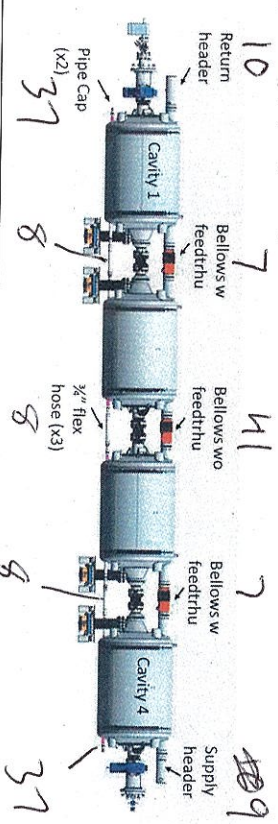
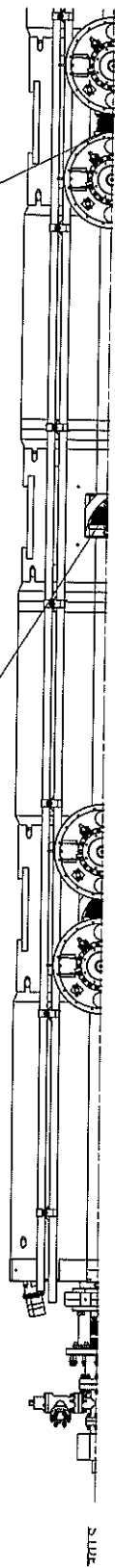


Step No	Instructions	Data Inputs
5	Install the MLI Blankets (CRM9007000-1060, -1061, -1062, & -1063) on helium vessel ends and under the tuner mounting area. CP-SNSPPU-CMA-INST-MLI.docx will be used for all MLI work outlined in this Traveler.	[[HVMLITech]] <<SRF>> [[HVMLIDate]] <<TIMESTAMP>> [[HVMLIComment]] <<COMMENT>>
6	Install the 2K circuit – weld 3" helium return line bellows (2× 104211500-A017, 1× 104211500-A026), 3" supply and return headers (1× 104211500-A018 & 1× 104211500-A019), crossover flex lines (104211500-A027), and ¾" end caps. In this traveler, drawing number in ORNL's format typically omits the "-M8U-8200" portion for brevity. <u>Procedure:</u> • Pull wires through wire loop inside He vessel heads. • Install bellows/pull heater wires through separate feedthru ports in double tophat bridging areas. • Add bellows protectors to the 2 phase bellows • Pull liquid level wires through the 3" return header. • Install G10 standoffs to protect wires during welding. • Weld all components using appropriate procedure and Cu cooling block. • Verify header to header length of cavity string as per drawing number 104211500-A002 = 227.37" (Actual should be 0.09" long due to lollipop tooling), record the dimension. • Verify gate valve to gate valve length = 220.18" • Upload the completed 2 phase weld maps, they also include SN's for process piping components. 	<pre> [[Welder2KC]] <<SRF>> [[Weld2KCDate]] <<TIMESTAMP>> [[Weld2KCComment]] <<COMMENT>> [[2PhaseWeldMaps]] <<FILEUPLOAD>> [[ReturnHeader]] <<SN>> 10 [[RtBellow1]] <<SN>> 7 [[RtBellow2]] <<SN>> 41 [[RtBellow3]] <<SN>> 7 [[SpBellow1]] <<SN>> 8 [[SpBellow2]] <<SN>> 8 [[SpBellow3]] <<SN>> 8 [[SupplyHeader]] <<SN>> 89 [[Header2HeaderDist]] <<FLOAT>> [[Valve2ValveDist]] <<FLOAT>> </pre> Ref: 104211500-A002



ACCESS PANEL REMOVED
FOR TOOLING

BOTTOM VIEW
ITEM 4 REMOVED FOR CLARITY

ACCESS PANEL REMOVED
FOR TOOLING

THE NUTS 3

ARITY.

U-8200-P001

THIS
OW SLIDING.

ITEM NO.	DESCRIPTION	QUANTITY	UNIT	REVISION
12	SS-4-TM-6	1	PC	1
46	SS-4-TM-6	1	PC	1
32	CH900700-1053	1	PC	1
44	CH900700-1064	1	PC	1
8	4-48 UNF HEX MACHINE	1	PC	1
42	HEX SOCKET HEAD SET SCREW	1	PC	1
40	104211500-480-8200	1	PC	1
39	CH900700-3015	1	PC	1
38	HEX HEAD JAW NUT	1	PC	1
37	75 CAP-WELO STL ST 304 SCH	1	PC	1
36	TYPE B PLAIN REGULAR	1	PC	1
35	48-32 X .50 SHCS SS SILVER	1	PC	1
34	SOLID SEAL TECH DOUBLE ENDED GF CONDUCTOR 8	1	PC	1
33	SET SCREW 3/16-16 UNC X	1	PC	1
16	1.25L COP PL	1	PC	1

ITEM NO.	DESCRIPTION	QUANTITY	UNIT	REVISION
4	4-40UNC X .50 LG SHCS	1	PC	1
31	CH900700-3012	1	PC	1
30	SPEC 80250-013-S	1	PC	1
29	104210200-480-8200	1	PC	1
28	NOR 191000	1	PC	1
27	4-40UNC X .50 LG SHCS	1	PC	1
26	LAKESIDE	1	PC	1
25	CH900700-3011	1	PC	1
24	CH900700-3010	1	PC	1
23	CH900700-3009	1	PC	1
22	CH900700-3008	1	PC	1
21	CH900700-3007	1	PC	1
20	CH900700-3006	1	PC	1
19	CH900700-3005	1	PC	1
18	CH900700-1053	1	PC	1
17	CH900700-1053	1	PC	1

ITEM NO.	DESCRIPTION	QUANTITY	UNIT	REVISION
16	CH900700-1062	1	PC	1
15	CH900700-1061	1	PC	1
14	CH900700-1060	1	PC	1
13	CH900700-1053	1	PC	1
12	CH900700-1027	1	PC	1
11	CH900700-1026	1	PC	1
10	104211500-480-8200	1	PC	1
9	104211500-480-8200	1	PC	1
8	104211500-480-8200	1	PC	1
7	104211500-480-8200	1	PC	1
6	CH900700-3014	1	PC	1
5	CH900700-3013	1	PC	1
4	104211500-480-8200	1	PC	1
3	104211500-480-8200	1	PC	1
2	104211500-480-8200	1	PC	1
1	104211500-480-8200	1	PC	1

FOR LAB INTERNAL USE ONLY

SEE LAB MANUAL CHAPTER 611 FOR PRESSURE AND VACUUM SYSTEM SAFETY SUPPLEMENT AND TESTING AND DOWLING SUPPLEMENT

CLASS

PRESSURE/VACUUM CLASS

CODE

PRESSURE SYSTEM NUMBER

PS-CRM-18-001

THIRD ANGLE PROJECTION

DO NOT SCALE DRAWING

DATE

1-8

1

3

Approved: 11/20/2015, E-Shop ID: 144511, signed by: Mr. J. A. Murphy, Sr. & Mr. W. H. Murphy, Jr. & Mr. C. G. Murphy, Jr. & Mr. D. Murphy, Jr.