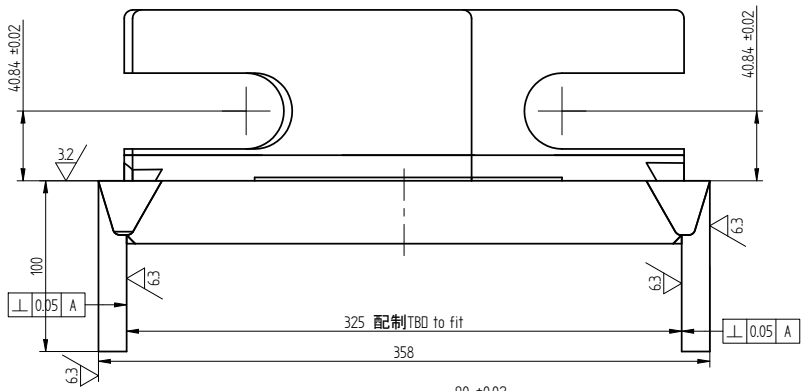
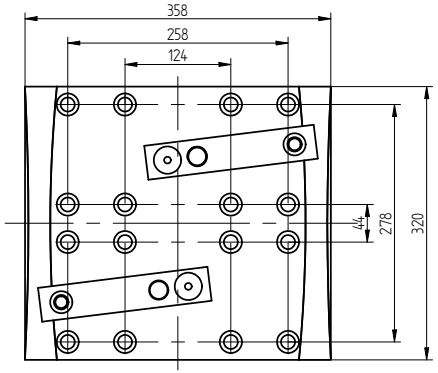
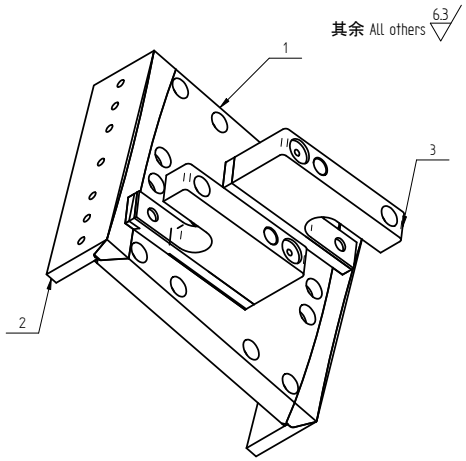
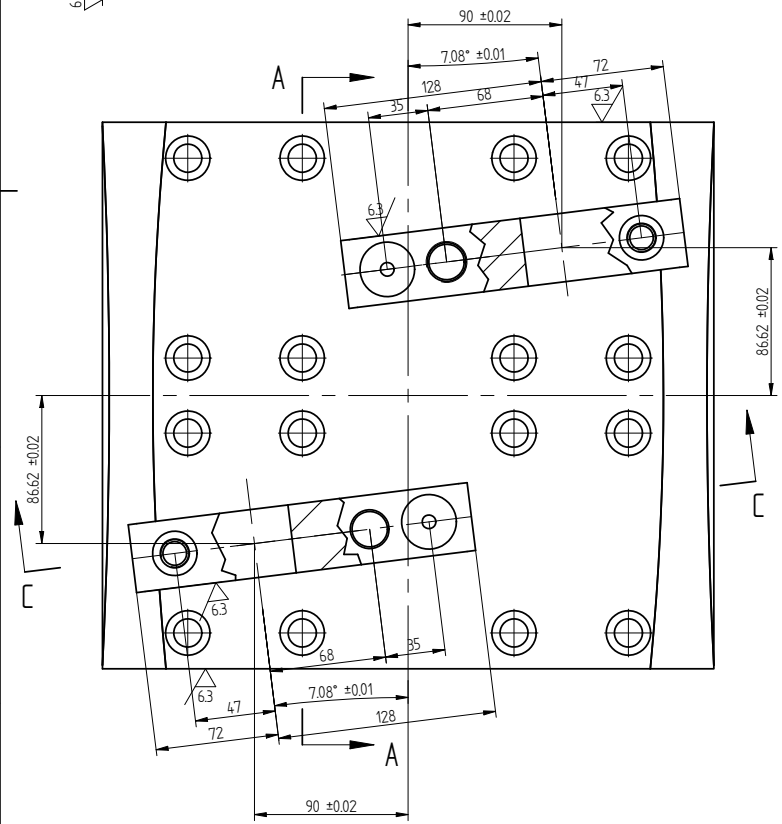
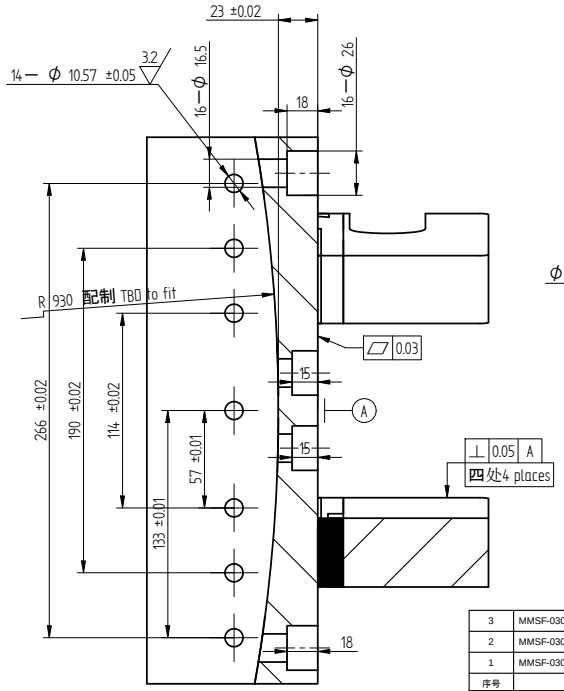
标记	处数	更改文件号	签 字	日 期



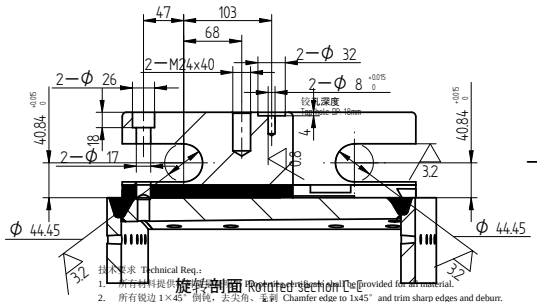








剖面Section A-A



旋转剖面 Rotated Section C-C

技术要求 Technical Req.:

1. 所有材料提供材质证明书 Material certificate shall be provided for all material.
2. 所有锐边 1×45° 倒钝，去尖角、毛刺 Chamfer edge to 1x45° and trim sharp edges and deburr.
3. 所有元件在焊接和装配前应去除油脂、污物、灰尘等，并应保持干燥，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；按 JB4730 无损检测要求，对接焊缝进行射线无损检测，II 级为合格，其他焊缝进行渗透检测，I 级为合格；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. X ray inspect all seamwelding and shall be graded II; and comply JB4730 procedure. Conduct dye penetration test on other welding and shall be graded I. Refer to “Cleaning and Welding Procedure for MICE Cold Mass and Cryostat”
5. 焊后去应力退火，再精加工，表面电抛光 Annealing part after welding, finish and electrically polish surfaces afterwards.
6. 侧板销孔与冷质量骨架配做 Dowel pin hole on side plate matching drill with cold mass bobbin.
7. 内外表面光洁、不得有划痕、刻槽等缺陷 Surface free of scratch and defect.
8. 未注尺寸公差按 GB/T 1804-2000 f 级 ,未注形位公差按 GB/T 1184-1996 H 级制造 See title box for un-marked tolerances.
9. 所有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-0301-4010—03	冷端支座耳 EAR OF COLD END BRACKET FOR COLD MASS SUPPORT	2	304		9.159	
2	MMSF-0301-4010—02	冷端支座侧板 COLD MASS SUPPORT SIDE PLATE OF COLD END BRACKET	2	304		6.989	
1	MMSF-0301-6010—01	冷端支座底板2 COLD MASS SUPPORT BOTTOM PLATE OF COLD END BRACKET 2	1	304		.000	

设 计			SSRF上海光源		
绘 图					
校 核					
审 核		计算机文件名	MMSF-0301-6010-00A.dft	冷端支座组件2	
会 签		制图软件	Solid Edge	冷端支座2	
		数 量 / 重 量	比 例 / 图 幅		
审 定		2 / 40.34	1:2 / A2	MMSF-0301-6010—00	版本 A
批 准		共 1 张	第 张		

REV	AUTHOR	APPROVED	DATE	CHANGE DESCRIPTION
A				INITIAL REVISION

UNLESS OTHERWISE SPECIFIED
TOLERANCES: .0± .25 .00±.125 .000±.050
FRACTIONS: ± —/—
ANGLES: ± —°/MM
MACH. SURFS: 125 ✓ ±.005
REFASME Y14.5M-1994, THREADS ARE CLASS 2
BREAK EDGES .016 MAX. ON MACHINED WORK
REMOVE BURRS, WELD SPLATTER & LOOSE SCALE

PROJECT NAME: MICE
SCALE: 1:1
MU 1025
FIRST ANGLE PROJECTION

ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY
UNIVERSITY OF CALIFORNIA
MUON IONIZATION COOLING EXPERIMENT (MICE)
MICE/MUCOOL SUPERCONDUCTING COUPLING MAGNET
COLD END BRACKET 2 FOR COLD MASS SUPPORT

SHEET 1 OF 1 | SIZE: 5 | DWG NO. 27H862 | REV A