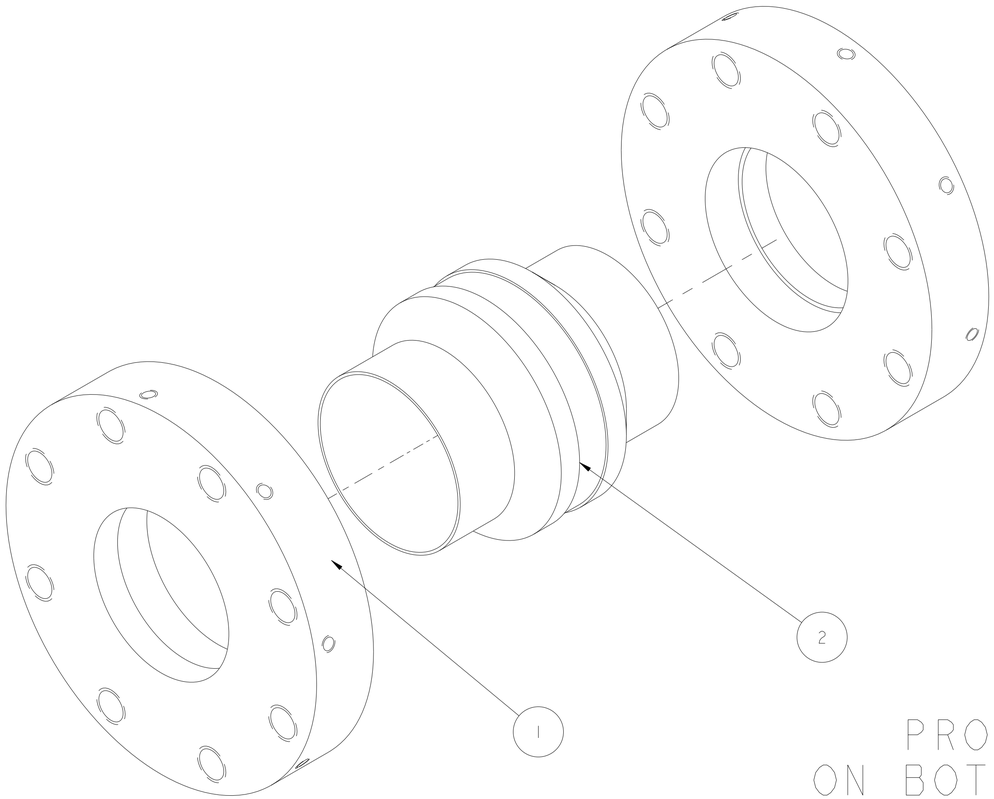
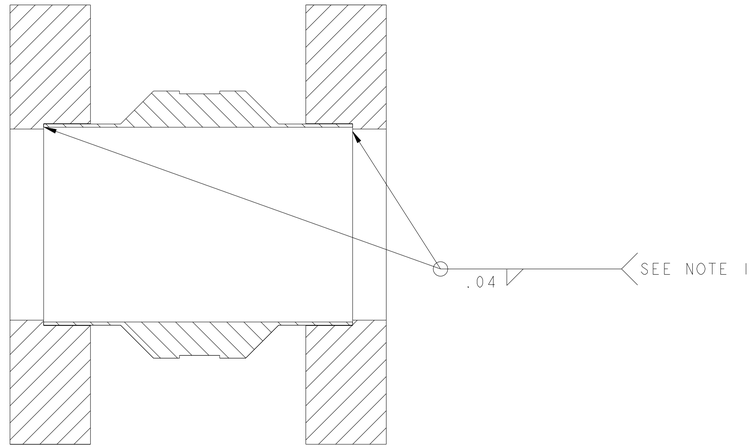
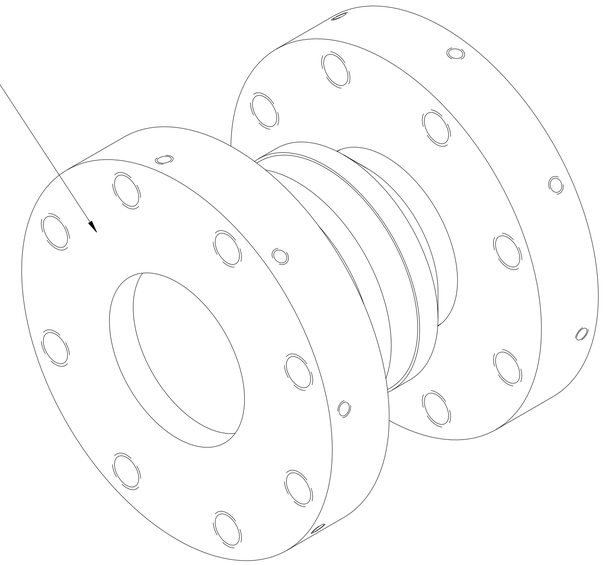
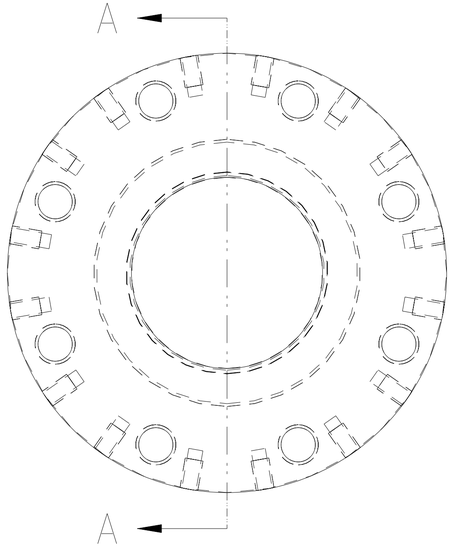


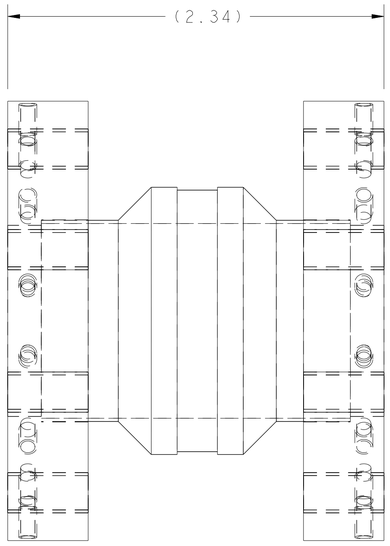


SECTION A - A

PROTECT O-RING SEAL SURFACE
ON BOTH FLANGES DURING WELDING







NOTES
1. FINISHED PART TO BE VACUUM TIGHT. LEAK RATE NOT TO EXCEED 1 x 10^{-8} torr - l/sec He.
2. BAG AFTER WELDING TO MAINTAIN HIGH VACUUM CLEANLINESS

REV	DWG	CHK	ZONE	DATE	CHANGES

UNLESS OTHERWISE SPECIFIED
PROJECTION:
TOLERANCES: X.X ± 0.1 | FRAC. ± 1/64 | X.XX ± 0.03 | Angles ± 1.0° | X.XXX ± 0.010 | FINISH 125
DO NOT SCALE PRINT
THREADS ARE CLASS 2
CHAMFER ENDS OF ALL SCREW TREADS 30°
CUT ROUND, 1.5 THREAD RELIEF ON MACHINED THREADS
BREAK EDGES .016 MAX. ON MACHINED WORK
REMOVE BURRS, WELD SPLATTER & LOOSE SCALE
IN ACCORDANCE WITH ASME Y14.5M & B46.1

ITEM	PART NO	REQD	DESCRIPTION	MATERIAL
2	CERAMASEAL 9999-03-W	1	ELECTRIC ISOLATOR VACUUM PIPE	KOVAR & ALUMINA OXIDE
1	25B192	2	BCM 2 THREADED O-RING FLANGE	316 STAINLESS STEEL

SHOP ORDERS
ACCT NO. -
NO. REQD -
SER NO. -
DATE ISSD -
DEL TO -
DATE REQD -
SURFACE TREATMT ULTRA HIGH VACUUM CLEANING
IDENT METHOD TAG
PROJECT NUMBER na
PROJECT NAME SPALLATION NEUTRON SOURCE
DWG BY TREVOR GOULDING DATE 22-Mar-00
CHK BY DARYL OSHATZ DATE -
APR BY DARYL OSHATZ DATE -

ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY
UNIVERSITY OF CALIFORNIA - BERKELEY

SNS-FES MEBT
MECHANICAL SUBSYSTEMS
BCM 2 ISOLATOR PIPE WITH O-RING FLANGES

MICROFILMED: | PATENT CLEAR: | DWG. TYPE ASSEM | DESIGN ACCT. NO. - | SHOWN ON - | CATEGORY CODE FE3313 | SCALE: 2/1 | DO NOT SCALE PRINTS | SHEET 1 OF 1 | DWG. NO. 25B1964 | SIZE A | REV.

Dwg. File: 25B196 Model File: 25B196