NOTES:

1. WEIGHT OF WELDMENT IS APPROXIMATELY 265 LBS AFTER ALL MACHINING IS COMPLETE. SEE SHEET 2.
2. ALL WELDING SHALL HAVE QUALIFIED WELDING PROCEDURE SPECIFICATIONS (WPS), AND WELDER PERFORMANCE QUALIFICATION (WPQ) FOR WELDERS AVAILABLE FOR REVIEW. ALL WPS AND WPQ SHALL BE QUALIFIED TO THE LATEST EDITION OF AWS D1.1 OR ASME SECTION IX IN THE PERFORMANCE OF THIS WORK.
3. THE APPLICABLE CODE WILL BE D1.1 FOR FABRICATION, EXAMINATION, AND INSPECTION CRITERIA. ALL INSPECTIONS SHALL BE DONE BY PERSONNEL QUALIFIED IN ACCORDANCE TO THE LATEST EDITION OF THE RECOMMENDED PRACTICES OF ASNT-TC-1A.
4. ALL WELDING RELATED MATERIAL SHALL BE VERIFIED BY THE WELDING SUPERVISOR.
5. EITHER CERTIFICATION OF CONFORMANCE TO 1018 HR STEEL OR MATERIAL TESTING REPORT IS REQUIRED, AND SHALL BE PRESENTED TO THE RESPONSIBLE ENGINEER AT THE END OF THE PROJECT.
6. 100% VISUAL EXAMINATION PER AWS D1.1 IS REQUIRED. THE EXAMINATION RECORDS AND REPORTS ARE REQUIRED, AND SHALL BE PRESENTED TO THE RESPONSIBLE ENGINEER AT THE END OF THE PROJECT.
7. THE JLAB RISK CODE IS 4; ALL WELDS ARE JLAB CLASS "A"; JLAB WPS 006 REVISION 1 SHALL BE USED. HOWEVER, IF THE WELDMENT IS FABRICATED BY A VENDOR OF JLAB, THIS SPECIFIC REQUIREMENT SHALL BE IGNORED.
8. ALL SURFACES ON WELDMENT SHALL BE HAND OR POWER TOOL CLEANED. REMOVE ALL SHARP CORNERS.
9. ALL SURFACES SHALL BE PRIMED WITH ONE 2.0 MIL COAT OF RUSTOLEAN #1573 OR EQUIVALENT. SURFACES SHALL BE PAINTED WITH ONE ADDITIONAL INTERMEDIATE 1.5 COAT OF RUSTOLEUM #2766. APPLY A FINISH COAT OF STD WHITE FULL GLOSS ALKYD PAINT OR EQUIVALENT. VENDOR SHALL PAINT INDIVIDUAL SECTIONS OF MATERIAL PRIOR TO THE SECTIONS BEING WELDED INTO AN ASSEMBLY. AFTER FILED WELDING IS COMPLETED, TOUCH UP ALL DAMAGED OR UNPAINTED AREAS IN ACCORDANCE WITH THE ABOVE PAINT SYSTEM.

PARTS LIST

QTY REQD	ITEM NO.	PART OR IDENTIFYING NO.	MANUFACTURER OR DESCRIPTION	MATERIAL SPECIFICATION	NOTES
1	1	YOKE	PLATE 2-1/2 x 12-1/4 x 20-3/8	1018 HR STEEL	-
1	2	POLE	PLATE 4 x 7 x 12-1/4	1018 HR STEEL	-
1	3	LOCATING BAR	BAR 2 x 2 x 12-1/4	1018 HR STEEL	-

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

TRACKING NO. N/A	APPROVALS	DATE	HALL A - GENL EOPT - BEAM LINE SC MOELLER POLARIMETER MOELLER 04 ASSY
	DRAWN S. ESP	20 FEB 12	
	CHECKED		
	APPROVED		
	APPROVED		
	APPROVED		

SIZE B | DWG. NO. A00000-04-01-0805 | REV. -

SCALE 1:2 | WEIGHT 0 A00000-04-01-0800 | SHEET 1 OF 2

THIRD ANGLE PROJECTION

UNLESS OTHERWISE NOTED: FINISH 125 MACHINED SURFACES; DEBURR & BREAK ALL SHARP EDGES

MATERIAL 1018 HOT ROLLED STEEL

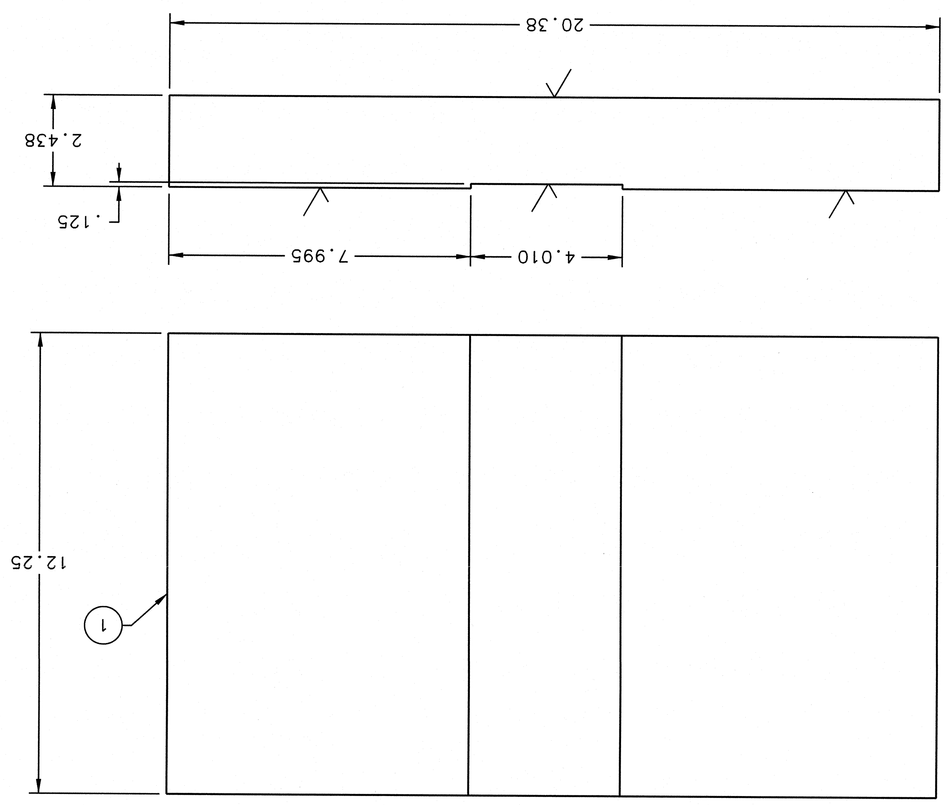
DOCUMENT CONTROL STAMP

DO NOT SCALE DRAWING

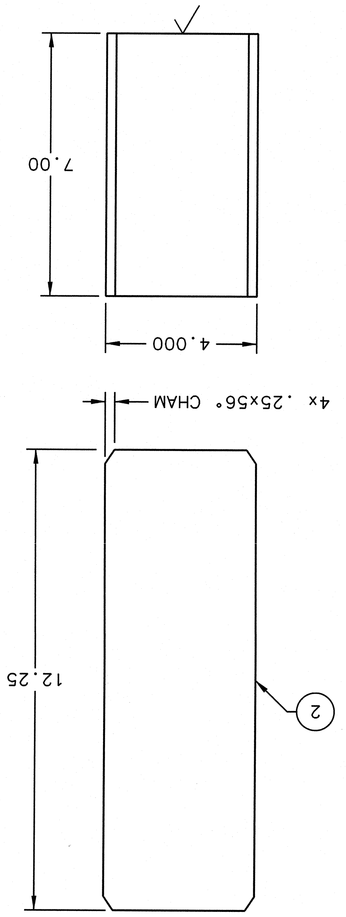
Jefferson Lab — Thomas Jefferson National Accelerator Facility — Office of Science — U.S. Department of Energy — United States Department of Energy — Newport News Virginia

UNLESS OTHERWISE SPECIFIED: DIM & TOL PER ASME Y14.5 DIMENSIONS ARE IN INCHES TOLERANCES ARE: FRACTIONS ± 1/64 DECIMAL .X ± .1 .XX ± .01 .XXX ± .005 ANGLES ± 1 .30'

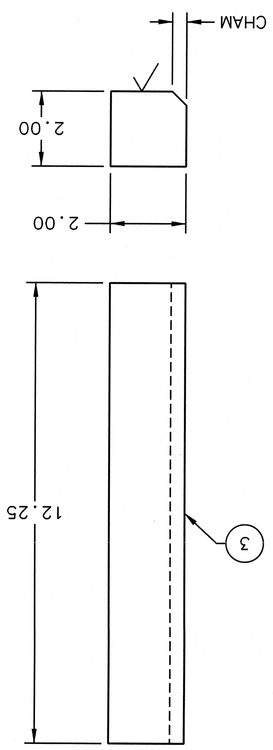
ITEM 1 - DETAIL 1-7A



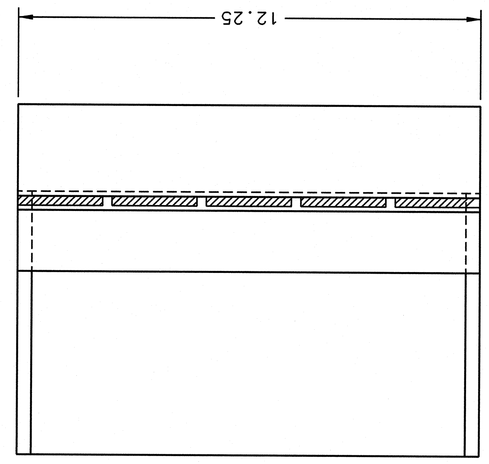
ITEM 2 - DETAIL 1-5A



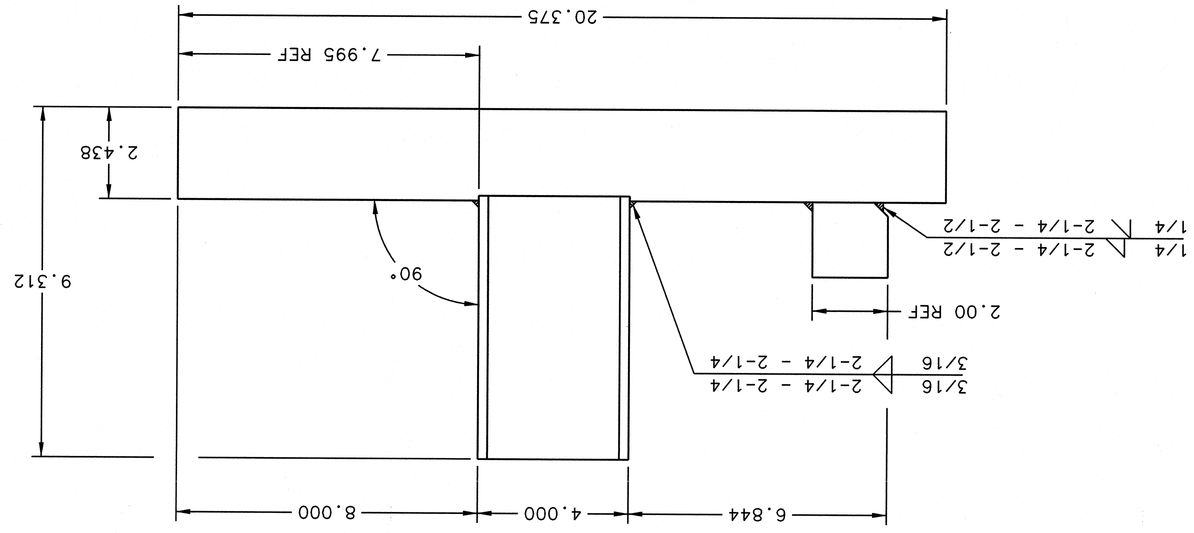
ITEM 3 - DETAIL 1-3A



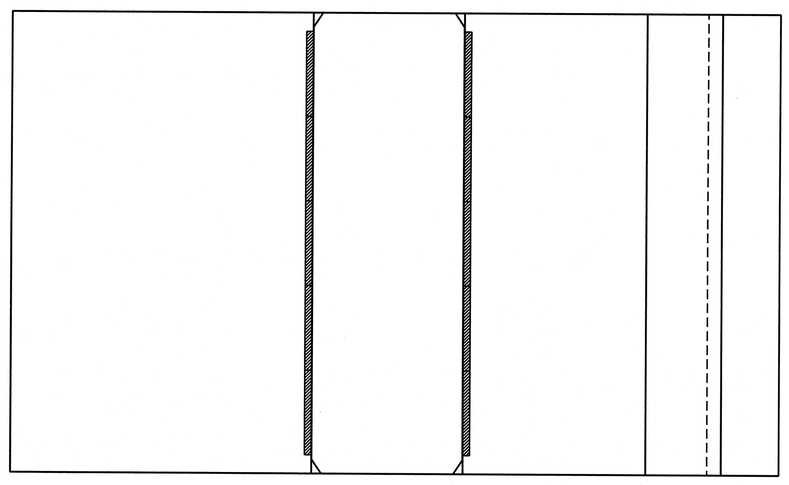
L SIDE VIEW 1-5D



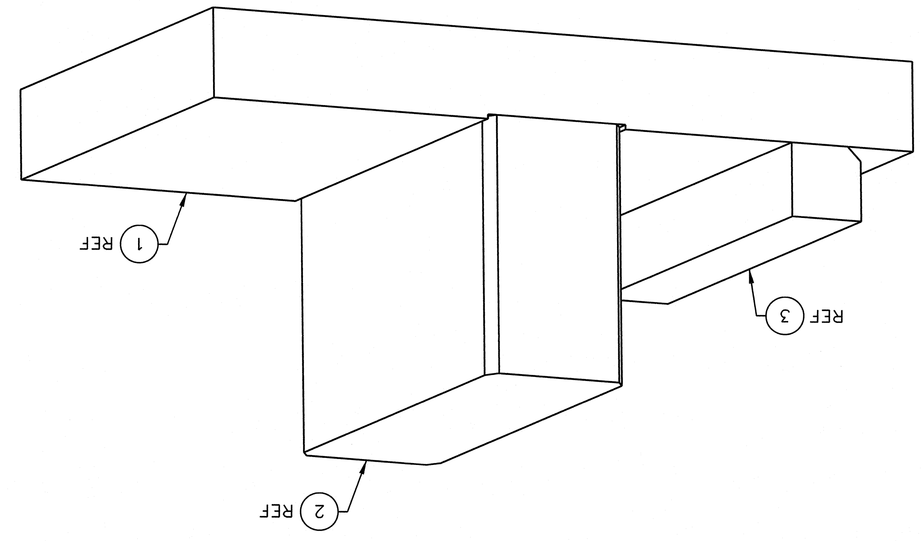
FRONT VIEW 1-3D



TOP VIEW 1-3F



ISO VIEW 1-7F



ZONE	REV	DESCRIPTION	DATE	APPROVED

REVISION HISTORY