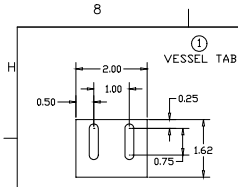
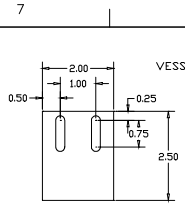
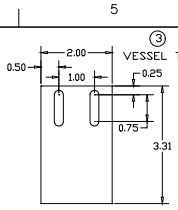


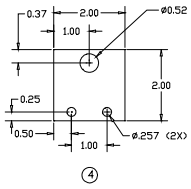
1 VESSEL TAB



2 VESSEL TAB



3 VESSEL TAB



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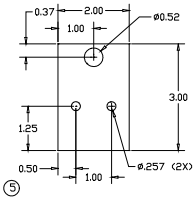
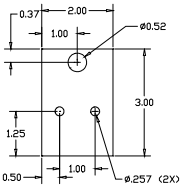
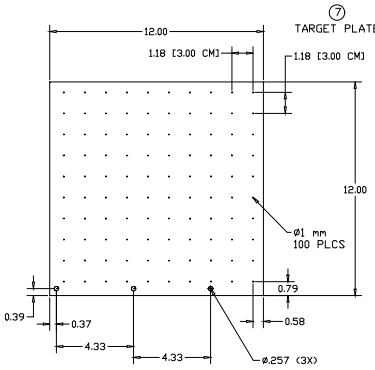


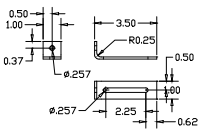
5 MANIFOLD TAB



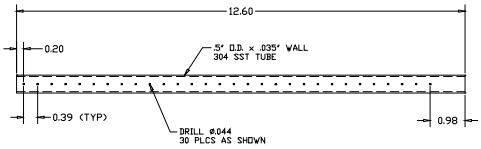
6 MANIFOLD TAB



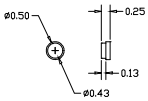
7 TARGET PLATE



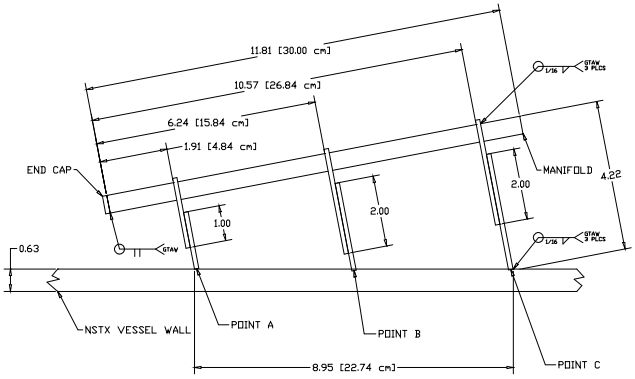
8 TARGET PLATE TAB



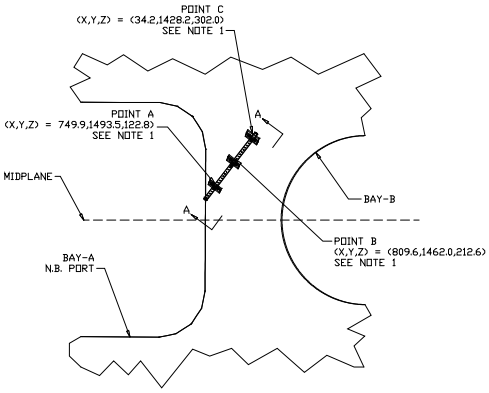
9 GAS PUFF MANIFOLD



10 MANIFOLD END CAP



VIEW A-A



NSTX VESSEL INNER WALL BETWEEN BAY A AND B
LOOKING FROM MACHINE CENTER OUTWARD

NOTES:

1. POINTS A,B AND C ARE THE TAB WELD LOCATIONS ON THE INNER VESSEL WALL AS DEVELOPED IN THE GAS PUFF MANIFOLD CAD MODEL.

MARK POINTS A,B, AND C ON THE WALL USING THE FARO MEASURING ARM SYSTEM FOR WELDER GUIDANCE.

2. WELDING SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF AWS D1.6 (FOR STRUCTURAL WELDING OF AUSTENITIC STAINLESS STEEL) AND PPPL PROCEDURE NO. EM-002

VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH THE ACCEPTANCE CRITERIA OF AWS D1.6.

QD	CUD	QTY	PART NO	DESCRIPTION	DRAWING NO.	MATERIAL
		1	10	MANIFOLD END CAP		304 OR 316 SST
		1	9	GAS PUFF MANIFOLD		304 OR 316 SST
		3	8	TARGET PLATE TAB, 1/8" THK		304 OR 316 SST
		1	7	TARGET PLATE, 1/4" THK		ALUMINUM
		1	6	MANIFOLD TAB, 1/8" THK		304 OR 316 SST
		1	5	MANIFOLD TAB, 1/8" THK		304 OR 316 SST
		1	4	MANIFOLD TAB, 1/8" THK		304 OR 316 SST
		1	3	VESSEL TAB, 1/8" THK		304 OR 316 SST
		1	2	VESSEL TAB, 1/8" THK		304 OR 316 SST
		1	1	VESSEL TAB, 1/8" THK		304 OR 316 SST

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON FRACTIONS ± 1/64 ON DECIMALS ± .005 ANGLES ± 1/2°

DO NOT SCALE DRAWING

DRAWING IS A PROPERTY OF PPPL AND SHALL NOT BE REPRODUCED OR TRANSFERED TO OTHERS WITHOUT WRITTEN PERMISSION

NSTX GAS PUFF IMAGING MANIFOLD AND PORT MIS-ALIGNMENT

WELDING ENGINEER
APPROVED: R. PARSELLS
DATE: 09/04/02

NEXT ASSEM.

DRAWN	FIM	DATE: 8/29/02	USE FILE MANIPULATE
ENGR	FEDER	APPROVAL	
DFN	FEDER	FEDER	E-9D1544
CHK	LABIK	DOC. GL.	SHT 1 of 1 REV 0