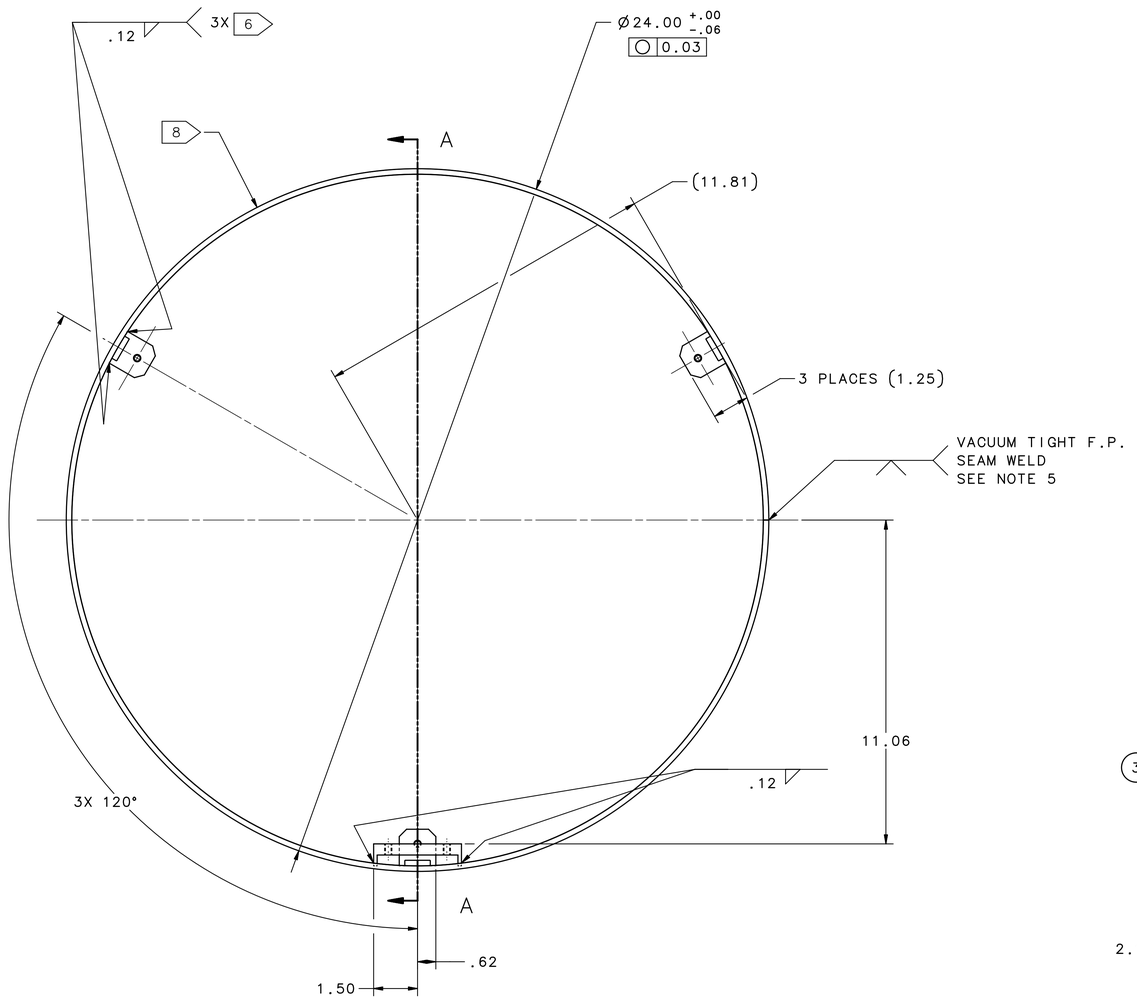
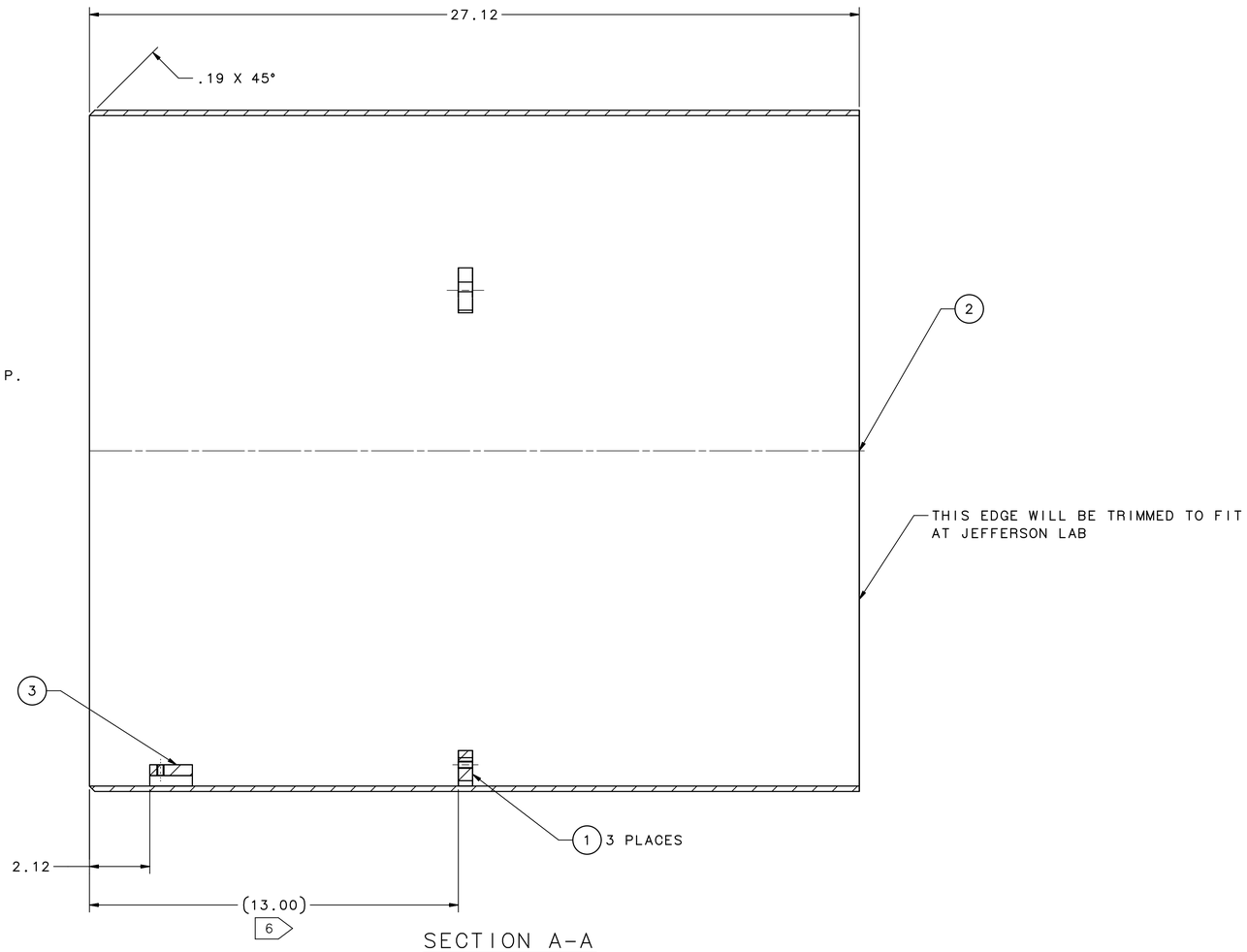
REVISION HISTORY			
ZONE	REV	DESCRIPTION	DATE/REVISER





SECTION A-A

NOTES:

1. MATERIAL SHALL BE 3/16" TITANIUM GRADE 2. ROLLED, WELDED AND ROLLED AGAIN. VIBRATORY STRESS RELIEVED.
2. ALL PRESSURE BOUNDARY MATERIAL SHALL BE SUPPLIED FROM VENDOR WITH:
   A. MILL HEAT NUMBERS
   B. CERTIFIED MATERIAL TEST REPORTS INCLUDING CHEMICALS AND PHYSICALS.
3. ONE KNOCK-OUT PER HEAT NUMBER SHALL BE SUPPLIED BY THE VENDOR.
4. VACUUM LEAK CHECK SHALL BE IN ACCORDANCE WITH JLAB SPECIFICATION: 11141-S-0029
   No detectable leak greater than 1x10-10 STD cc of He/sec
5. PROVIDE CERTIFICATION THAT WELD WAS PERFORMED PER QUALIFIED WELD PROCEDURE BY A WELDER QUALIFIED FOR THAT PROCEDURE PER ASME BPVC, SECTION 9.

6. FIELD WELD AT FINAL ASSEMBLY WHERE CENTER LEG SUPPORTS (104211700-M8U-8200-A001-5 AND 104211700-M8U-8200-A002-4) ARE LOCATED.

7. CLEAN AND HANDLE TITANIUM PER JLAB SPECIFICATION: 11520-S-0100

8 PART IS TO BE SERIALIZED PER SOW

QTY. REQD	ITEM NO.	PART OR IDENTIFYING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL SPECIFICATION	NOTES
1	3	CRM9007020-1013	HEATER BLOCK		
1	2		TUBE 24.00 OD X .19 WALL	TITANIUM GR. 2	
3	1	104211700-M8U-8200-A031	HELIUM VESSEL CAVITY SUPPORT BLOCK		

PARTS LIST

EACH SHEET OF MULTI-SHEET DRAWINGS SHALL ALWAYS HAVE THE SAME REVISION LEVEL.

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
CODE	BPVC
	PRESSURE SYSTEMS NUMBER: PS-CRM-18-001

DIM & TOL PER ASME Y14.5 2009. UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ARE: FRACTIONS ± 1/8; DECIMAL .X ±.1, .XX ±.01, .XXX ±.005; ANGLES ± .50°

THIRD ANGLE PROJECTION

MATERIAL: SEE PARTS LIST

FINISH MACHINED SURFACES 125 UNLESS OTHERWISE NOTED
DEBURR & BREAK ALL SHARP EDGES

DO NOT SCALE DRAWING

DRAWN R.D. LASSITER | DATE 19DEC2018

United States Department of Energy — Jefferson Lab, Thomas Jefferson National Accelerator Facility — Newport News Virginia

CRM
SPALLATION NEUTRON SOURCE - PPU
HE VESSEL
HELIUM VESSEL - SHELL WELDMENT

SIZE E | DWG. NO 104211700-M8U-8200-A020 | REV —

SCALE 1:2 | USED ON ASSY NO. 104211700-M8U-8200-A026 | SHEET 1 OF 1