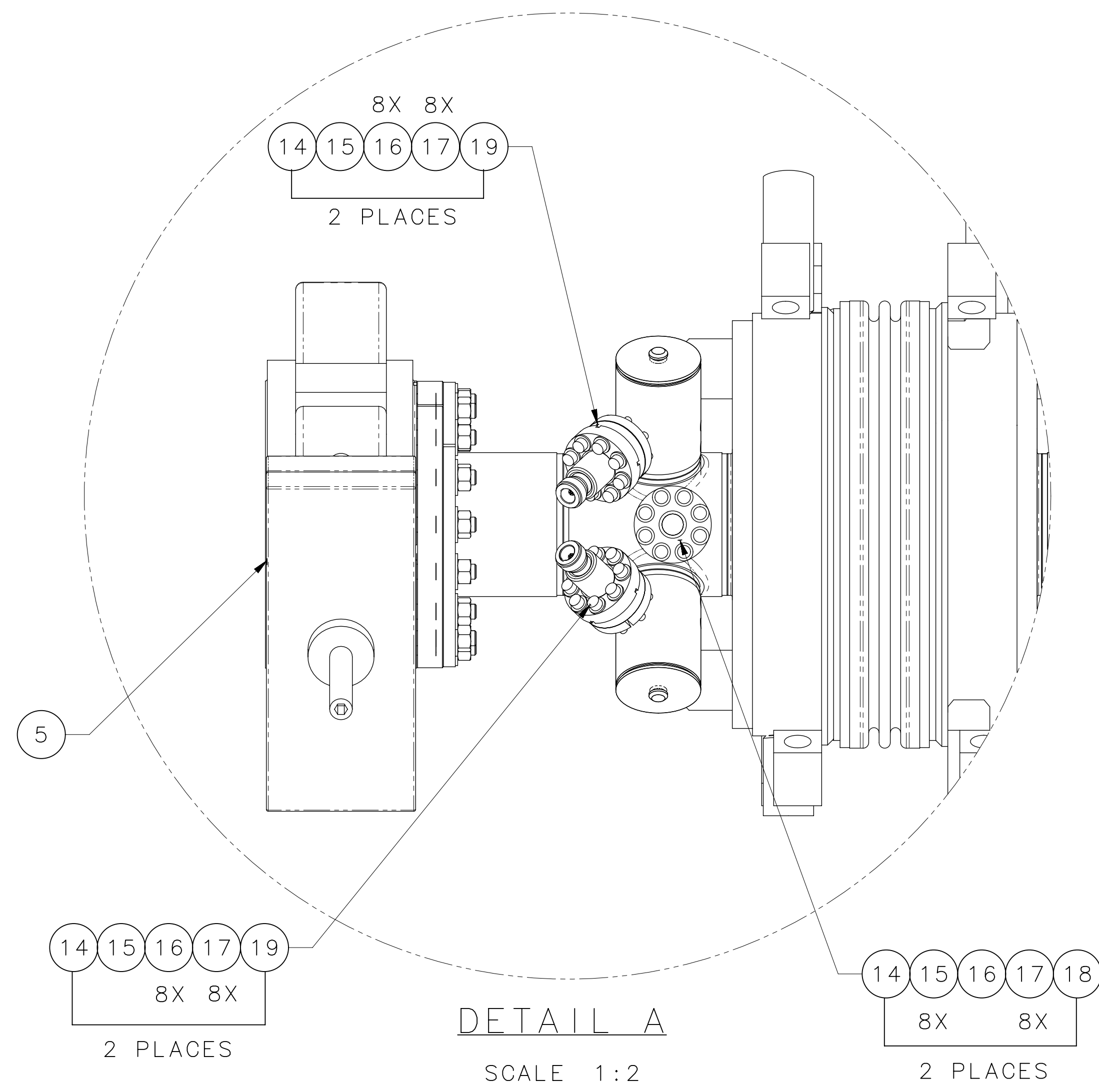
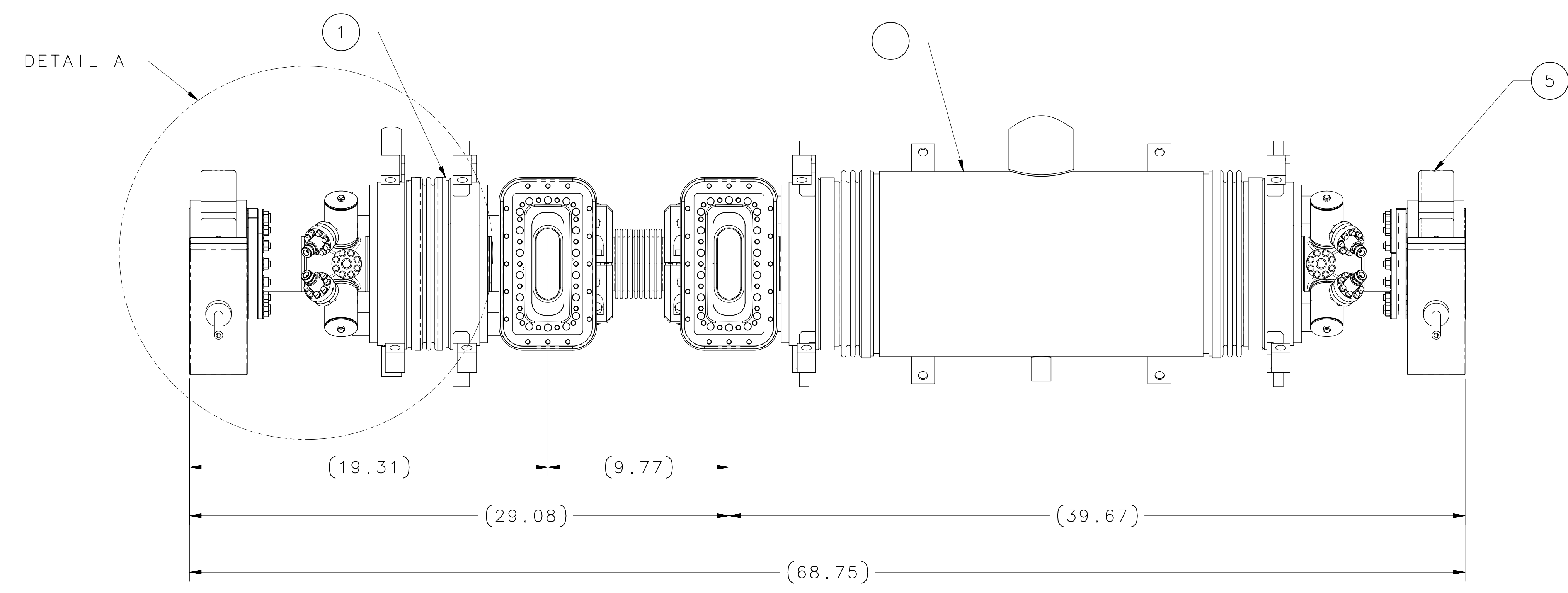
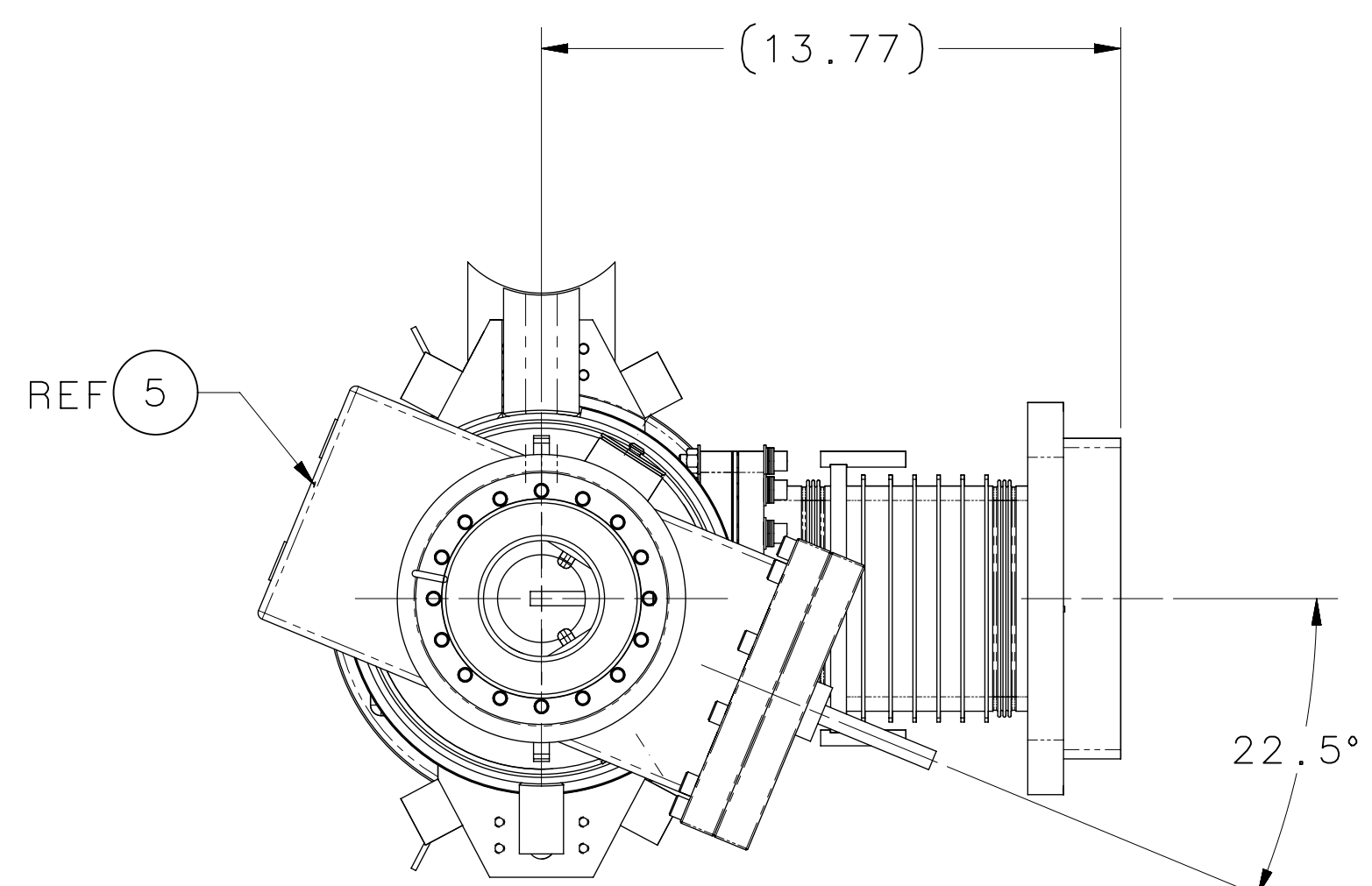
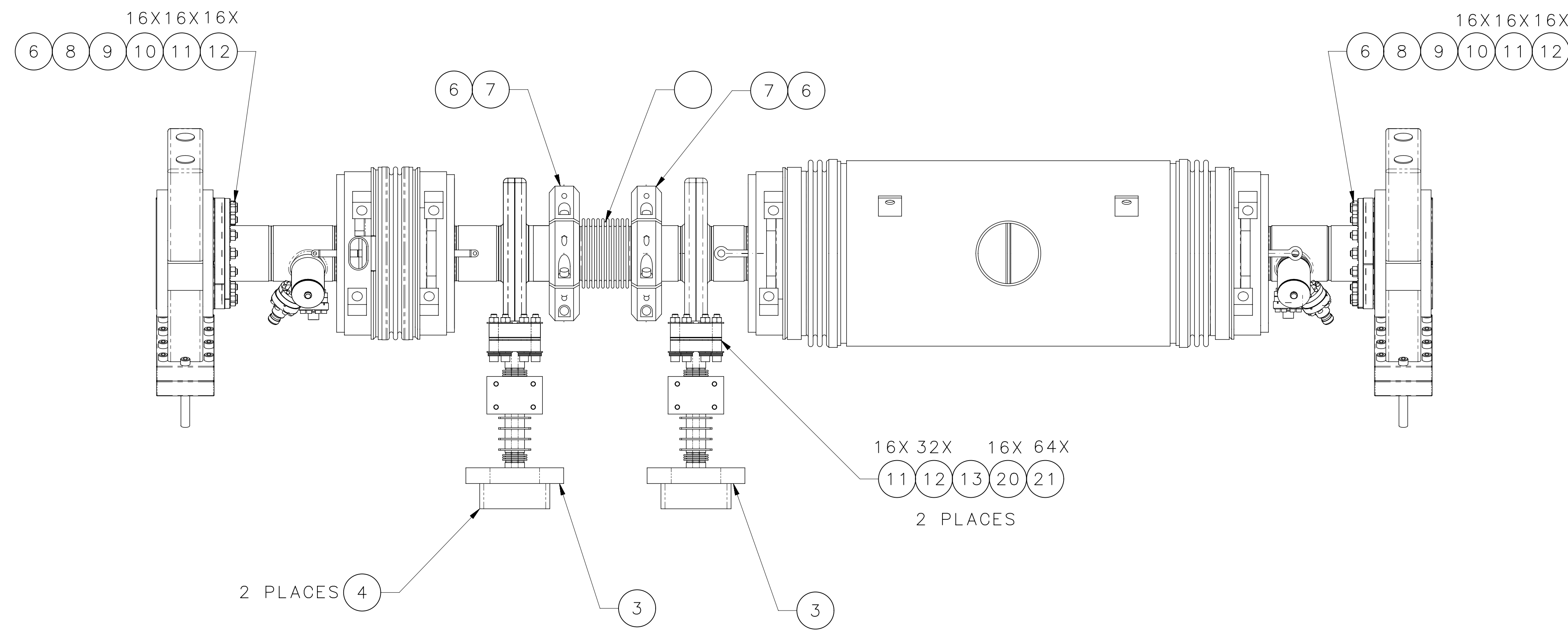


REVISION HISTORY				
ZONE	REV	DESCRIPTION	DATE	APPROVED
	A	REVISED ITEM 22 TO JL0002616	4/15/15 DDS	



NOTES :

1. LARGE HELIUM VESSEL OUTLET SHALL BE ON TOP FOR BOTH CAVITIES.
2. PROTECT FLANGE FACES DURING ALL PHASES OF ASSEMBLY.
3. PERFORM VACUUM LEAK CHECK PER TJNAF SPECIFICATION 11141-S-0033.
4. CAVITY STRING SHALL BE LEAK CHECKED WITH VALVES, ITEM 5, OPEN. AFTER SUCCESSFUL LEAK CHECK, CLOSE AND CAP VALVES.
5. CLEAN AND HANDLE PER TJNAF SPECIFICATION 11141-S-0035.
6. RESTRAIN WAVEGUIDE BELLOWS, ITEM 3, PRIOR TO PUMPING DOWN CAVITY STRING.

QTY	ITEM NO.	PART OR IDENTIFYING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL SPECIFICATION	NOTES
1	22	JL0002616	CAV TO CAV BELLOWS ASSY		
128	21	KEY BELLEVILLE INC K0625-B-047-316(L)	BELLEVILLE SPRING WASHER .317 ID X .625 OD X .047 THK	316L STAINLESS STEEL	
32	20		12 POINT BOLT .312-24 X 2.50 LG.	STAINLESS STEEL A-286	
4	19	CRM1207014-0020	HOM FEED THRU		
2	18	CRM1007014-0010	FEED THRU-FIELD PROBE		
48	17		WASHER #8 TY B PLAIN NARROW	316L STAINLESS STEEL	
48	16		SOCKET HEAD CAP SCREW #8-32 UNC X 1.12 LG.	STAINLESS STEEL A-286	
6	15	115130-1038	HOM NUT PLATE		
6	14	115430-1029	FIELD PROBE FLANGE GASKET		
2	13	CRM1007014-0028	SERPENTINE SEAL		
96	12		FLAT WASHER .312	316L STAINLESS STEEL	
64	11		HEX NUT .312-24UNF	SILICON BRONZE	
32	10		STUD .312-24UNF X 1.75 LG.	STAINLESS STEEL A-286 SILVER PLATED	
2	9	CRM1207014-0029	STIFFENING RING		
2	8	JL0024833	SPLIT FLANGE		
2	7	CRM1007014-0011	RADIAL WEDGE CLAMP ASSY		
4	6	115110-1011C	BEAMLINE FLANGE GASKET -DET		
2	5	VAT 244856	RF-ALL METAL GATE VALVE		
2	4	CRM1207075-0036	WINDOW INSTALLATION - CLEAN ROOM		
2	3	CRM1207070-0000	12GEV WAVEGUIDE ASSEMBLY		
1	2	CRM1107020-1000	HELIUM VESSEL		
1	1	CRM1107020-1100	INJ CAV 2 CELL HELIUM VESSEL ASSY		

EACH SHEET OF MULTI-SHEET DRAWINGS SHALL ALWAYS HAVE THE SAME REVISION LEVEL.

UNIT & TOL PER ASME Y14.5 UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ARE FRACTIONS DECIMAL ANGLES ± N/A ± .01 ± .50°

THIRD ANGLE PROJECTION

FINISH UNLESS OTHERWISE NOTED SURFACES TO BE PER & BREAK ALL SHARP EDGES

DO NOT SCALE DRAWING

DRAWN: B. SPELL DATE: 2/24/2015

MATERIAL: SEE PARTS LIST

United States Department of Energy
Jefferson Lab
 Thomas Jefferson National Accelerator Facility
 Newport News, Virginia

CRM INJECTOR CRYOMODULE CAVITY STRING CLEAN ROOM

SIZE: DWG. NO. E CRM1107014-0002 REV. A
 SCALE: 1:1 (SEE DR ASSY NO. CRM107001-0001) SHEET 1 OF 1