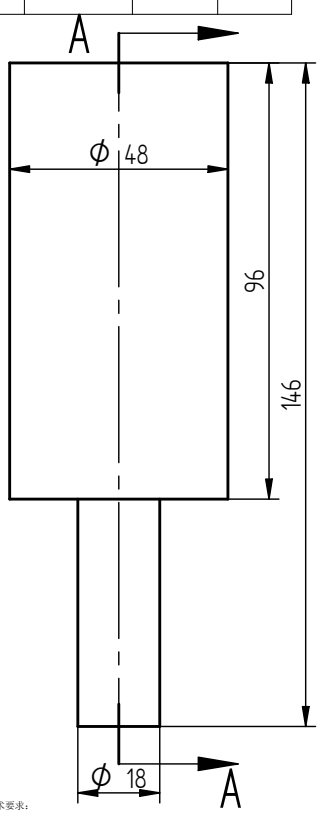
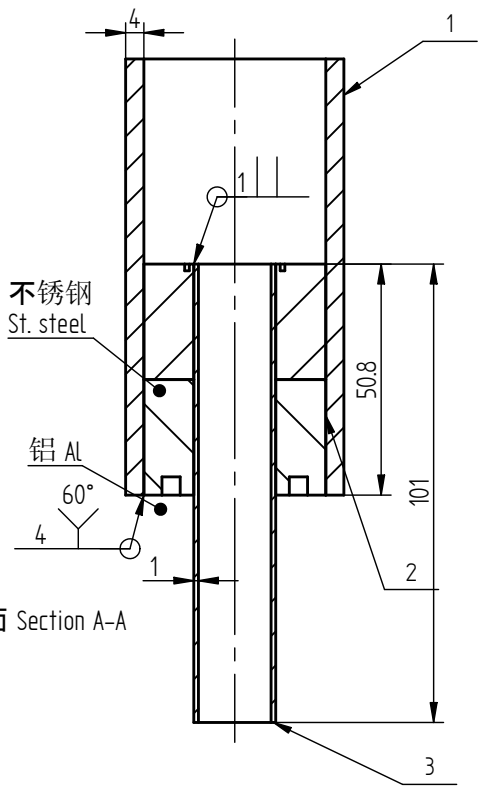
| 标记 | 处数 | 更改文件号 | 签 字 | 日 期 |
|---|---|---|---|---|
| | | | | |
| | | | | |
| | | | | |

注:所有尺寸为最终尺寸，请自放加工余量.
All dimensions are final, machining allowance shall be considered.

全部 All: 6.3




剖面 Section A-A

技术要求：

1. 提供材质证明书 Properties certificate shall be provided for all material.
2. 焊缝检查：焊后不得有气孔、裂缝等影响强度的缺陷；按 JB4730 对焊缝进行射线无损检查，II 级为合格 Visually check welding seams, they shall be defect free. X ray inspect all seamwelding and shall be graded II.
3. 各元件在焊前进行清洁处理，去除油污、污垢、灰尘等烘干或吹干，并保持干燥；清洗和焊接参照工艺文件“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 Prcedure for MICE Cold Mass and Cryostat” shall be complied.
4. 未注尺寸公差按 GB/T 1804-2000 f 级，未注形位公差按 GB/T 1184-1996 k 级进行制造 See title box for un-marked tolerances.
5. 组焊后需经压力试验；试验介质为干燥氦气，试验压力为 0.5MPa，试验方法参见 GB150 0.5Mpa , dry He gas pressure check after welding, refer to GB150 for details.
6. 压力测试后经氦质谱仪常温和液氦温度检漏，每道焊缝漏率应小于 $1\times10^{-10}$Pa.m$^3$/S,检漏方法见“MICE 冷质量和低温恒温器真空检漏程序” After pressure check, He leak detector check all welding seems under room and cryogenic temperature, the leakage shall be less than 1×10-10Pa•m3/S . Comply to “Vacuum Leak Check Procedure for MICE Cold Mass and Cryostat”.
7. 6061 铝采用氩弧焊，焊丝牌号 ER5356. Al 6061 parts shall be welded with MIG or TIG method and solder ER6356.
8. 不锈钢焊接采用氩弧焊，焊丝牌号 H0Cr21Ni10. St. steel parts shall be welded with argon-arc welding method and H0Cr21Ni10 solder.

| 序号 | 代号 | 名称 | 数量 | 材料 | 单重 | 总重 | 备注 |
|---|---|---|---|---|---|---|---|
| 3 | MMSF-0301-1042-03 | Φ18液位计接管 UPPER PART OF LEVEL GAGUE ACCESS TUBE JOINT ASSEMBLY | 1 | 304 | | 0.043 kg | |
| 2 | MMSF-0301-1042-02 | Φ18钢铝接头 LEVEL GAGUE ACCESS DIA18 BIMETAL JOINT | 1 | 6061AL-304SS | | | 钢铝复合板 |
| 1 | MMSF-0301-1042-01 | 氦容器-液位计接管 LOWER PART OF LEVEL GAGUE ACCESS TUBE | 1 | 6061-T651 | | 0.143 kg | |

| | | | | | |
|---|---|---|---|---|---|
| 设 计 | | | | SSRF上海光源 | |
| 绘 图 | | | | | |
| 校 核 | | | | 上氦容器顶板组件 | |
| 审 核 | | 计算机文件名 | MMSF-0301-1042-00A.dft | | |
| 会 签 | | 制图软件 | Solid Edge | 液位计接头组件 | |
| | | 数 量 / 重 量 | 比 例 / 图 幅 | | |
| 审 定 | | 1 / 0.45 | 1:1.25 / A4 | MMSF-0301-1042-00 | 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✓ BE 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
DO NOT SCALE PRINT
SCALE: 1:1
CATEGORY CODE: MU 1025
FRIST ANGLE PROJECTION

ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY
UNIVERSITY OF CALIFORNIA

MUON IONIZATION COOLING EXPERIMENT (MICE)
MICE/MUCOOL SUPERCONDUCTING COUPLING MAGNET
UPPER RESERVOIR LVL GAGUE ACCESS TUBE JOINT ASSEM

1 SHEET OF 1 | SIZE: 5 | DWG NO: 27H776 | REV A