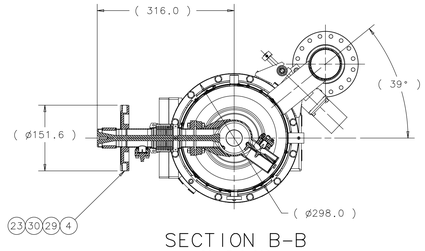
NOTES (UNLESS OTHERWISE SPECIFIED):

1. ALL DIMENSIONS, UNLESS SPECIFIED, ARE IN ROOM TENPERATURE.
2. ASSEMBLY PER FERMILAB ENGINEERING SPECIFICATION: 5520.000-ES-
3. TRIM AND CLEAN 2-PHASE PIPE BEFORE WELDING ITEMS #3. THE INSTALLATION DISTANCE IS FREE LENGTH FOR ITEM #3.
4. MAINTAIN A DIRT & GREASE - FREE WORKING ENVIRONMENT, KEEPS ALL PARTS AND ASSEMBLIES FREE OF DIRT, GREASE, OIL AND CHIPS.
5. FABRICATE ALL PIPING CONNECTION PER ASME B31.3, MORMAL FLUID SEVICES.
6. THE FOLLOWING DOCUMENTS SHALL BE SUPPLIED:
   A. WELDS PROCEDURE SPECIFICATION (WPS).
   B. PROCEDURE QUALIFICATION RECORDS (PQR).
   C. WELDER PERFORMANCE QUALIFICATION (WPQ).
   D. EXAMINATION REPORT.
7. WELD TO BE PERFORMED USING AN ARGON SHIELD, ROTARY WELDING TOOL WITH AN INNER ARGON SHIELD-50% ARGON/50% HELIUM.NO VISIBLE SIGNS OF OXIDATION ARE ALLOWED.
8. ALL CONTINUOUS WELDS TO BE VACUUM LEAK TIGHT. NO LEAK SHALL BE DETECTABLE ON THE MOST SENSITIVE SCALE OF A HELIUM LEAK DETECTOR WITH A MINIMUM SENSITIVITY OF 10^{-10} ATM. CC/SEC.
9. PROTECT ALL SEALING SURFACES FROM DENTS AND SCRATCHES.

REVISION HISTORY

CAD MAINTAINED. CHANGES SHALL BE INCORPORATED BY THE DESIGN ACTIVITY.

ZONE	REV	DESCRIPTION	DATE	CHECKED	APPROVED
	A	INITIAL RELEASE			



SECTION B-B
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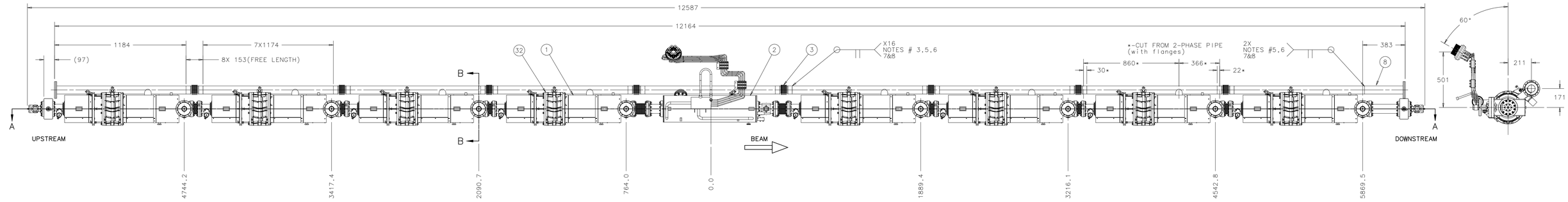
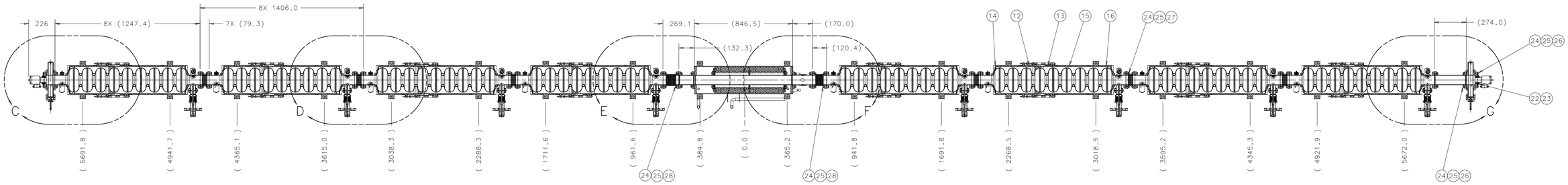
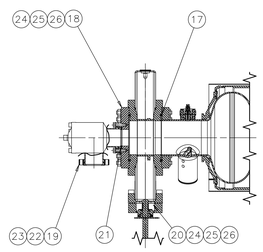
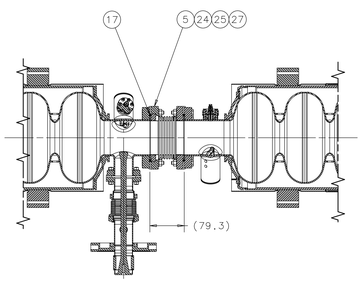




SECTION A-A



DETAIL C
SCALE 0.200



DETAIL D
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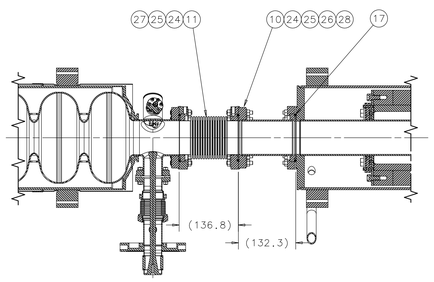

DETAIL E
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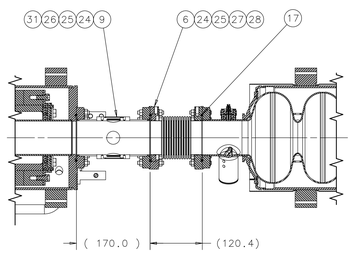

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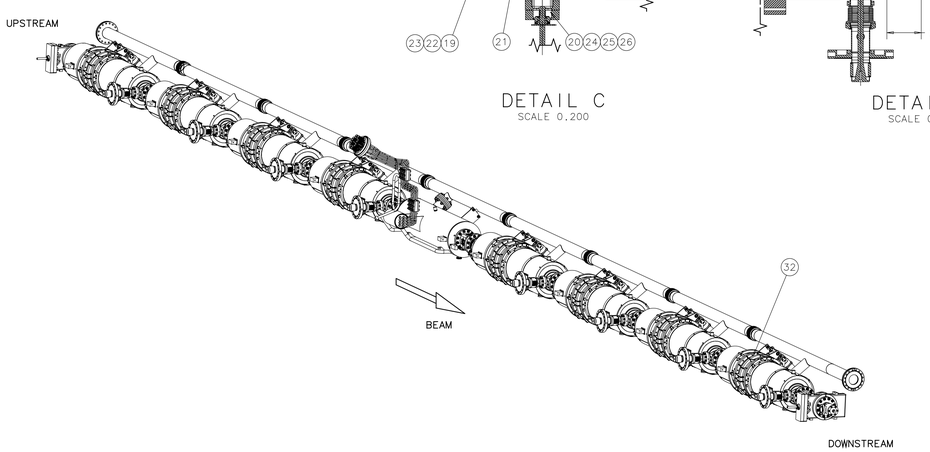

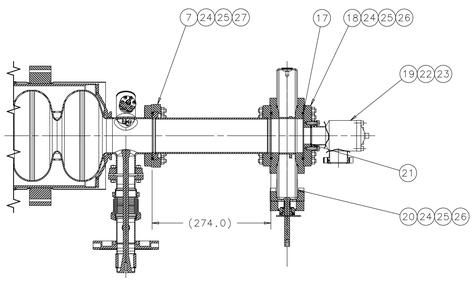

DETAIL F
SCALE 0.200

ITEM	P.I.N.	DESCRIPTION	QTY
32	886555	ASSY-PIEZO SLIM TUNER INFN	8
31	922495	PIN CORRECTOR-BPM	2
30	COM'L	NUT M6-1.0, Si BRONZE	128
29	COM'L	ROD THRD M6-1.0 X 40, SS316	64
28	COM'L	ROD THRD M8-1.25 X 65, SS316	24
27	COM'L	ROD THRD M8-1.25 X 50, SS316	180
26	COM'L	SET SCREW M8-1.25 X40, SS316	72
25	COM'L	NUT M8-1.25, Si BRONZE	276
24	COM'L	WASHER M8, SS316	276
23	COM'L	WASHER M6, SS316	140
22	COM'L	HHS M6-1.0 X 25, SS316	12
21	COM'L	COPPER GASKET MDC P/N 191004	2
20	COM'L	RF ALL METAL GATE VALVE	2
19	COM'L	VAT VALVE ANGLE 54032-GE02-0002	2
18	880125	FLANGE END-ADAPTOR	2
17	MB-439232	SEAL FOR NW78 FLANGE	22
16	792835	1-3GHZ MAGNETIC SHIELD CPLR ASSY	8
15	792825	1-3GHZ MAGNETIC SHIELD DWNSTR ASSY	8
14	792655	1-3GHZ MAGNETIC SHIELD UPSTR ASSY	8
13	792815	1-3GHZ MAGNETIC SHIELD BT2 ASSY	8
12	792635	1-3GHZ MAGNETIC SHIELD BT1 ASSY	8
11	870205	BELLOWS LONG WELDMENT	1
10	954135	EXTENSION-2 WELDMENT	1
9	MC-460390	COLD BPM HOUSIG ASSEMBLY	1
8	789555	2-PHASE HE PIPE EXTENSION	2
7	880285	EXTENSION WELDMENT	1
6	911695	BELLOWS WELDMENT	1
5	819055	BELLOWS INTERCONNECT WWLDMENT	6
4	3964328A000	COUPLER TTF III, COLD ASSEMBLY	8
3	858465	BELLOW WELDMENT HE PIPE	8
2	926125	DOUBLET T4CM ASSEMBLY	1
1	872825	G3 HE VESSEL RF CAVITY ASSEMBLY	8

PARTS LIST

NEXT ASSY	USED ON
-	-

APPLICATION

FINISH: N/A

MATERIAL: SEE PART LIST

UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN MILLIMETERS
INTERPRET DIM PER ASME Y14.5M-1994
BREAK ALL SHARP EDGES .75 MAX.
ALL MACH. SURFACES 3.2 MAX.

TOLERANCES: X ± 2, .X ± 0.8, .XX ± 0.13, ANGLE ± 1°

THIRD ANGLE PROJECTION

		DATE
DRAWN BY	Y. ORLOV	23NOV11
CHECKED BY		
ENGINEERED BY		
DATABASE	DESY EDMS	TEAM/GROUP
CAD	I-DEAS	SOLID MODEL NO. D00000000999483

FERMI NATIONAL ACCELERATOR LABORATORY
UNITED STATES DEPARTMENT OF ENERGY
P.O. BOX 500, BATAVIA, IL 60510-0500

TITLE: ILC TYPE IV CRYOMODULE COLD MASS ASSEMBLY (WITH MAGNET) CAVITY STRING-ASSY-T4CM

SIZE	CAGE CODE	DWG NO.	REV
A0	0U5R6	D00000000819885	A

SCALE 1:8 | DO NOT SCALE DRAWING | SHEET 1 OF 1

Created: 10:20:26 on 23-11-11 (D-M-Y) By: orlov State: 1-INITIAL