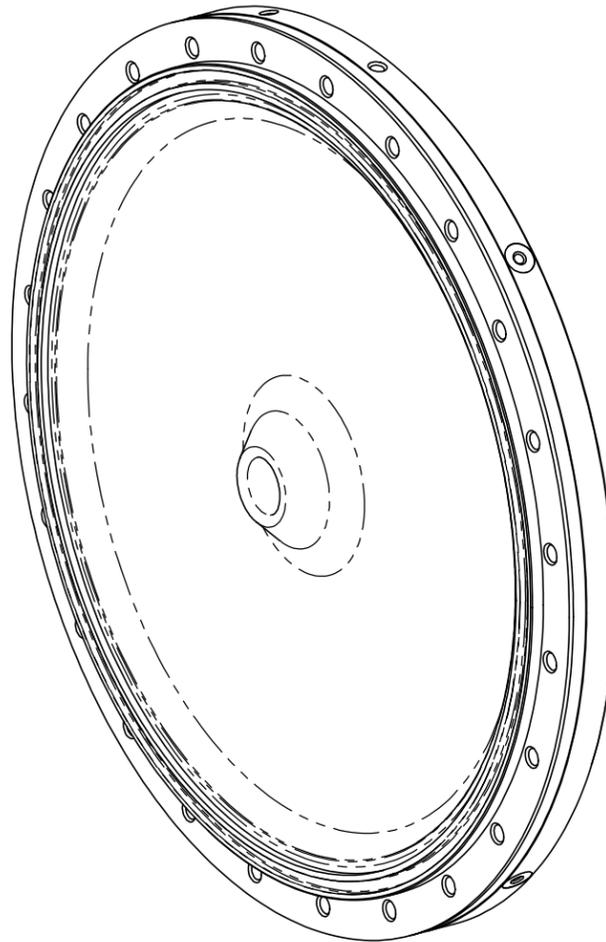
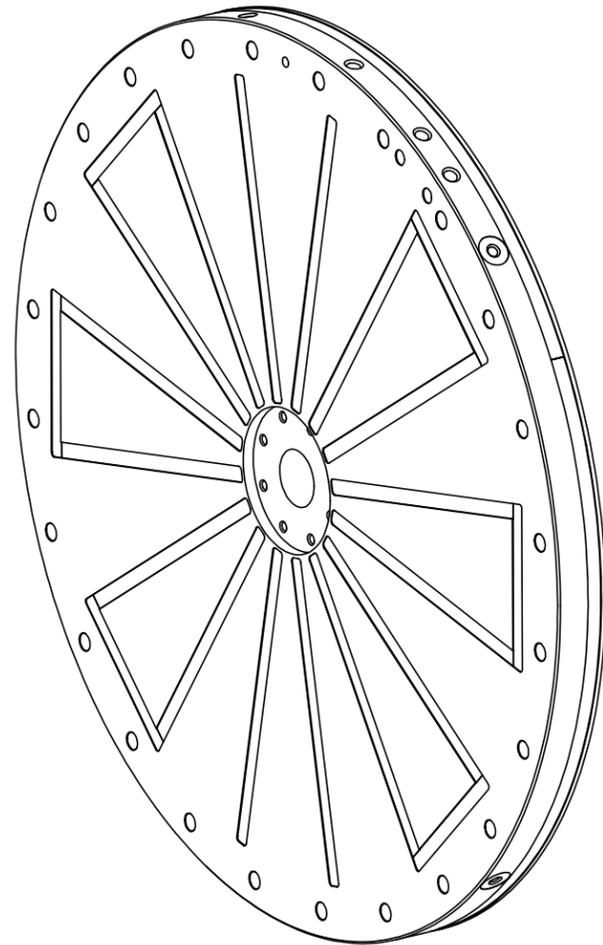


8 7 6 5 4 3 2 1

REVISIONS					
ZONE	REV	DESCRIPTION	CHANGED BY	DATE	CLASS REVIEW APPROVED
	A	INITIAL RELEASE (SEE TITLE BLOCK)			



ISO VIEWS
FOR REF ONLY

NOTE:
THE FOLLOWING ARE THE ONLY THINGS THAT ARE DIFFERENT FROM THE 30 MM BORE CAVITY:

- NOSE CONTOUR
- DIAMETER OF AXIAL C'BORE
- ROTATION ANGLE OF .250-28 BOLT CIRCLE
- DIAMETER OF .250-28 BOLT CIRCLE
- DEPTH OF .250-28 HOLES

REFER TO THE DRAWINGS FOR THE 30 MM BORE CAVITY FOR DETAILS NOT SHOWN ON THIS DRAWING. THE 30 MM BORE CAVITY WELDMENT DRAWINGS ARE: JPAW-BC-003 AND JPAW-BC-004.

WELDMENT WEIGHT: 106.714 LBS

FOR TECHNICAL QUESTIONS, CONTACT: JIM POTTER 505-690-8701

01 BUNCHER CAVITY, 36 MM BORE: NARROW SIDE WELDMENT

QTY	PART/DRAWING #	DESCRIPTION	MATERIAL	ITEM #
1	JPAW-BC-016, ITEM 01	BUNCHER CAVITY, 36 MM BORE; NARROW SIDE WELDMENT	304 STAINLESS STEEL	01

NOTES:

- 001 DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1994.
- 002 ALL INSIDE CORNERS TO BE R .015 MAX.
- 003 REMOVE ALL SHARP BURRS AND BREAK SHARP EDGES, INCLUDING HOLES .015 MAX.
- 004 DIMENSIONS APPLY AFTER PLATING.

TASK CONTRACTOR			
A FILLED IN DATE INDICATES THAT THE APPROVAL SIGNATURE HAS BEEN OBTAINED FROM THAT PERSON NR=NOT REQUIRED			
INITIAL RELEASE APPROVALS			
DESIGNED	JIM POTTER	JPAW	06/11/01
DRAWN	DANNY GALLANT	GI	06/11/01
CHECKED	JIM POTTER	JPAW	06/11/01
ENGINEERING	JIM POTTER	JPAW	06/11/01
APPROVED	JIM POTTER	JPAW	06/11/01

JP Accelerator Works
280A Central Park Square
Los Alamos, NM 87544

PROJECT: SNS
BUNCHER CAVITY, 36 MM BORE
NARROW SIDE WELDMENT
WELDMENT DETAIL

UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES. TOLERANCES ARE:
X = ± .030
XX = ± .010
XXX = ± .005

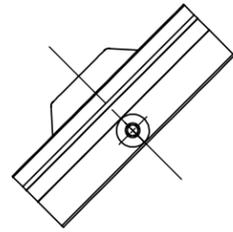
ANGULAR = ± .5°
MACHINED FINISH = 32/

SIZE D DRAWING NUMBER JPAW-BC-016 REV A

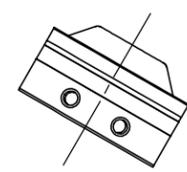
SCALE 1:2 DO NOT SCALE DRAWING SHEET 1 OF 5

8 7 6 5 4 3 2 1

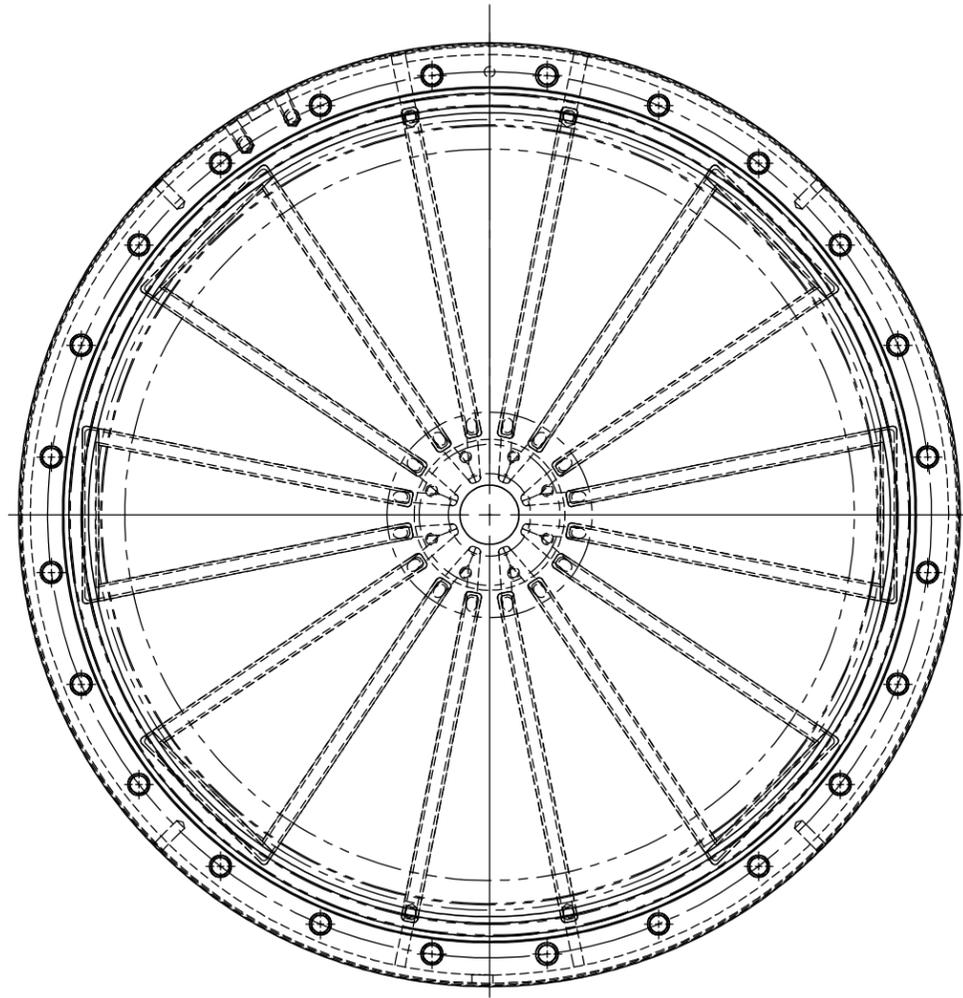
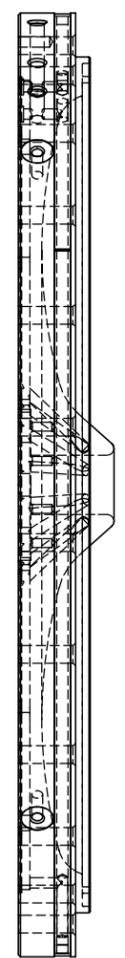
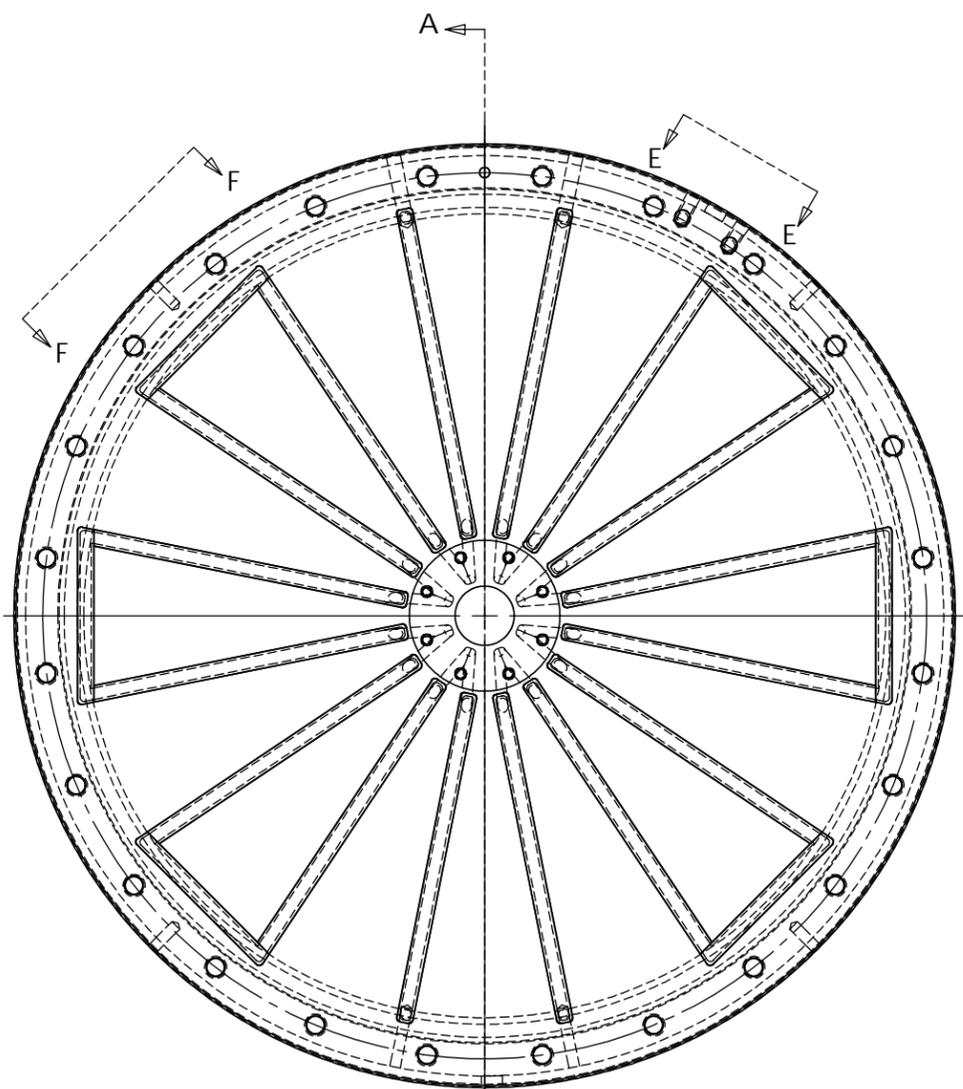
8 7 6 5 4 3 2 1



SECTION F-F



SECTION E-E



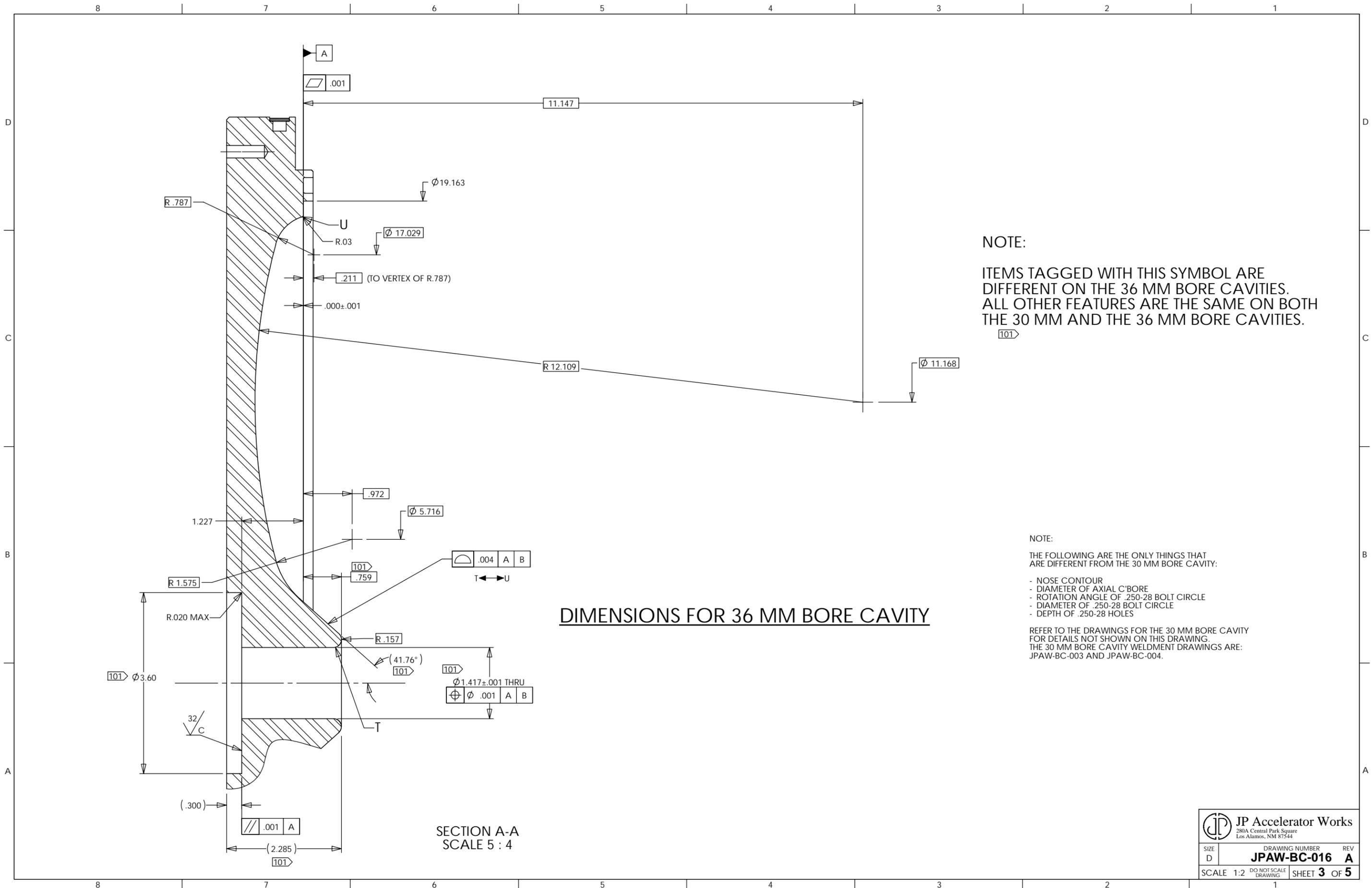
NOTE:
THE FOLLOWING ARE THE ONLY THINGS THAT ARE DIFFERENT FROM THE 30 MM BORE CAVITY:

- NOSE CONTOUR
- DIAMETER OF AXIAL C'BORE
- ROTATION ANGLE OF .250-28 BOLT CIRCLE
- DIAMETER OF .250-28 BOLT CIRCLE
- DEPTH OF .250-28 HOLES

REFER TO THE DRAWINGS FOR THE 30 MM BORE CAVITY FOR DETAILS NOT SHOWN ON THIS DRAWING. THE 30 MM BORE CAVITY WELDMENT DRAWINGS ARE: JPAW-BC-003 AND JPAW-BC-004.

<p>JP Accelerator Works 280A Central Park Square Los Alamos, NM 87544</p>		SIZE	DRAWING NUMBER	REV
		D	JPAW-BC-016	A
SCALE 1:2		DO NOT SCALE DRAWING	SHEET 2 OF 5	

8 7 6 5 4 3 2 1



NOTE:
 ITEMS TAGGED WITH THIS SYMBOL ARE DIFFERENT ON THE 36 MM BORE CAVITIES. ALL OTHER FEATURES ARE THE SAME ON BOTH THE 30 MM AND THE 36 MM BORE CAVITIES.

NOTE:
 THE FOLLOWING ARE THE ONLY THINGS THAT ARE DIFFERENT FROM THE 30 MM BORE CAVITY:

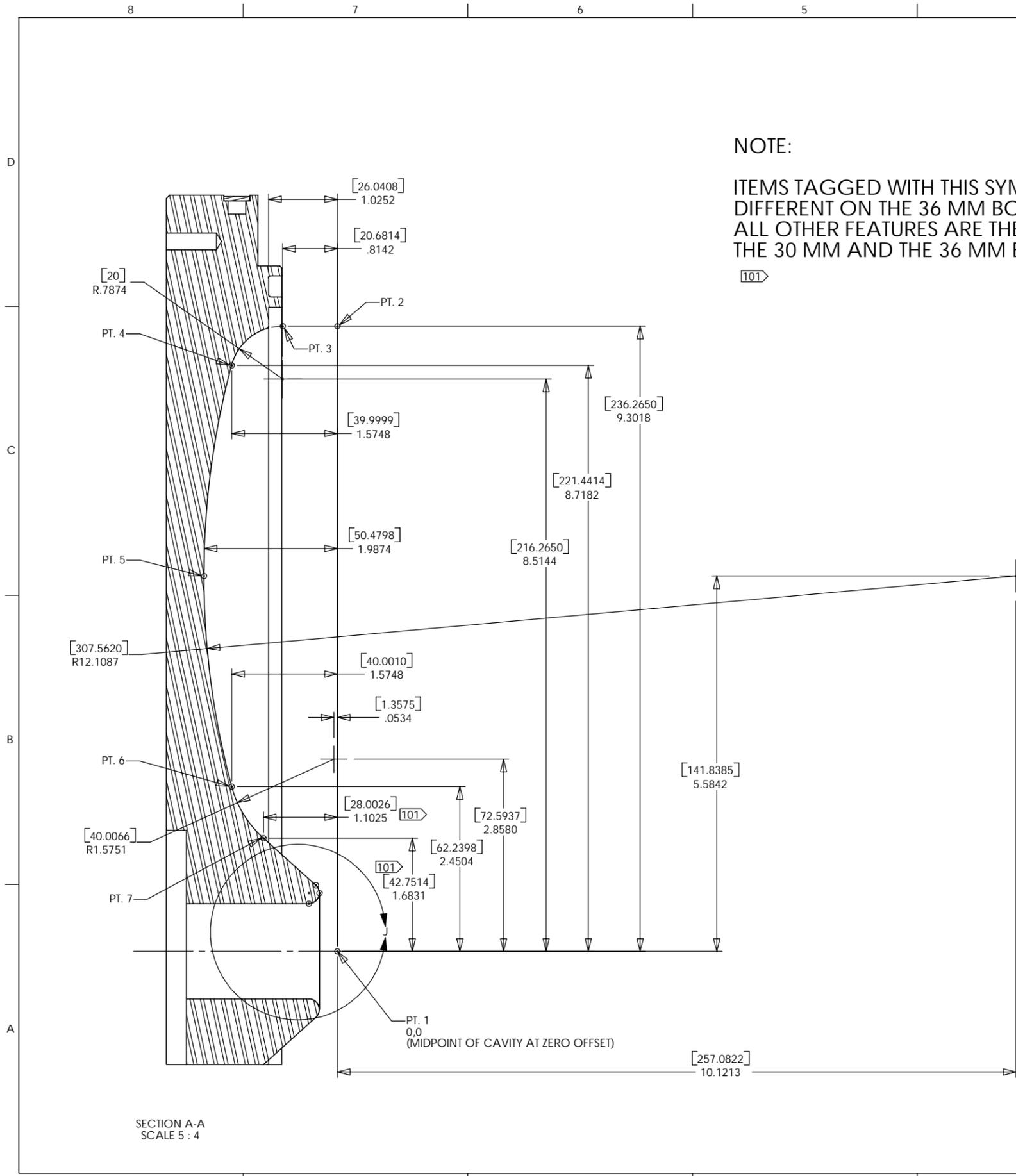
- NOSE CONTOUR
- DIAMETER OF AXIAL C'BORE
- ROTATION ANGLE OF .250-28 BOLT CIRCLE
- DIAMETER OF .250-28 BOLT CIRCLE
- DEPTH OF .250-28 HOLES

REFER TO THE DRAWINGS FOR THE 30 MM BORE CAVITY FOR DETAILS NOT SHOWN ON THIS DRAWING. THE 30 MM BORE CAVITY WELDMENT DRAWINGS ARE: JPAW-BC-003 AND JPAW-BC-004.

DIMENSIONS FOR 36 MM BORE CAVITY

SECTION A-A
 SCALE 5 : 4

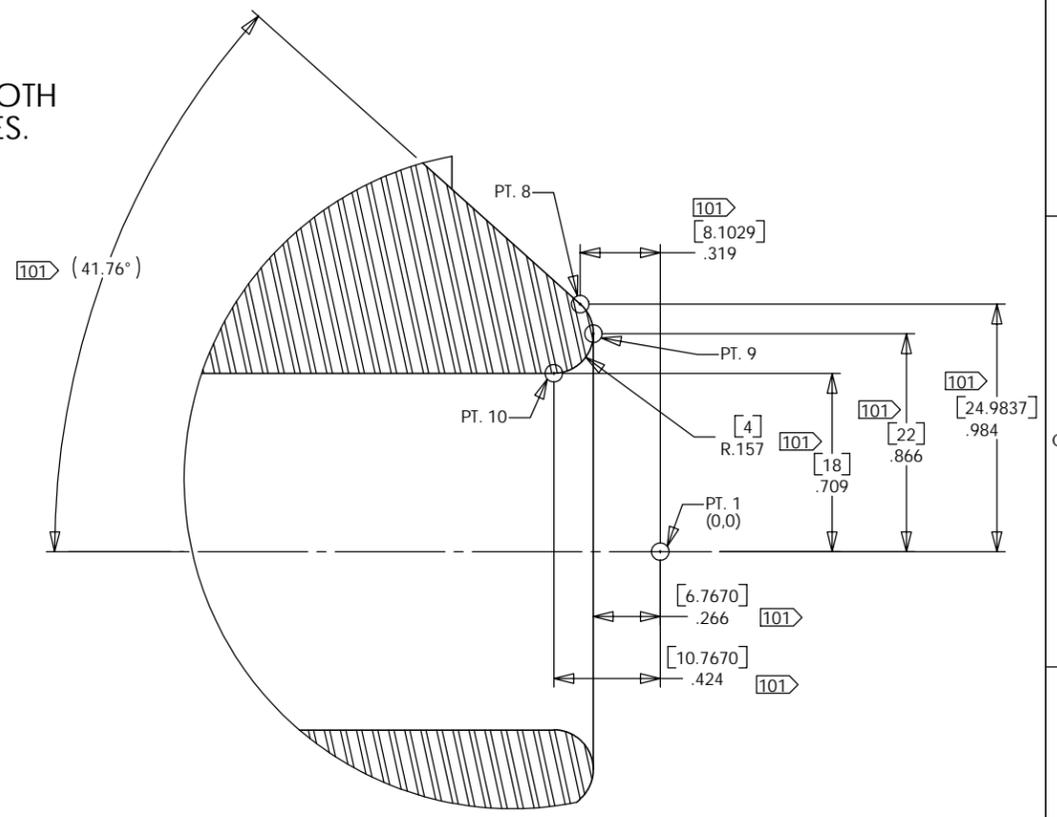
JP Accelerator Works <small>280A Central Park Square Los Alamos, NM 87544</small>		
SIZE D	DRAWING NUMBER JPAW-BC-016	REV A
SCALE 1:2 <small>DO NOT SCALE DRAWING</small>	SHEET 3 OF 5	



NOTE:

ITEMS TAGGED WITH THIS SYMBOL ARE DIFFERENT ON THE 36 MM BORE CAVITIES. ALL OTHER FEATURES ARE THE SAME ON BOTH THE 30 MM AND THE 36 MM BORE CAVITIES.

[101]



DETAIL J
SCALE 3:1

DIMENSIONS FOR 36 MM BORE CAVITY

NOTE:

THE FOLLOWING ARE THE ONLY THINGS THAT ARE DIFFERENT FROM THE 30 MM BORE CAVITY:

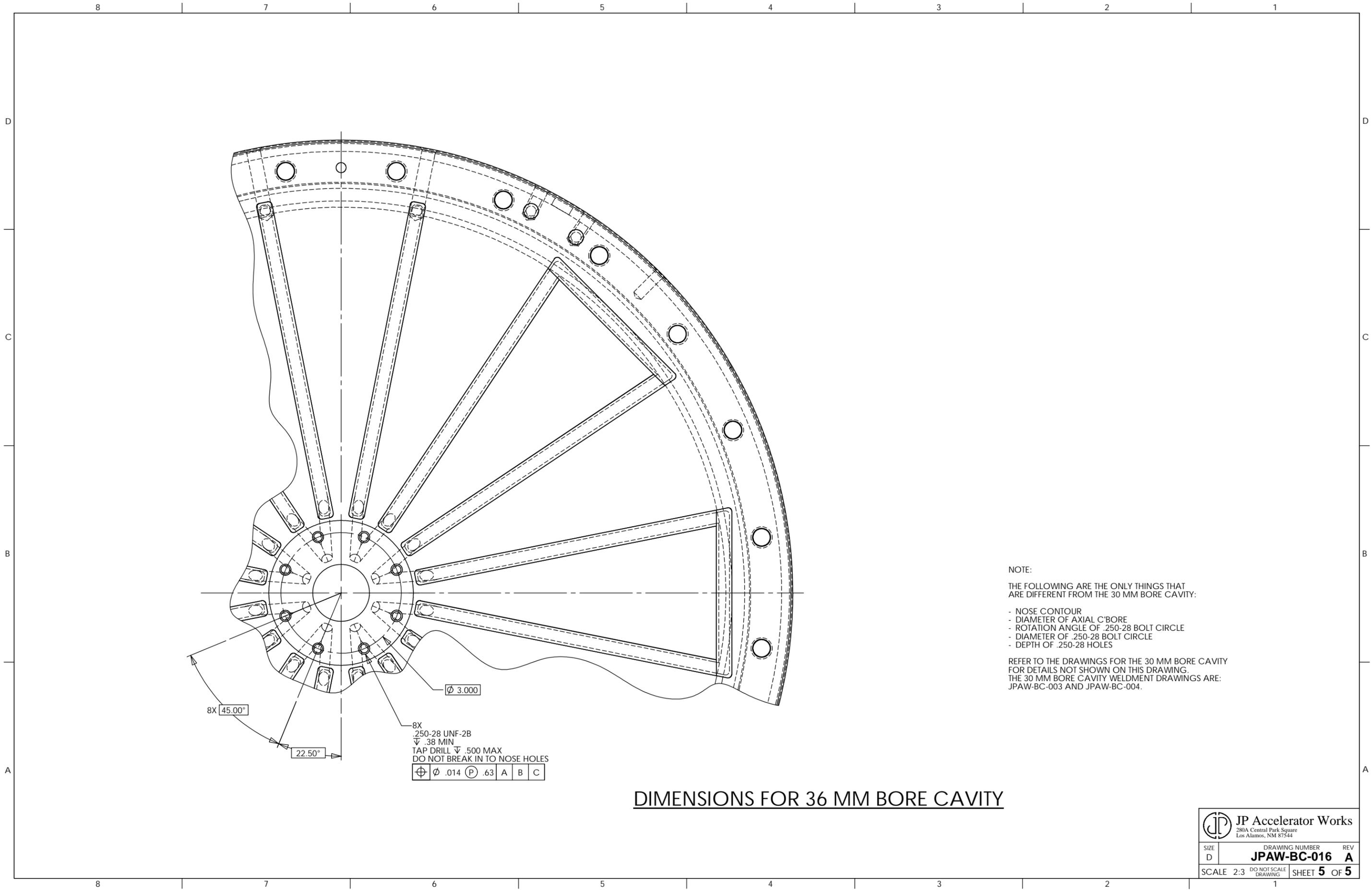
- NOSE CONTOUR
- DIAMETER OF AXIAL C'BORE
- ROTATION ANGLE OF .250-28 BOLT CIRCLE
- DIAMETER OF .250-28 BOLT CIRCLE
- DEPTH OF .250-28 HOLES

REFER TO THE DRAWINGS FOR THE 30 MM BORE CAVITY FOR DETAILS NOT SHOWN ON THIS DRAWING. THE 30 MM BORE CAVITY WELDMENT DRAWINGS ARE: JPAW-BC-003 AND JPAW-BC-004.

REFERENCE SHEET ONLY

- USE TO VERIFY CAVITY PROFILE.
- MAY BE USED AS A PROGRAMMING REFERENCE FOR FABRICATION.
- TOLERANCES SHOWN ON THE OTHER SHEETS TAKE PRECEDENCE.

<p>JP Accelerator Works 280A Central Park Square Los Alamos, NM 87544</p>		
SIZE D	DRAWING NUMBER JPAW-BC-016	REV A
SCALE 1:2 DO NOT SCALE DRAWING	SHEET 4 OF 5	



NOTE:
 THE FOLLOWING ARE THE ONLY THINGS THAT
 ARE DIFFERENT FROM THE 30 MM BORE CAVITY:

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- DIAMETER OF AXIAL C'BORE
- ROTATION ANGLE OF .250-28 BOLT CIRCLE
- DIAMETER OF .250-28 BOLT CIRCLE
- DEPTH OF .250-28 HOLES

REFER TO THE DRAWINGS FOR THE 30 MM BORE CAVITY
 FOR DETAILS NOT SHOWN ON THIS DRAWING.
 THE 30 MM BORE CAVITY WELDMENT DRAWINGS ARE:
 JPAW-BC-003 AND JPAW-BC-004.

8X 45.00°

22.50°

Ø 3.000

8X
 .250-28 UNF-2B
 .38 MIN
 TAP DRILL .500 MAX
 DO NOT BREAK IN TO NOSE HOLES

⊕	Ø .014	Ⓟ	.63	A	B	C
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DIMENSIONS FOR 36 MM BORE CAVITY

 JP Accelerator Works <small>280A Central Park Square Los Alamos, NM 87544</small>		
SIZE D	DRAWING NUMBER JPAW-BC-016	REV A
SCALE 2:3 DO NOT SCALE DRAWING	SHEET 5 OF 5	