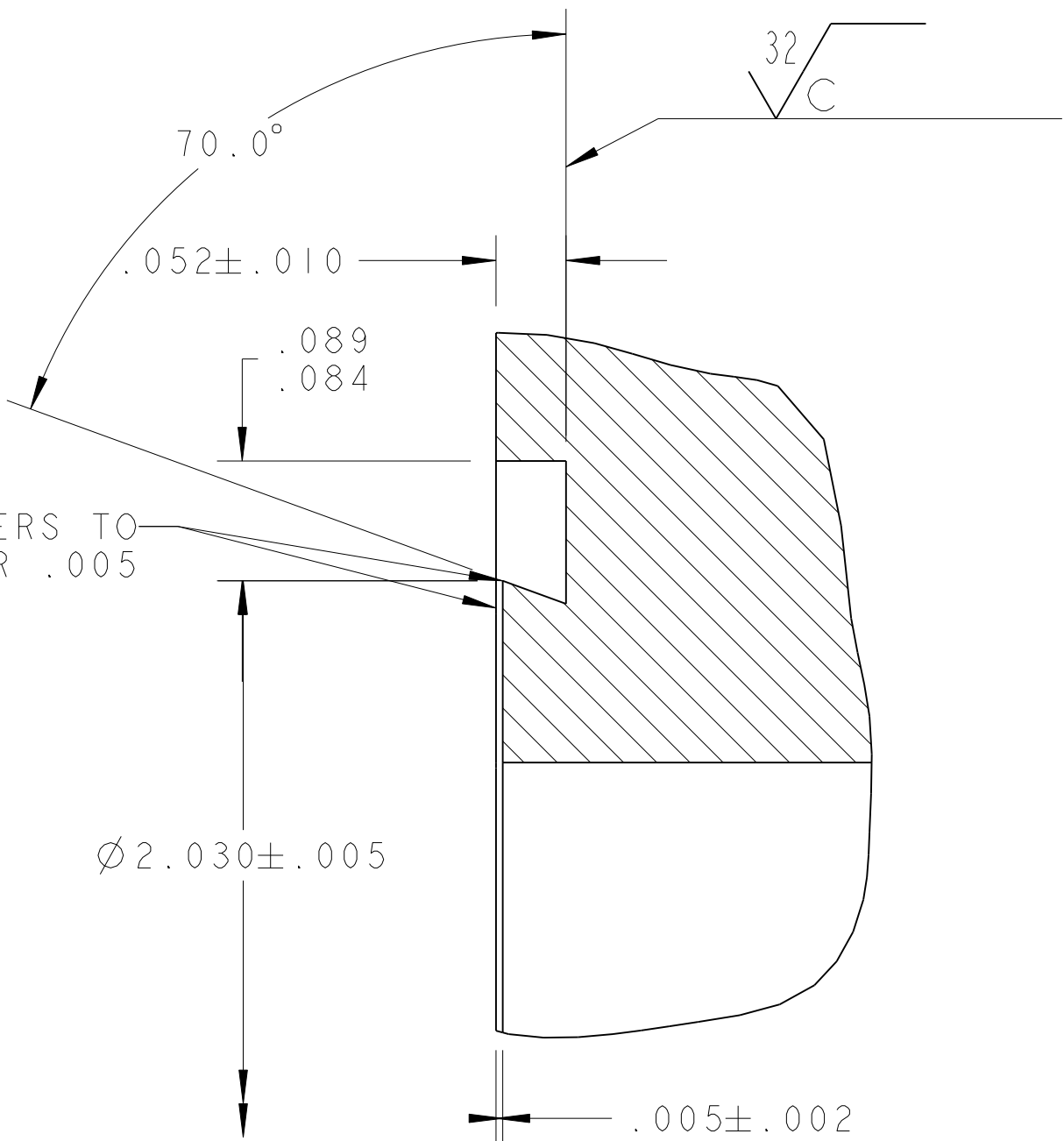
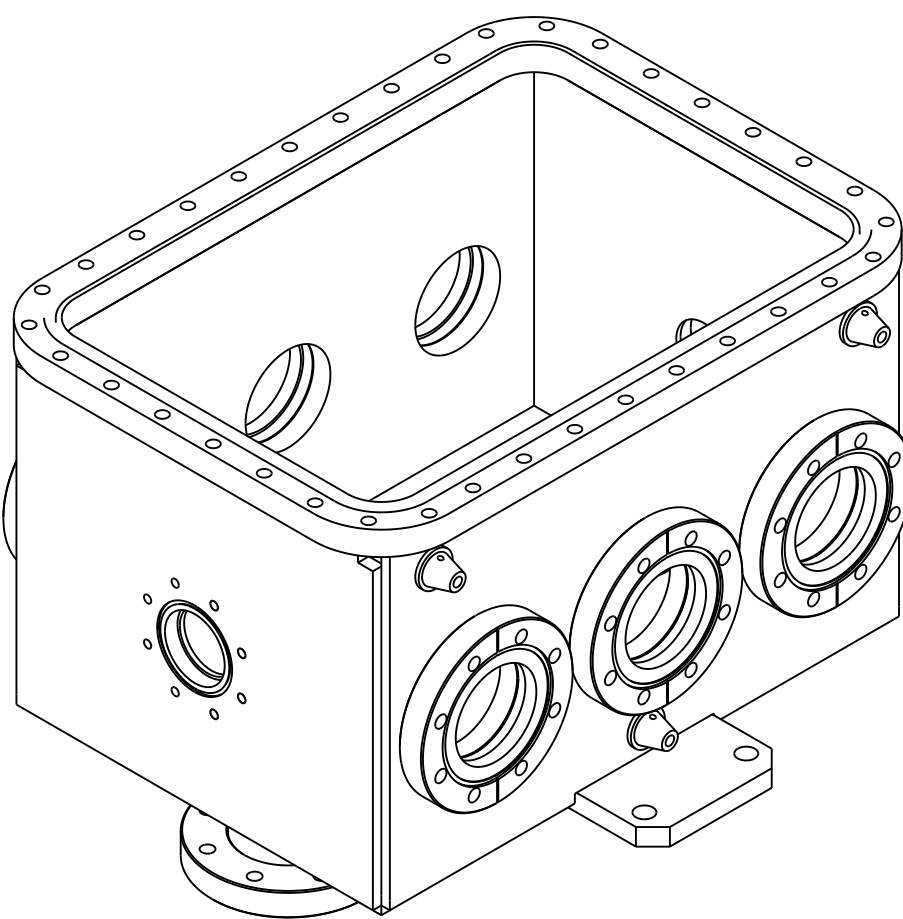
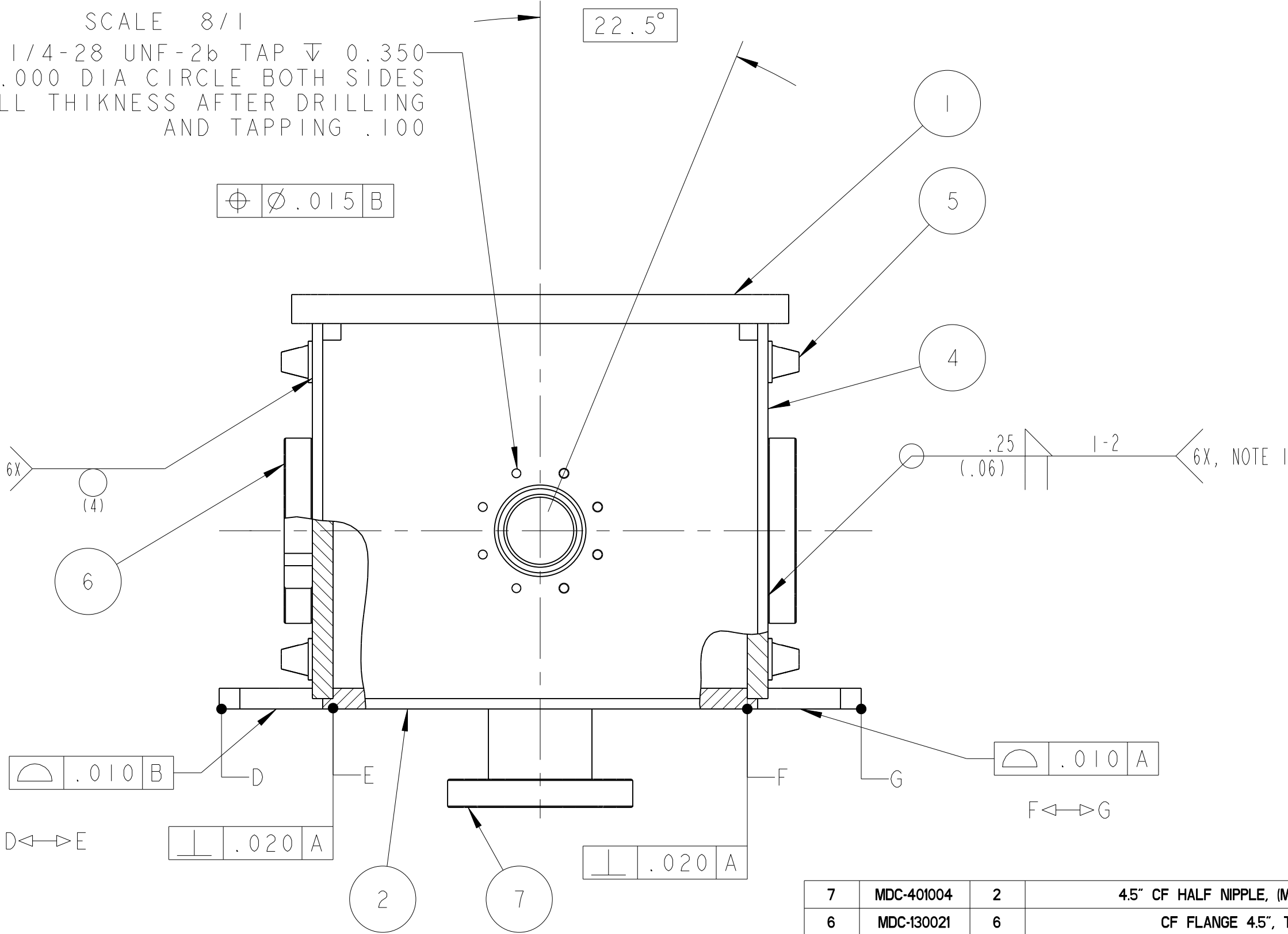
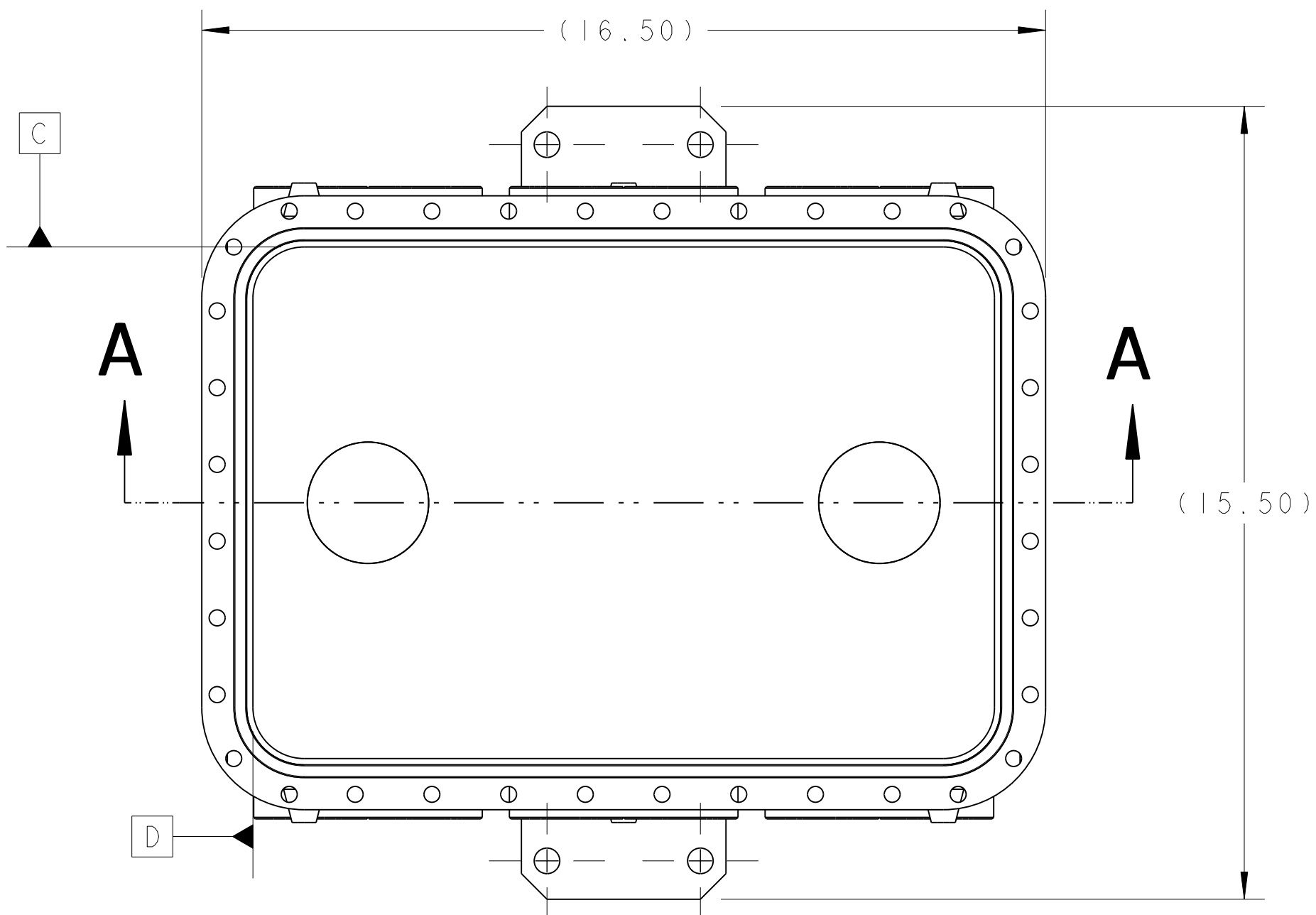




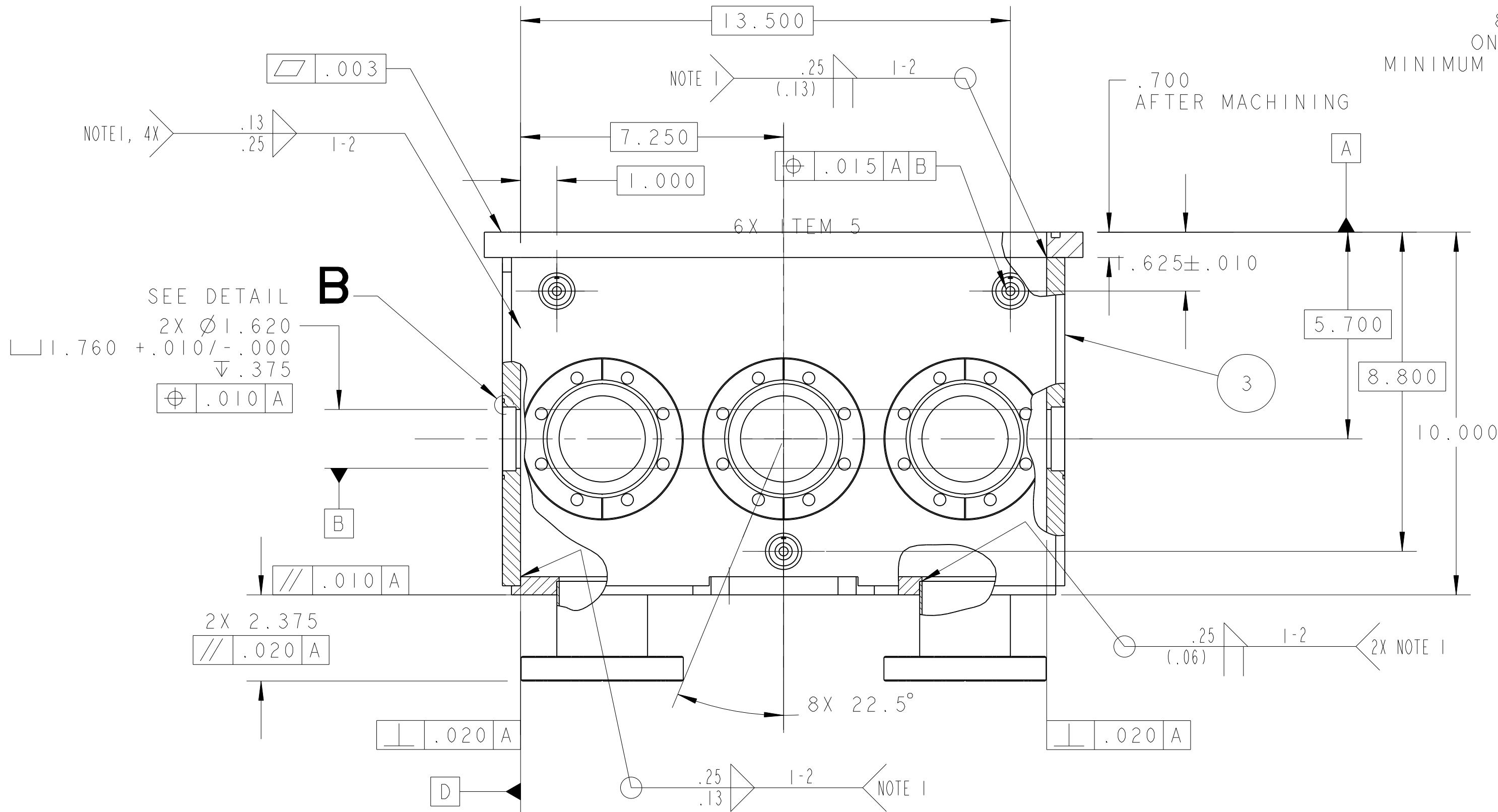
DETAIL B
SCALE 8/1
8X 1/4-28 UNF-2b TAP ∇ 0.350
ON 3.000 DIA CIRCLE BOTH SIDES
MINIMUM WALL THICKNESS AFTER DRILLING
AND TAPPING .100



PARTIAL SECTION B-B



PARTIAL VIEW SECTION A-A



NOTES:

1. FINISHED PART TO BE VACUUM TIGHT.
LEAK RATE NOT TO EXCEED 1×10^{-8} TORR - LITERS PER SECOND HELIUM.
2. ULTRA-HIGH VACUUM CLEANING AND PACKING REQUIRED.
3. ASSEMBLE IN CLEAN ENVIRONMENT.
AFTER ASSEMBLY AND WELDING, WRAP TO MAINTAIN CLEANLINESS.
4. PROTECT CONFLAT FLANGE KNIFE EDGE AT ALL TIMES.

							UNLESS OTHERWISE SPECIFIED	
							PROJECTION: 	
							XX ± 0.1	FRAC. ± 1/64
E	AZ	B3,4	3/22/01		CHANGED VIEW TO PARTIAL SECTION B-B		XXX ± 0.03	Angles ± 10°
E	AZ	B3,4	3/22/01		PERPENDICULARITY WAS .005 IS .020		XXXX ± 0.010	FINISH 
D	AZ		2/7/01		EXTENDED BOTTOM PLATE, ADDED CHAMFERS TO END PLATES		DO NOT SCALE PRINT	
C	AZ		2/5/01		UPPER FIDUCIALS LOWERED		THREADS ARE CLASS 2	
B	AZ		1/20/01		CORRECTED INTERFERENCE PROBLEMS WITH CHOPPER PLATES.		CHAMFER ENDS OF ALL SCREW THREADS 30°	
A	AZ		1/15/01		INITIAL RELEASE.		CUT ROUND, 15 THREAD RELIEF ON MACHINED THREADS	
							BREAK EDGES .016 MAX. ON MACHINED WORK	
							REMOVE BURRS, WELD SPATTER & LOOSE SCALE	
							IN ACCORDANCE WITH ASME Y14.5M & B46.1	
REV	DWG	CHK	ZONE	DATE	CHANGES			

7	MDC-401004	2	4.5" CF HALF NIPPLE, (MODIFY AS REQUIRED)	304 SS
6	MDC-130021	6	CF FLANGE 4.5", TAPPED HOLES	304 SS
5	28Q5363	6	LBNL SUPPLIED SURVEY FIXTURE	17-4-PH SS
4	25B425	2	CHOPPER BOX SIDE PLATE	304 SS
3	25B423	2	CHOPPER BOX END PLATE	304 SS
2	25B422	1	CHOPPER BOX BOTTOM PLATE	304 SS
1	-	1	CHOPPER BOX TOP FLANGE	304 SS
ITEM	PART NO	REQD	DESCRIPTION	MATERIAL
SHOP ORDERS				
ACCT NO.	NO. REQD	SER. NO.	DATE ISSD	DATE REQD
DEL. TO				
SURFACE TREATMT				
IDENT METHOD	TAG			
PROJECT NUMBER	na			
PROJECT NAME	N/A			
DWG BY	A ZACHOSZCZ	DATE	06-Feb-01	
CHK BY	D. OSHATZ	DATE		
APR BY	D. OSHATZ	DATE		
ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY UNIVERSITY OF CALIFORNIA - BERKELEY				
SNS - FES MEBT BEAM TRANSPORT SYSTEMS CHOPPER BOX WELDMENT				
MICROFILMED:	DWG. TYPE	SHOWN ON	SCALE:	DO NOT SCALE PRINTS
	ASSEM	-	3/8	
PATENT CLEAR:	DESIGN ACCT. NO.	CATEGORY CODE	DWG. NO.	SIZE
	-	FE3312	25B4214	REV. E
SHEET 1 OF 2				

