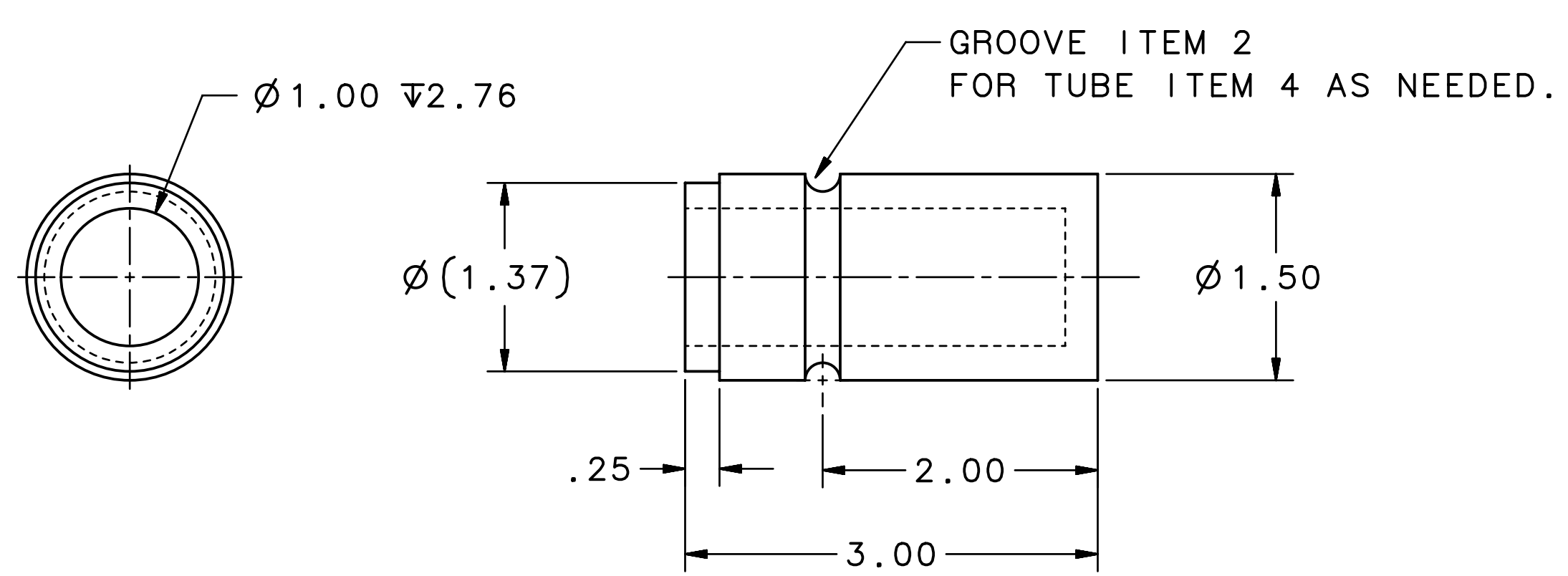
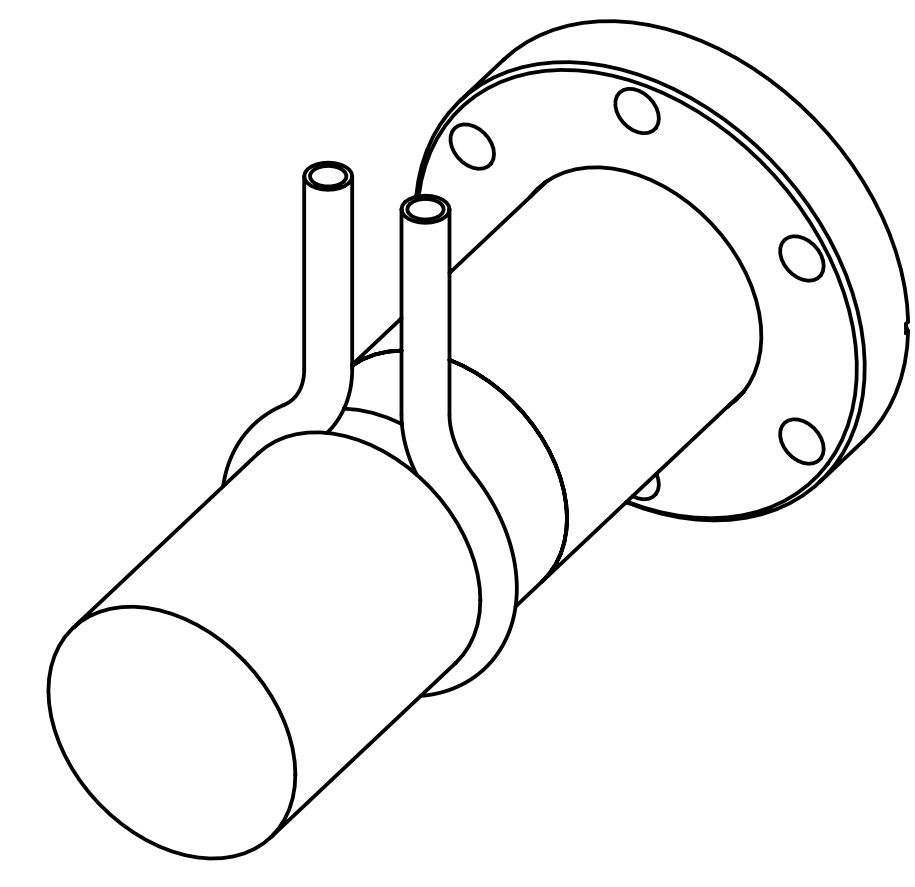
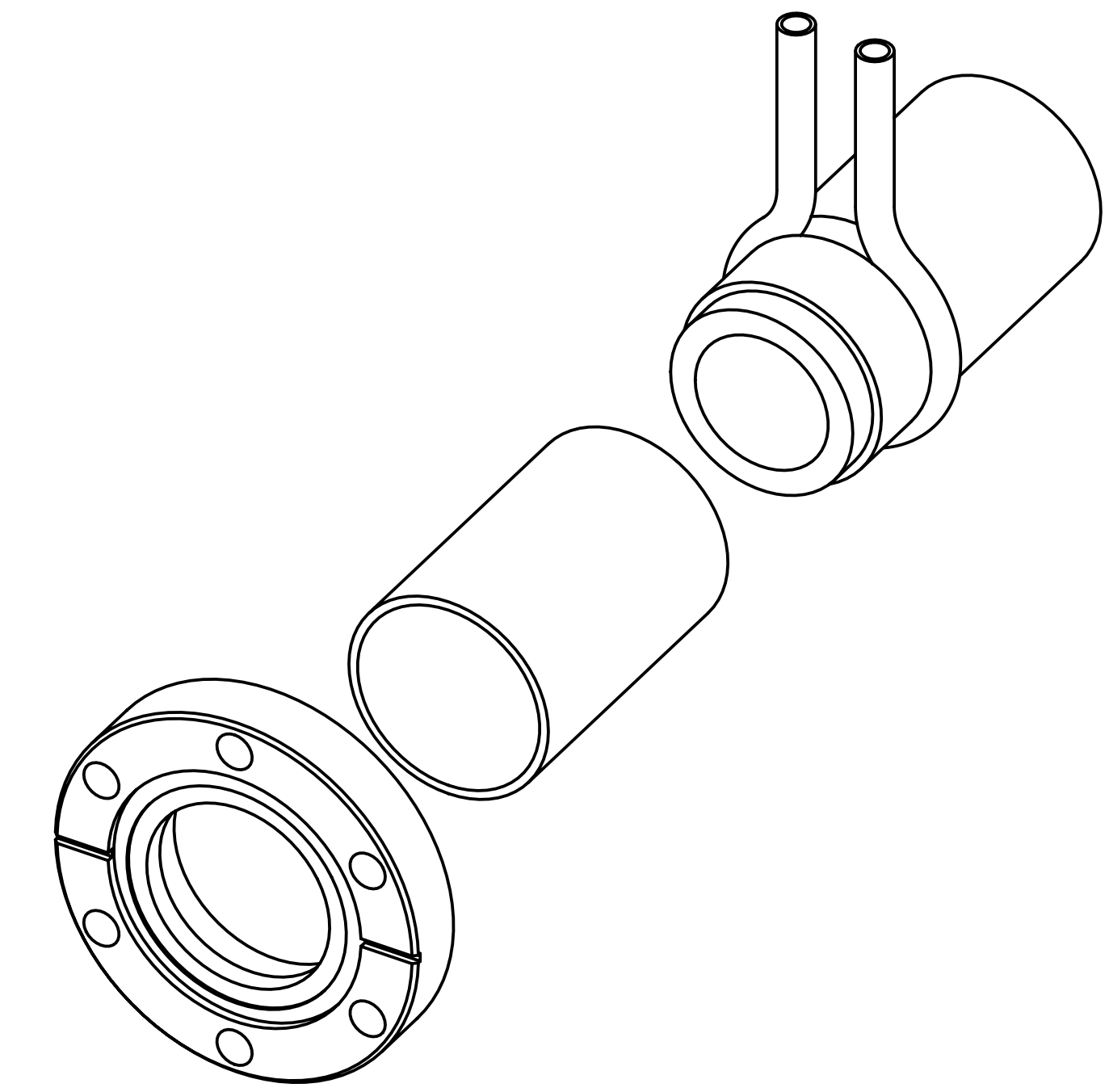


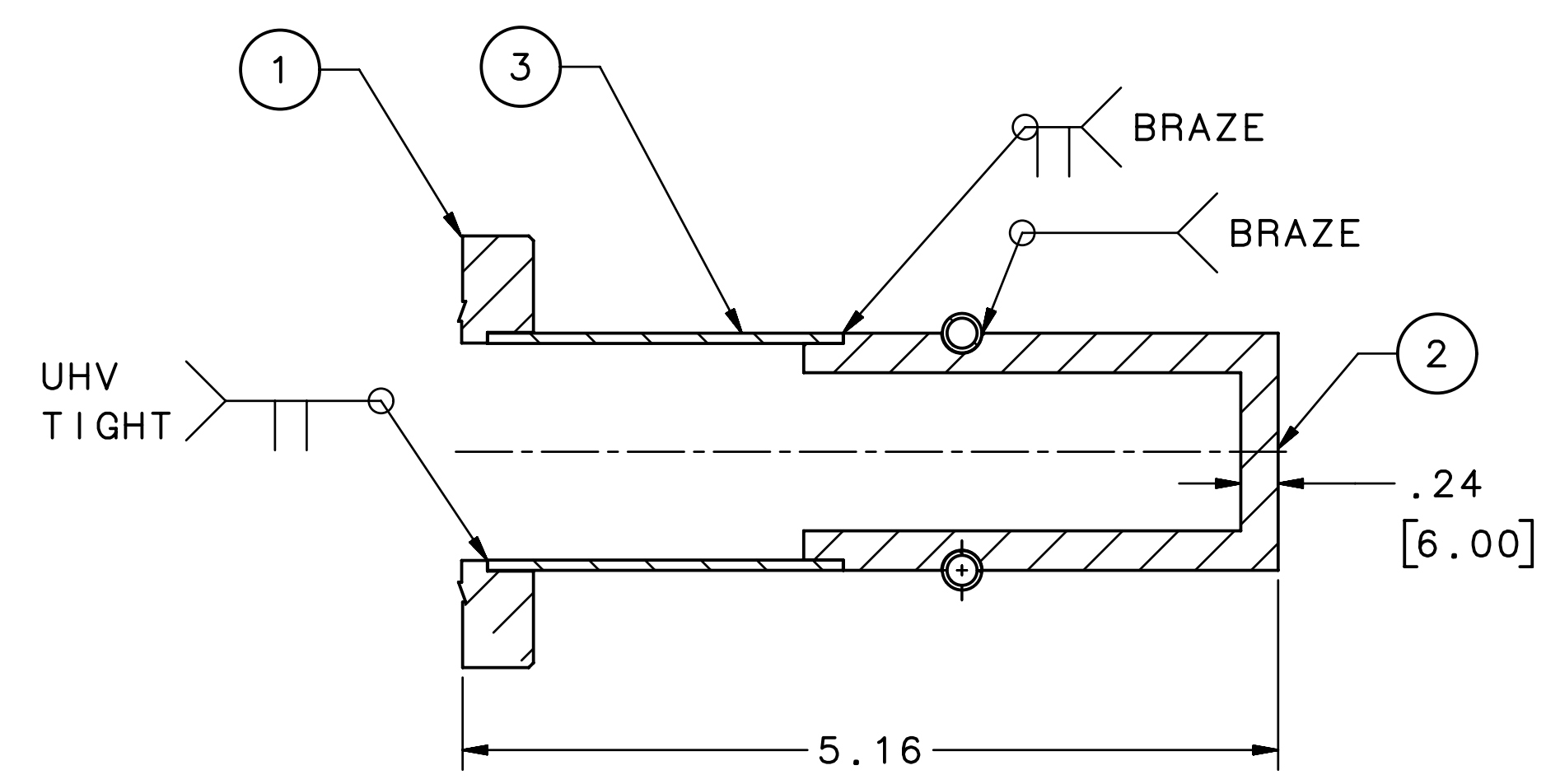
REVISION HISTORY				
ZONE	REV	DESCRIPTION	DATE	APPROVED



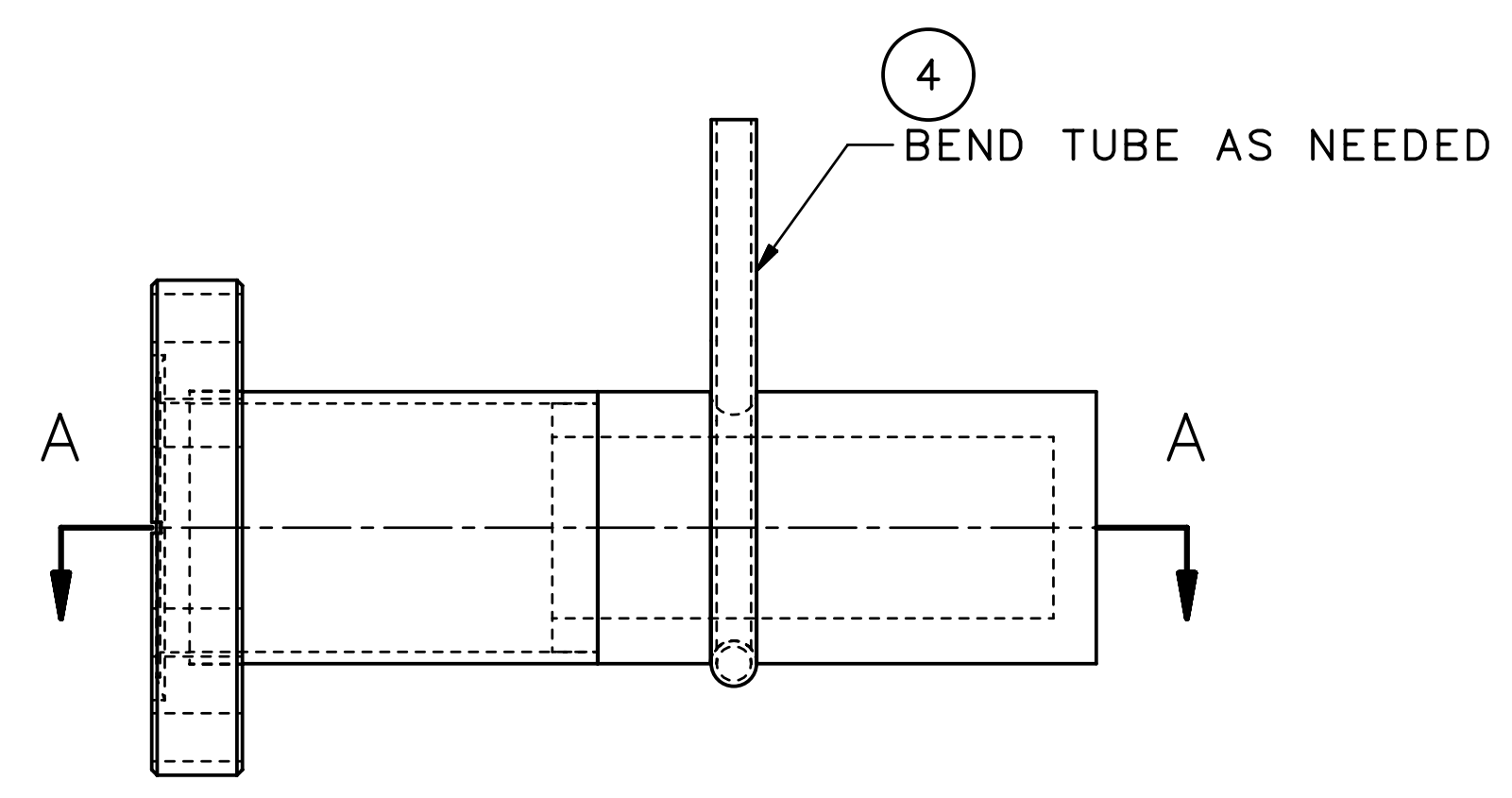
ITEM 2



ISOMETRIC



SECTION A-A



NOTES:

- ASME Y14.5-2009 IS USED FOR ALL DIMENSIONING AND TOLERANCING.
- USE THE FOLLOWING CEBAF SPECIFICATIONS:
 FABRICATION OF UHV EQUIPMENT: #22631-S-001
 CLEANING & HANDLING OF UHV COMPONENTS: #22632-S-001
 WELDING OF UHV COMPONENTS: #22633-S-001
 HELIUM LEAK TEST FOR UHV COMPONENTS: #22634-S-001
- PROTECT FLANGE FACE DURING AND AFTER PROCESSING WITH SUITABLE PLASTIC CAP. DAMAGE TO FLANGE FACE IS UNACCEPTABLE.
- ALL TOLERANCES APPLY AFTER WELDING UNLESS OTHERWISE STATED.
- PART NUMBER JL0015733 TO BE ENGRAVED, ETCHED OR STAMPED ON SIDE OF FLANGE USING .25 HIGH CHARACTERS.

QTY REQD	ITEM NO.	PART OR IDENTIFYING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL SPECIFICATION	NOTES
1	3	-	TUBE 1-1/2 OD X 0.065 THK	STAINLESS STEEL TYPE 304	-
1	2	-	COPPER PLUG	COPPER	-
1	1	-	CF FLANGE 2-3/4 OD X 1-1/2 NOM ID, NR	STAINLESS STEEL TYPE 304	-

FOR JLAB INTERNAL USE ONLY		DIM & TOL PER ASME Y14.5 UNLESS OTHERWISE SPECIFIED. DIMENSIONS ARE IN INCHES. TOLERANCES ARE: FRACTIONS .X ± .1 ANGLES ± .50° DECIMAL .XX ± .01 XXX ± .005		MATERIAL SEE PARTS LIST		United States Department of Energy Jefferson Lab Thomas Jefferson National Accelerator Facility Newport News Virginia	
ALL WELDS ON THIS DRAWING ARE AS DEFINED BY JLAB ES & H MANUAL, WELDING & BRAZING PROGRAM SUPPLEMENT.		THIRD ANGLE PROJECTION		FINISH 125 UNLESS OTHERWISE NOTED MACHINE SURFACES DEBURR & BREAK ALL SHARP EDGES		ACC INJECTOR (DETAILS & ASSEMBLIES) BUBBLE CHAMBER CU RADIATOR WINDOW ASSY	
WELD CLASS	WELD SPECIFICATION	DO NOT SCALE DRAWING		SIZE DWG. NO.	REV.	SCALE 1:1 USED ON ASSY NO. JL0015130 SHEET 1 OF 1	
C	BPS 026	DRAWN S.A. GREGORY DATE 10JUN14		D	A	JL0015733	
	WELD ANALYSIS						
	NA						