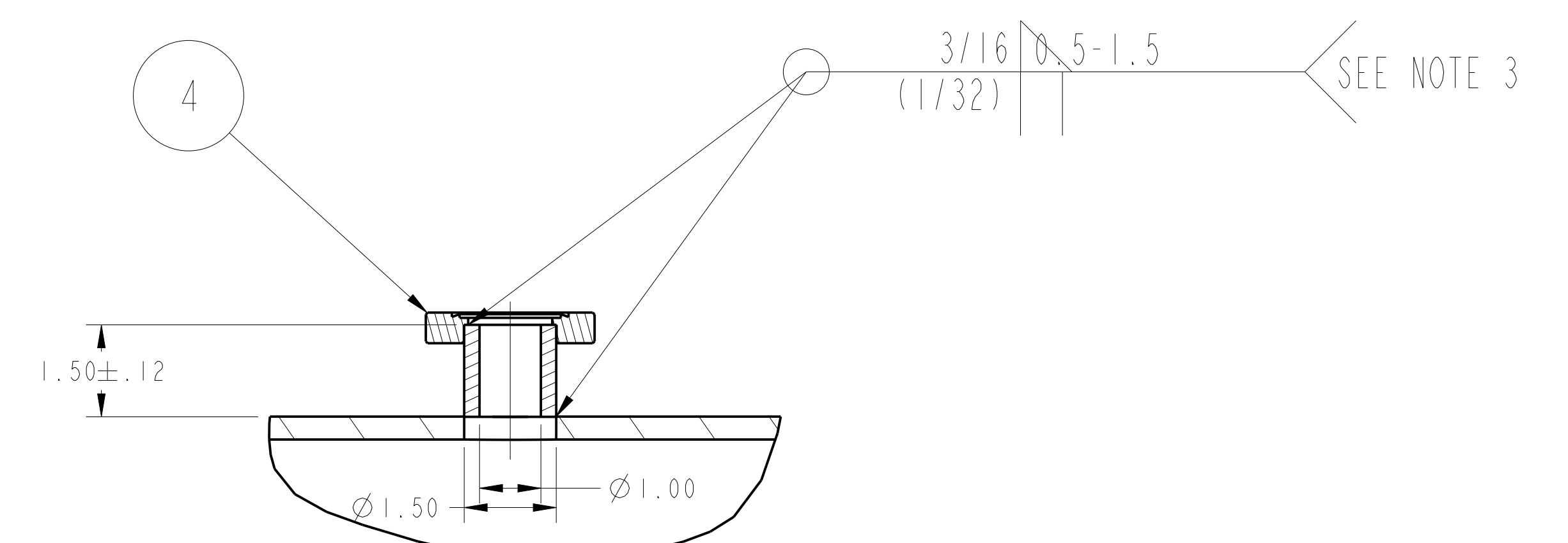
DETAIL F
SCALE 0.500
TYPICAL 11 PLACES
SEE NOTE 4



ISO VIEW
SCALE 0.500



LEG MOUNTING PLATE
SCALE 0.500
TYPICAL 4 PLACES



SECTION C-C
SCALE 0.500
2 PLACES

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

RELEASED FOR FABRICATION / INSTALLATION
PPPL Drafting

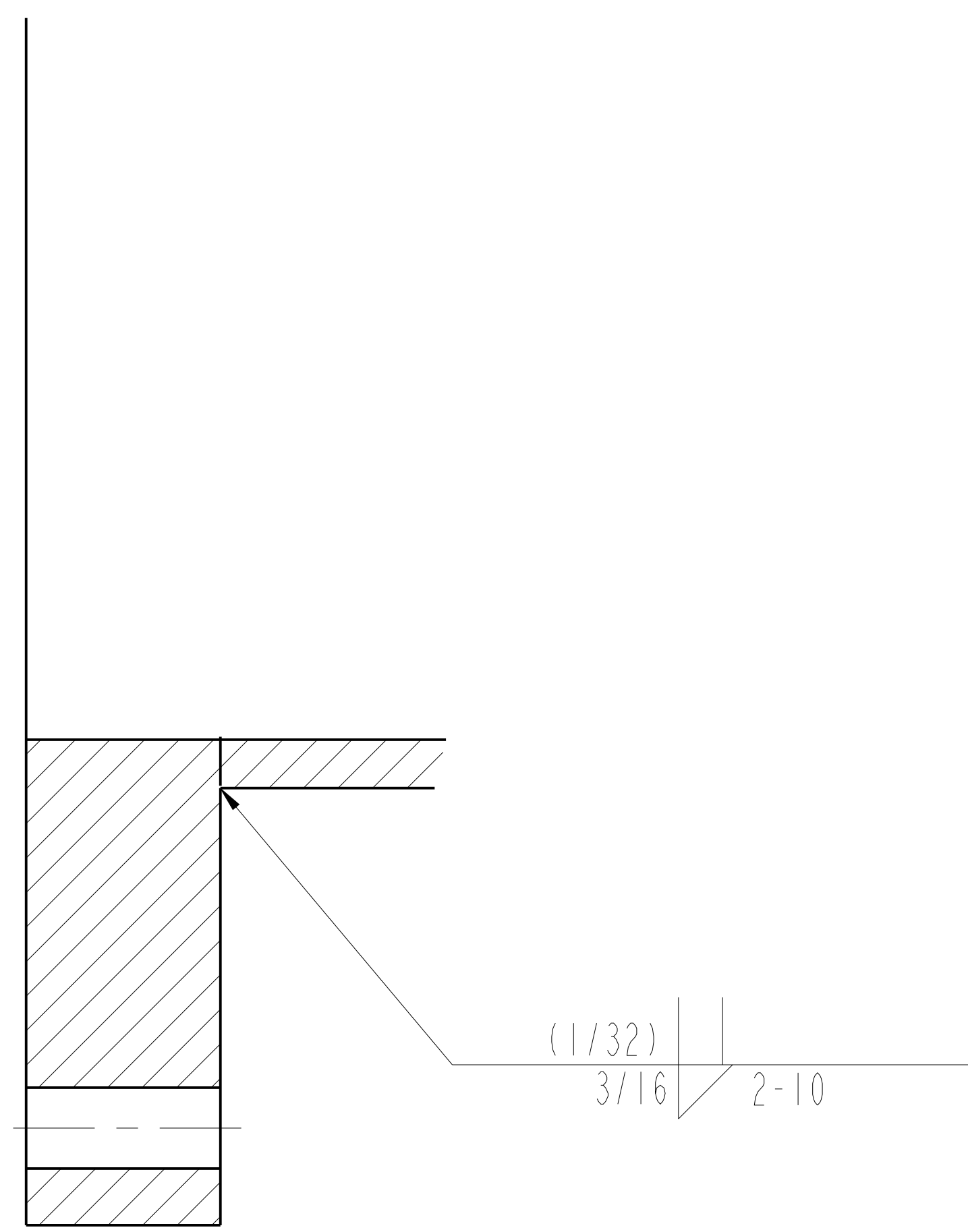
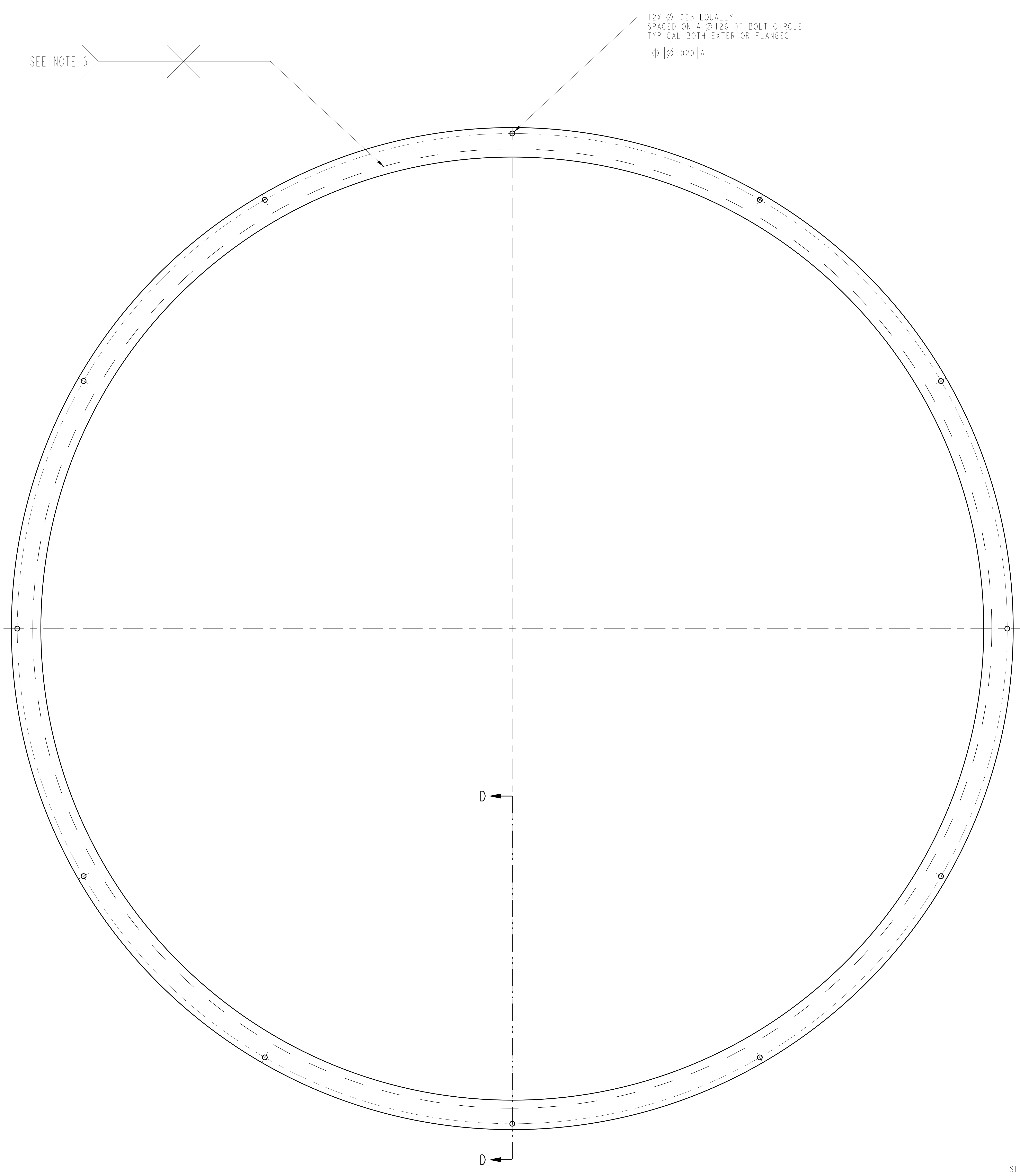
RELEASE LEVEL: Fabrication
DWG VERSION NO: 118

WELDING ENGINEER
APPV: M. Styer DATE: 6/10/15

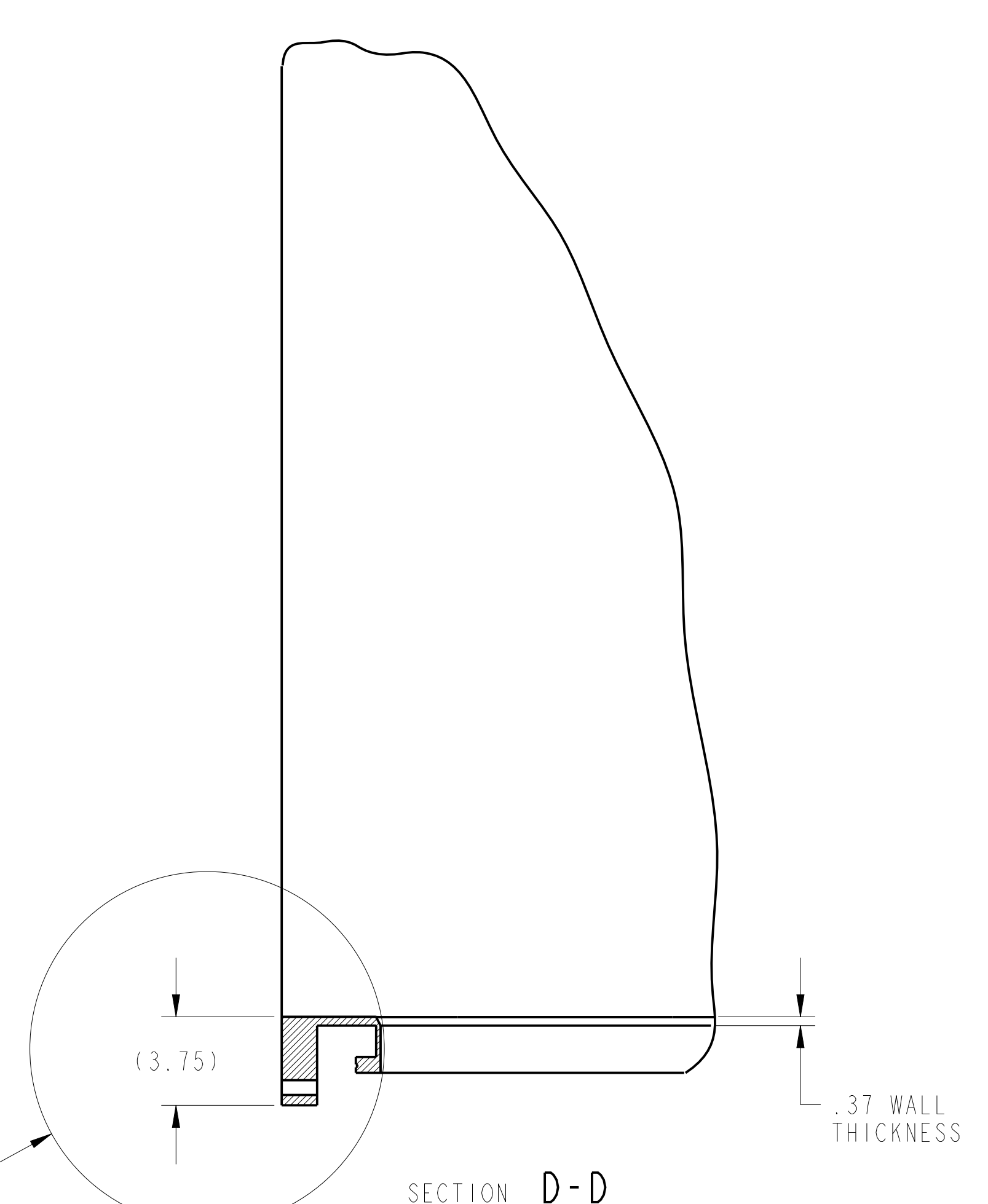
COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES: UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .055/020	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY FACILITY FOR LABORATORY RECONNECTION EXPERIMENT FLARE VACUUM VESSEL WELDMENT
DO NOT VERIFY INFORMATION BY SCALING DRAWING	TOLERANCES - NON-CUMULATIVE DECIMAL-INCH FRACTIONS XXX 0.100 01°-12' 01/16 XXX 0.030 12°-12' 01/16 XXX 0.010 72°-120' 01/16 ANGULAR 00°-15' 00/16 120° 01/16	DIV: MECH. ENG. DATE: 5/5/2015 ENG: M KALISH DSN: J MITCHELL CHK: M KALISH
SCALE:		APPROVER M KALISH
NEXT ASSEMBLY		E-FL300-002
		SHEET 3 OF 4 REV 0

SEE SHEET 1 FOR NOTES & PARTS LIST

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



DETAIL F
SCALE 1.000



SECTION D-D
SEE SHEET 1 FOR NOTES & PARTS LIST

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

SCALE 0.200

RELEASED FOR FABRICATION / INSTALLATION
PPPL Drafting

RELEASE LEVEL: Fabrication
DWG VERSION NO: 1.18

WELDING ENGINEER
APPROVED: M. Syer DATE: 6/10/15

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED Pro E	CENTRAL FILES: (UNLESS OTHERWISE SPECIFIED) DIMENSIONS ARE IN INCHES MACHINE SURFACES BREAK SHARP EDGES .005/.020	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY FACILITY FOR LABORATORY RECONNECTION EXPERIMENT FLARE VACUUM VESSEL WELDMENT
DO NOT VERIFY INFORMATION BY SCALING DRAWING	TOLERANCES - NON-CUMULATIVE DECIMAL - INCH FRACTIONS X .100 0°-12° 0.174 X .030 12°-12° 0.174 X .010 12°-12° 0.174 ANGULAR 0°-15° 0.001 12°-0.002	DIV: MECH. ENG. DATE: 5/5/2015 ENG: M KALISH DSN: J MITCHELL CHK: M KALISH
SCALE:	NEXT ASSEMBLY	APPROVED: M KALISH E-FL300-002 SHEET 4 OF 4 REV 0

FLARE-E-FL300-002