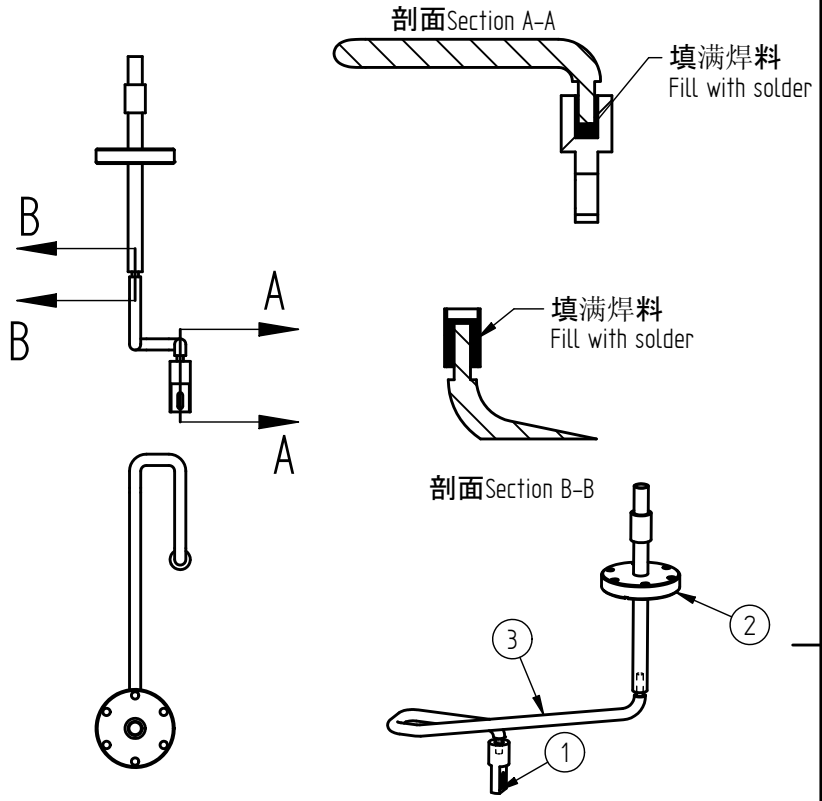
标记	处数	更改文件号	签 字	日 期



技术要求 Technical Req.:
1、所有材料均需提供材料质量证明书Properties certificate shall be provided for all material.
2、所有锐边1x45°倒钝，去尖角、毛刺或飞边 Chamfer edge to 1x45°and trim sharp edges and deburr.
3、所有元件在焊接和装配前需清洁处理，去除油脂、污物、灰尘等，吹干或烘干且干燥保存，具体参见"MICE冷质量和低温恒温器清洗及焊接程序"
Clean all parts before welding or assembly and keep dry. All requirements written in "Cleaning and Welding Procedure for MICE Cold Mass and Cryostat" shall be complied.
4、焊接完成后必须对焊缝进行外观检查，焊缝表面不得有裂缝、气孔、夹渣及咬边等焊接缺陷。
参见"MICE冷质量和低温恒温器清洗及焊接程序" Visually check welding seams, they shall be defect free. Refer to "Cleaning and Welding Procedure for MICE Cold Mass and Cryostat"
5、焊接坡口配制 Machining weld bevel to match.
6、铜电流引线两端分别与室温端和冷端导冷铜板之间连接时，先螺钉固定，而后低温钎焊 Screw fix Cu leads with warm end and cold end of Cu cooling plate first, then weld.
7、铜电流引线设计电流210A，材料采用T2或者铜电缆，RRR需在10-15之间；引线长度385mm，导电面积约26.5mm^2，保持IL/A=3.071x10^-6A/m。
Design current for Cu lead is 210A, material is T2 or Cu cable, RRR shall be 10-15, lead length is 385mm, conducting area is about 26.5mm2, keep IL/A=3.071x10^-6A/m.
8、未注尺寸公差按 GB/T 1804-2000 m级，未注形位公差按GB/T 1184-1996 k 级制造See title box for un-marked tolerances.

序号	代号	名称	数量	材料	单重	总重	备注
3		铜引线 ASK ABOUT	1	T2		.000	长度387mm
2		电流引线电连接器CF35 ASK ABOUT	1	304		.000	外购
1	MMSF-0301-2010－01	铜引线接头 CU LEAD JOINT FOR LEADS 1 AND 2	1	T2		.065	

设 计			SSRF上海光源			
绘 图						
校 核						
审 核			计算机文件名	MMSF-0301-2010-00AQ.dft	电流引线组件	
会 签			制图软件	Solid Edge		
			数 量 / 重 量	比 例 / 图 幅	铜电流引线右 、右	
审 定			2 / 0	1:5 / A4	MMSF-0301-2010－00	版本 A
批 准			共 1 张	第 张		

REV	AUTHOR	APPROVER	DATE	CHANGE DESCRIPTION
A				INITIAL REVISION

UNLESS OTHERWISE SPECIFIED
TOLERANCES: .0± .25 .00±.125 .000±.050
FRACTIONS: ± -/--
ANGLES: ± -.-°/MM
MACH. SURFS.: 125 OR BETTER
REF:ASME Y14.5M-1994, THREADS ARE CLASS 2
BREAK EDGES .016 MAX. ON MACHINED WORK
REMOVE BURRS, WELD SPLATTER & LOOSE SCALE

PROJECT NAME: MICE

ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY
UNIVERSITY OF CALIFORNIA

MUON IONIZATION COOLING EXPERIMENT (MICE)
MICE/MUCOOL SUPERCONDUCTING COUPLING MAGNET
CU LEADS 1 AND 2

DO NOT SCALE PRINT | CATEGORY CODE: MU 1025
SCALE: 1:1
FRIST ANGLE PROJECTION
SHEET 1 OF 1 | SIZE: 5 | DWG NO: 27H846 | REV A