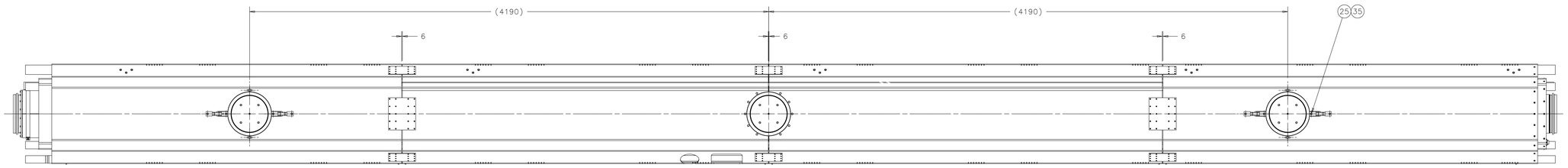
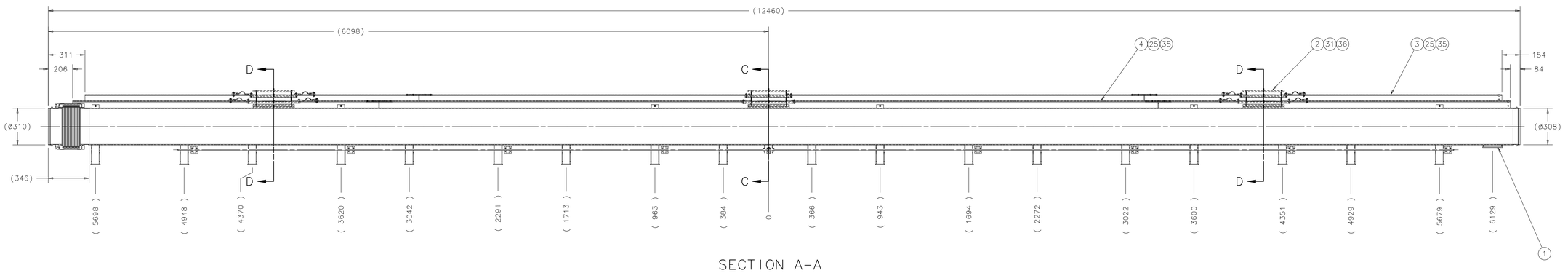
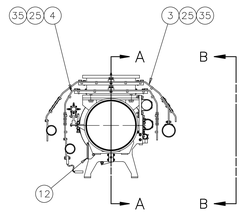
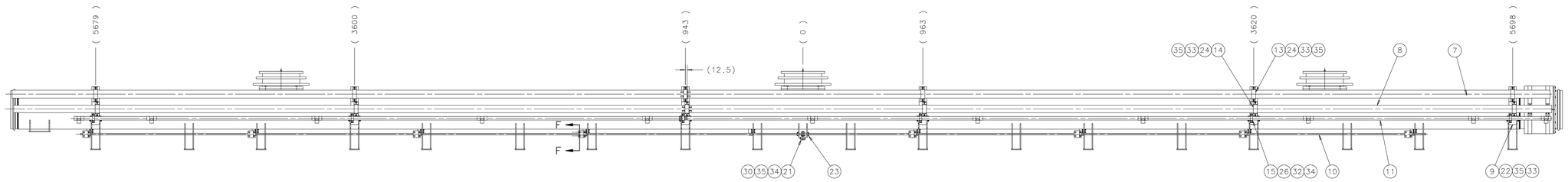
REVISION HISTORY					
CAD MAINTAINED, CHANGES SHALL BE INCORPORATED BY THE DESIGN ACTIVITY.					
ZONE	REV	DESCRIPTION	DATE	CHECKED	APPROVED
	A	INITIAL RELEASE			





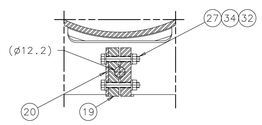
SECTION A-A





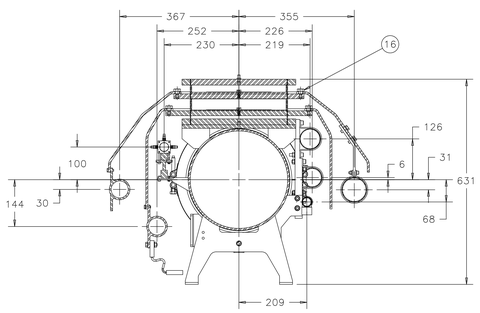
WIEW B-B

ITEMS ##3 & 4 NOT SHOWN



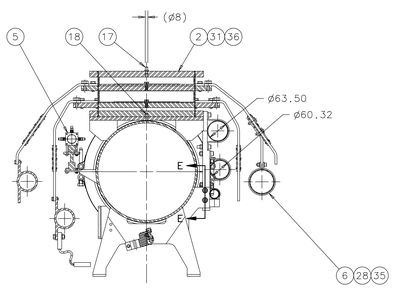
SECTION F-F

SCALE 0.400



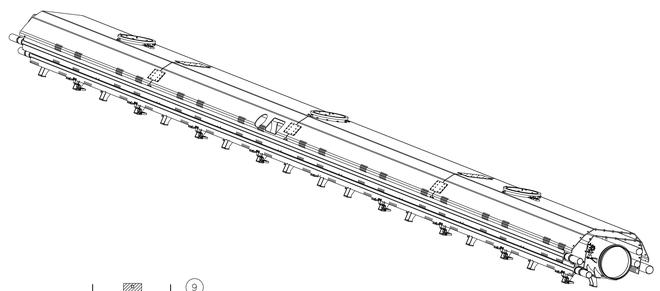
SECTION D-D

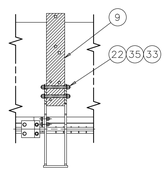
SCALE 0.150



SECTION C-C

SCALE 0.150





SECTION E-E

SCALE 0.140

ITEM	P.I.N.	DESCRIPTION	QTY
36	COM'L	WASHER M16, 316 SS	12
35	COM'L	WASHER M8, 316 SS	95
34	COM'L	WASHER M6, 316 SS	124
33	COM'L	HEX NUT M8-1.25, 316 SS	34
32	COM'L	HEX NUT M6-1.0, 316 SS	62
31	COM'L	HEX HCS M16-2 X 35, 316 SS	12
30	COM'L	HEX HCS M8-1.25 X 40, 316 SS	2
29	COM'L	HEX HCS M8-1.25 X 25, 316 SS	28
28	COM'L	HEX HCS M8-1.25 X 20, 316 SS	15
27	COM'L	HEX HCS M6-1 X 40, 316 SS	32
26	COM'L	HEX HCS M6-1 X 35, 316 SS	12
25	COM'L	HEX HCS M6-1 X 25, 316 SS	18
24	COM'L	SOCKET HCS M8-1.25 X 35, 316 SS	24
23	COM'L	COLLAR, McMASTER #3369K17, OR EQ.	2
22	COM'L	THREADED ROD M8-1.25 X 100, 316 SS	12
21	806525	CLAMP INVAR-QUAD	1
20	905085	PLATE INVAR ROD	16
19	905105	BLOCK INVAR ROD	16
18	need DWG	PIN LOCATING (UB-501, Reid supply)	3
17	MB-442643	PIN LOCATION	3
16	need DWG	SCREW LOCK-M8 (see MB-440196)	4
15		CLAMP STEP MOTOR	6
14		CLAMP 5K FWD	6
13		CLAMP 2K FWD	6
12	732831	BRACKET 2K WARMUP PIPE SUPPORT	9
11		STEPING MOTOR PIPE	1
10	905075	ROD INVAR	1
9	792855	BRACKET MNTNG FWD PIPE	6
8	792845	FWD PIPE 5K WLDMT	1
7	731931	FWD PIPE 2.2K WLDMT	1
6	763621	40K PIPE ASSY	1
5	908845	WPM-ASSY GROUP	1
4	807615	4K SHIELD UPPER WELDMENT-MAGNET	1
3	904345	80K SHIELD UPPER WLDMT ASSY	1
2	756951	POST ASSEMBLY	3
1	784035	HGR PIPE W-MAG MACH	1

PARTS LIST

NOTES (UNLESS OTHERWISE SPECIFIED):

1. ASSEMBLY MUST BE FREE OF DIRT, GREASE, OIL AND CHIPS.
2. ASSEMBLY TO BE FREE OF ALL SHARP EDGES, CORNERS, AND BURRS.
3. ALL DIMENSIONS ARE IN MILLIMETERS; DIMENSIONS IN [.XX] ARE IN INCHES.

NEXT ASSY	USED ON
APPLICATION	

FINISH: N/A

MATERIAL: N/A

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

DRAWN BY: Y. ORLOV	DATE: 18OCT11	
CHECKED BY	DATE	
ENGINEERED BY	DATE	
DATABASE: DESY EDMS	TEAM/GROUP	
CAD: I-DEAS	SOLID MODEL NO.: N/A	

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) COLD-MASS_UPPER-ASSY

SIZE	CAGE CODE	DWG NO.	REV
A0	0U5R6	D00000000960995	A

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

Created: 16:06:14 on 18-10-11 (D-M-Y) By: orlov State: 1-INITIAL