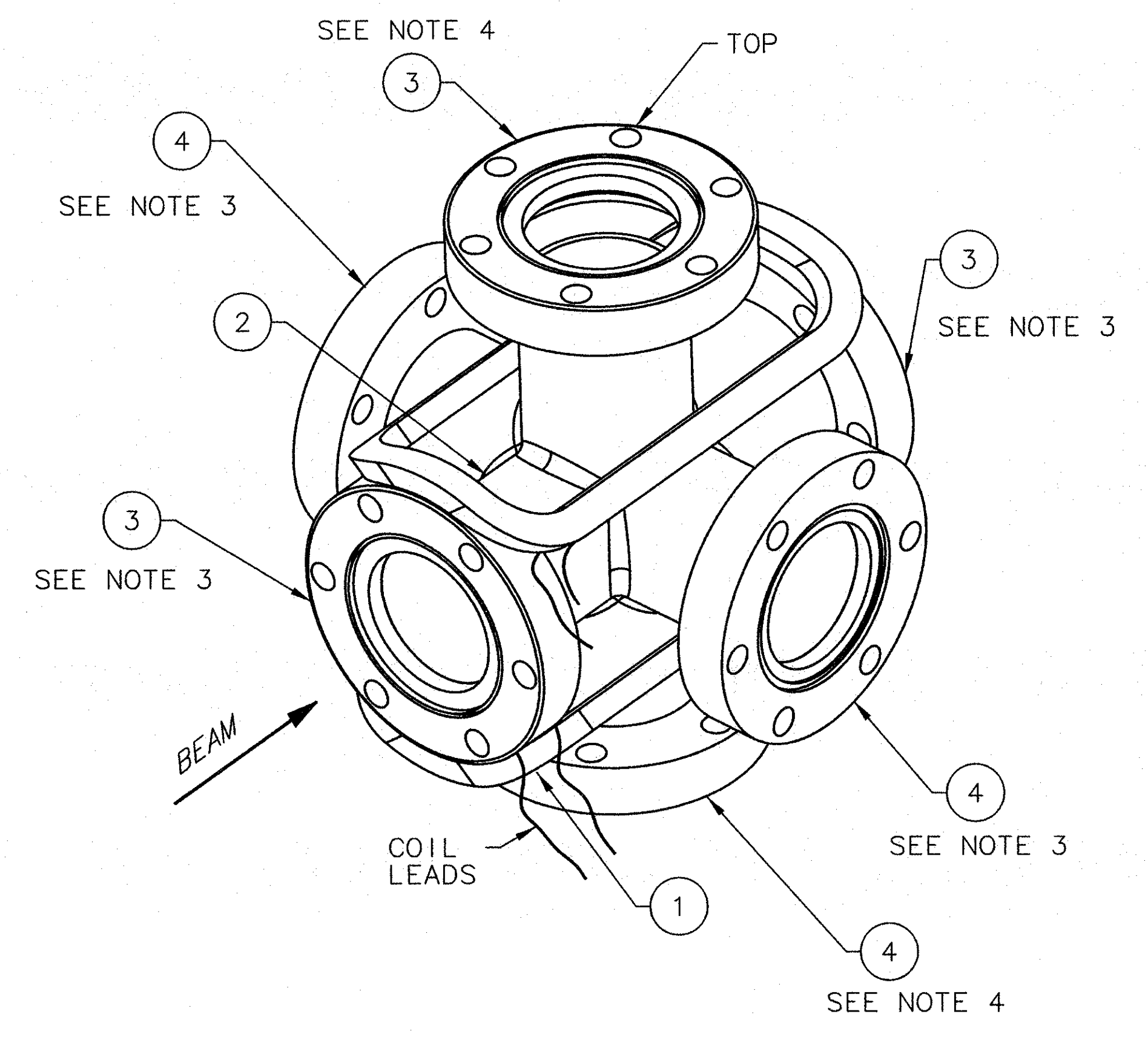
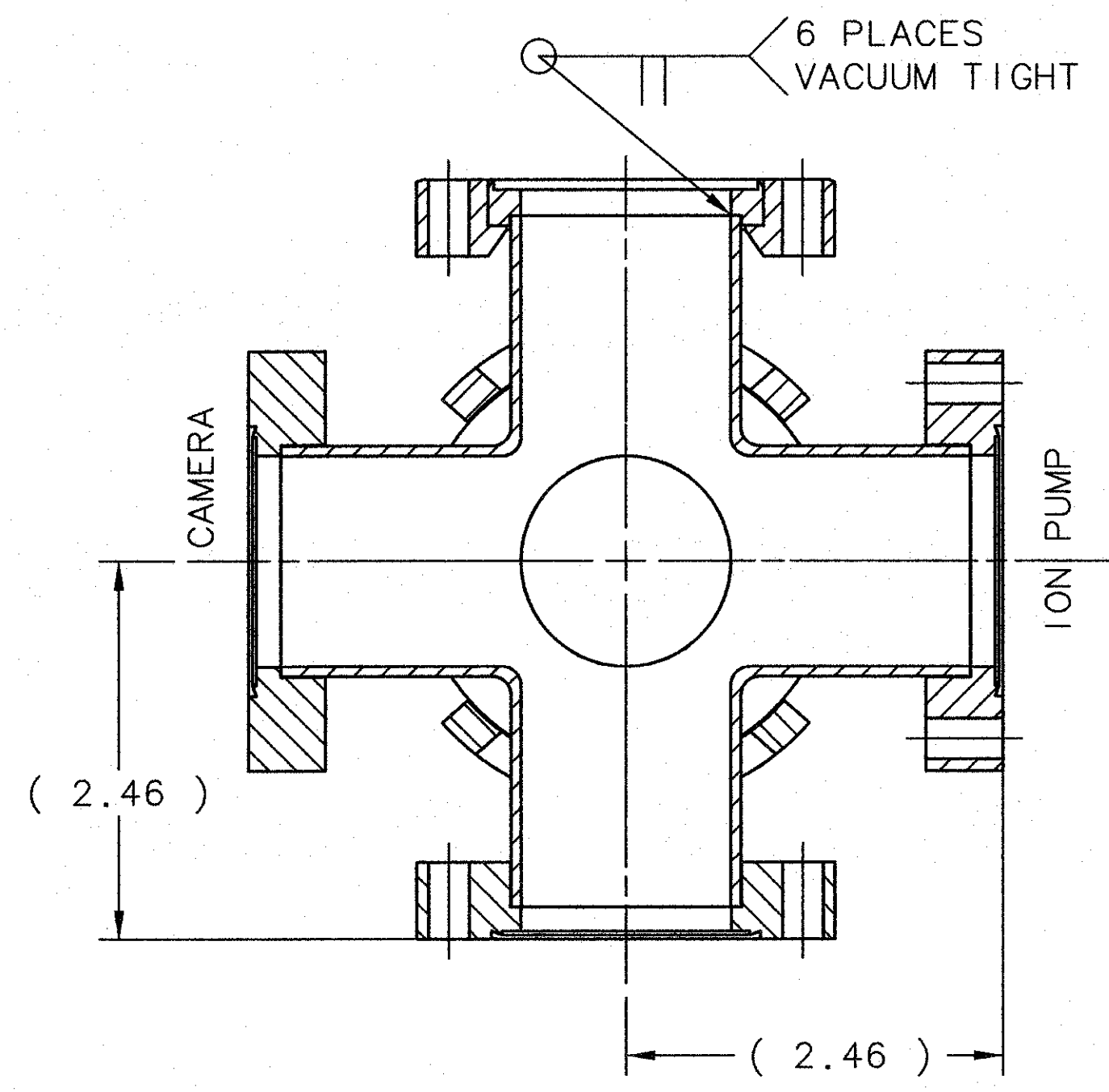
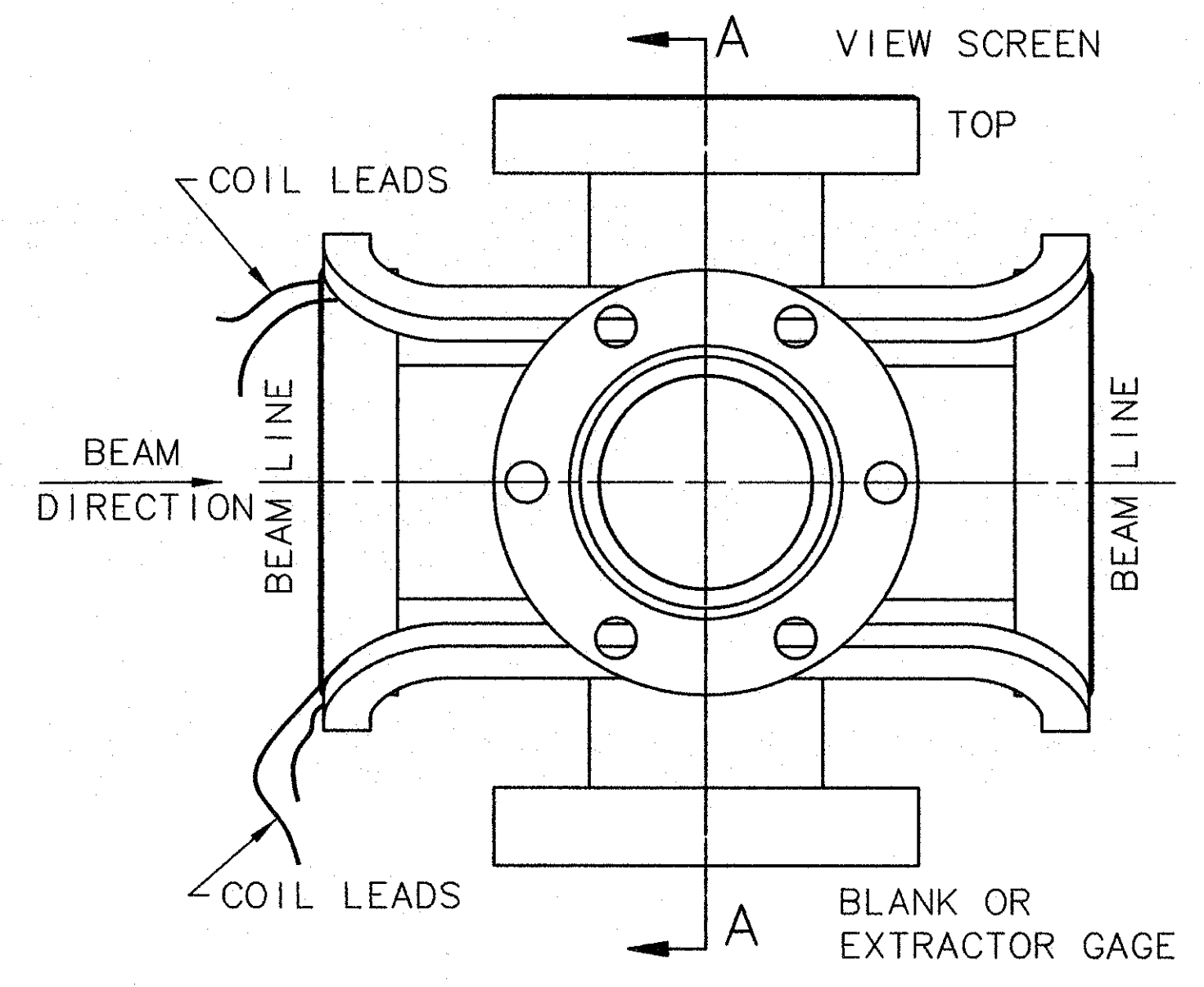


REVISION HISTORY				
ZONE	REV	DESCRIPTION	DATE	APPROVED



ISOMETRIC VIEW

NOTES

- USE THE FOLLOWING TJNAF SPECIFICATIONS:
 FABRICATION OF UHV EQUIPMENT #22631-S-001
 CLEANING AND HANDLING OF UHV COMPONENTS #22632-S-001
 WELDING SPECIFICATION FOR UHV COMPONENTS #22633-S-001
 HELIUM LEAK TEST FOR UHV COMPONENTS #22634-S-001
- PROTECT FLANGE FACES DURING AND AFTER PROCESSING WITH SUITABLE PLASTIC CAPS. DAMAGE TO KNIFE EDGES IS UNACCEPTABLE.
- WELD 2 OF ITEM 3 AND 2 OF ITEM 4 TO CROSS (ITEM 2) AS SHOWN IN THE ISOMETRIC VIEW. ASSEMBLE COILS (ITEM 1) ON CROSS WITH LEADS ORIENTED UPSTREAM.
- WELD 1 OF ITEM 3 AND 1 OF ITEM 4 TO CROSS. PROTECT COILS FROM HEAT AND POSSIBLE WELD DAMAGE.

QTY REQD	ITEM NO.	PART OR IDENTIFYING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL SPECIFICATION	NOTES
3	4	MDC P/N 110014	2-3/4 OD NON ROTATABLE FLANGE 1.50 TUBE	STAINLESS STEEL	
3	3	MDC P/N 100014	2-3/4 OD ROTATABLE FLANGE 1.50 TUBE	STAINLESS STEEL	
1	2	MDC P/N 407502	SIX WAY CROSS 1.50 TUBE	STAINLESS STEEL	
2	1	MAG-001-5519-0002	35 TURN COIL		

DOCUMENT CONTROL STAMP DCG	DIM & TOL PER ASME Y14.5 UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: FRACTIONS DECIMAL ANGLES ± N/A .XX ± .01 ± .50° .XXX ± .005	TRACKING NO. N/A	United States Department of Energy	 ACC INJECTOR BEAMLINE COMPONENTS QW QUAD- CROSS ASSEMBLY
		APPROVALS	DATE	
MATERIAL SEE PARTS LIST	THIRD ANGLE PROJECTION	DRAWN M R MAJOR	08DEC09	SIZE DWG. NO. D ACC-200-4000-1035
FINISH MACHINED SURFACES UNLESS OTHERWISE NOTED DEBURR & BREAK ALL SHARP EDGES	DO NOT SCALE DRAWING	CHECKED D. M. ANSICK	12/10/09	REV. -
		APPROVED J. RAMON	2/10/09	SCALE 1:1 USED ON ASSY NO. - SHEET 1 OF 1