

**CHAMBER #1 ASSY**  
QTY 1

- NOTES:
- 1) VESSEL TO BE DESIGNED AND FABRICATED PER ASME SECT. VIII DIV.1
  - 2) ALL WELDING PER ASME SECT. IX & SHALL BE PERFORMED BY QUALIFIED WELDERS
  - 3) ALL DOUBLE FILLET WELDS TO BE VENTED ON OUTSIDE
  - 4) VESSEL TO BE PRESSURE TESTED TO 15 PSIG.
  - 5) HMSLT AFTER PRESSURE TEST WITH A MIN DETECTABLE LEAK RATE OF 2.0x10 E-9 STD CC/SEC.
  - 6) ITEM 5 FLANGE TO ALIGN WITH FLANGE ON CHAMBER #2
  - 7) MASK MACHINED SEAL SURFACES AND PAINT EXTERIOR SURFACES ONLY

ITEM	QTY	PART NUMBER	DESCRIPTION
5	1	4000 Body Flange DWG-06	SA105, Forged Ring to finish at : 1.50" thk x 44.62"OD x 39.50"OD
6	1	4000 Lifting Eye DWG-04	SA36, 3/8" thk x 2 63" x 4.55"
8	2	4000 Support Base DWG-04	SA36, 1/2" thk x 5.00" x 35.00" Lg.
9	2	400x400 Angles DWG-04	SA36, 4" x 4" x 3/8" thk x 20 ft RL
11	1	4000 Chamber v2 DWG-02	SA516 Gr70, 1/4" x laser cut to 68.37" x 125.13" Lg.
12	1	4000 F&D Head DWG-03	SA516 CR.70. ASME F&D Head, 39.50" min ID x 188" min. thk w/ 2" SF
13	1	4000 Head Nozzle DWG-05	SA312 TP304/304L, Pipe, 14" SCH10S x 3" Lg.
14	1	F1650X1400R	SA240 304/304L, 16.5" OD ROTATABLE CF Flange, 14.0" Nom Bore w/ Cir Hoies
15	1	4000 Shell Nozzle DWG-05	SA249 TP304/304L, TUBE, 8" OD x .12" Wall x 4"
16	1	F1000X800N	SA240 304/304L, 10" OD NON-ROTATABLE CF Flange, 8" Nom Bore w/ Cir hoies
17	2	4000 Tank Cradle DWG-04	SA36, 1/4" x 6" x 120" Lg.
18	2	4000 Lifting Eye Base DWG-04	SA36, 1/4" x 6.50" x 18" Lg.

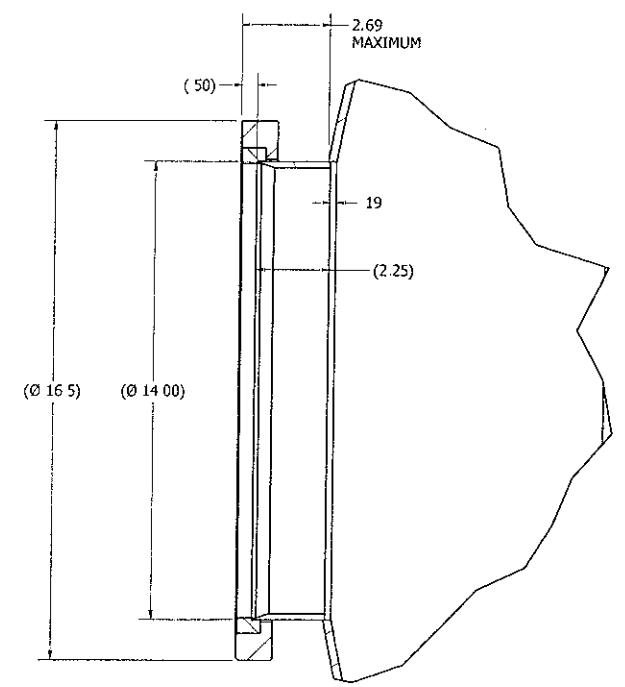
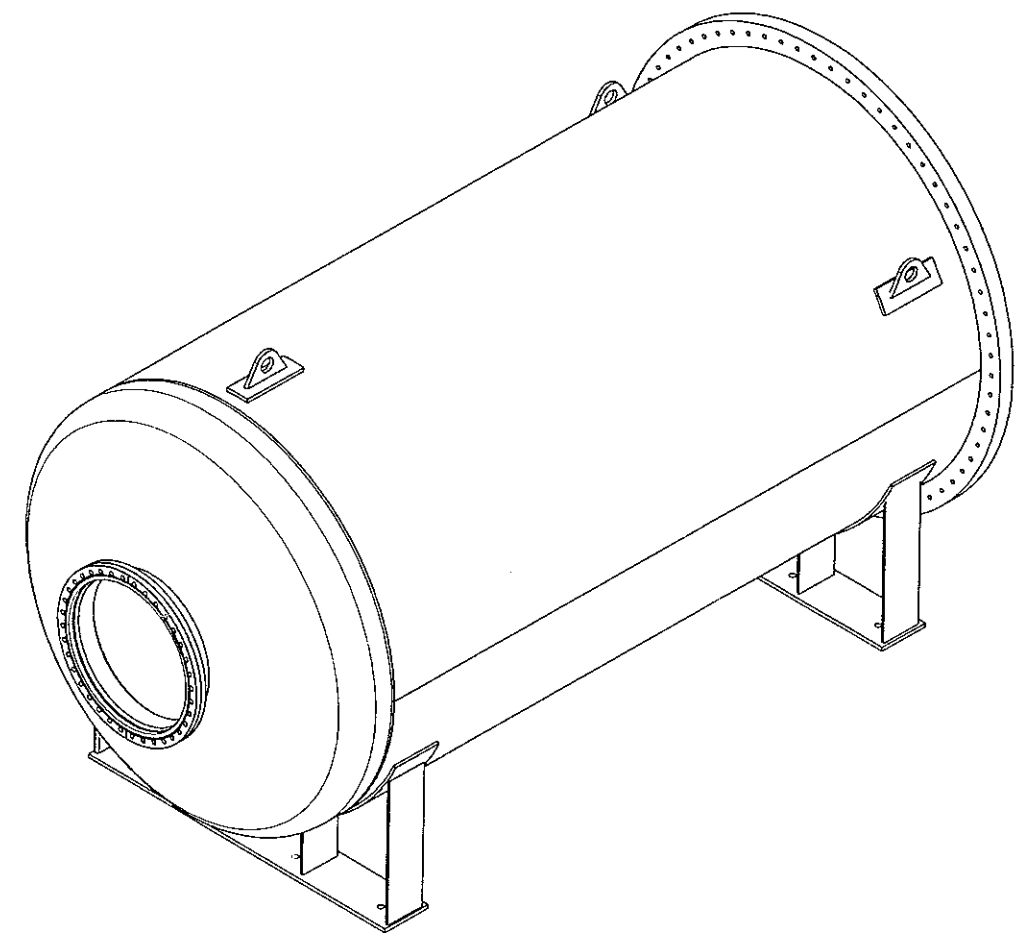
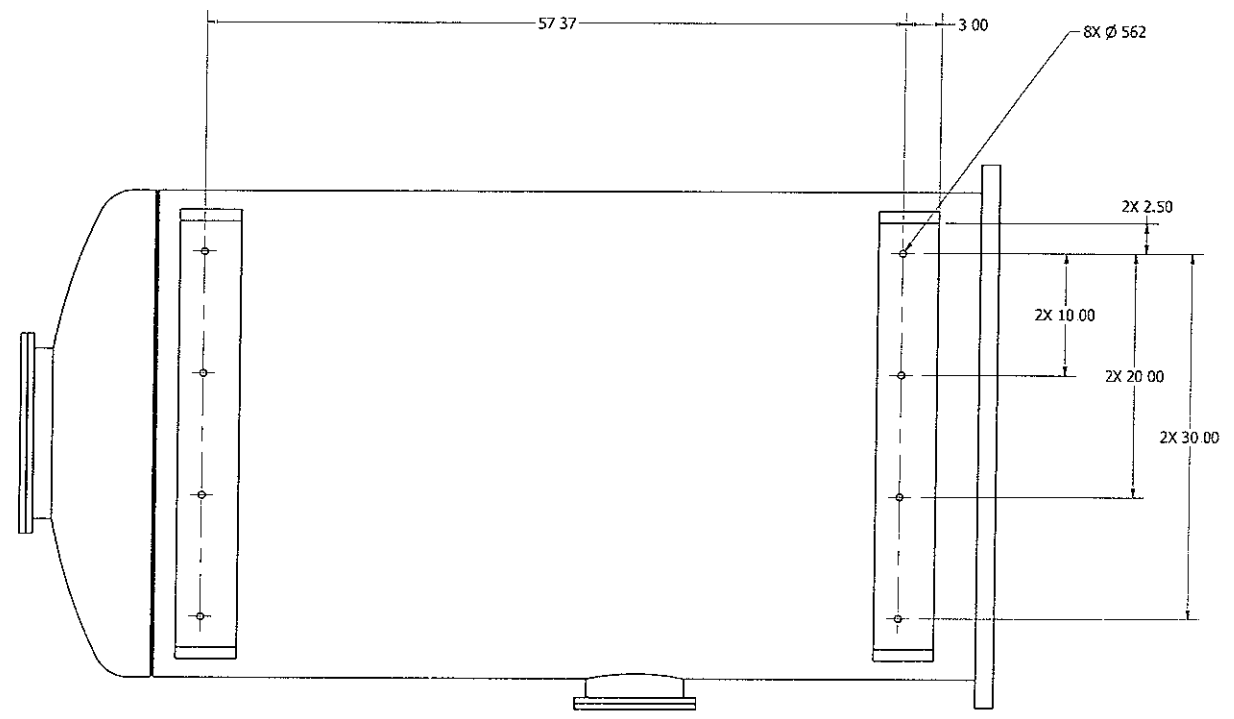
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UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES  
TOLERANCES ON:  
DECIMALS .x 1 ANGLES ± 0.5 deg  
.xx .01 FRACTIONS xxx 005 1/16  
MACHINE FINISH 63 RMS

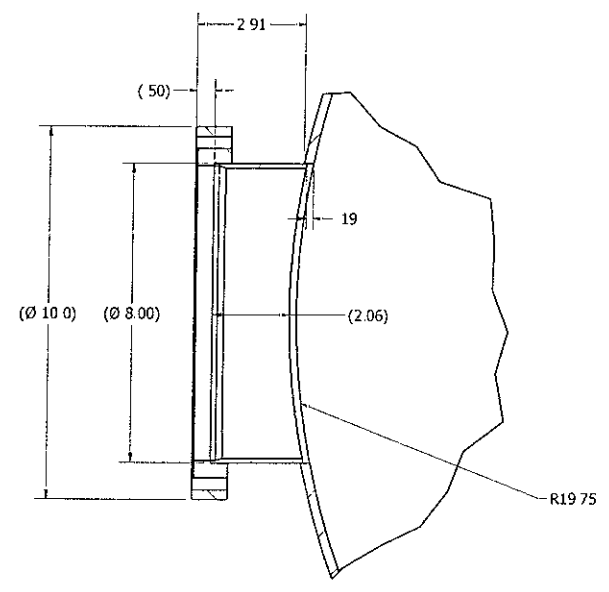
DRAWN JJS 12/23/2014  
CHECKED  
APPROVED

**Meyer Tool & Mfg., Inc.**  
TITLE  
CHAMBER #1 WELDMENT.  
PROTON-RADIUS VACUUM CHAMBER

SIZE D DWG NO 2351-01 REV 0  
SCALE SHEET 1 OF 3



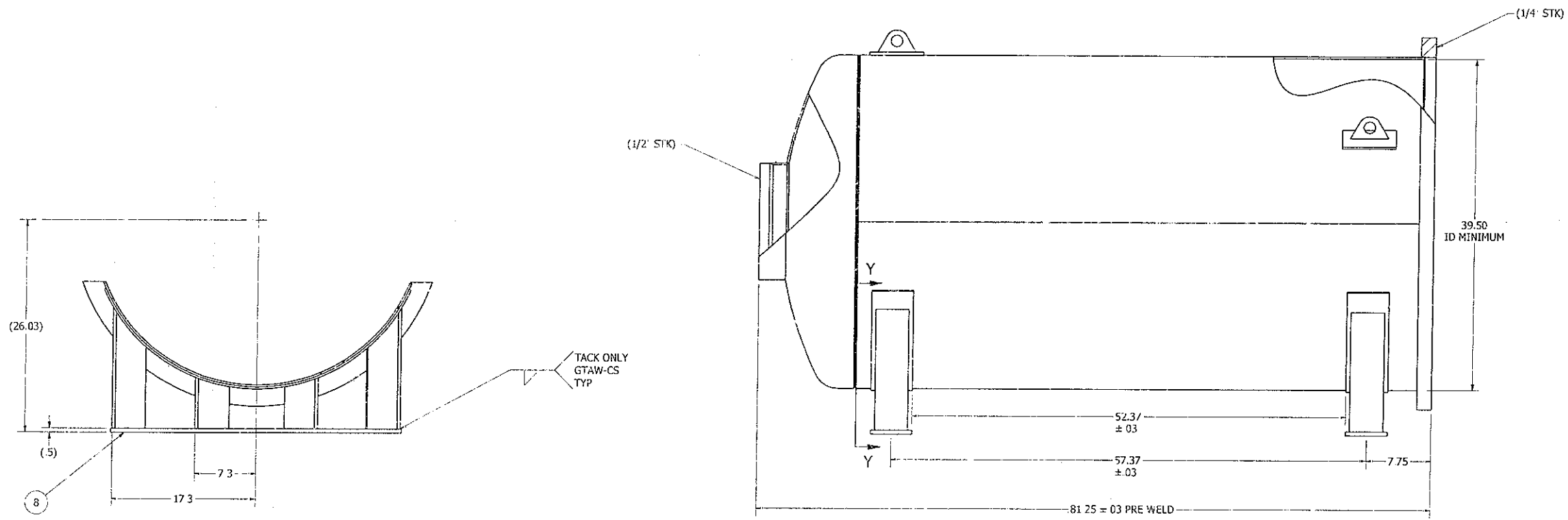
ITEM 01-13 AND 01-14 DETAIL



ITEM 01-15 AND 01-16 DETAIL

NOTE:  
1 SEE SHEET 1 FOR WELD DETAILS.

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	SIZE D	DWG NO 2351-01	REV 0
	SCALE	SHEET 2 OF 3	
	1		



SECTION Y-Y  
SCALE 0 13 : 1

DETAIL OF CHAMBER WITH PRE-MACHINE DIMENSIONS

**NOTE:**

- ITEM 09 LEGS ARE LONG WITH MACHINING STOCK. ITEM 08 BASE IS ONLY TACK WELDED TO LEGS FOR INITIAL MACHINING SET UP. REVIEW TRAVELER -0002 OP 90.

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED
A	Added support leg location dimensions	1/15/2015	<i>[Signature]</i>

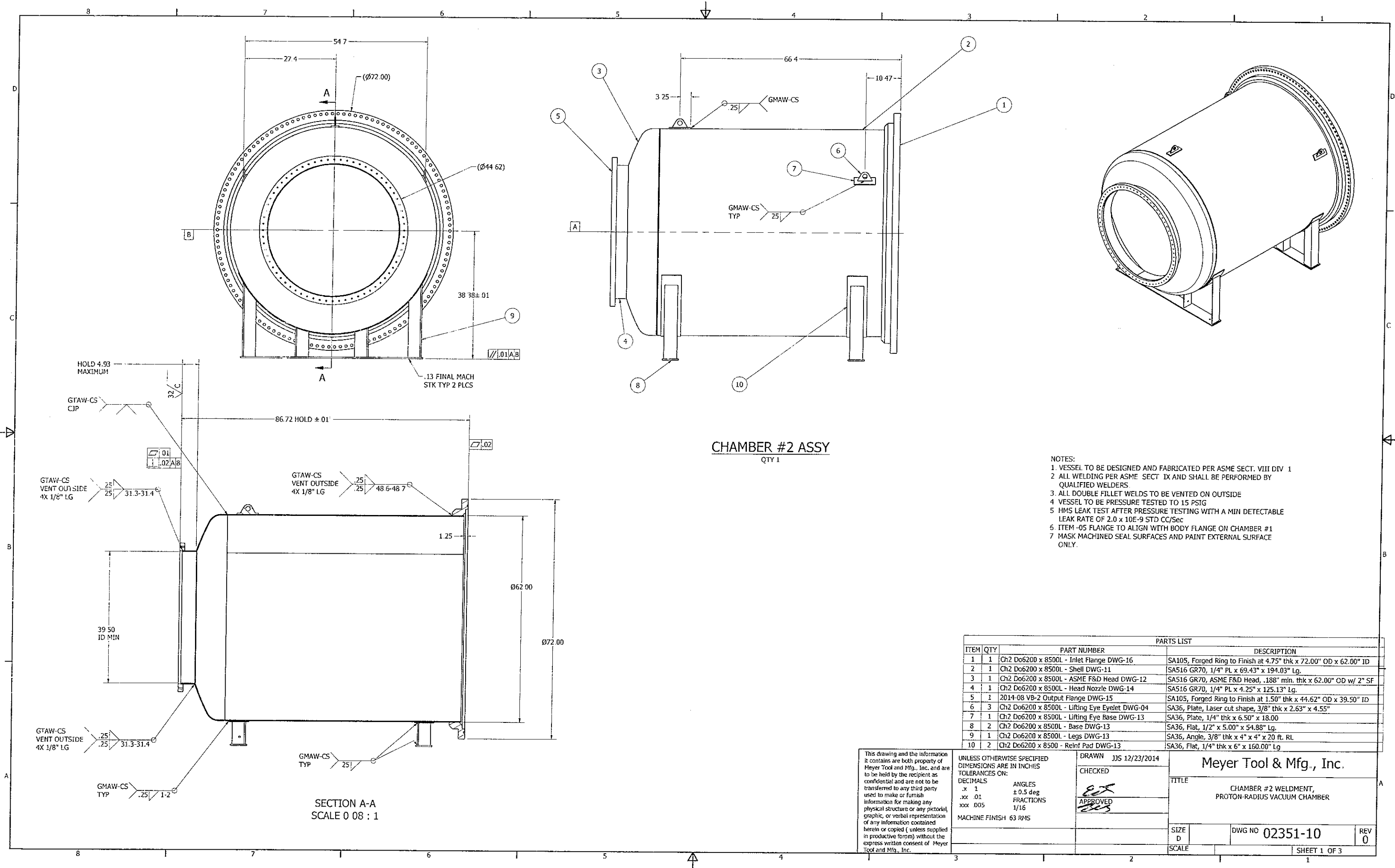
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TOLERANCES ON:  
DECIMALS      ANGLES  
.x 1              ± 0.5 deg  
.xx .01          FRACTIONS  
.xxx .005       1/16  
MACHINE FINISH 63 RMS

DRAWN JJS 12/23/2014  
CHECKED  
*[Signature]*  
APPROVED  
*[Signature]*

Meyer Tool & Mfg., Inc.  
TITLE  
CHAMBER #1 WELDMENT,  
PROTON-RADIUS VACUUM CHAMBER

SIZE D      DWG NO 2351-01      REV A  
SCALE      SHEET 3 OF 3



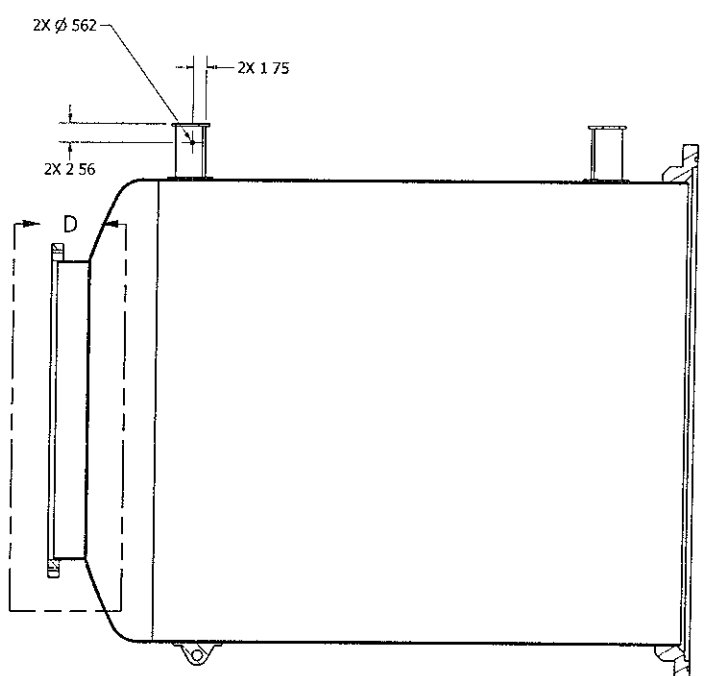
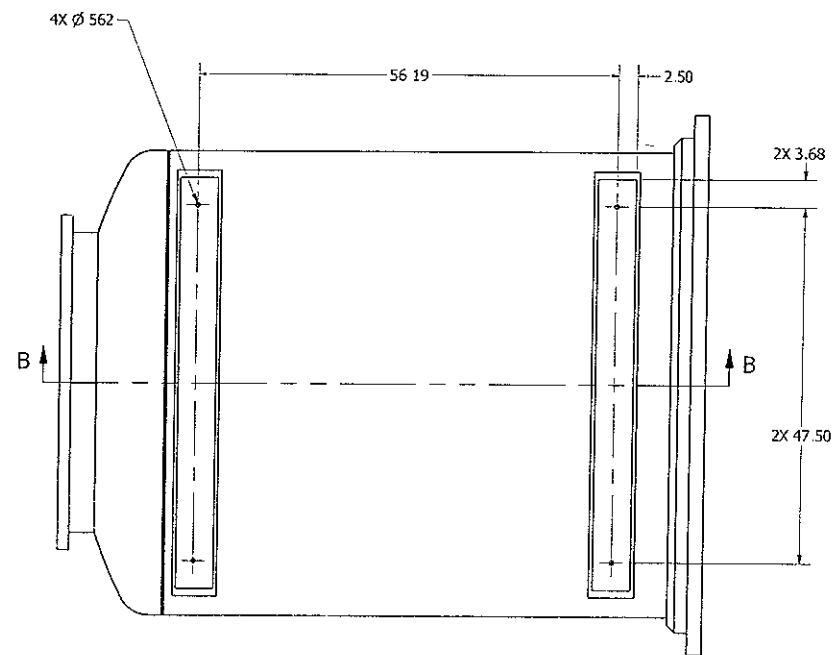
ITEM QTY		PART NUMBER	DESCRIPTION
1	1	Ch2 Do6200 x 8500L - Inlet Flange DWG-16	SA105, Forged Ring to Finish at 4.75" thk x 72.00" OD x 62.00" ID
2	1	Ch2 Do6200 x 8500L - Shell DWG-11	SA516 GR70, 1/4" PL x 69.43" x 194.03" Lg.
3	1	Ch2 Do6200 x 8500L - ASME F&D Head DWG-12	SA516 GR70, ASME F&D Head, .188" min. thk x 62.00" OD w/ 2" SF
4	1	Ch2 Do6200 x 8500L - Head Nozzle DWG-14	SA516 GR70, 1/4" PL x 4.25" x 125.13" Lg.
5	1	2014-08 VB-2 Output Flange DWG-15	SA105, Forged Ring to Finish at 1.50" thk x 44.62" OD x 39.50" ID
6	3	Ch2 Do6200 x 8500L - Lifting Eye Eyelet DWG-04	SA36, Plate, Laser cut shape, 3/8" thk x 2.63" x 4.55"
7	1	Ch2 Do6200 x 8500L - Lifting Eye Base DWG-13	SA36, Plate, 1/4" thk x 6.50" x 18.00
8	2	Ch2 Do6200 x 8500L - Base DWG-13	SA36, Flat, 1/2" x 5.00" x 54.88" Lg.
9	1	Ch2 Do6200 x 8500L - Legs DWG-13	SA36, Angle, 3/8" thk x 4" x 4" x 20 ft. RL
10	2	Ch2 Do6200 x 8500L - Reinf Pad DWG-13	SA36, Flat, 1/4" thk x 6" x 160.00" Lg

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UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON:  
 DECIMALS .x 1  
 .xx .01  
 .xxx .005  
 ANGLES ± 0.5 deg  
 FRACTIONS 1/16  
 MACHINE FINISH 63 RMS

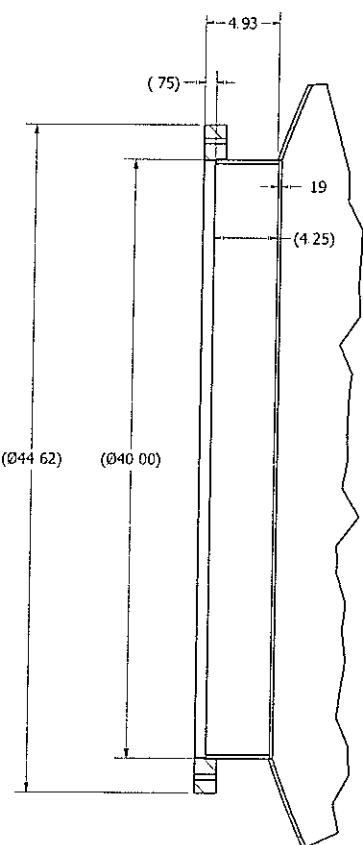
DRAWN JJS 12/23/2014  
 CHECKED  
 APPROVED

**Meyer Tool & Mfg., Inc.**  
 TITLE CHAMBER #2 WELDMENT, PROTON-RADIUS VACUUM CHAMBER  
 SIZE D DWG NO 02351-10 REV 0  
 SCALE SHEET 1 OF 3



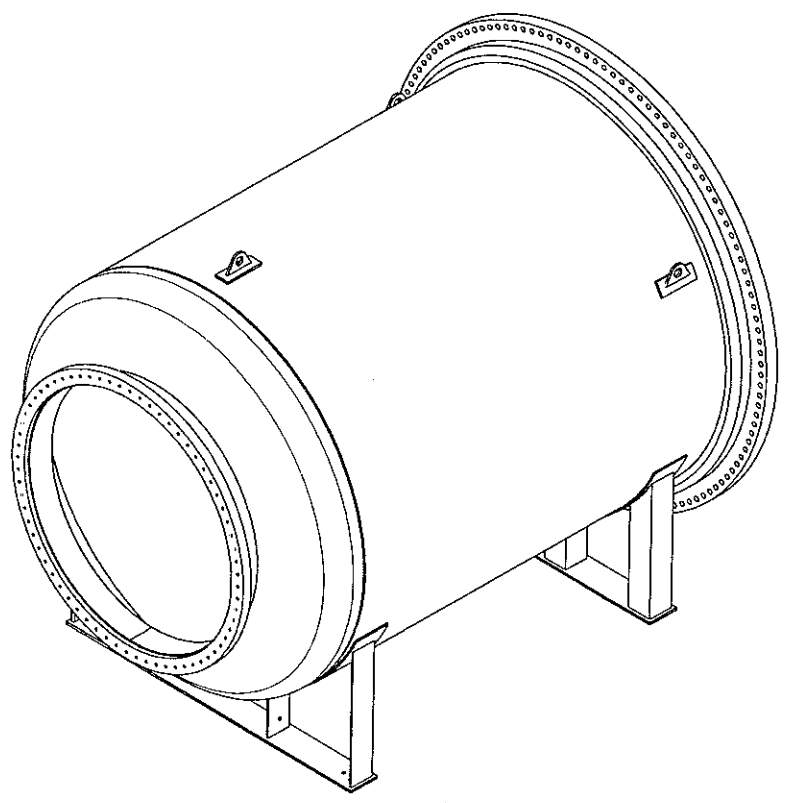
SECTION B-B  
SCALE 0.08 : 1

SUPPORT BASE HOLES DETAIL

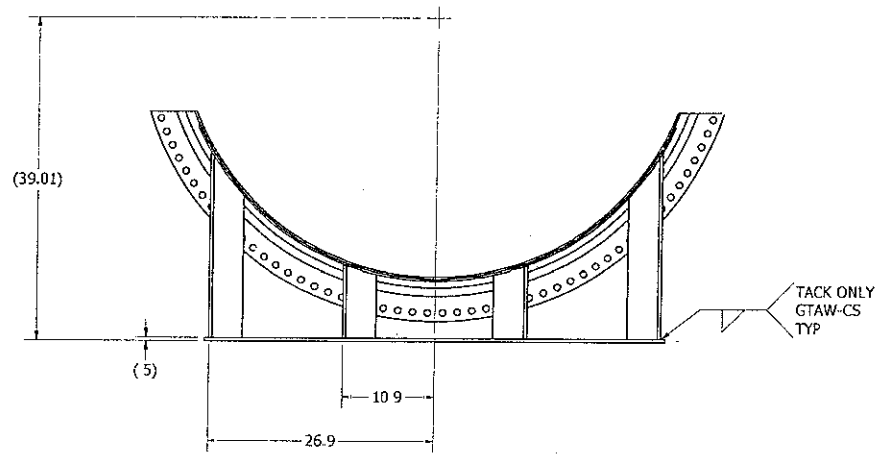


DETAIL D  
SCALE 0.16 : 1

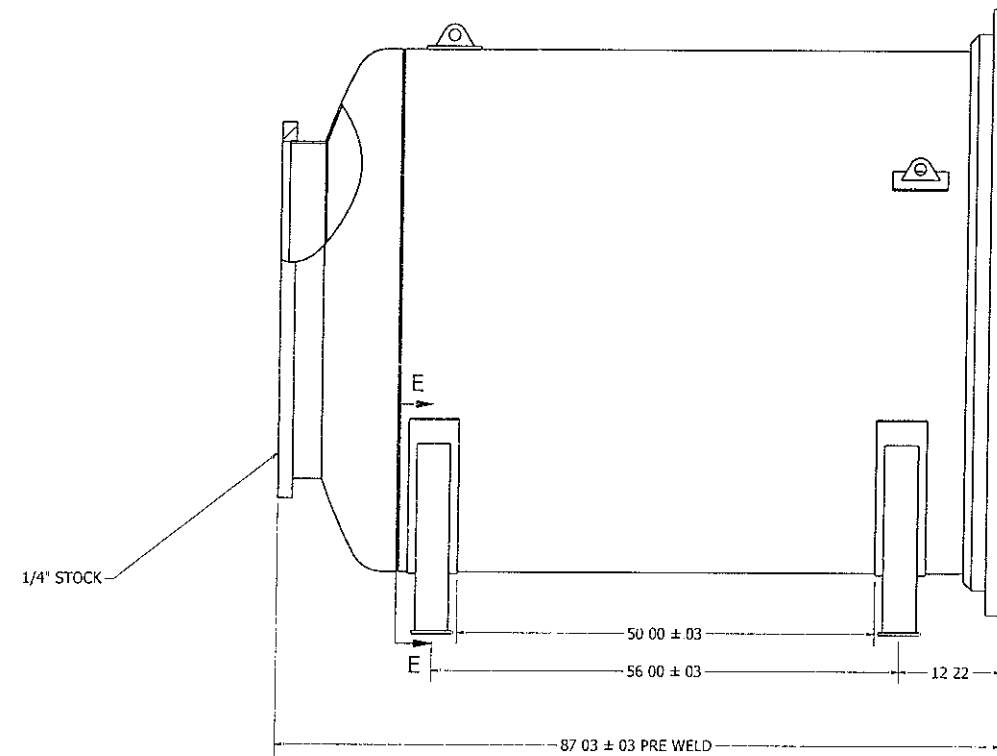
NOTES:  
1. SEE SHEET 1 FOR WELD DETAILS



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	SIZE D	DWG NO 02351-10	REV 0
	SCALE	SHEET 2 OF 3	



SECTION E-E  
SCALE 0.09 : 1



DETAIL OF CHAMBER PRE-MACHINE DIMENSIONS

NOTE:  
1. ITEM 09 LEGS ARE LONG WITH MACHINING STOCK.  
ITEM 08 BASE IS ONLY TACK WELDED TO LEGS FOR  
INITIAL MACHINING SETUP. REVIEW TRAVELER -0003  
FOR DETAILS.

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	SIZE D SCALE	DWG NO 02351-10 REV 0	SHEET 3 OF 3