



4 IPS FLEX ASSEMBLY 75600-E-0248-1



- RECOMMENDED FABRICATION PROCEDURE :

1. ASSEMBLE PIPES, EARS & HOSE SECTIONS.
2. PLACE RODS THRU EARS WITH NUTS LOOSE AT EACH SIDE OF EACH EAR.
3. ADJUST ASSEMBLY TO MAKE BOTH ENDS PARALLEL TO WITHIN 1/32" WITH NUTS ON RODS POSITION ALL INNER NUTS TIGHT TO EARS & TACK WELD INNER NUTS TO RODS WHILE IN PARALLEL POSITION.
4. BACK OUTER NUTS AT BOTH ENDS TO 1/8" CLEAR OF EARS & TACK WELD OUTER NUTS TO RODS AT THIS LOCATION.
5. LEAK TEST ASSEMBLY.
6. INSTALL RUBBER PROTECTION SLEEVE (ITEM 16 THRU 19) AROUND CONVOLUTIONS & SECURE WITH WIRE TIES (ITEM 20).
7. RUBBER SHEETS ITEMS 16 THRU 19 TO WRAP AROUND HOSE & OVERLAP ENDS. SUGGEST USING 1/2" AT TRIAL PROTOTYPE TO CHECK LENGTH & THEN CUT OTHER PIECES TO MATCH. (PARTS LIST LENGTH HAS APPROX. 7" ADDED TO MEAN CALC. DIA.) OVERLAP TO BE LOCATED BETWEEN THREADED RODS.

ASSY. 1 UNLESS TOL. PER ANSI Y14.8, ALL DIMENSIONS ARE IN INCHES TOLERANCES ARE: FRACTIONS DECIMAL ANGLES * V32 * .XXX * * 1 *		CADD I.D. NO. 1/wbs79/wbs.7/wbs.7.5/75000/0248	
MATERIAL SEE PARTS LIST		APPROVALS	DATE
FINISH ☒ UNLESS OTHERWISE NOTED DEBUR & BREAK ALL SHARP EDGES		DRAWN R BROWN CHECKED M.R.Z.	9/26/99 10/12/99
DO NOT SCALE DRAWING		APPROVED [Signature] APPROVED [Signature]	10/19/99 10/19/99

CEBAF
The Continuous Electron Beam Accelerator Facility
NEWPORT NEWS, VIRGINIA
UNITED STATES DEPARTMENT OF ENERGY

BARE CONVOLUTED HOSE ASSEMBLY
(3 IPS, 4 IPS, 5 IPS & 6 IPS)

0	SIZE DWG. NO.				75600-E-0248		F	
2	E		SCALE HALF		USED ON ASSY NO. 71700-E-0042 & 43		SHEET OF	