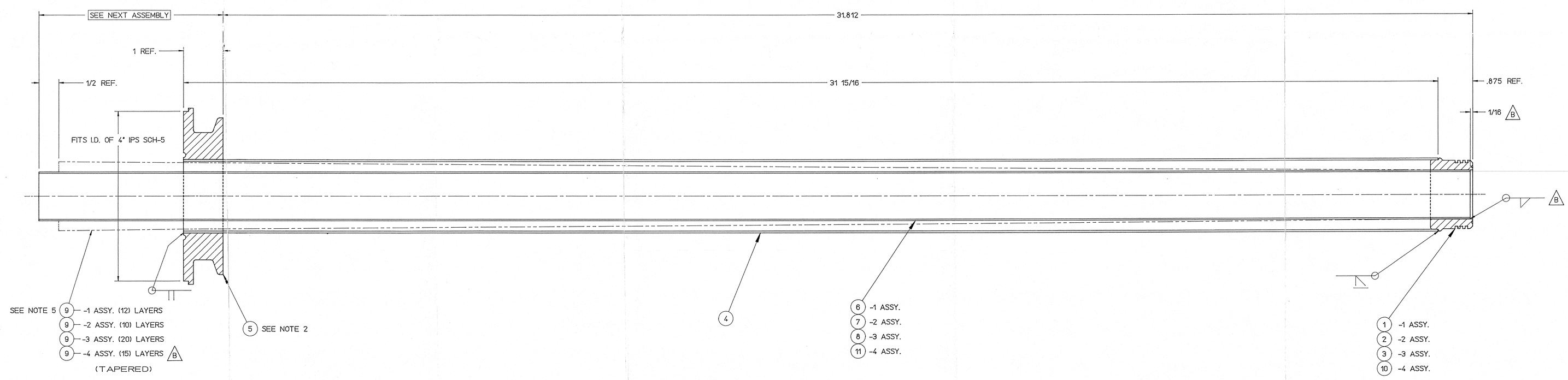
REVISIONS				
ZONE	REV.	DESCRIPTION	BY	APPROVED
B 1-3	A	CORRECTED LGTH. OF ITEM 4 (WAS 31.687)	MRZ 3/4/93	R. BROWN 3/5/93 D. KASHY 3/8/93
D-E 1	B	CH'GD. WELDING REQMTS. (WAS SQUARE WELD), ADDED 1/16 DIM. CH'GD. SUPER-INSUL. REQMTS. FOR -4 ASSY. (WAS 10 LAYERS)	MRZ 10/6/93	10/22/93 D.H.E. 10/27/93



QTY REQD -1 ASSY	QTY REQD -2 ASSY	QTY REQD -3 ASSY	QTY REQD -4 ASSY'S	ITEM NO.	PART OR IDENTIFYING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL SPECIFICATION	NOTES
A/R				11		PIPE, 1" IPS SCH-5	A-312, TYPE 304	NOTE 1
1				10	75600-B-0215-4	MALE LABYRINTH END, 2" BAYONET	ST.STL., TYPE 304	
A/R	A/R	A/R	A/R	9		SUPERINSUL. (TRIANGULAR BLANKET)	ALUMINIZED MYLAR & CEREX	NOTE 5
	A/R			8		PIPE, 3/4"IPS SCH-5	A-213, TYPE 304	NOTE 1
		A/R		7		TUBE, 1 3/8"O.D.x .035"W.	A-213, TYPE 304	NOTE 1
			A/R	6		TUBE, 1 1/4"O.D.x .035"W.	A-213, TYPE 304	NOTE 1
1	1	1	1	5	75600-B-0185	U-TUBE FLANGE (4 "IPS SCH-5)	ST.STL., TYPE 304	NOTE 2
A 1	1	1	1	4		TUBE, 1 7/8"O.D.x .049"W.x 31 15/16" LG.	A-213, TYPE 304	
	1			3	75600-B-0215-3	MALE LABYRINTH END, 2" BAYONET	ST.STL., TYPE 304	
		1		2	75600-B-0215-2	MALE LABYRINTH END, 2" BAYONET	ST.STL., TYPE 304	
			1	1	75600-B-0215-1	MALE LABYRINTH END, 2" BAYONET	ST.STL., TYPE 304	

PARTS LIST

NOTES:

1. INNER LINE LENGTH & TYPE (ITEM 6,7,8 OR 11) SHALL BE AS DETERMINED ON INSTALLATION DWG. TO ELIMINATE WELDS.
2. DESIGN SHOWN IS CEBAF / FERMI STYLE, SEE DWG.75600-D-0020 FOR FURTHER INFO. THIS ASSEMBLY TO MATE WITH FEMALE BAYONET ON DWG. 75300-E-0028. OPTIONS WITH 5 IPS SCH-5 & 3 IPS SCH-5 or 10 JACKETS ARE AVAILABLE, REPLACE ITEM 5 WITH DWG. 75600-B-0174 (FOR 5"IPS) or DWG. 75600-B-0173 (FOR 3 IPS)
3. ALL PARTS MUST BE CLEANED, FREE OF GREASE, OIL, OR OTHER CONTAMINENTS PRIOR TO ASSEMBLY.
4. "HELIUM LEAK TEST" NO LEAK SHALL BE DETECTABLE ON THE MOST SENSITIVE SCALE OF A HELIUM LEAK DETECTOR WITH MIMIMUM SENSITIVITY OF 10^{-9} CC/SEC.
5. SUPER INSULATION TO BE INSTALLED ON INNER TUBE TO 1/2" FROM END (NEAREST U-TUBE FLANGE) TO PERMIT WELDING AT INSTALLATION.
6. MAXIMUM ALLOWABLE PRESSSURE 418 PSI. OPTIONAL LOWER PRESS. MALE BAYONET SEE DWG.75300-E-0029.

DIM. & TOL. PER ANSI Y14.5
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ARE:
FRACTIONS ± 1/64 DECIMAL .XX ± N/A .XXX ± .010 ANGLES ± N/A

MATERIAL: SEE PARTS LIST

FINISH: N/A UNLESS OTHERWISE NOTED
DEBURR & BREAK ALL SHARP EDGES

DO NOT SCALE DRAWING

CADD I.D. NO. /wbs/579/wbs_7/wbs_7_5/75300/E0109

APPROVALS	DATE
DRAWN M. ZARECKY	6/25/90
CHECKED D. KASHY	7/12/90
APPROVED D. KASHY	7/12/90
APPROVED D. KASHY	7/12/90

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

2" MALE BAYONET ASSEMBLY (.049"W. OUTER)

SIZE E DWG. NO. 75300-E-0109 REV. B

SCALE FULL USED ON ASSY NO. - SHEET 1 OF 1

DWG. NO. 75300-E-0029 SHT. 1 REV. B