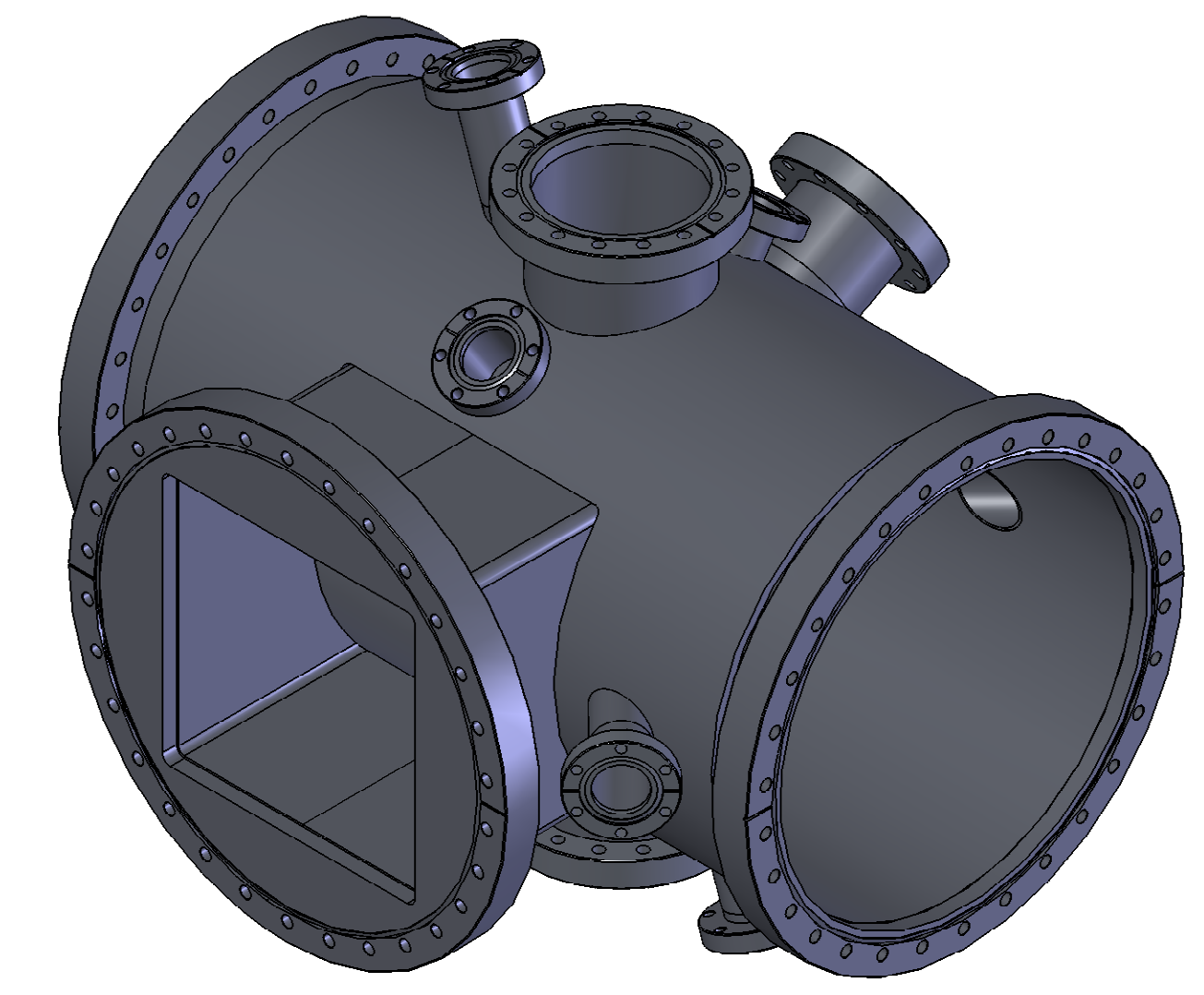
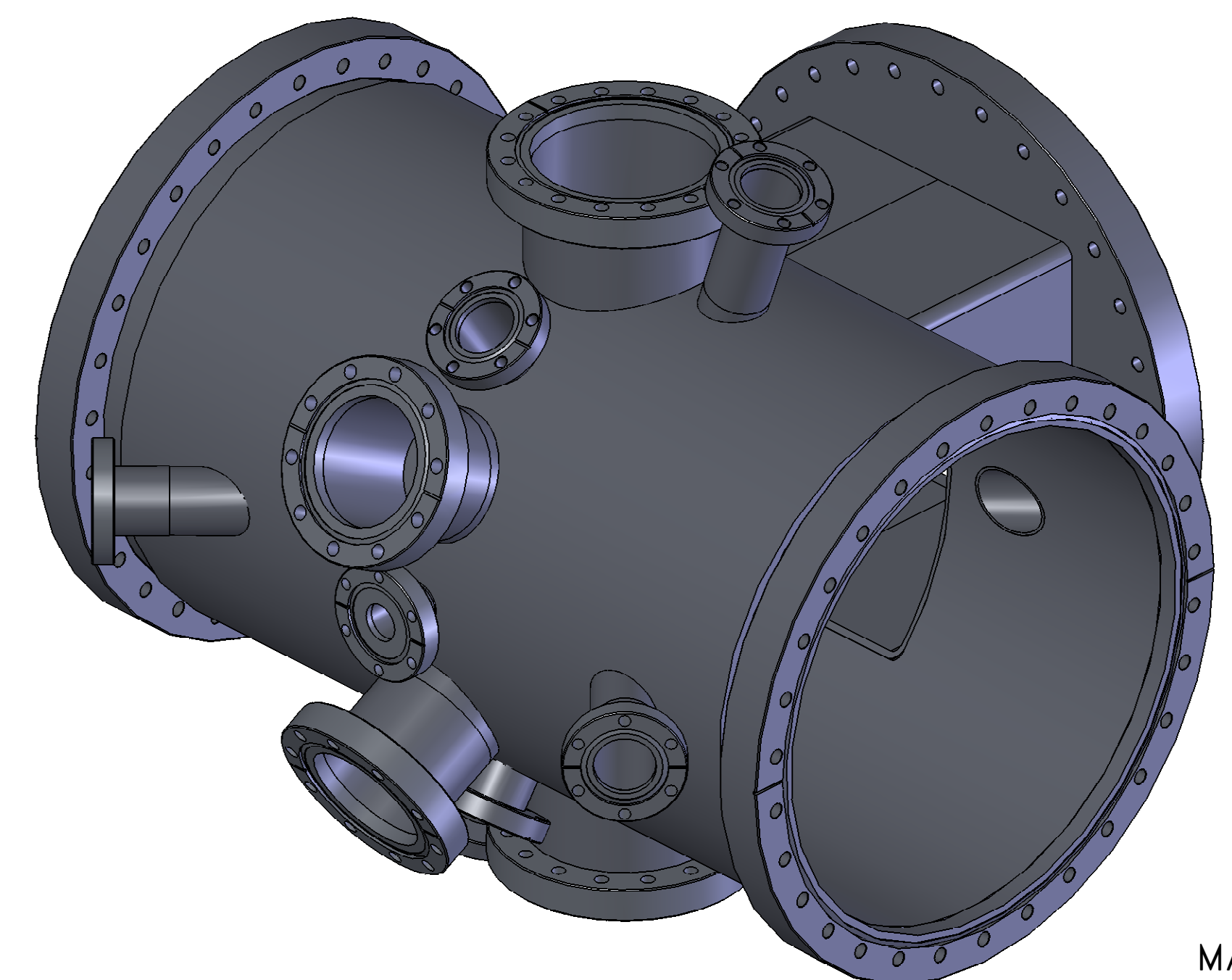
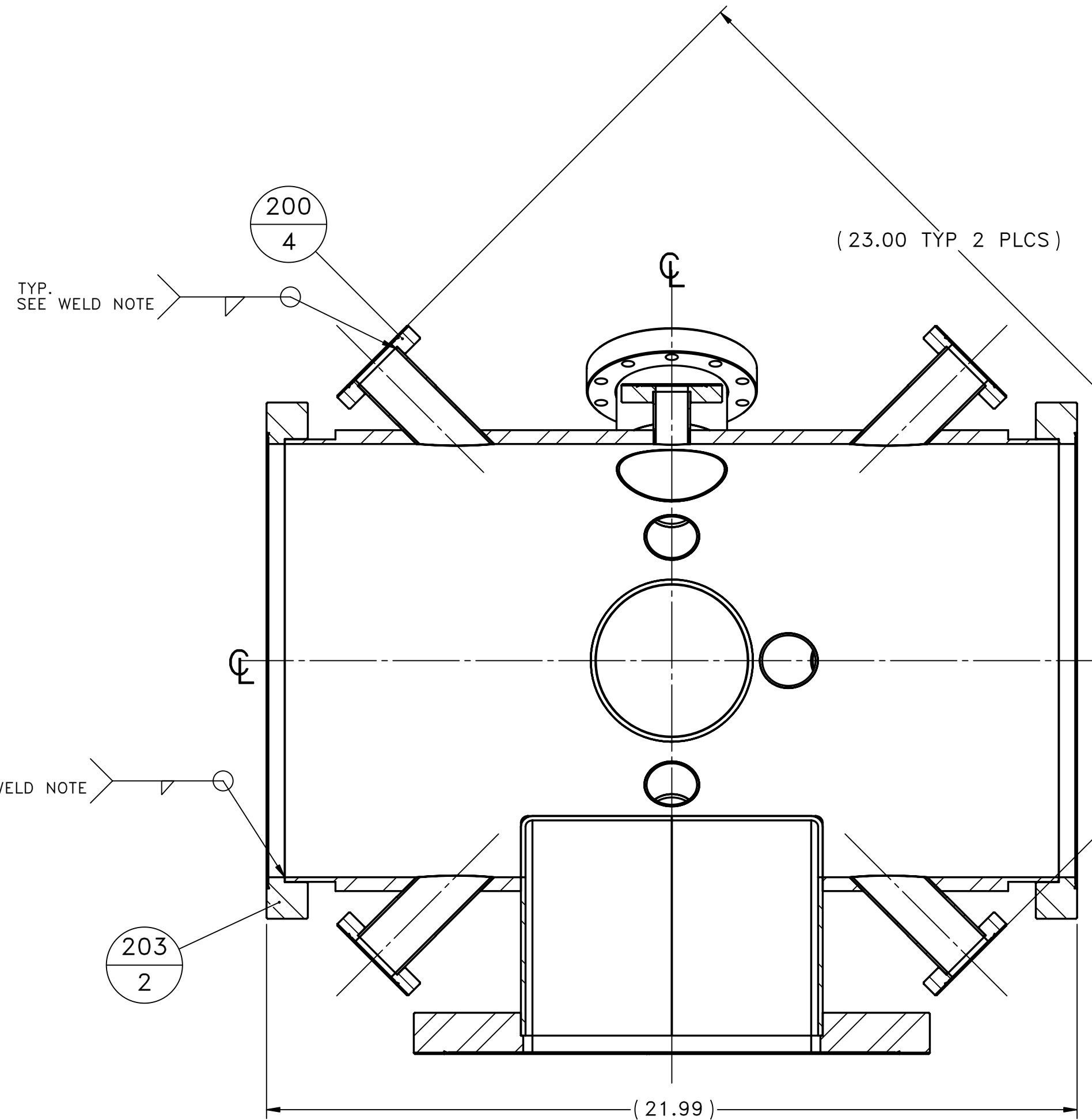
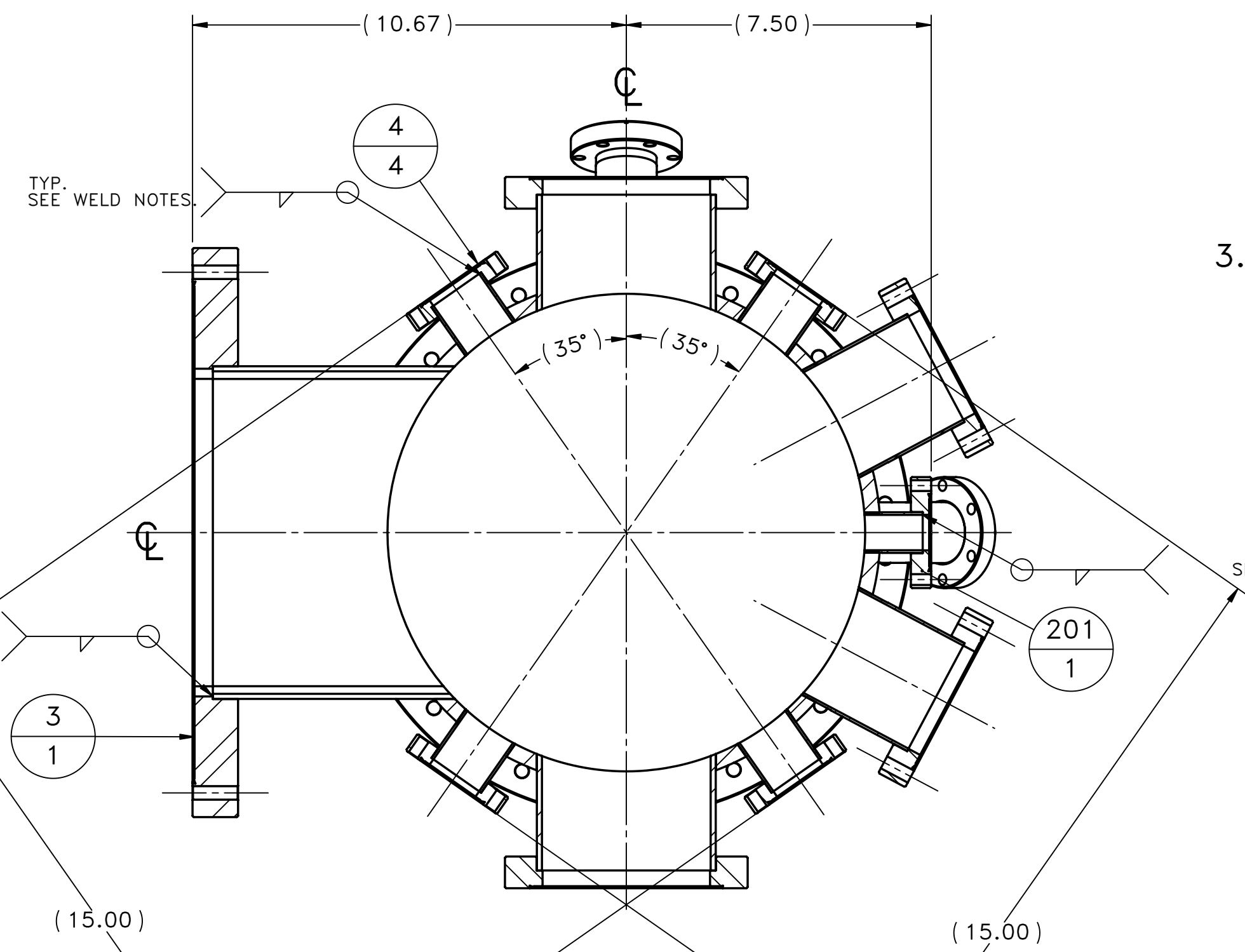
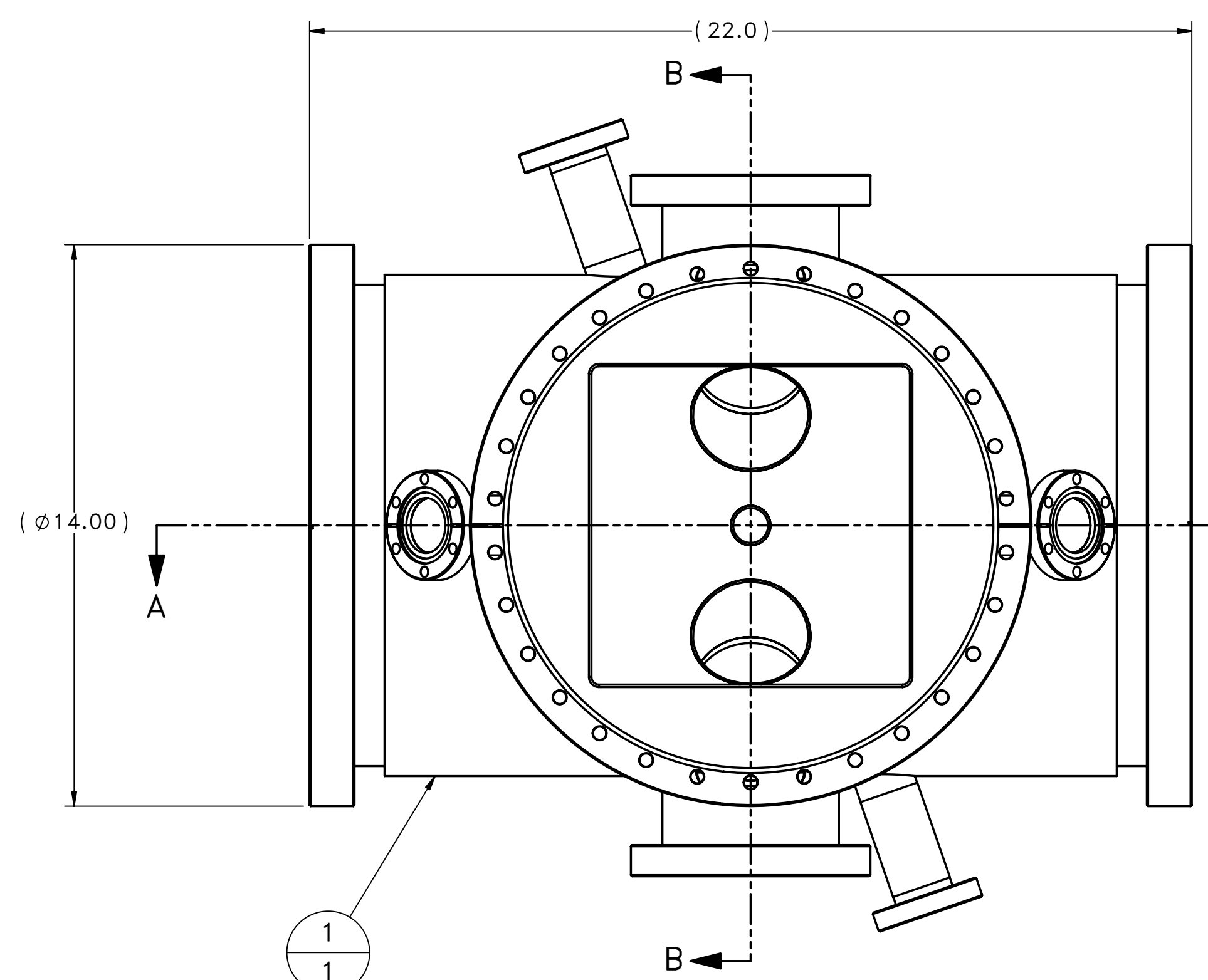


ITEM	REF No.	DESCRIPTION	MATERIAL	QTY.
1	ILE2314	WELD ASSEMBLY TUBES TO CHAMBER	S.S.	1
2	ILE2324	6" CF MOD, THRU BOLT HOLE, NON ROTATABLE	AISI 304	2
3	ILE2325	14" CF MOD, THRU BOLT HOLE, NON ROTATABLE	AISI 304	1
4	ILE2326	2.75 CF MOD	AISI 304	6
200	MDC-110014	CF FLANGE, NONROTATABLE, THRU BOLT HOLE, OD 2.75 X TUBE 1.50	AISI 304	4
201	MDC-110012	CF FLANGE, NONROTATABLE, THRU BOLT HOLE, OD 2.75 X TUBE 1.00	AISI 304	1
202	MDC-110024	CF FLANGE, NOROTATABLE, THRU BOLT HOLE, OD 4.63 X TUBE 3.00	AISI 304	2
203	MDC-110038	CF FLANGE, NON ROTATABLE, THRU BOLT HOLE, O.D. 14.00 x TUBE 12.00	AISI 304	2



MANUFACTURING PROCESS:

- MACHINE ALL PARTS ACCORDING TO THEIR DETAILS ENSURING THAT ENOUGH MATERIAL IS LEFT ON FOR FINAL MACHINING OPERATIONS ON DWG. ILE2314.
- PERFORM WELDING PROCEDURE ON DWG. ILE2314D ACCORDING TO SPECIFICATIONS.
 - VACUUM CHECK PORTS AND REPAIR ANY LEAKS IN EXCESS OF 1.0×10^{-10} TORR-LITRE/SEC.
 - MACHINE ALL TUBE ENDS ACCORDING TO THEIR SPECIFICATION.
- PERFORM WELDING PROCEDURE ON DWG. ILE2313D ACCORDING TO SPECIFICATIONS.
 - VACUUM CHECK PORTS AND REPAIR ANY LEAKS IN EXCESS OF 1.0×10^{-10} TORR-LITRE/SEC.



- WELD NOTE:
- SCRIBE LINES ON FLANGES FOR ALIGNMENT.
 - WELDS TO BE AUTOGENOUS
 - WELDS MUST BE INTERNAL AND LEAK CHECKED 10^{-10}
 - ANY LEAKS IN EXCESS OF 1.0×10^{-10} TORR-LITRE/SEC MUST BE REPAIRED.

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DESIGNED	A.M.	SUB-ASSY:	
DRAWN	Daniel Rowbotham	ASSEMBLY:	
CHECKED	A.M.		
REA #	1030		
TRACKING #			

REV	DATE	ZONE	REVISION DESCRIPTION	APPROVED
B	5/28/2010		ECO-2167 - Added item #4	A.G.
A	5/14/2010		ECO-2165 - Change control appls.	A.G.

		CANADA'S NATIONAL LABORATORY FOR PARTICLE AND NUCLEAR PHYSICS	
4004 WESBROOK MALL VANCOUVER, BRITISH COLUMBIA CANADA V6T-2A3			
SCALE: 1:3 DATE: 02-05-10		DWG. NO.: ILE2313 SIZE: D SHEET: 1 OF 2 REV: B	

