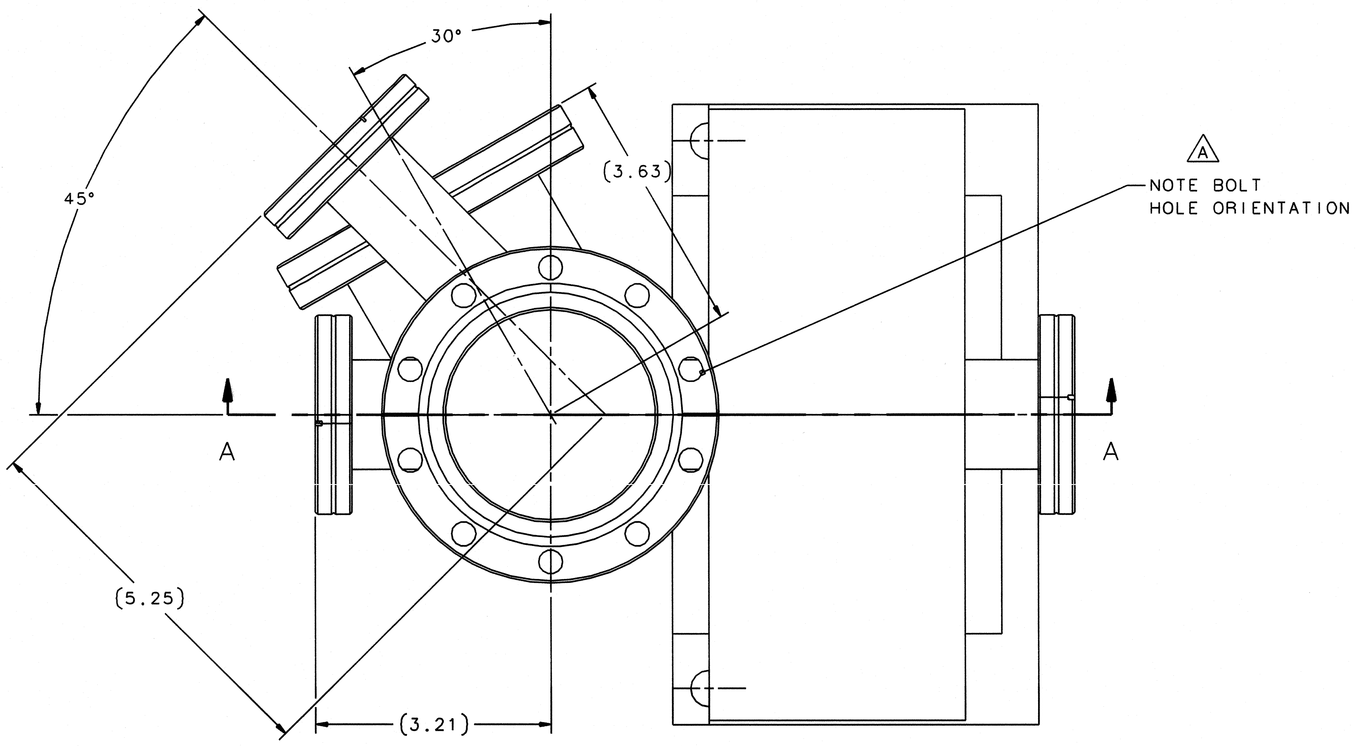
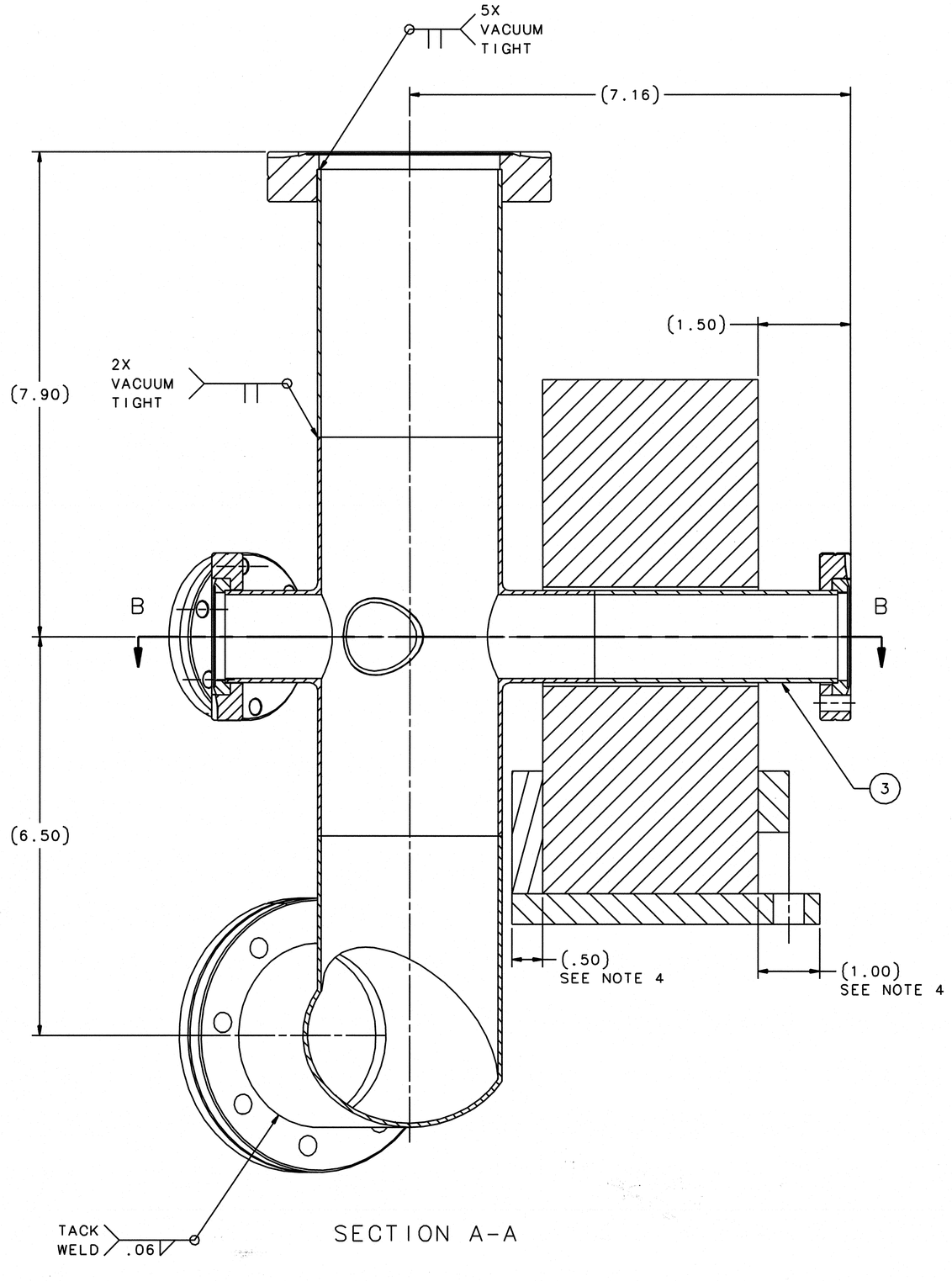
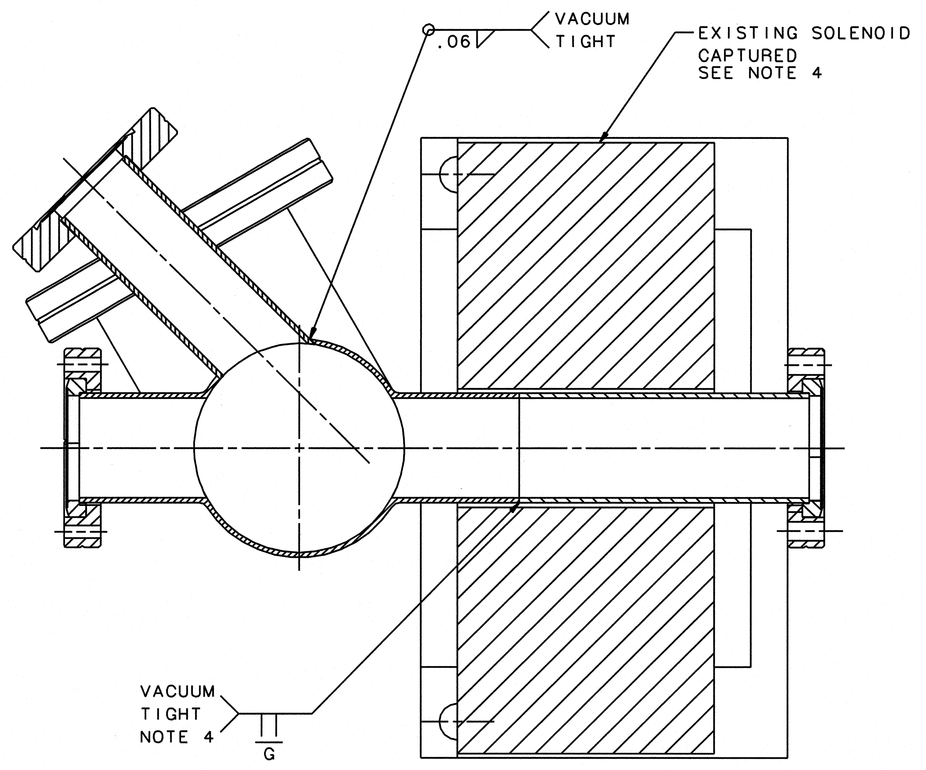
REVISION HISTORY				
ZONE	REV	DESCRIPTION	DATE	APPROVED
7G	A	REVISED: ORIENTATION OF ITEM 4 MRM 7/7/11	7/7/11	

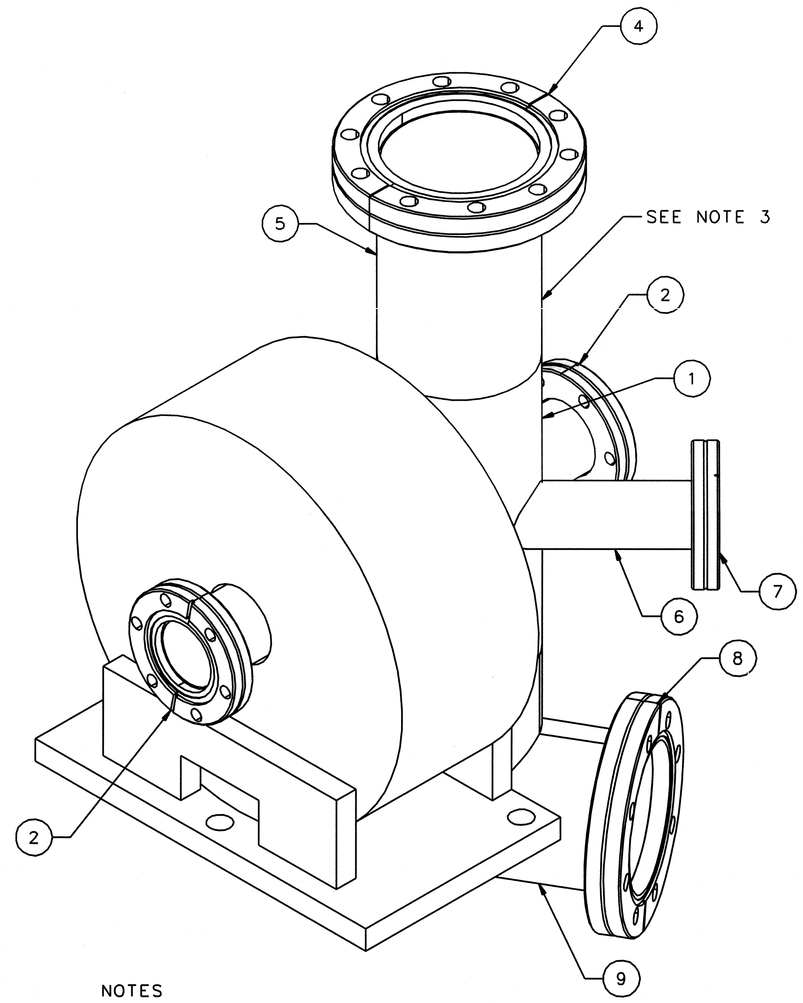




SECTION A-A



SECTION B-B



NOTES

1. USE THE FOLLOWING JLAB SPECIFICATIONS:

   FABRICATION OF U.H.V. 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

2. PROTECT FLANGE FACES DURING AND AFTER PROCESSING WITH SUITABLE PLASTIC CAPS. DAMAGE TO KNIFE EDGES OR OTHER SEALING SURFACES IS UNACCEPTABLE.

3. PART NUMBER TO BE ENGRAVED OR ETCHED IN THE THE APPROXIMATE AREA SHOWN, USING MINIMUM .25 HIGH CHARACTERS. (ACC2005000-0038)

4. AFTER WELDING TUBE (ITEM 3) TO CROSS (ITEM 1), INSTALL SOLENOID ONTO TUBE PRIOR TO WELDING FLANGE (ITEM 2). NOTE ORIENTATION OF SOLENOID; IT IS NOT SYMMETRIC.

PARTS LIST

QTY REQD	ITEM NO	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL SPECIFICATION	NOTES
1	9	NOR-CAL # E-300M	3.00 OD X .065 WALL MITERED ELBOW	304 STAINLESS STEEL	
1	8	ACC2005000-0039	4.50 OD CF NON ROTATABLE FLANGE		
1	7	NOR-CAL # 275-125N	2.75 OD X 1.25 ID NONROTATABLE CF	304 STAINLESS STEEL	
1	6	ACC2005000-0040	1.25 OD X .065 WALL X 4.00 LG TUBE		
1	5		3.00 OD X .065 WALL X 4.37 LG TUBE	304 STAINLESS STEEL	
1	4	NOR-CAL # 462-300N	4.62 OD X 3.00 ID NONROTATABLE CF	304 STAINLESS STEEL	
1	3		1.50 OD X .065 WALL X 3.95 LG TUBE	304 STAINLESS STEEL	
2	2	NOR-CAL # 275-150R	2.75 OD X1.50 ID ROTATABLE CF	304 STAINLESS STEEL	
1	1	ACC2005000-0041	MOD 3.00 X 1.50 REDUCER CROSS		

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

FOR JLAB INTERNAL USE ONLY

ALL WELDS ON THIS DRAWING ARE AS DEFINED BY JLAB ES & H MANUAL CHAPTER 6122 App T6.

DOCUMENT CONTROL STAMP

DIM & TOL PER ASME Y14.5
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ARE:
FRACTIONS ± N/A DECIMAL X ± .1, XX ± .01, XXX ± .005 ANGLES ± 30'

TRACKING NO N/A

THIRD ANGLE PROJECTION

APPROVALS	DATE
DRAWN M R MAJOR	30JUN11
CHECKED D MACHIE	7/6/2011
APPROVED B W POELKER	7/6/2011
APPROVED J GRAMES	7/6/11

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

ACC
INJECTOR
POSITRON
TARGET CHAMBER ASSEMBLY

WELD CLASS	WELD SPECIFICATION	MATERIAL	FINISH MACHINED SURFACES
C	#22633-S-001	AS NOTED	N/A √ UNLESS OTHERWISE NOTED DEBURR & BREAK ALL SHARP EDGES
	WELD ANALYSIS N/A		DO NOT SCALE DRAWING

SIZE E | DWG NO ACC-200-5000-0038 | REV A

SCALE 1:1 | USED ON ASSY NO N/A | SHEET 1 OF 1