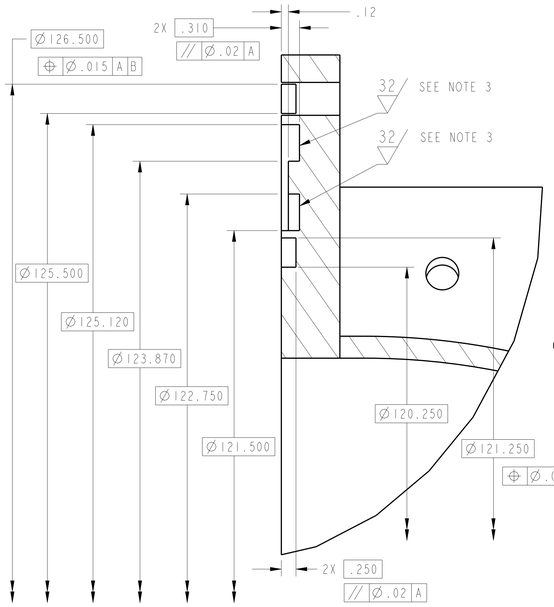
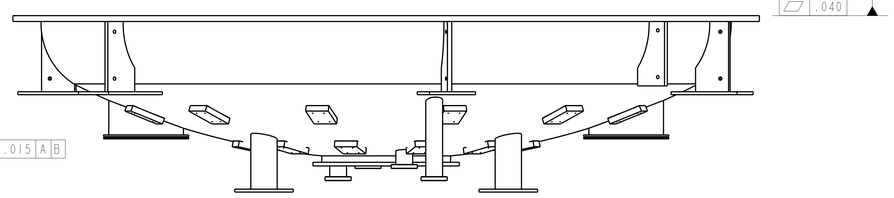
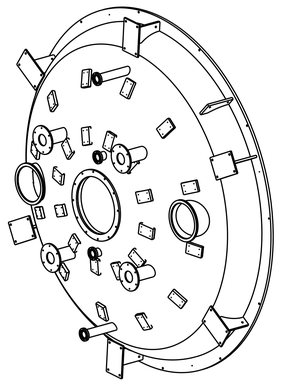
NO.	REVISION	BY	CH	SUP	APPROVED	DATE

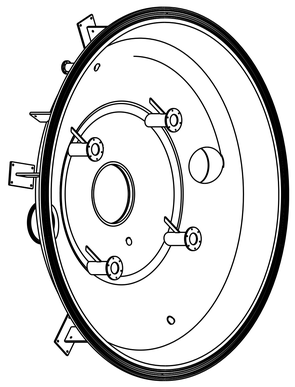


DETAIL B
SCALE 1.000

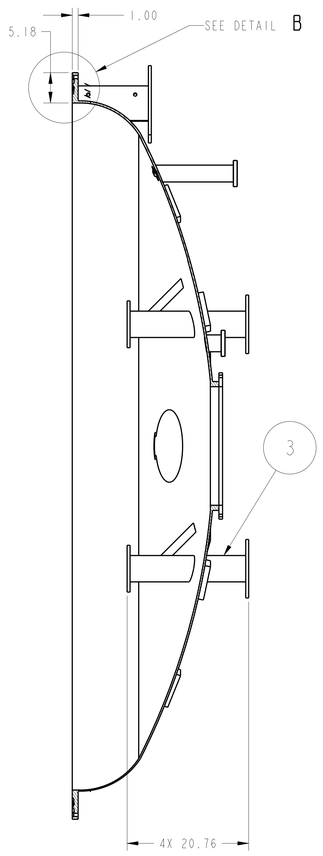




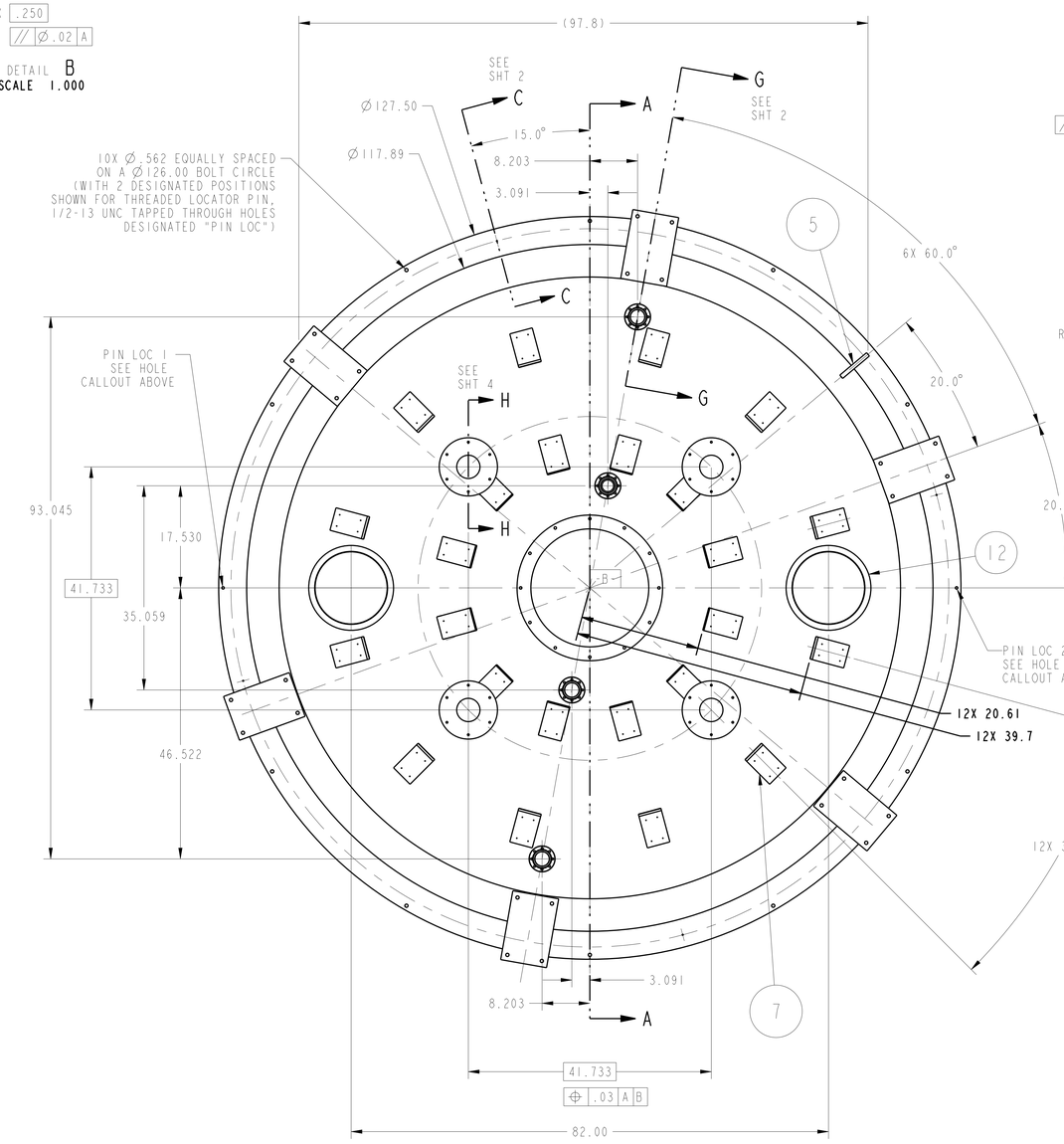
ISO VIEW
SCALE 0.050

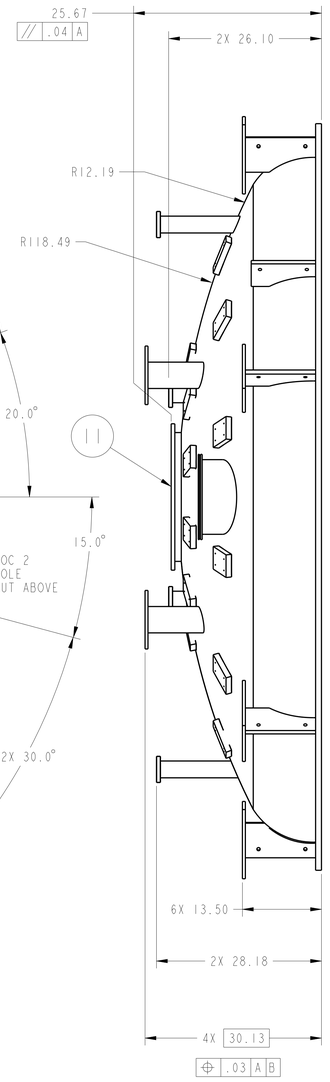


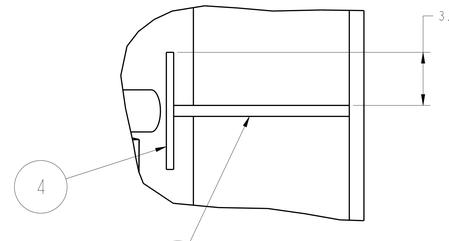
ISO VIEW - BACK
SCALE 0.050

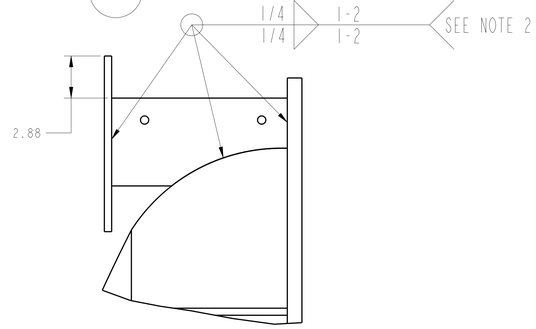


SECTION A-A









COIL MOUNT AND PLATE
WELDING DETAIL
SCALE 0.250
TYP 6 PLACES

NOTES:

1. MATERIAL : 304 SS UNLESS OTHERWISE SPECIFIED.
   VESSEL WALL THICKNESS IS 0.37".

2. 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.

3. SURFACE FINISH TO BE CIRCUMFERENCIAL FOR VACUUM SEALING.

-01 ASSY	PART NO	DRAWING NO	NOMENCLATURE OR DESCRIPTION	MAT'L	QTY REQD
2	12	COMM	NW320 12.75" FLANGE - MDC PART NO. 820005 OR EQUIV	SS	
1	11	E-FL300-005-11	FLANGE	304 SS	
4	10	E-FL300-005-10	GUSSET, 0.38" THICK X 2" WIDE	304 SS	
4	9	E-FL300-005-9	FLANGE, 8"	304 SS	
4	8	E-FL300-005-8	FLANGE, 10"	304 SS	
24	7	E-FL300-005-7	PLATE, MOUNT	304 SS	
4	6	E-FL300-005-6	FLANGE, MODIFIED 4.5 OD NON-ROT CONFLAT	304 SS	
7	5	E-FL300-005-5	RAIL MOUNT	304 SS	
6	4	E-FL300-005-4	COIL PLATE	304 SS	
4	3	E-FL300-005-3	FLANGE TUBE, FLUX CORE, 4" ID	304 SS	
6	2	E-FL300-005-2	COIL MOUNT	304 SS	
1	1	E-FL300-005-1	ENDCAP, VESSEL	304 SS	
X	—	THIS DRAWING	ENDCAP WELDMENT, FLARE VACUUM VESSEL	——	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		NO	X

RELEASED FOR FABRICATION / INSTALLATION
PPPL Drafting: Lewis Morris

RELEASE LEVEL: Fabrication
DWG VERSION NO: 1.12

WELDING ENGINEER
APPVD Morgan C. Styer DATE:

COMPUTER GENERATED DRAWING
MANUAL CHANGES NOT PERMITTED
Pro E
DO NOT VERIFY INFORMATION BY SCALING DRAWING
SCALE:
NEXT ASSEMBLY
E-FL600-001

CENTRAL FILES:
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
MACHINE SURFACES 125
BREAK SHARP EDGES .005/.020
TOLERANCES NON-CUMULATIVE

DECIMAL-INCH		FRACTIONS	
.X	±.100	0°-12°	±1/16
.XX	±.030	12°-72°	±1/8
.XXX	±.010	72°-120°	±1/4
ANGULAR	±0°-15'	OVER 120°	±1/2

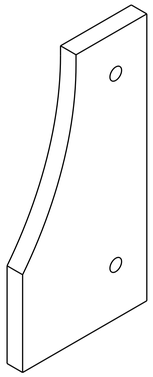
PRINCETON PLASMA PHYSICS LABORATORY
PRINCETON UNIVERSITY
FACILITY FOR LABORATORY RECONNECTION EXPERIMENT
FLARE
VACUUM VESSEL
ENDCAP WELDMENT

DIV: MECH. ENG. DATE: 5/5/2015
ENG: M KALISH APPROVED
DSN: J MITCHELL M KALISH
CHK: M KALISH CHK MK SUPV LM

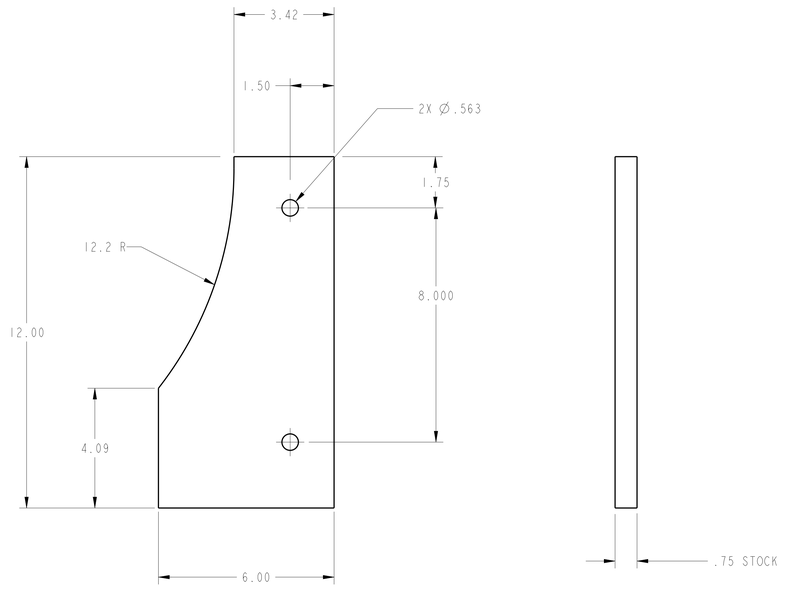
E-FL300-005
SHEET 1 OF 4 REV 0

FLARE E-FL300-005

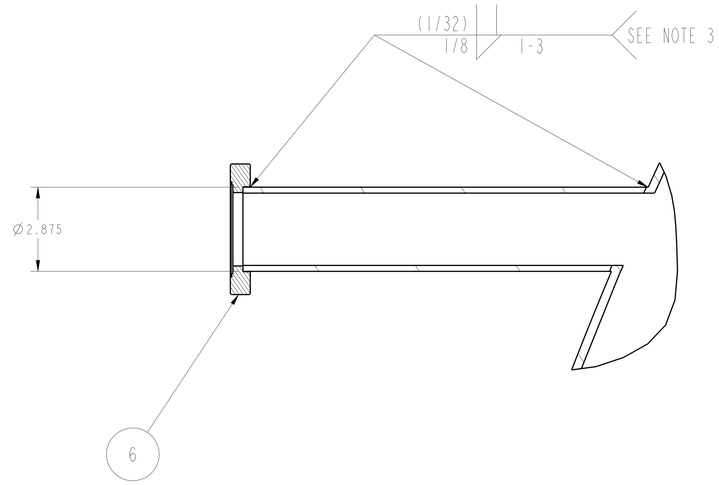
NO.	REVISION	BY	CH	SUP	APPROVED	DATE



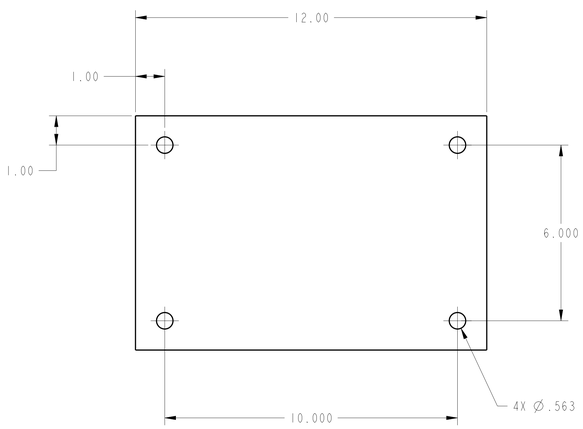
ISO VIEW
SCALE 0.500

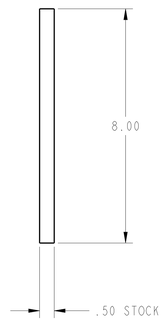


2 COIL MOUNT

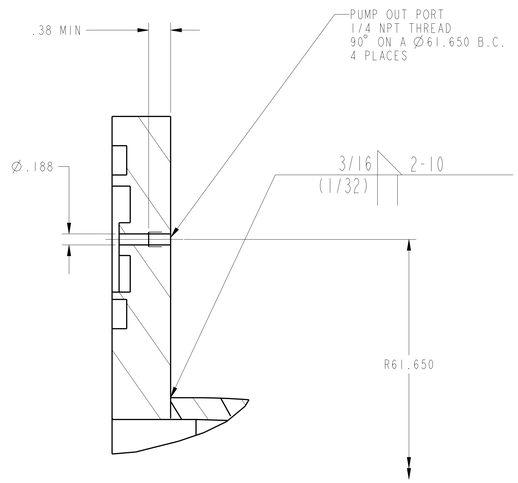


SECTION G-G
SCALE 0.500

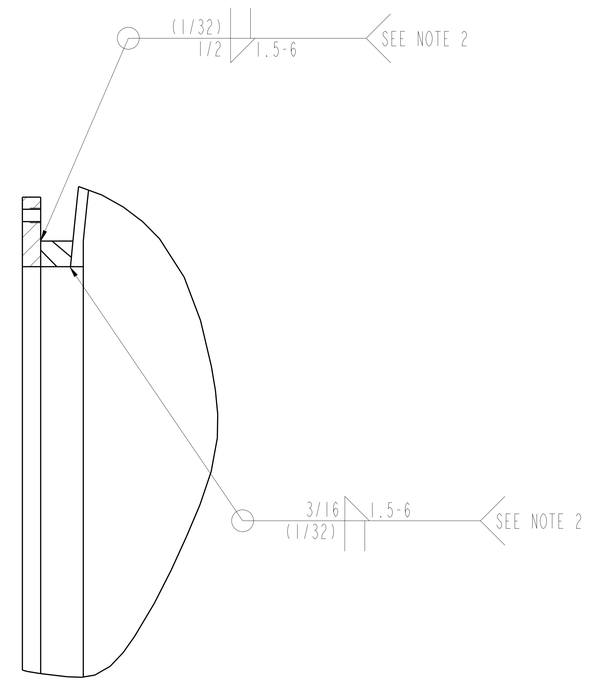




4 COIL PLATE



SECTION C-C
SCALE 1.000
TYP 4 PLACES



WELDING DETAIL OF
CENTER FLANGE

SEE SHEET 1 FOR NOTES & 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 | NO

RELEASED FOR FABRICATION / INSTALLATION
PPPL Drafting: Lewis Morris

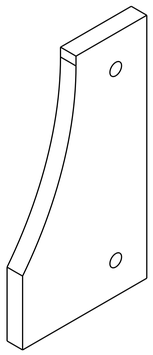
RELEASE LEVEL: Fabrication
DWG VERSION NO: 1.12

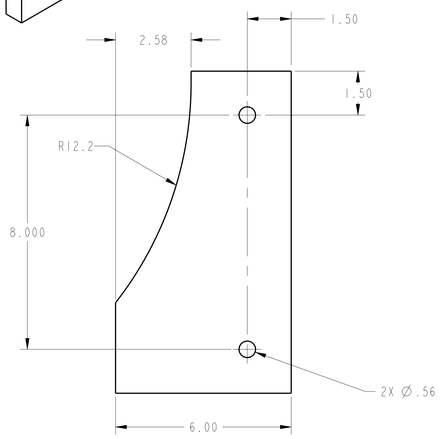
WELDING ENGINEER
APPVD M. Styer DATE 6/10/15

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED	CENTRAL FILES:	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY
Pro E	UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES MACHINE SURFACES 125	FACILITY FOR LABORATORY RECONNECTION EXPERIMENT
DO NOT VERIFY INFORMATION BY SCALING DRAWING	BREAK SHARP EDGES .005/.020	FLARE VACUUM VESSEL ENDCAP WELDMENT
SCALE:	TOLERANCES NON-CUMULATIVE	DIV: MECH. ENG. DATE: 5/5/2015
NEXT ASSEMBLY	DECIMAL-INCH: .X ±.100, .XX ±.030, .XXX ±.010, ANGULAR ±0°-15'; FRACTIONS: 0°-12° ±1/16, 12°-72° ±1/8, 72°-120° ±1/4, OVER 120° ±1/2	ENG: M KALISH APPROVED; DSN: J MITCHELL M KALISH; CHK: M KALISH CHK MK SUPV LM
		E-FL300-005
		SHEET 2 OF 4 REV 0

FLARE E-FL300-005

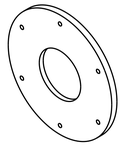
NO.	REVISION	BY	CH	SUP	APPROVED	DATE



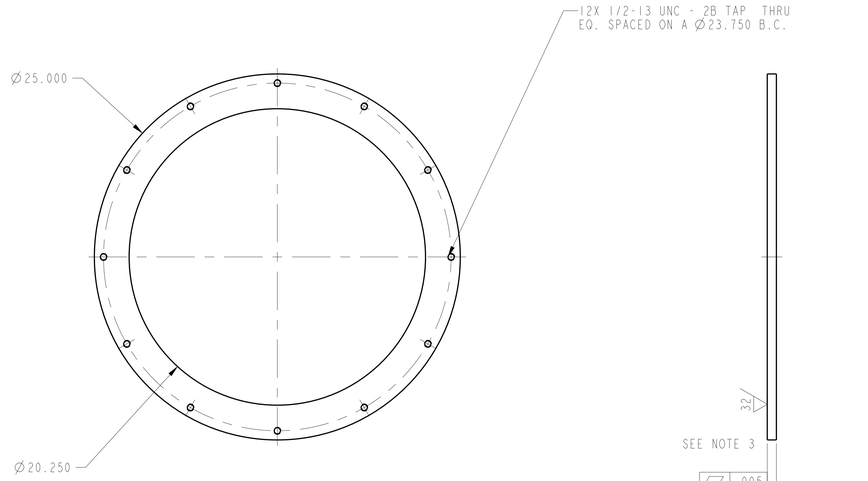


5 RAIL MOUNT

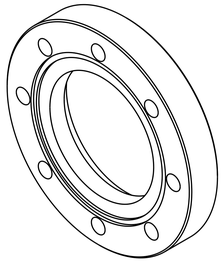
NOTE: MAKE AN ADDITIONAL 6 SPARES; SHIP WITH WELDMENT



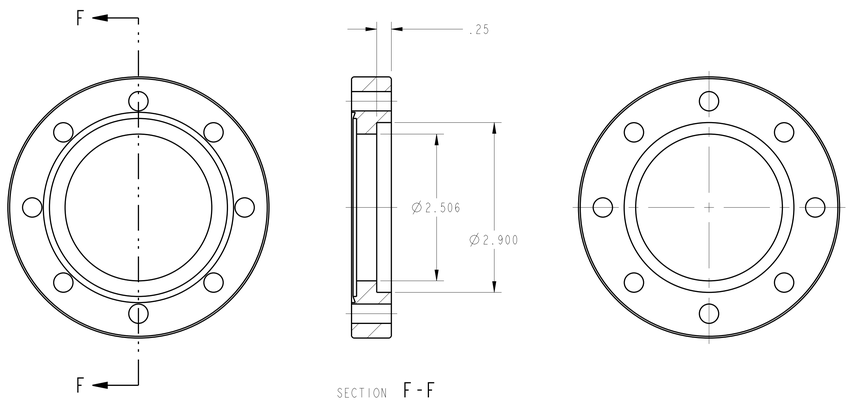
8 FLANGE



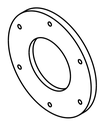
11 FLANGE

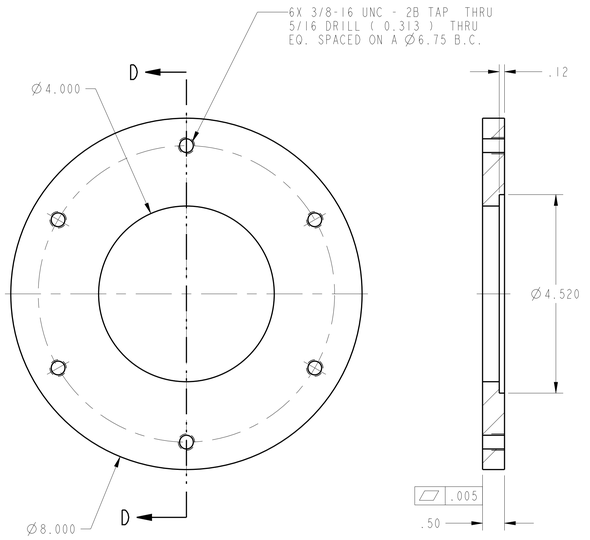


MAKE FROM 4.50" OD NON-ROTATABLE CONFLAT FLANGE

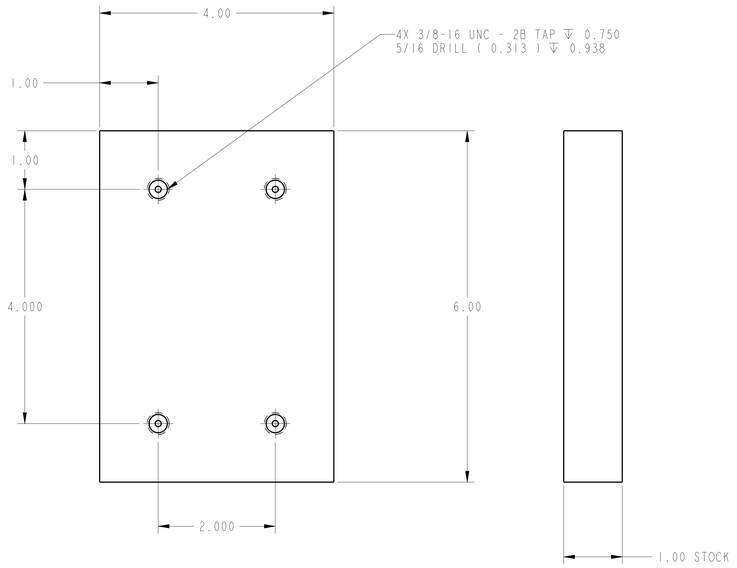


6 FLANGE, MODIFIED





9 FLANGE



7 PLATE MOUNT

SEE SHEET 1 FOR NOTES & 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 | NO

RELEASED FOR FABRICATION / INSTALLATION
PPPL Drafting: Lewis Morris

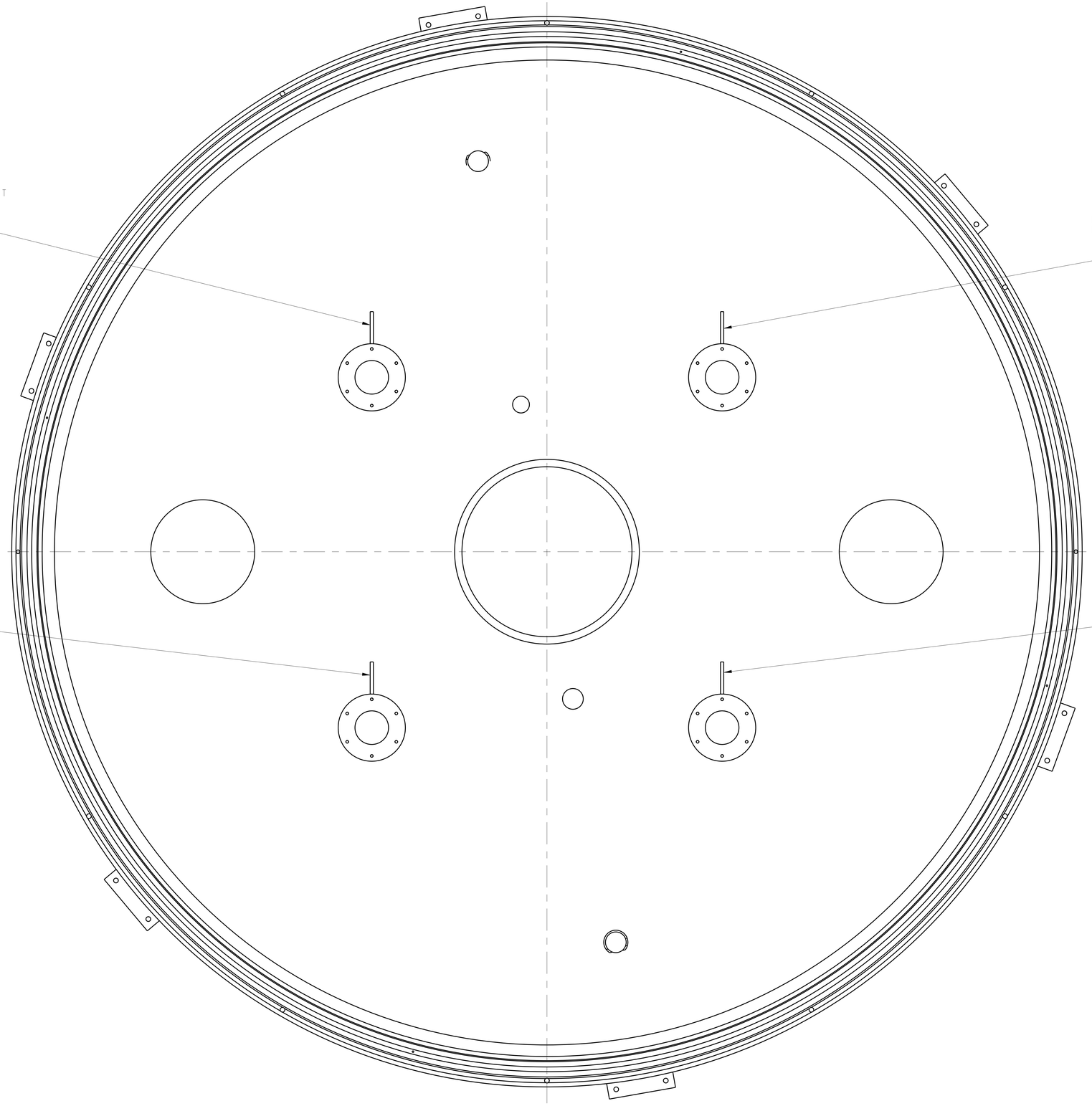
RELEASE LEVEL: Fabrication
DWG VERSION NO: 1.12

WELDING ENGINEER
APPVD: DATE:

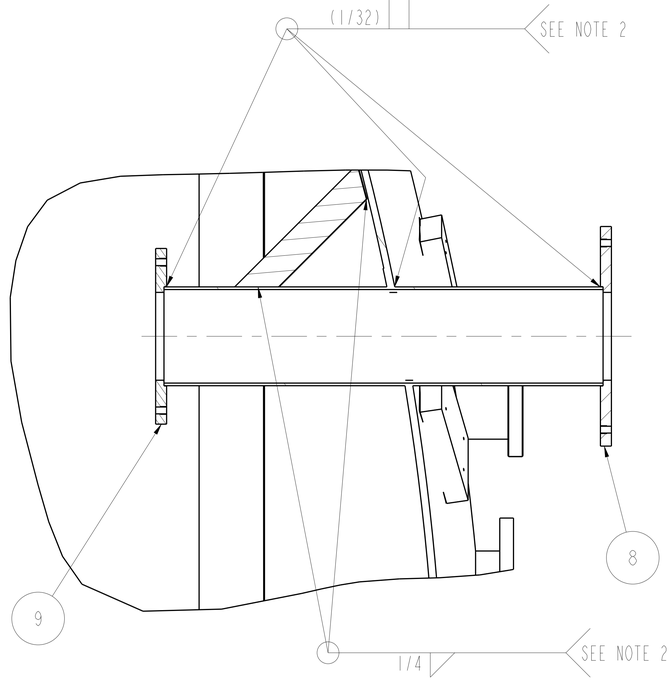
COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED	CENTRAL FILES:	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY
Pro E	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES MACHINE SURFACES 125	FACILITY FOR LABORATORY RECONNECTION EXPERIMENT FLARE VACUUM VESSEL ENDCAP WELDMENT
DO NOT VERIFY INFORMATION BY SCALING DRAWING	BREAK SHARP EDGES .005/.020	
SCALE:	TOLERANCES NON-CUMULATIVE	DIV: MECH. ENG. DATE: 5/5/2015
NEXT ASSEMBLY	DECIMAL-INCH .X ±.100 .XX ±.030 .XXX ±.010 ANGULAR ±0°-15' FRACTIONS 0°-12° ±1/16 12°-72° ±1/8 72°-120° ±1/4 OVER 120° ±1/2	ENG: M KALISH APPROVED M KALISH DSN: J MITCHELL CHK: M KALISH CHK MK SUPV LM
		E-FL300-005 SHEET 3 OF 4 REV 0

FLARE-E-FL300-005

NO.	REVISION	BY	CH	SUP	APPROVED	DATE



SCALE 0.200



SECTION H-H
SCALE 0.375

SEE SHEET 1 FOR NOTES & 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 [ ] NO [ ]

RELEASED FOR FABRICATION / INSTALLATION
PPPL Drafting: Lewis Morris
Digitally signed by Lewis Morris
DN: cn=Lewis Morris, o=PPPL, ou=Engineering, email=lmorris@pppl.gov, c=US
Date: 2015.06.10 14:49:11 -04'00'

RELEASE LEVEL: Fabrication
DWG VERSION NO: 1.12

WELDING ENGINEER
APPVD M. Styer DATE 6/10/15

COMPUTER GENERATED DRAWING MANUAL CHANGES NOT PERMITTED	CENTRAL FILES:	PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY	
	UNLESS OTHERWISE SPECIFIED	FACILITY FOR LABORATORY RECONNECTION EXPERIMENT	
Pro E	DIMENSIONS ARE IN INCHES MACHINE SURFACES 125	FLARE: VACUUM VESSEL ENDCAP WELDMENT	
DO NOT VERIFY INFORMATION BY SCALING DRAWING	BREAK SHARP EDGES .005/.020		
SCALE:	TOLERANCES NON-CUMULATIVE	DIV: MECH. ENG. DATE: 5/5/2015	
NEXT ASSEMBLY	DECIMAL-INCH FRACTIONS .X ±.100 0°-12° ±1/16 .XX ±.030 12°-72° ±1/8 .XXX ±.010 72°-120° ±1/4 ANGULAR ±0°-15' OVER 120° ±1/2	ENG: M KALISH APPROVED DSN: J MITCHELL M KALISH CHK: M KALISH CHK MK SUPV LM	E-FL300-005 SHEET 4 OF 4 REV 0

FLARE E-FL300-005