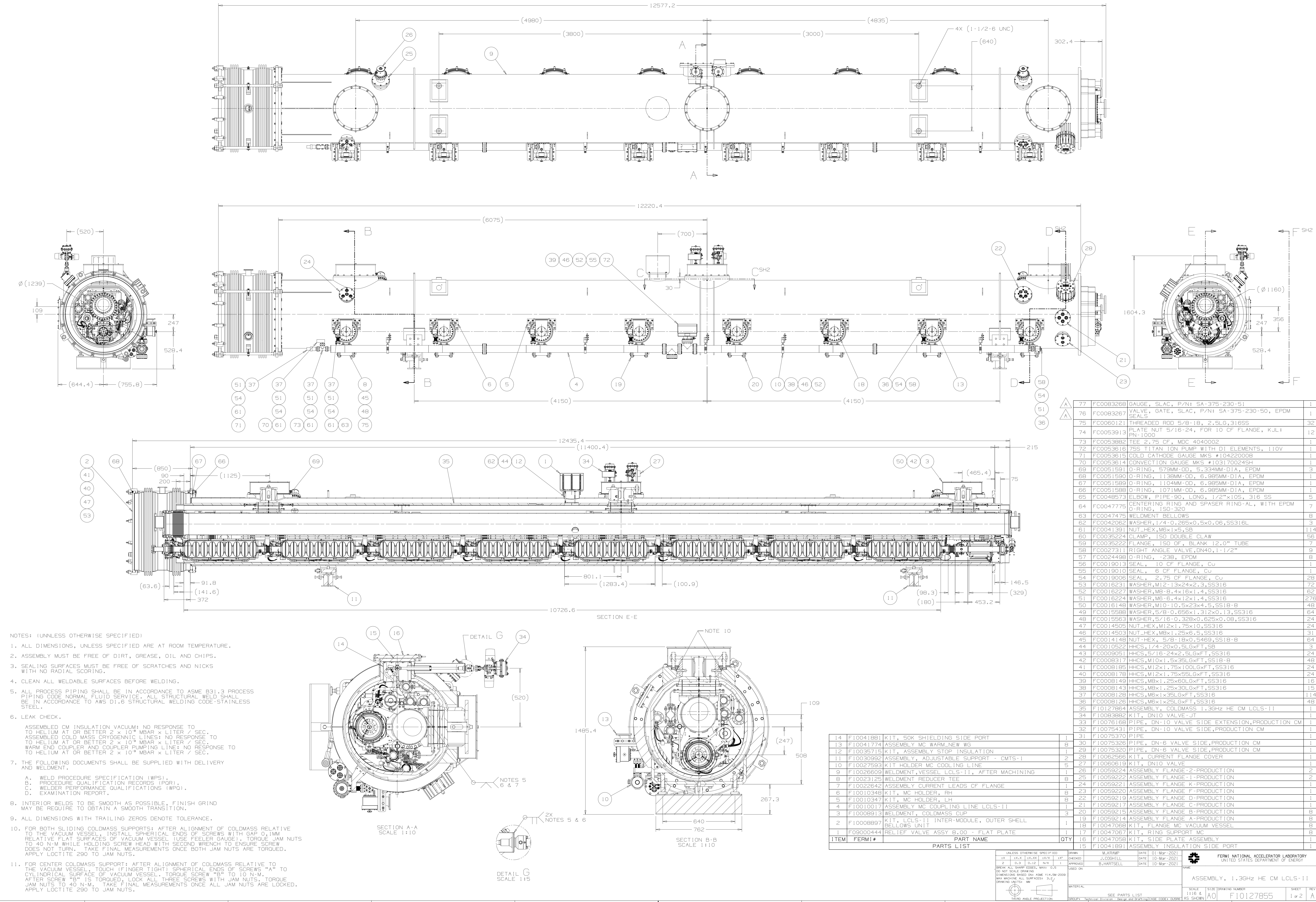


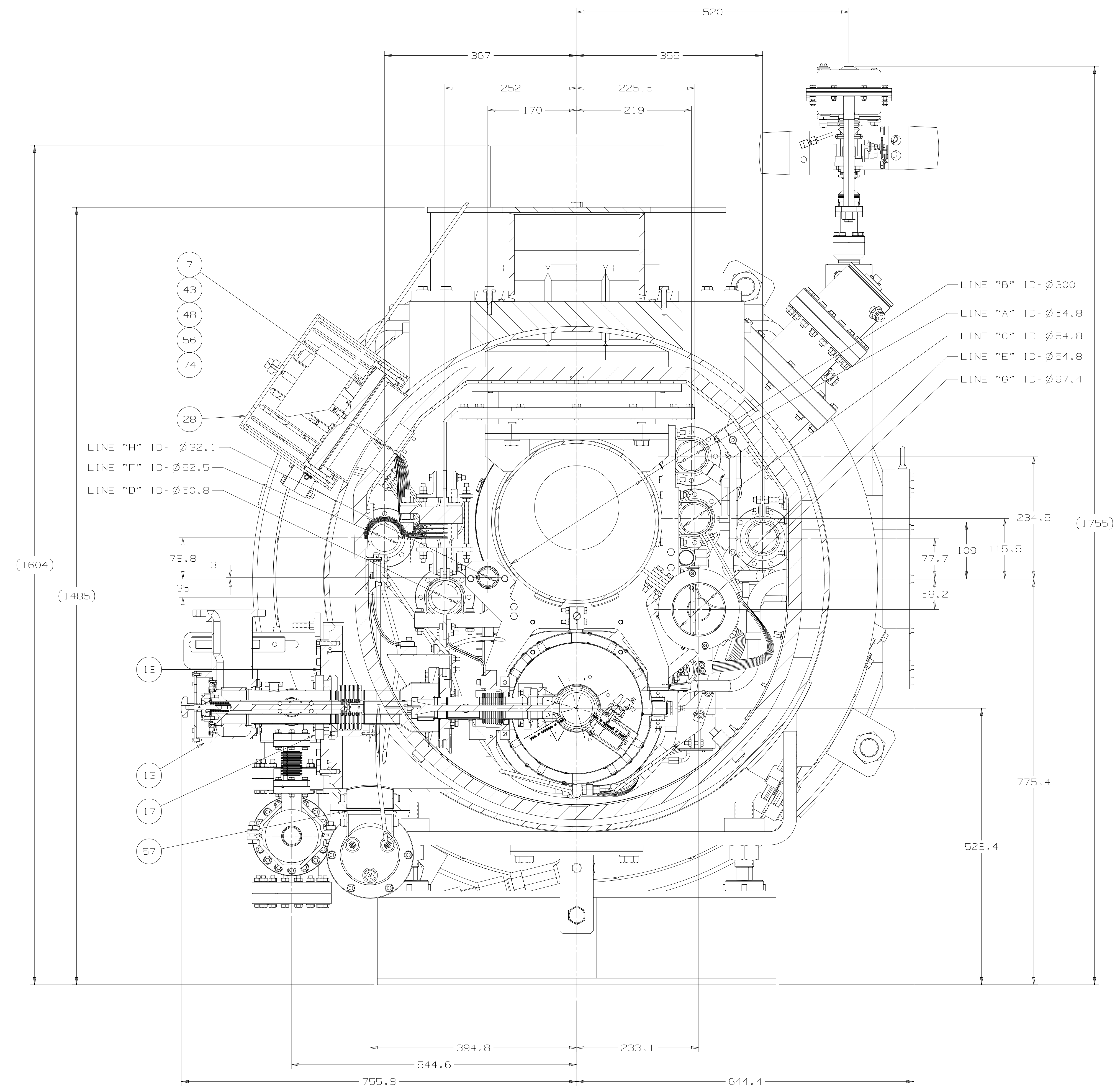
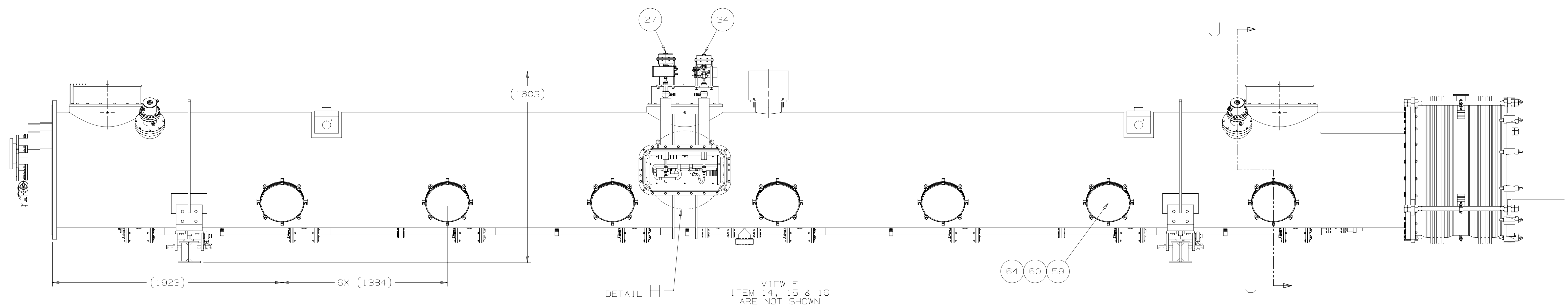


NOTES: (UNLESS OTHERWISE SPECIFIED)

- ALL DIMENSIONS, UNLESS SPECIFIED ARE AT ROOM TEMPERATURE.
- ASSEMBLY MUST BE FREE OF DIRT, GREASE, OIL AND CHIPS.
- SEALING SURFACES MUST BE FREE OF SCRATCHES AND NICKS WITH NO RADIAL SCORING.
- CLEAN ALL WELDABLE SURFACES BEFORE WELDING.
- ALL PROCESS PIPING SHALL BE IN ACCORDANCE TO ASME B31.3 PROCESS PIPING CODE NORMAL FLUID SERVICE. ALL STRUCTURAL WELD SHALL BE IN ACCORDANCE TO AWS D1.8 STRUCTURAL WELDING CODE-STAINLESS STEEL.
- LEAK CHECK.
ASSEMBLED CM INSULATION VACUUM: NO RESPONSE TO HELIUM AT OR BETTER 2 x 10⁻⁶ MBAR x LITER / SEC.
ASSEMBLED COLD MASS CRYOGENNIC LINES: NO RESPONSE TO HELIUM AT OR BETTER 2 x 10⁻⁶ MBAR x LITER / SEC.
WARM END COUPLER AND COUPLER PUMPING LINE: NO RESPONSE TO HELIUM AT OR BETTER 2 x 10⁻⁶ MBAR x LITER / SEC.
- THE FOLLOWING DOCUMENTS SHALL BE SUPPLIED WITH DELIVERY AND WELDMENT.
A. WELD PROCEDURE SPECIFICATION (WPS).
B. PROCEDURE QUALIFICATION RECORDS (PQR).
C. WELDER PERFORMANCE QUALIFICATIONS (WPQ).
D. EXAMINATION REPORT.
- INTERIOR WELDS TO BE SMOOTH AS POSSIBLE, FINISH GRIND MAY BE REQUIRE TO OBTAIN A SMOOTH TRANSITION.
- ALL DIMENSIONS WITH TRAILING ZEROS DENOTE TOLERANCE.
- FOR BOTH SLIDING COLDMASS SUPPORTS: AFTER ALIGNMENT OF COLDMASS RELATIVE TO THE VACUUM VESSEL, INSTALL SPHERICAL ENDS OF SCREWS WITH GAP 0.1MM RELATIVE FLAT SURFACES OF VACUUM VESSEL (USE FEELER GAUGE). TORQUE JAM NUTS TO 40 N-M WHILE HOLDING SCREW HEAD WITH SECOND WRENCH TO ENSURE SCREW DOES NOT TURN. TAKE FINAL MEASUREMENTS ONCE BOTH JAM NUTS ARE TORQUED. APPLY LOCTITE 290 TO JAM NUTS.
- FOR CENTER COLDMASS SUPPORT: AFTER ALIGNMENT OF COLDMASS RELATIVE TO THE VACUUM VESSEL, TOUCH (FINGER TIGHT) SPHERICAL ENDS OF SCREWS "A" TO CYLINDRICAL SURFACE OF VACUUM VESSEL. TORQUE SCREW "B" TO 10 N-M. AFTER SCREW "B" IS TORQUED, LOCK ALL THREE SCREWS WITH JAM NUTS. TORQUE JAM NUTS TO 40 N-M. TAKE FINAL MEASUREMENTS ONCE ALL JAM NUTS ARE LOCKED. APPLY LOCTITE 290 TO JAM NUTS.

ITEM	FERMI #	PART NAME	QTY
14	F10041881	KIT, 50K SHIELDING SIDE PORT	1
13	F10041774	ASSEMBLY MC WARM NEW WG	8
12	F10035715	KIT, ASSEMBLY STOP INSULATION	1
11	F10030992	ASSEMBLY, ADJUSTABLE SUPPORT - CMTS-1	2
10	F10027593	KIT HOLDER MC COOLING LINE	5
9	F10026609	WELDMENT, VESSEL LCLS-II, AFTER MACHINING	1
8	F10023125	WELDMENT REDUCER TEE	2
7	F10022642	ASSEMBLY CURRENT LEADS OF FLANGE	1
6	F10010348	KIT, MC HOLDER, RH	8
5	F10010347	KIT, MC HOLDER, LH	8
4	F10010017	ASSEMBLY MC COUPLING LINE LCLS-II	1
3	F10008913	WELDMENT, COLDMASS CUP	3
2	F10008897	KIT, LCLS-II INTER-MODULE, OUTER SHELL BELLWOWS UNIT	1
1	F09000444	RELIEF VALVE ASSY 8.00 - FLAT PLATE	1
18	F10047058	KIT, SIDE PLATE ASSEMBLY	1
15	F10041891	ASSEMBLY INSULATION SIDE PORT	1

UNLESS OTHERWISE SPECIFIED	DRAWN	DATE	10-MAR-2021
1X	M. KRAMP	DATE	10-MAR-2021
2X	J. COGHILL	DATE	10-MAR-2021
3X	B. HARTSELL	DATE	10-MAR-2021
4X		DATE	
5X		DATE	
6X		DATE	
7X		DATE	
8X		DATE	
9X		DATE	
10X		DATE	



SECTION D-D
SCALE 1:4

