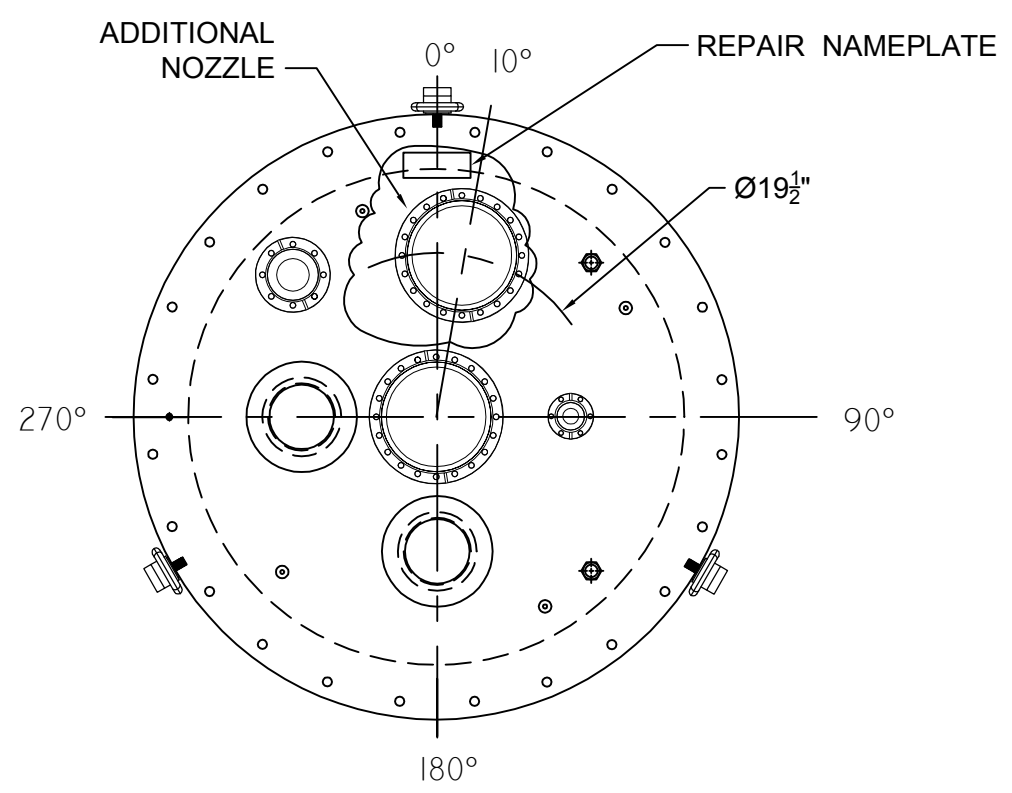
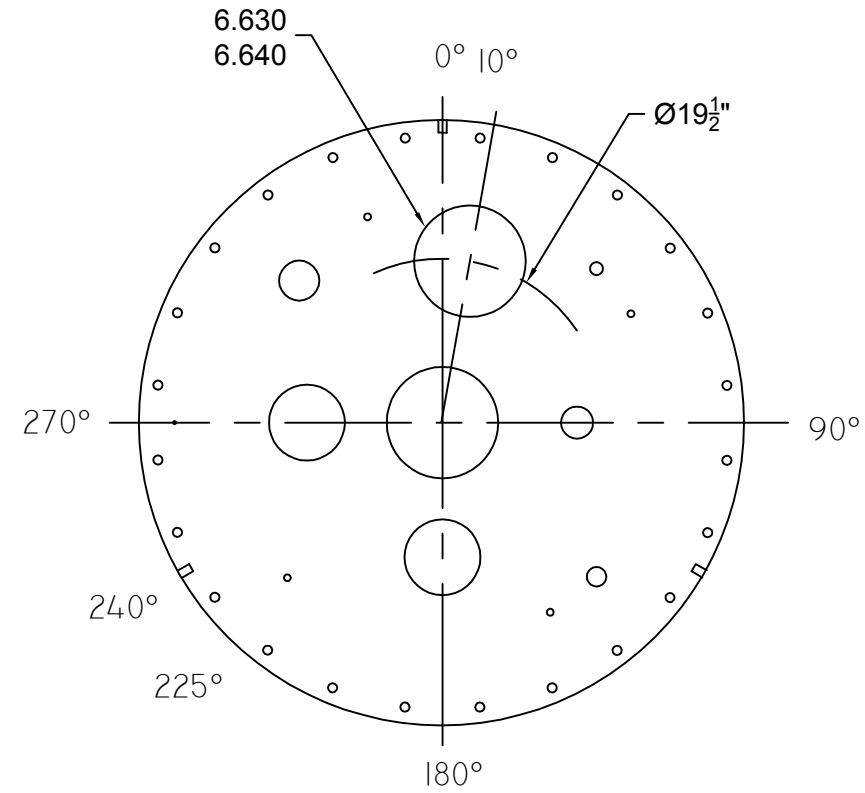


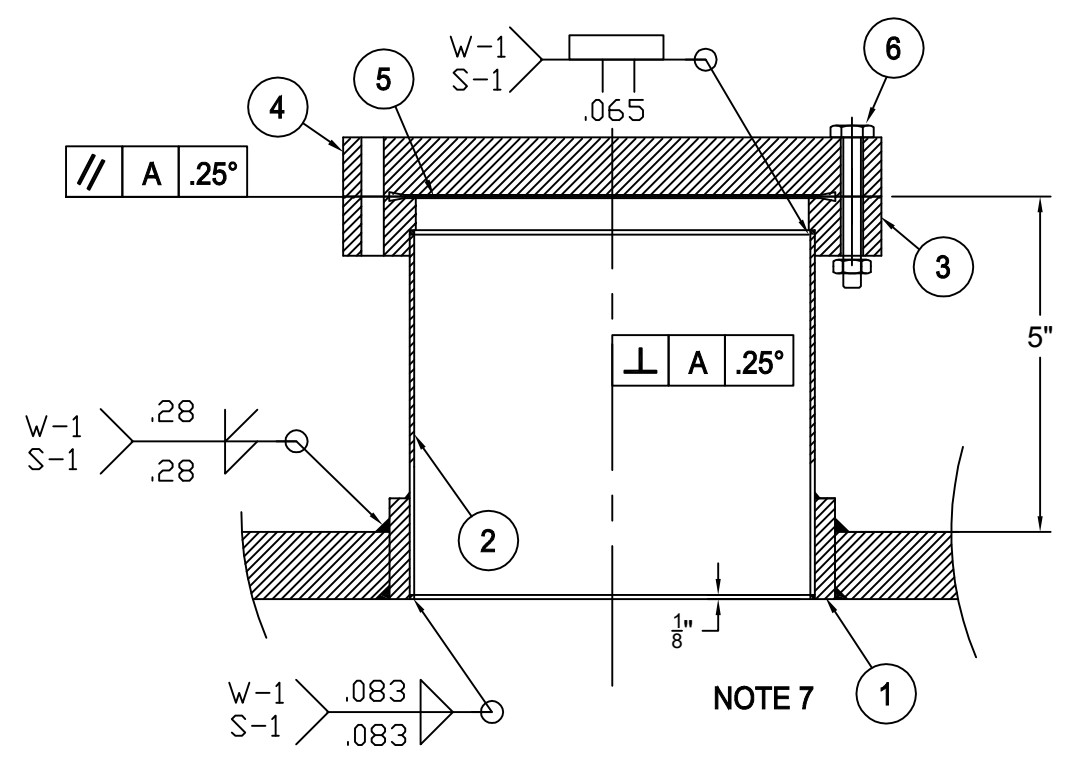
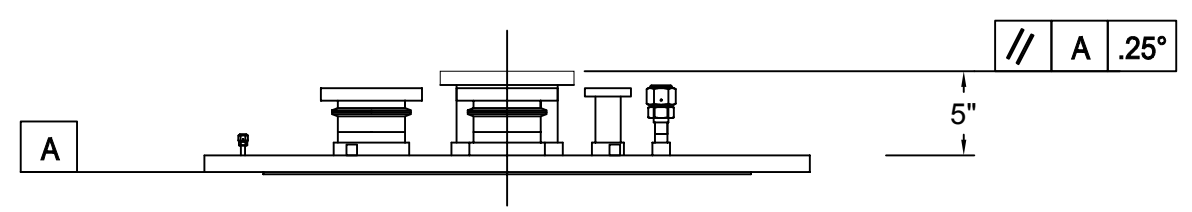
ITEM	QTY.	BILL OF MATERIALS	MATERIAL	PART NO.
1	1	6"-SCH 80 PIPE 1 3/4" LG MACHINED TO 6.02" I.D.	SA-312-TP-304	
2	1	6" O.D. x 0.083" WALL TUBING 5 1/2" LG	SA-249-TP-304	
3	1	800-600N CF FLANGE	S.S.	
4	1	800-000N BLANK FLANGE	S.S.	
5	1	COPPER GASKET 800 CG	COPPER	
6	20	5/16-24 x 2 1/4" SILVER PLATED BOLT, NUT & WASHER 800-BK-12-S		



PLAN

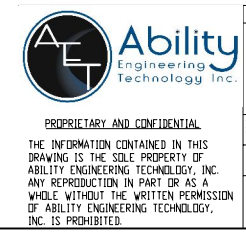


- DESIGN AND MANUFACTURING REQUIREMENTS**
- 1.0 DESIGNED AND FABRICATED IN ACCORDANCE WITH THE 2013 EDITION OF THE ASME BOILER AND PRESSURE VESSEL CODE SECTION VIII, DIVISION 1. FOR 20 PSI. AND FULL VACUUM M.A.W.P. AT 100°F MAXIMUM, -320°F MINIMUM.
 - 2.0 TEST 40 PSIG. PNEUMATIC.
 - 3.0 CLEAN VESSEL OF FOREIGN MATTER, GREASE, WELD SPATTER, ETC., BREAK ALL SHARP EDGES.
 - 4.0 CORROSION ALLOWANCE: NONE
 - 5.0 X-RAY: NONE
 - 6.0 CRITICAL ANGULAR DIMENSIONS:
NOZZLES 1 AND 6 MUST BE VERTICAL WITHIN +/- 0.25°
TOP OF FLANGE/VCR ON NOZZLES 1 AND 6 MUST BE HORIZONTAL WITHIN +/- 0.25°
 - 7.0 BORE THIS ITEM TO FIT NOZZLE WITHIN 0.005"
 - 8.0 FOLLOW DIMENSIONAL TOLERANCES IN DRAWING TITLE BLOCK UNLESS OTHERWISE NOTED



ADDITIONAL NOZZLE DETAIL

Frank Yehling



UNLESS OTHERWISE SPECIFIED:		NAME	DATE	CUSTOMER:
DIMENSIONS ARE IN INCHES		DRAWN	MM/HH	09/30/13
TOLERANCES:		CHECKED		
DECIMAL .XX = +0.01		ENG APPR.		
XXX = +0.01		MFG APPR.		
XXXX = +0.005		QA		
ANGULAR *0.50°		COMMENTS:		
INTERPRET GEOMETRIC TOLERANCING PER ASME Y14.5-2009				
FINISH UNLESS OTHERWISE NOTED				
BOURR AND BREAK ALL SHARP EDGES				
TITLE:				FERMI NATIONAL LABORATORY
TITLE:				MICROBOONE HIGH VOLTAGE CRYOSTAT TOP FLANGE ASSEMBLY
SIZE	DWG. NO.	REV		
D	8636-5475	1		
SCALE: VARIES				SHEET 1 OF 1