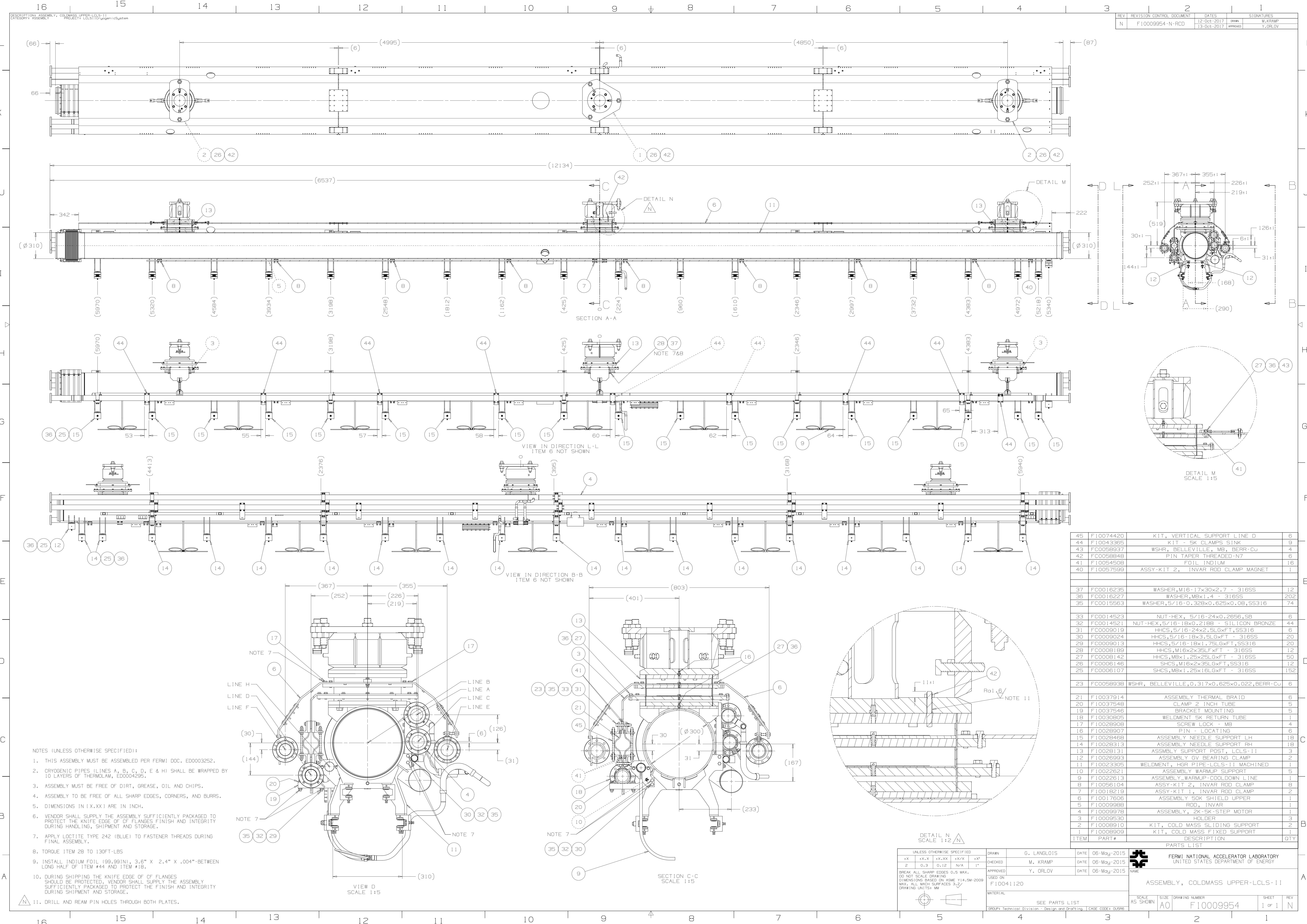




NOTES (UNLESS OTHERWISE SPECIFIED):

1. THIS ASSEMBLY MUST BE ASSEMBLED PER FERMI DOC. ED0003252.
2. CRYOGENIC PIPES (LINES A, B, C, D, E & H) SHALL BE WRAPPED BY 10 LAYERS OF THERMOLAM, ED0004295.
3. ASSEMBLY MUST BE FREE OF DIRT, GREASE, OIL AND CHIPS.
4. ASSEMBLY TO BE FREE OF ALL SHARP EDGES, CORNERS, AND BURRS.
5. DIMENSIONS IN [X.XX] ARE IN INCH.
6. VENDOR SHALL SUPPLY THE ASSEMBLY SUFFICIENTLY PACKAGED TO PROTECT THE KNIFE EDGE OF CF FLANGES FINISH AND INTEGRITY DURING HANDLING, SHIPMENT AND STORAGE.
7. APPLY LOCTITE TYPE 242 (BLUE) TO FASTENER THREADS DURING FINAL ASSEMBLY.
8. TORQUE ITEM 28 TO 130FT-LBS.
9. INSTALL INDIUM FOIL (99.991N), 3.6" X 2.4" X .004" BETWEEN LONG HALF OF ITEM #44 AND ITEM #18.
10. DURING SHIPPING THE KNIFE EDGE OF CF FLANGES SHOULD BE PROTECTED. VENDOR SHALL SUPPLY THE ASSEMBLY SUFFICIENTLY PACKAGED TO PROTECT THE FINISH AND INTEGRITY DURING SHIPMENT AND STORAGE.
11. DRILL AND REAM PIN HOLES THROUGH BOTH PLATES.

45	F10074420	KIT, VERTICAL SUPPORT LINE D	6
44	F10043365	KIT - 5K CLAMPS SINK	9
43	FC0058937	WSHR, BELLEVILLE, M8, BERR-CU	4
42	FC0058848	PIN TAPER THREADED-N7	6
41	F10054508	FOIL INDIUM	16
40	F10057599	ASSY-KIT 2, INVAR ROD CLAMP MAGNET	1
37	FC0016235	WASHER, M16-17x30x2.7 - 316SS	12
36	FC0016227	WASHER, M8x1.4 - 316SS	202
35	FC0015563	WASHER, 5/16-0.328x0.625x0.08, SS316	74
33	FC0014523	NUT-HEX, 5/16-24x0.2656, SB	6
32	FC0014521	NUT-HEX, 5/16-18x0.2188 - SILICON BRONZE	44
31	FC0009019	HHCS, 5/16-24x2.5LGxFT, SS316	6
30	FC0009024	HHCS, 5/16-18x3.5LGxFT - 316SS	20
29	FC0009013	HHCS, 5/16-18x1.75LGxFT, SS316	20
28	FC0008189	HHCS, M16x2x35LFxFT - 316SS	12
27	FC0008142	HHCS, M8x1.25x25LGxFT - 316SS	50
26	FC0008146	SHCS, M16x2x35LGxFT, SS316	12
25	FC0008107	SHCS, M8x1.25x16LGxFT - 316SS	152
23	FC0058938	WSHR, BELLEVILLE, 0.317x0.625x0.022, BERR-CU	6
21	F10037914	ASSEMBLY THERMAL BRAID	6
20	F10037548	CLAMP 2 INCH TUBE	5
19	F10037546	BRACKET MOUNTING	5
18	F10030805	WELDMENT 5K RETURN TUBE	1
17	F10028908	SCREW LOCK - M8	4
16	F10028907	PIN - LOCATING	6
15	F10028468	ASSEMBLY NEEDLE SUPPORT LH	18
14	F10028313	ASSEMBLY NEEDLE SUPPORT RH	18
13	F10028131	ASSEMBLY SUPPORT POST, LCLS-I1	3
12	F10026993	ASSEMBLY GV BEARING CLAMP	2
11	F10023305	WELDMENT, HGR PIPE-LCLS-I1 MACHINED	1
10	F10022621	ASSEMBLY WARMUP SUPPORT	5
9	F10022613	ASSEMBLY WARMUP-COOLDOWN LINE	1
8	F10056104	ASSY-KIT 2, INVAR ROD CLAMP	8
7	F10018219	ASSY-KIT 1, INVAR ROD CLAMP	2
6	F10017806	ASSEMBLY 50K SHIELD UPPER	1
5	F10009988	ROD, INVAR	1
4	F10009978	ASSEMBLY, 2K-5K-STEP MOTOR	1
3	F10009530	HOLDER	3
2	F10008910	KIT, COLD MASS SLIDING SUPPORT	2
1	F10008909	KIT, COLD MASS FIXED SUPPORT	1
ITEM	PART#	DESCRIPTION	QTY

PARTS LIST			FERMI NATIONAL ACCELERATOR LABORATORY UNITED STATES DEPARTMENT OF ENERGY		
NAME			ASSEMBLY, COLDMASS UPPER-LCLS-I1		
SCALE	SIZE	DRAWING NUMBER	SHEET	REV	
AS SHOWN	A0	F10009954	1 of 1	N	