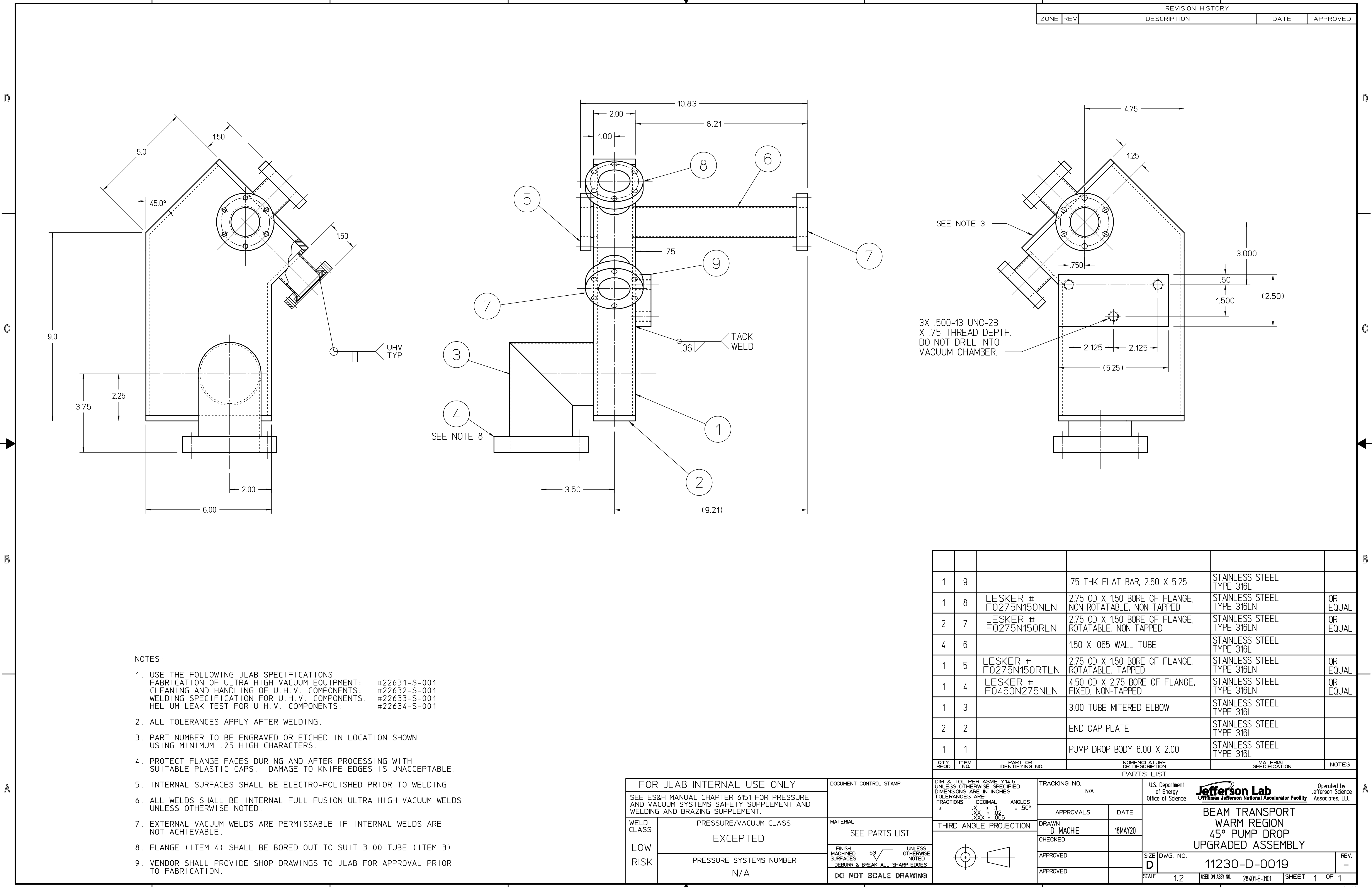




NOTES:

- USE THE FOLLOWING JLAB SPECIFICATIONS
FABRICATION OF ULTRA HIGH VACUUM EQUIPMENT: #22631-S-001
CLEANING AND HANDLING OF U.H.V. COMPONENTS: #22632-S-001
WELDING SPECIFICATION FOR U.H.V. COMPONENTS: #22633-S-001
HELIUM LEAK TEST FOR U.H.V. COMPONENTS: #22634-S-001
- ALL TOLERANCES APPLY AFTER WELDING.
- PART NUMBER TO BE ENGRAVED OR ETCHED IN LOCATION SHOWN USING MINIMUM .25 HIGH CHARACTERS.
- PROTECT FLANGE FACES DURING AND AFTER PROCESSING WITH SUITABLE PLASTIC CAPS. DAMAGE TO KNIFE EDGES IS UNACCEPTABLE.
- INTERNAL SURFACES SHALL BE ELECTRO-POLISHED PRIOR TO WELDING.
- ALL WELDS SHALL BE INTERNAL FULL FUSION ULTRA HIGH VACUUM WELDS UNLESS OTHERWISE NOTED.
- EXTERNAL VACUUM WELDS ARE PERMISSABLE IF INTERNAL WELDS ARE NOT ACHIEVABLE.
- FLANGE (ITEM 4) SHALL BE BORED OUT TO SUIT 3.00 TUBE (ITEM 3).
- VENDOR SHALL PROVIDE SHOP DRAWINGS TO JLAB FOR APPROVAL PRIOR TO FABRICATION.

FOR JLAB INTERNAL USE ONLY	
SEE ES&H MANUAL CHAPTER 6151 FOR PRESSURE AND VACUUM SYSTEMS SAFETY SUPPLEMENT AND WELDING AND BRAZING SUPPLEMENT.	
WELD CLASS	PRESSURE/VACUUM CLASS
LOW RISK	EXCEPTED
	PRESSURE SYSTEMS NUMBER
	N/A

DOCUMENT CONTROL STAMP	
MATERIAL	
SEE PARTS LIST	
FINISH MACHINED SURFACES DEBURR & BREAK ALL SHARP EDGES	
DO NOT SCALE DRAWING	

DIM & TOL PER ASME Y14.5 UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: FRACTIONS DECIMAL ANGLES	
X .02	
XXX ± .005	
THIRD ANGLE PROJECTION	

TRACKING NO.	
N/A	
APPROVALS	
DRAWN	DATE
D. MACHE	18MAY20
CHECKED	
APPROVED	
APPROVED	

U.S. Department of Energy Office of Science	
Operated by Jefferson Science Associates, LLC	
BEAM TRANSPORT WARM REGION 45° PUMP DROP UPGRADED ASSEMBLY	
SIZE	DWG. NO.
D	11230-D-0019
SCALE	1:2
USED ON ASSY NO.	28401E-0101
SHEET	1 OF 1

QTY REQD	ITEM NO.	PART OR IDENTIFYING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL SPECIFICATION	NOTES
1	9		.75 THK FLAT BAR, 2.50 X 5.25	STAINLESS STEEL TYPE 316L	
1	8	LESKER # F0275N150NLN	2.75 OD X 1.50 BORE OF FLANGE, NON-ROTATABLE, NON-TAPPED	STAINLESS STEEL TYPE 316LN	OR EQUAL
2	7	LESKER # F0275N150RLN	2.75 OD X 1.50 BORE OF FLANGE, ROTATABLE, NON-TAPPED	STAINLESS STEEL TYPE 316LN	OR EQUAL
4	6		1.50 X .065 WALL TUBE	STAINLESS STEEL TYPE 316L	
1	5	LESKER # F0275N150RTLN	2.75 OD X 1.50 BORE OF FLANGE, ROTATABLE, TAPPED	STAINLESS STEEL TYPE 316LN	OR EQUAL
1	4	LESKER # F0450N275NLN	4.50 OD X 2.75 BORE OF FLANGE, FIXED, NON-TAPPED	STAINLESS STEEL TYPE 316LN	OR EQUAL
1	3		3.00 TUBE MITERED ELBOW	STAINLESS STEEL TYPE 316L	
2	2		END CAP PLATE	STAINLESS STEEL TYPE 316L	
1	1		PUMP DROP BODY 6.00 X 2.00	STAINLESS STEEL TYPE 316L	