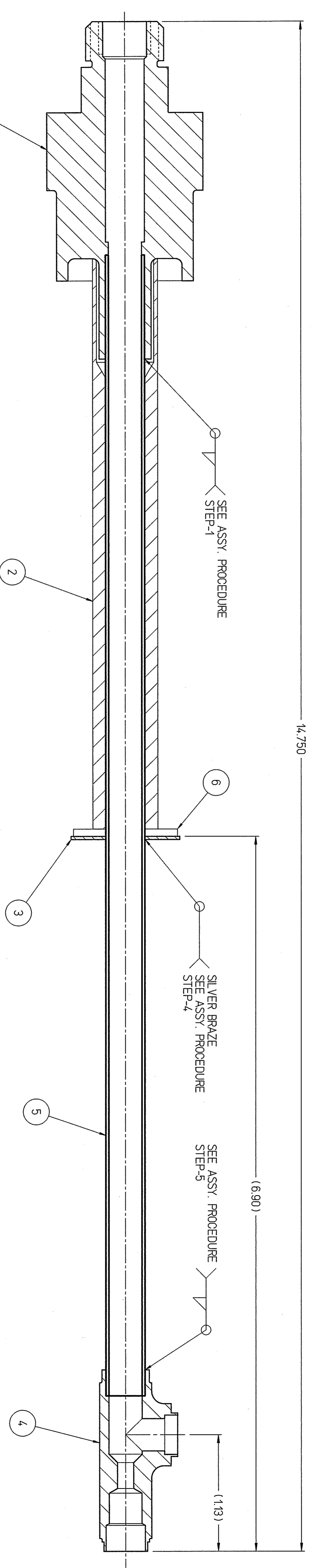


DWG. NO.	75600-D-0460	SHT. 1	REV. -
REVISIONS		DATE	APPROVED
ZONE	REV.	DESCRIPTION	



ASSEMBLY PROCEDURE:

- 1) ALL PARTS MUST BE CLEANED, FREE OF GREASE, OIL, OR OTHER CONTAMINANTS. SURFACES MUST BE SUITABLE FOR HIGH VACUUM.
- 2) ASSEMBLE VALVE BONNET (ITEM 1) TO TUBE (ITEM 5), WELD AND LEAK TEST.
- 3) INSTALL G-10 SUPPORT TUBE (ITEM 2) AND EPOXY TO VALVE BONNET (ITEM 1).
- 4) INSTALL FLAT WASHER (ITEM 6) AND THERMAL INTERCEPT RING (ITEM 3) AND SILVER BRAZE.
- 5) INSTALL VALVE BODY (ITEM 4) TO TUBE (ITEM 5), WELD AND LEAK TEST.
- 6) "HELIUM LEAK TEST" NO LEAK SHA.; BE DETECTABLE ON THE MOST SENSITIVE SCALE OF A HELIUM LEAK DETECTOR WITH A MINIMUM SENSITIVITY OF 1×10^{-9} CC/SEC

QTY	REV	PART OR IDENTIFYING NO.	DESCRIPTION OR IDENTIFICATION	MATERIAL SPECIFICATION	NOTES
1	6	-	WASHER FLAT 3/8 STD. (100 OD. x .071 THK. APPROX.)	ST. STL.	-
1	5	-	TUBE, .375 OD. x .028 W. x 11000 LG.	ST. STL., TYPE 304 SEAMLESS	-
1	4	75600-C-0449	VALVE BODY		-
1	3	75600-B-0453	THERMAL INTERCEPT RING		-
1	2	75600-B-0458	G-10 SUPPORT TUBE		-
1	1	75600-C-0454	VALVE BONNET		-

DIM. & TOL. PER ANSI Y14.5 DIMENSIONS ARE IN INCHES TOLERANCES ARE: FRACTIONS DECIMAL ANGLES $\pm .012$ $\pm .010$ $\pm .015$		CADD I.D. NO. (WSP/7)WBS.7.5/75600/00460		Thomas Jefferson National Accelerator Facility UNITED STATES DEPARTMENT OF ENERGY	
FINISH: UNLESS OTHERWISE SPECIFIED DEBURR & BREAK ALL SHARP EDGES		DRAWN: M. ZARECKY CHECKED: K. G. CAMMILLI DATE: 4/9/99		APPROVED: K. G. CAMMILLI DATE: 4/17/99	
DO NOT SCALE DRAWING		SIZE: D SCALE: 1:1		JACKET - SMALL JT VALVE WELDMENT ACCELERATOR CRYOGENICS STANDARD DETAIL WELDMENT 75600-D-0460	

