



1. BALL VALVE MODIFICATIONS AS FOLLOWS :
 - A) REMOVE (2) END FLANGES & (4) VALVE BODY 5/16-18 NUTS FROM VALVE ASSEMBLY.
 - B) REUSE (4) VALVE BODY 5/16-18 X 7/16" LONG BOLTS FOR THIS ASSEMBLY.
 - C) REMOVE & MODIFY BALL PER DRAWING 75600-B-0096. RE-INSTALL MODIFIED BALL SO THAT 3/8" DIA FLAT IS VISIBLE FROM TOP WHEN VALVE IS IN "CLOSED" POSITION (SEE TOP VIEW).
2. POSITION NUTS (ITEM 7) ON SCREW (ITEM 6) SO THAT END COUPLING (ITEM 8) SWIVELS FREELY. TACK WELD INNER NUT (ITEM 7) TO SCREW (ITEM 6) & TIGHTEN OUTER NUT (ITEM 7) TO SECURE SCREW.
3. VACUUM TEST : NO LEAK DETECTABLE ON THE MOST SENSITIVE SCALE OF A HELIUM LEAK DETECTOR w/ A MINIMUM SENSITIVITY OF 10^{-9} cc/sec.
4. INSTALL W/ MALE BAYONET INSERTED TO ASSURE PROPER ALIGNMENT. HOLD HANDLE 90° AWAY FROM 1/4" NPT PORTS. WITH HANDLES IN THE DOWN (PARALLEL WITH 1 1/2" TUBE) WHEN OPEN.

DIM. & TOL. PER ASSY Y44.9 DIM. & TOL. PER DRAWING DIMENSIONS ARE IN INCHES DIMENSIONS ARE IN MILLIMETERS FRACTIONS DECIMAL ANGLES ° ' " XXX.X .005		CADD ID. NO. 1wb5c7d1wb5.7_53700E-0060		PARTS LIST  The SLAC-LBL Electron Beam Accelerator Facility 2550 HAWTHORNE BLVD., BERKELEY, CA 94720 UNITED STATES DEPARTMENT OF ENERGY	
MATERIAL SEE PARTS LIST		DRAWN M. ZARECKY 3/21/89 CHECKED R. BROWN 4/19/89		1/2 FEMALE BAYONET ASSEMBLY w/CHEVRONS & 3 1/2" IPS JACKET	
FINISH ☒ UNLESS OTHERWISE NOTED DEBURR & BREAK ALL SHARP EDGES		APPROVED D. KASHY 4/19/89 APPROVED D. KASHY 4/19/89		SIZE DWG. NO. 75300-E-0060 DATE FULL (USED ON ASSY NO.) SHEET 1 OF 1	
DO NOT SCALE DRAWING				REV. F	