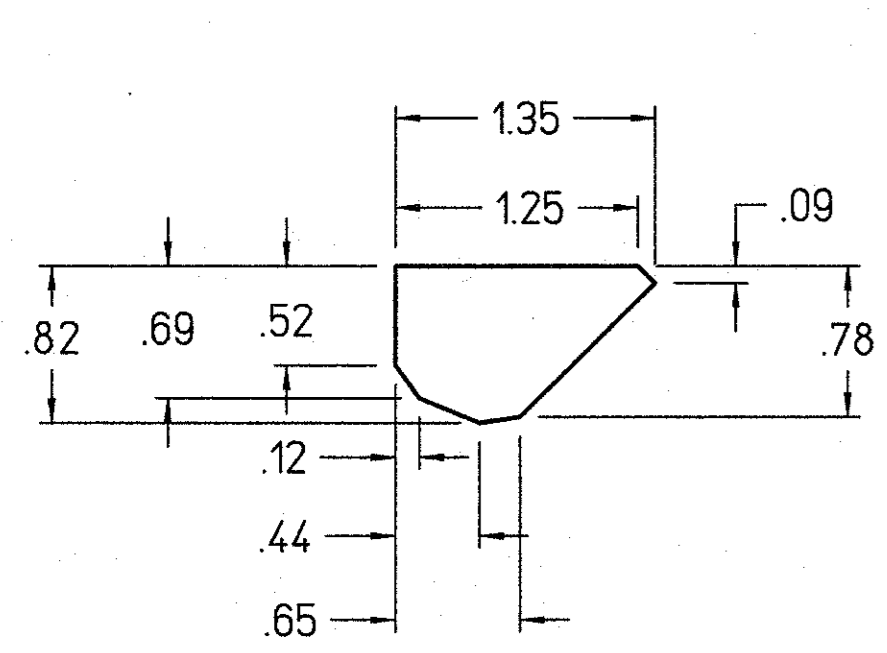
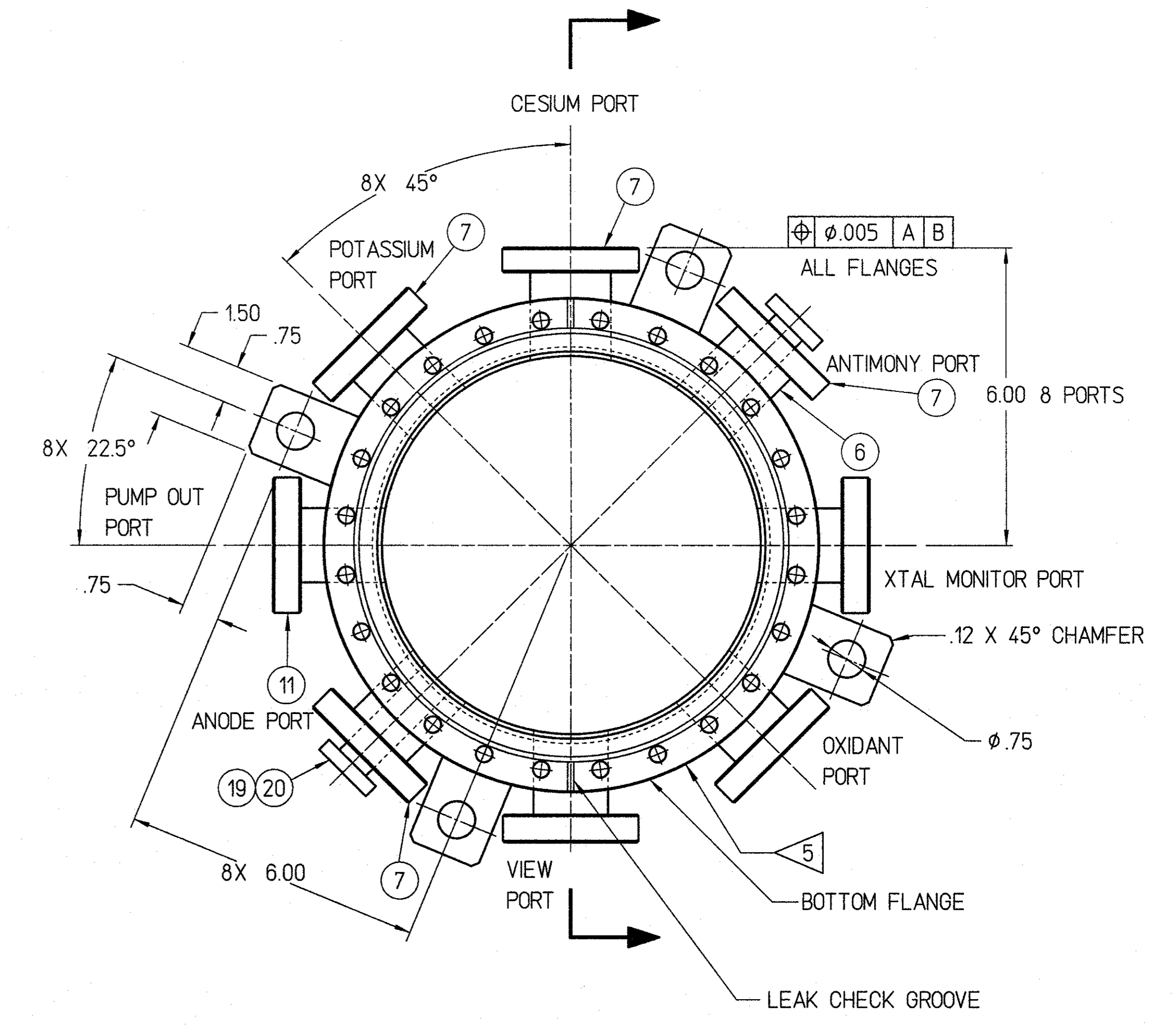
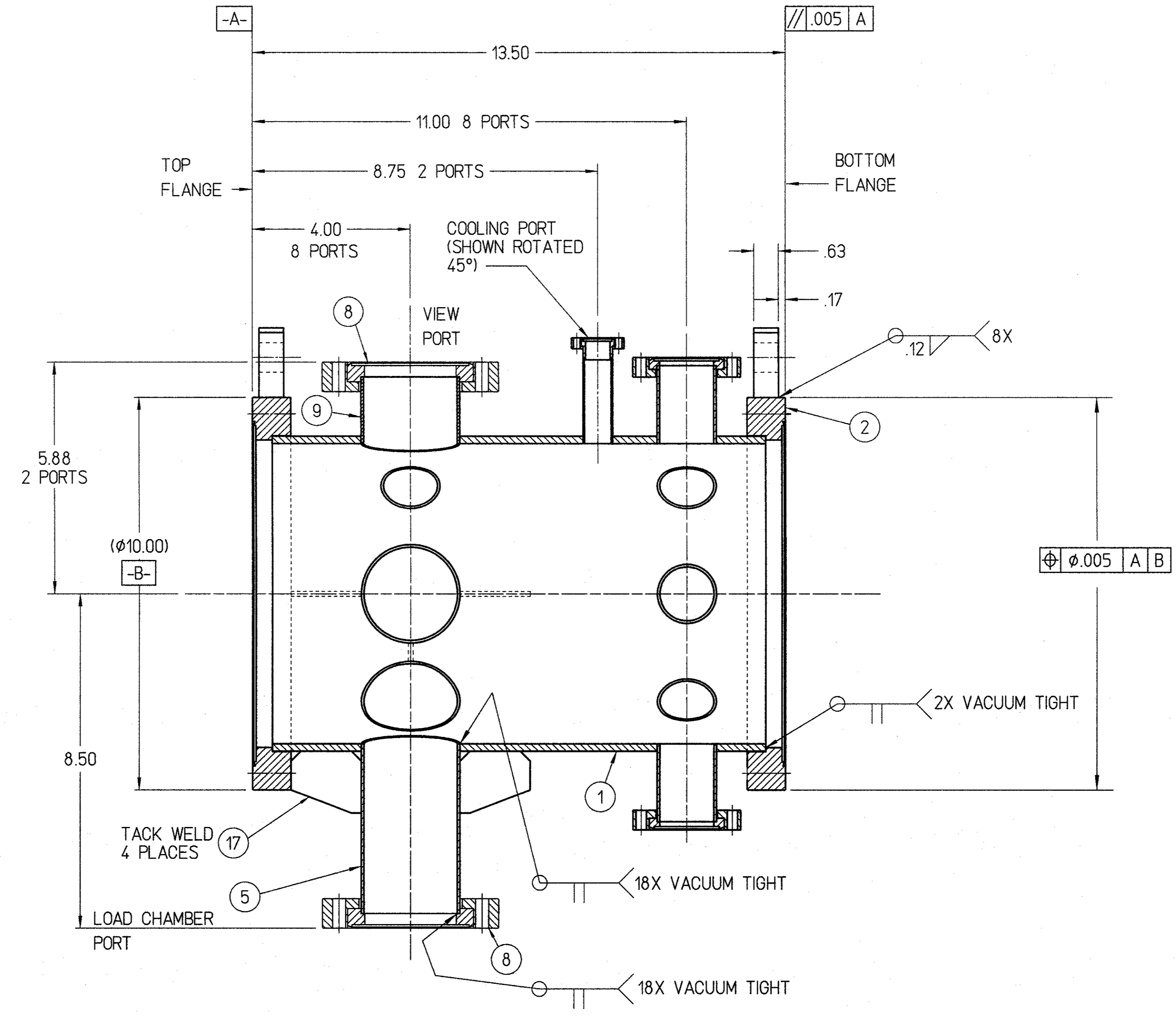
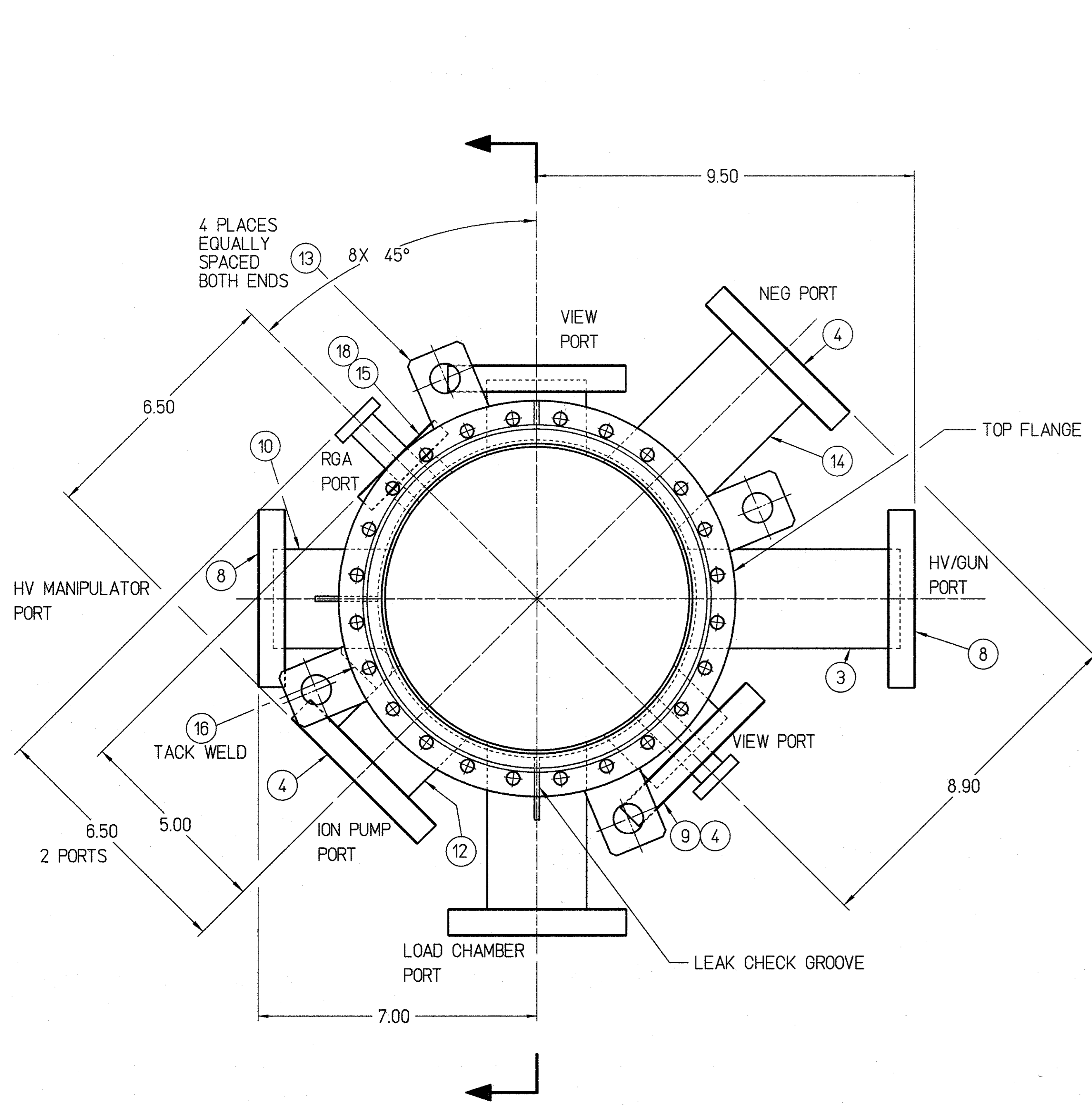
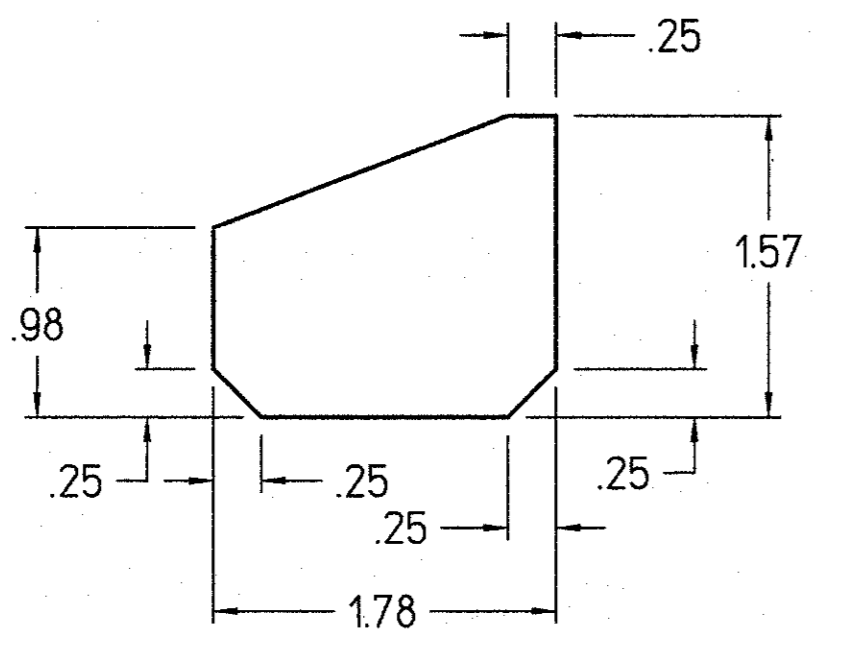


REVISION HISTORY				
ZONE	REV	DESCRIPTION	DATE	APPROVED



CHOCK DETAIL-1
SCALE: 1:1



CHOCK DETAIL-2
SCALE: 1:1

NOTES:

- USE THE FOLLOWING JLAB SPECIFICATIONS
 FABRICATION OF ULTRA HIGH VACUUM EQUIPMENT: #22631-S-001
 CLEANING AND HANDLING OF U.H.V. COMPONENTS: #22632-S-001
 WELDING SPECIFICATION FOR U.H.V. COMPONENTS: #22633-S-001
 HELIUM LEAK TEST FOR U.H.V. COMPONENTS: #22634-S-001
 SPECIFICATION FOR MANUFACTURE OF UHV CHAMBER: #FEL0000000-S-0005
- ALL TOLERANCES APPLY AFTER WELDING.
- SKIM CUT 32 FINISH INSIDE DIAMETER OF 8.00 TUBE (ITEM 1) PRIOR TO WELDING ON TUBES.
- 10.00 FLANGES (ITEM 2) SHALL BE ORIENTATED SUCH THAT THE LEAK CHECK GROOVES ARE IN LINE AND AS SHOWN. ALL OTHER FLANGES SHALL BE ORIENTATED SUCH THAT THE LEAK CHECK GROOVES ARE PARALLEL WITH THE 10.00 FLANGES.
- PART NUMBER TO BE ENGRAVED OR ETCHED IN LOCATIONS SHOWN USING MIN. .25 HIGH CHARACTERS.
- PROTECT FLANGE FACES DURING AND AFTER PROCESSING WITH SUITABLE PLASTIC CAPS. DAMAGE TO KNIFE EDGES IS UNACCEPTABLE.
- ESTIMATED WEIGHT - 55 LBS
- SUGGESTED FABRICATION SEQUENCE:
 A. WELD ITEMS 3, 5, 6, 9, 10, 12 AND 16-21 TO ITEM 1.
 B. ELECTROPOLISH SUB-ASSEMBLY.
 C. BAKE SUB-ASSEMBLY FOR 3 HOURS AT 900°C IN A VACUUM FURNACE PUMPED DOWN TO LESS THAN 3 X 10⁻⁶ E-6 TORR.
 D. WELD FLANGES TO SUB-ASSEMBLY.

QTY	ITEM NO	DESCRIPTION	MATERIAL	NOTES
2	20	TUBE, .75 O.D. X .035 WALL X 2.21 LG.	304 STAINLESS STEEL	
2	19	MDC# 100004 CF FLANGE, ROTATABLE 1.33 O.D. X .75 I.D.	STAINLESS STEEL	
1	18	TUBE, 1.50 O.D. X .065 WALL X 1.11 LG.	304 STAINLESS STEEL	
4	17	CHOCK DETAIL-2	304 STAINLESS STEEL .12 THICK PLATE	
1	16	CHOCK DETAIL-1	304 STAINLESS STEEL .12 THICK PLATE	
1	15	MDC# 120014 CF FLANGE, ROTATABLE, TAPPED, 2.75 O.D. X 1.50 I.D.	STAINLESS STEEL	
1	14	TUBE, 2.50 O.D. X .065 WALL X 4.98 LG.	304 STAINLESS STEEL	
8	13	.625 X 1.50 MOUNTING LUG X 1.82 LONG	304 STAINLESS STEEL	
1	12	TUBE, 2.50 O.D. X .065 WALL X 2.58 LG.	304 STAINLESS STEEL	
1	11	MDC# 110014 CF FLANGE, NON-ROTATABLE 2.75 O.D. X 1.50 I.D.	STAINLESS STEEL	
1	10	TUBE, 2.50 O.D. X .065 WALL X 3.08 LG.	304 STAINLESS STEEL	
2	9	TUBE, 2.50 O.D. X .065 WALL X 1.96 LG.	304 STAINLESS STEEL	
4	8	MDC# 100021 CF FLANGE, ROTATABLE, 4.50 O.D. X 2.50 I.D.	STAINLESS STEEL	
7	7	MDC# 100014 CF FLANGE, ROTATABLE 2.75 O.D. X 1.50 I.D.	STAINLESS STEEL	
8	6	TUBE, 1.50 O.D. X .065 WALL X 2.11 LG.	304 STAINLESS STEEL	
1	5	TUBE, 2.50 O.D. X .065 WALL X 4.58 LG.	304 STAINLESS STEEL	
3	4	MDC# 110021 CF FLANGE, NONROTATABLE 4.50 O.D. X 2.50 I.D.	STAINLESS STEEL	
1	3	TUBE, 2.50 O.D. X .065 WALL X 5.58 LG.	304 STAINLESS STEEL	
2	2	MDC# 110033 CF FLANGE, NONROTATABLE, 10.00 O.D. X 8.00 I.D.	STAINLESS STEEL	
1	1	TUBE, 8.00 O.D. X .25 WALL X 12.50 LG., ENDS CUT SQUARE	304 STAINLESS STEEL	

FOR JLAB REFERENCE: ALL WELDS ON THIS DRAWING ARE AS DEFINED BY JLAB ESSH MANUAL, CHAPTER 6122 APP 7B		DOCUMENT CONTROL STAMP IOG		DIM & TOL PER ASME Y14.5 UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE DECIMAL ANGLES IN DEGREES UNLESS NOTED	
WELD CLASS	APPLICABLE DOCUMENTS	MATERIAL	SEE PARTS LIST	THIRD ANGLE PROJECTION	TRACKING NO. NA
C	WELD SPECIFICATION: 22633-S-001 WELD ANALYSIS: N/A	FINISH: MACHINED SURFACES UNLESS OTHERWISE NOTED DEBURR & BREAK ALL SHARP EDGES	DO NOT SCALE DRAWING	APPROVALS: DRAWN: D. MACHE, 03FEB11; CHECKED: [Signature], 4/1/11; APPROVED: [Signature], 4/1/11	DATE: 4/1/11
EACH SHEET OF A MULTI-SHEET DRAWING SHALL ALWAYS CARRY THE SAME REVISION LEVEL				Thomas Jefferson National Accelerator Facility UNITED STATES DEPARTMENT OF ENERGY	
ACC INJECTOR DEPOSITION CHAMBER WELDMENT				ACC-200-6000-0105	
SCALE: 1:2				SHEET 1 OF 1	