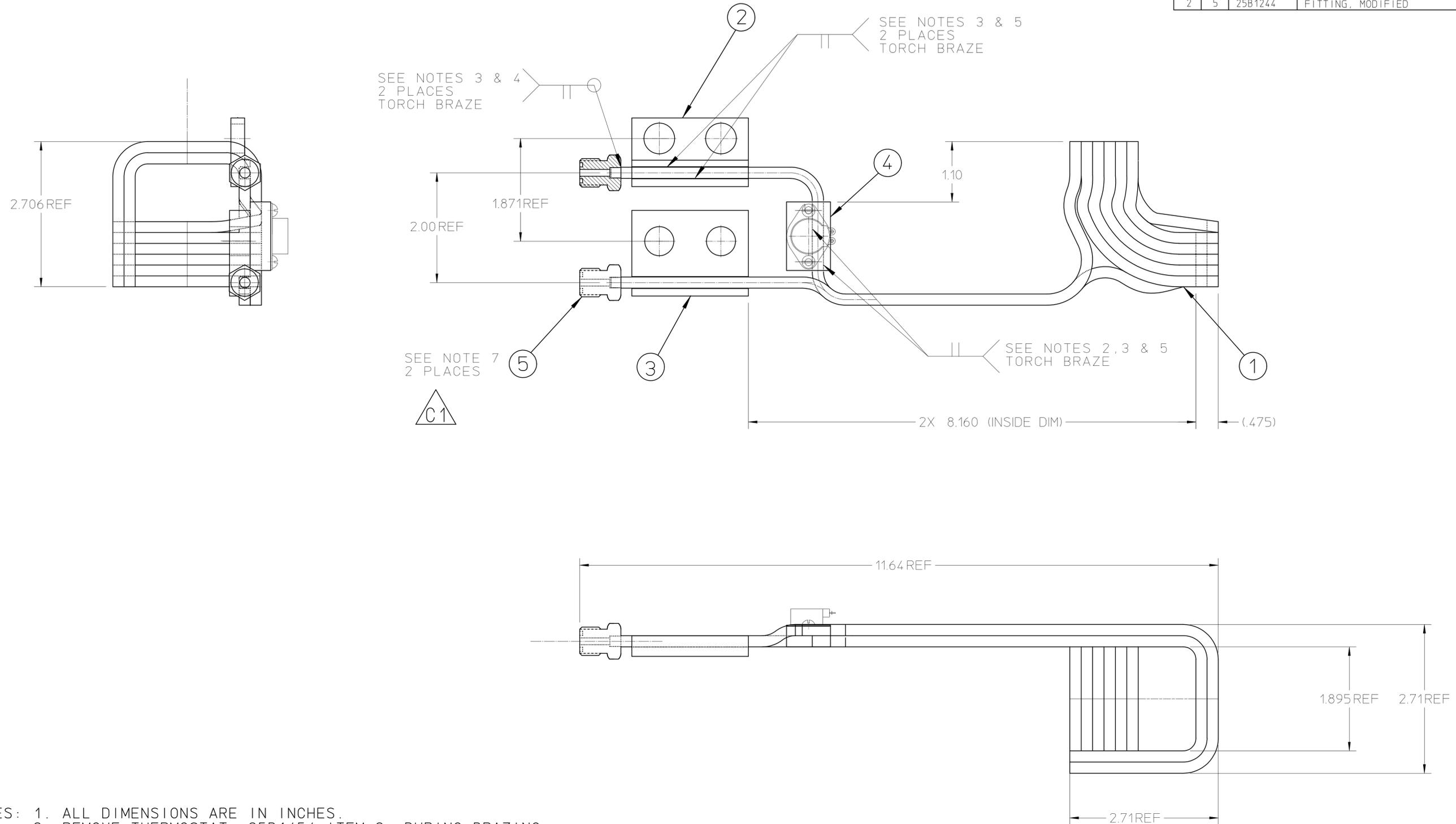


REQ	ITEM	PART NUMBER	DESCRIPTION
1	1	25B1624	RIGHT COIL WINDING - TERMINAL DETAIL
1	2	25B1404	CENTER OVERLAP FLAG
1	3	25B1204	NARROW LOWER FLAG
1	4	25B1454	THERMOSTAT ASSEMBLY
2	5	25B1244	FITTING, MODIFIED



- NOTES:
- ALL DIMENSIONS ARE IN INCHES.
  - REMOVE THERMOSTAT, 25B1454 ITEM 2, DURING BRAZING AND PLATING OPERATIONS.
  - BRAZE PER LBNL SPEC: M912.
  - PRESSURE AND FLOW TEST PER LBNL SPEC: M912.
  - AFTER BRAZING, REPAIR KAPTON INSULATION AS REQUIRED. THEN WRAP LEADS FROM COIL TO TERMINALS WITH B-STAGE EPOXY-FIBERGLASS INSULATION. BUILD UP TO BE .015/.0.30 ON ALL SURFACES. CURE AS REQUIRED.
  - SILVER PLATE PER DRAWING 25B1064, AFTER BRAZING AND EPOXY-FIBERGLASS APPLICATION.
  - VERIFY FEMALE THREAD ENGAGEMENT WITH ITEMS 5 AFTER PLATING.

REV	DWG	CHK	ZONE	DATE	CHANGES	TOLERANCES	UNLESS OTHERWISE SPECIFIED	SHOP ORDERS	LAWRENCE BERKELEY LABORATORY					
E	PL	PL		06-05-02	PLATING SPECIFICATION DRAWING 25B1064 ADDED TO NOTE 6.	.X ± -	FRAC. ± 1/64	ACCT. NO.	UNIVERSITY OF CALIFORNIA-BERKELEY					
D	PL	PL		06-04-02	ITEM 5, 25B1244, WAS 25D0853-1. QTY 2 WAS 1. NOTES 6 AND 7 CLARIFIED.	.XX ± .02	ANGLES ± 1°	DATE ISSD	DATE RECD	SERIAL NO.	NO. RECD.	SNS - FES MEBT		
C1	YM		A8	11-9-00	CHANGED NOTE 6 FOR PLATING	.XXX ± .005	FINISH 125	DELIVER TO	MECHANICAL BEAM TRANSPORT SYSTEMS - QUADS			LOWER LEFT COIL ASSEMBLY		
C1	YM		C6	11-9-00	ADDED NOTE 7 TO PART NO. 5	THREADS ARE CLASS 2		SURFACE TREATMENT		DEGREASE		PATENT CLEAR		
B1	YM		D3	4-24-00	WAS PART NO. 25B1244	CHAMFER ENDS OF ALL SCREW THREADS 30°		IDENT. METH.		TAG		DWG. TYPE	SHOWN ON	
A1	YM		D3	3-2-00	WAS PART NO. 25B1294	CUT 1.5 PITCH THRU RELIEF WITH ROUND NOSE TOOL ON MACHINE CUT THREADS.		BY		Y. MINAMIHARA	DATE	12-15-99	SCALE	FULL
						BREAK EDGES .016 MAX. ON MACHINED WORK		DATE				FE3312	DWG. NO.	25B1504
						REMOVE BURRS WELD SPLATTER & LOOSE SCALE		CHK. BY				FE3312	SIZE	E
						REFERENCES: ANSI Y14.5 & B46.1.							REV.	

25B1504E