



6" rotatable flange
(MDC part #100026)

Step 1: weld
tube (1" section)
to "insert" of
rotatable flange

Step 3: weld
disk to tube
(0.5" section)

Step 2: weld
window to disk

RELEASED FOR
FABRICATION/INSTALLATION
PPPL CENTRAL FILES:
RELEASE DATE: 5/17/00
EXPIRATION DATE: 5/17/00

NOTES: 1. WELDING SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS
OF PROCEDURE NO. EN-002. VISUAL WELD INSPECTION SHALL BE PERFORMED
IN ACCORDANCE WITH THE ACCEPTANCE CRITERIA OF ASME B3.3 CH. I D
2. THE ASSEMBLY SHALL BE LEAK TIGHT TO 10⁻⁴ TORR-LITERS/SEC AS
VERIFIED BY A HELIUM MASS SPECTROMETER LEAK DETECTOR

REV	DATE	BY	CHK	APPV	REV	DATE	BY	CHK	APPV	REV	DATE	BY	CHK	APPV
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<p>WATERMAN PROJECT SAPPHIRE WINDOW ISI #9711010 SPECIAL MATERIALIZED TUBE MDC #100026 6" ROTATABLE FLANGE MDC #100026</p> <p>304 ST. STEEL 304 ST. STEEL 304 ST. STEEL 304 ST. STEEL</p> <p>8-101218-2 8-101218-1 8-101218-1 8-101218-1</p> <p>COMPL. COMPL. COMPL. COMPL.</p> <p>DATE: 5-17-00</p> <p>ENG: R. EGLE APPROVED: [Signature] CHK: J. STEGEL</p> <p>PRINCETON PLASMA PHYSICS LABORATORY PRINCETON UNIVERSITY NATIONAL SPHERICAL TORUS EXPERIMENT GPI-MATERIALIZED TUBE WELDMENT</p> <p>DATE: 3-17-00 APPROVED: [Signature] CHK: J. STEGEL</p> <p>DATE: 5-17-00 APPROVED: [Signature] CHK: J. STEGEL</p>														