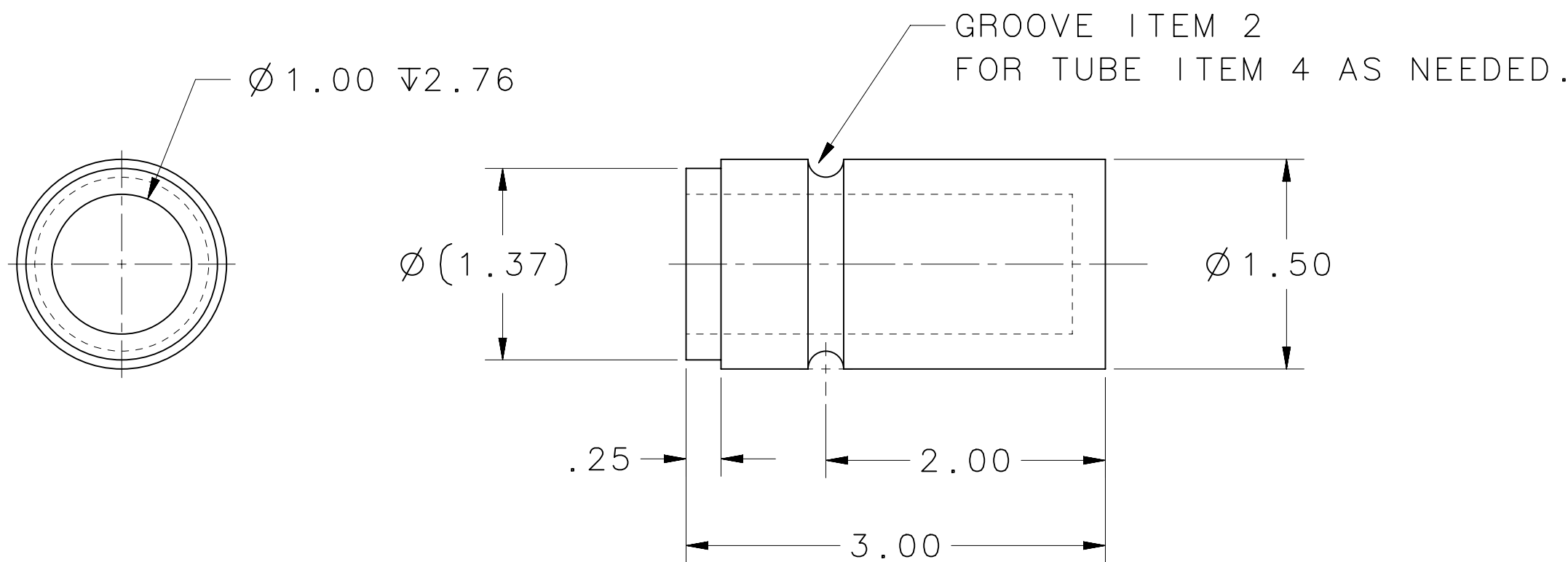


D

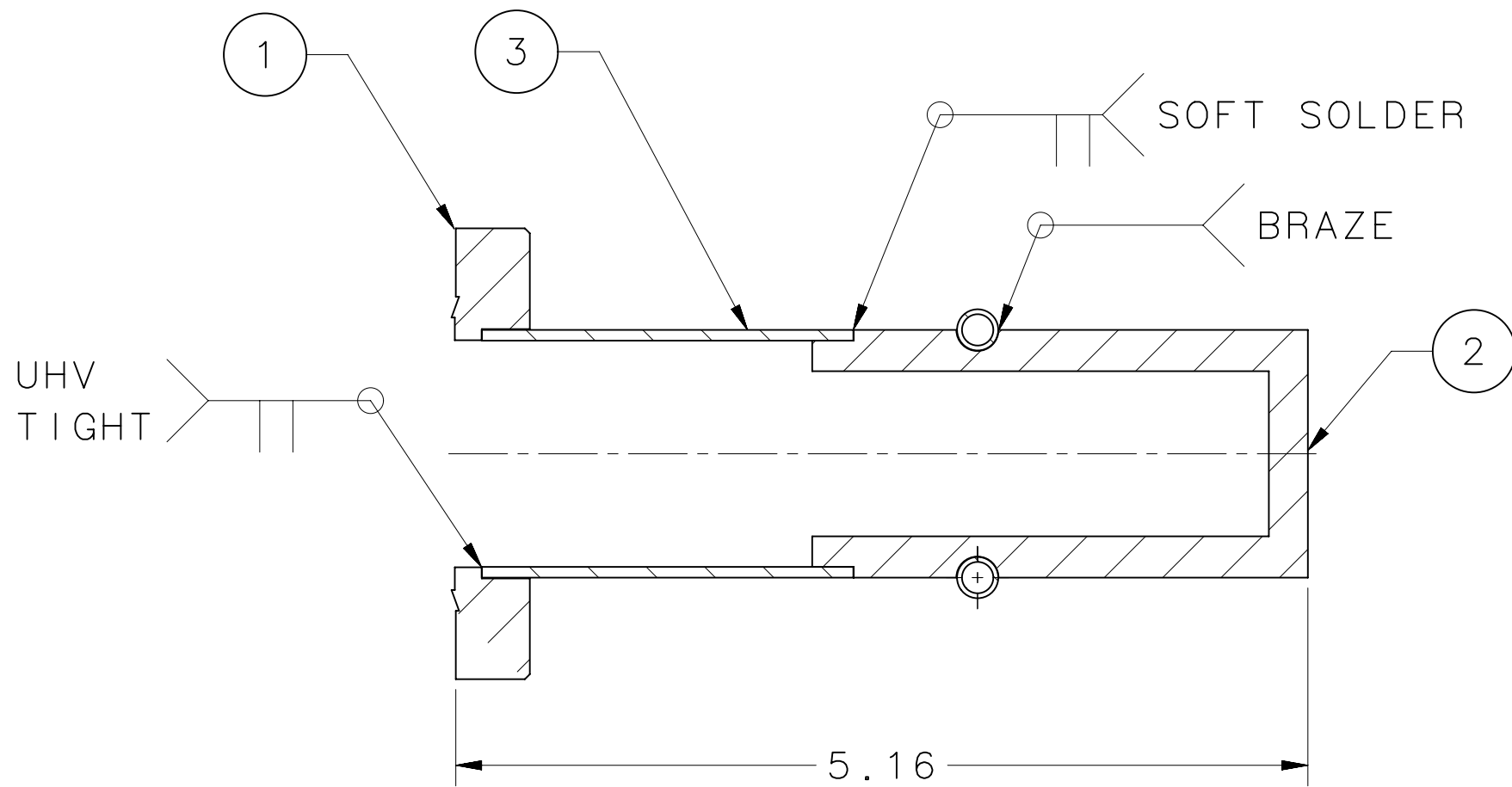
C

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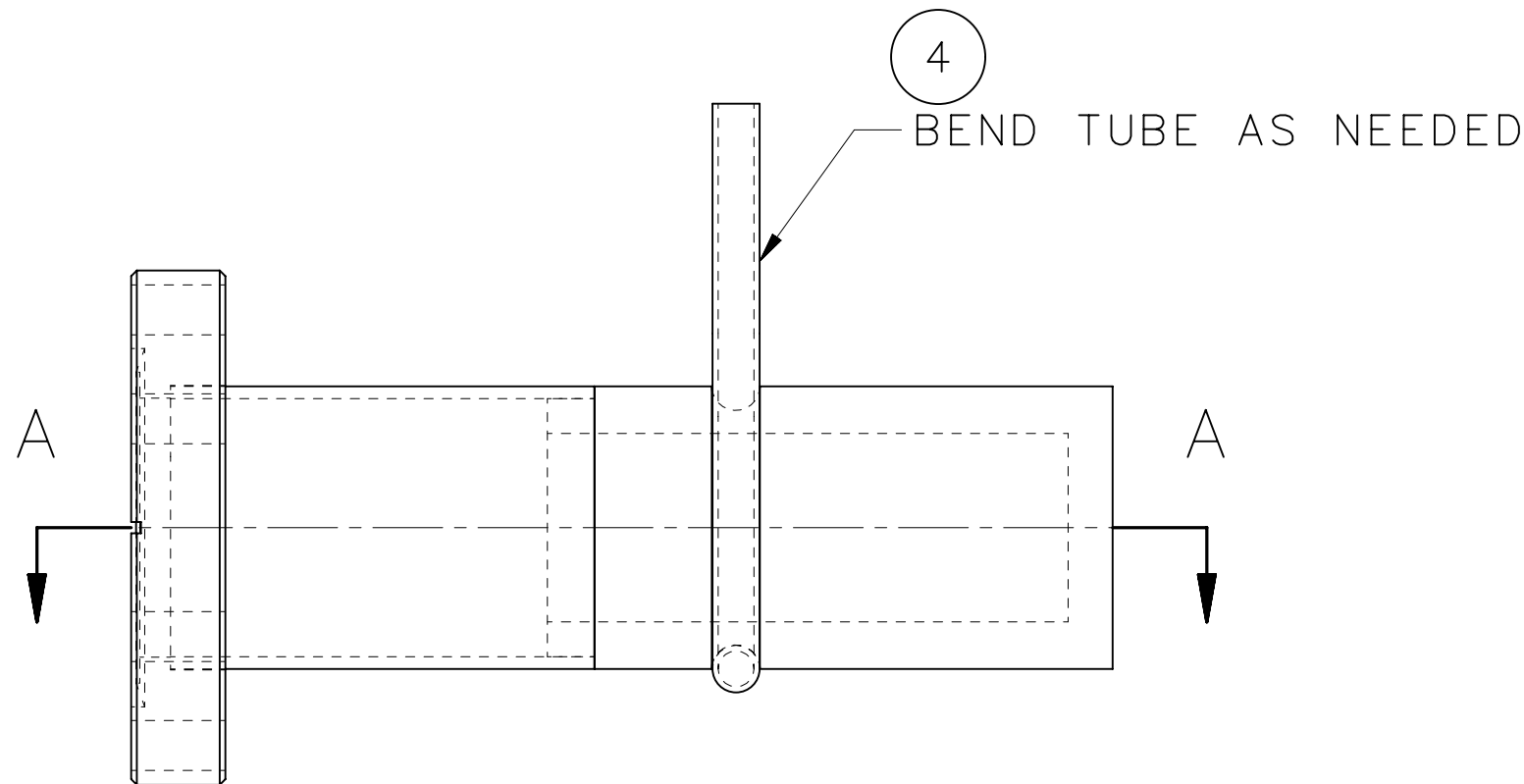
A



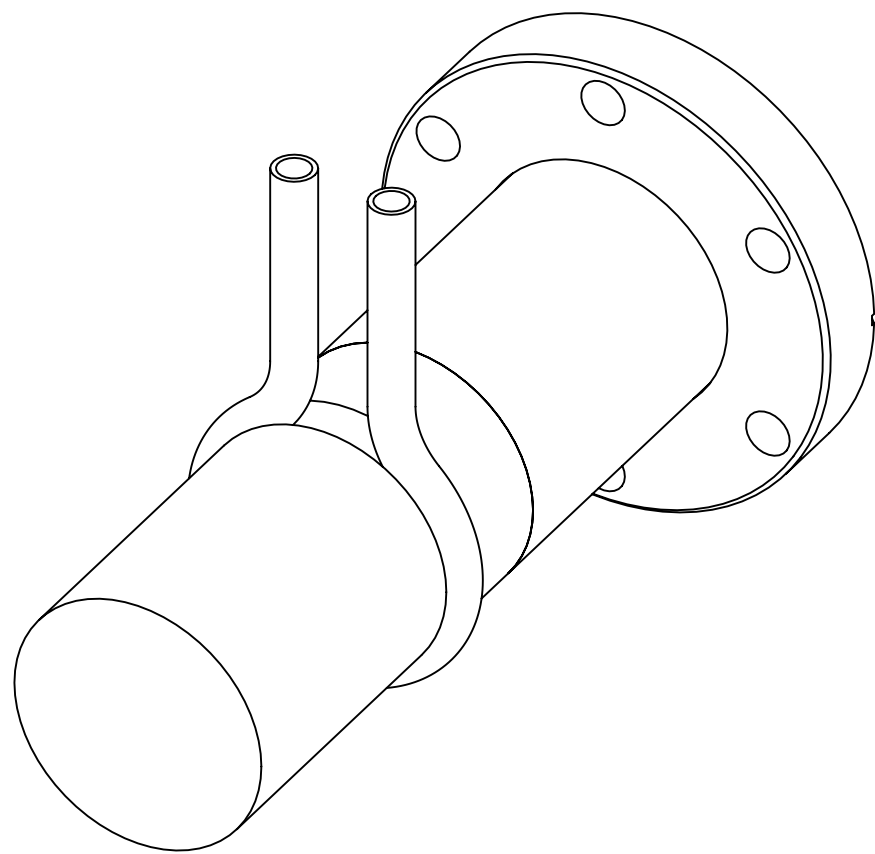
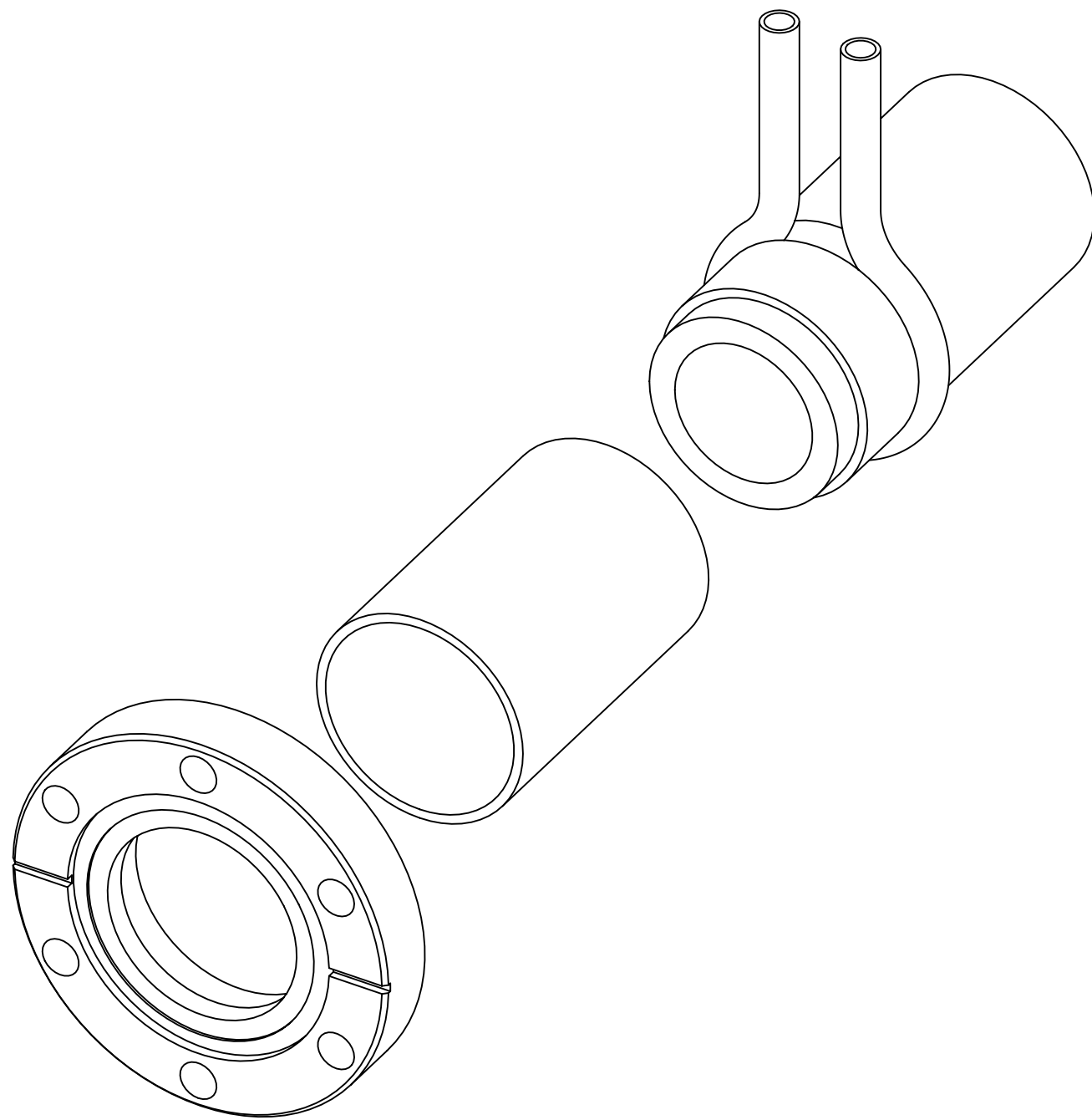
ITEM 2



SECTION A-A



BEND TUBE AS NEEDED

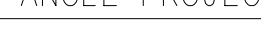


ISOMETRIC

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.

1	4	-	1/4 ACR TUBE 1/4 OD X 0.025 WALL THK	COPPER ASTM B75 C12200	-
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	-
QTY REQD	ITEM NO.	PART OR IDENTIFYING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL SPECIFICATION	NOTES

FOR JLAB INTERNAL USE ONLY			DIM & TOL PER ASME Y14.5. UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ARE: FRACTIONS DECIMAL ANGLES ± N/A .X ± .1 .XX ± .01 ± .50° .XXX ± .005		MATERIAL		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.			SEE PARTS LIST		FINISH MACHINE SURFACES DEBURR & BREAK ALL SHARP EDGES		125 UNLESS OTHERWISE NOTED		ACC INJECTOR (DETAILS & ASSEMBLIES) BUBBLE CHAMBER CU RADIATOR WINDOW ASSY			
WELD CLASS	WELD SPECIFICATION		THIRD ANGLE PROJECTION		DO NOT SCALE DRAWING		SIZE DWG. NO.		REV.			
C	BPS 026				DRAWN S.A. GREGORY		DATE 10JUN14		JL0015733		—	
	WELD ANALYSIS NA				SCALE 1:1		USED ON ASSY NO. JL0015130		SHEET 1		OF 1	