



ASSEMBLY PROCEDURE:

- 1.) ALL PARTS MUST BE CLEANED, FREE OF GREASE, OIL, OR OTHER CONTAMINANTS. SURFACES MUST BE SUITABLE FOR HIGH VACUUM.
- 2.) ASSEMBLE ROD (ITEM 1) AND VALVE STEM NOSE (ITEM 2) TO TUBE (ITEM 5), AND WELD.
- 3.) DRILL .06 HOLE (THRU ONE WALL ONLY OF TUBE (ITEM 5)
- 4.) ASSEMBLE SEAL (ITEM 3) AND LHe BULLET (ITEM 4) AS SHOWN
- 5.) *HELIUM LEAK TEST* NO LEAK SHA; BE DETECTABLE ON THE MOST SENSITIVE SCALE OF A HELIUM LEAK DETECTOR WITH A MINIMUM SENSITIVITY OF 1 X 10⁻⁹ CC/SEC

QTY	ITEM	PART OR IDENTIFYING NO.	DESCRIPTION OR IDENTIFYING PARTS LIST	REVISIONS	NOTES
1	5	-	TUBE, 5/16 OD, x .065 W x .10926 LG.		ST STL, TYPE 304 SEAMLESS
1	4	75600-B-0451	LHe BULLET, Cv = 0.3 EQ. %		-
1	3	75600-B-0448	SEAL		-
1	2	75600-B-0450	VALVE STEM NOSE		-
1	1	75600-B-0447	ROD		-

DIM & TOL. PER ANSI Y14.5
 DIMENSIONS ARE IN INCHES
 TOLERANCES ARE: DECIMAL ANGLES
 FRACTIONS DECIMAL ANGLES
 ± .002 XXX ± .005 ± N/A

CAD D. I.D. NO. /WS/7/WS.7.5/75600/00461
 APPROVALS: DRAWN M. ZARECKY DATE 4/8/99
 CHECKED K. G. G. DATE 4/9/99
 APPROVED K. G. G. DATE 4/9/99
 DESIGNED & BREAK ALL SHARP EDGES APPROVED

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

SEE PARTS LIST
 DO NOT SCALE DRAWING

Thomas Jefferson National Accelerator Facility
 UNITED STATES DEPARTMENT OF ENERGY
 ACCELERATOR CRYOGENICS
 STANDARD DETAIL
 STEM - SMALL JT VALVE WELDMENT
 SIZE DWG. NO. 75600-D-0461
 SHEET 1 OF 1

