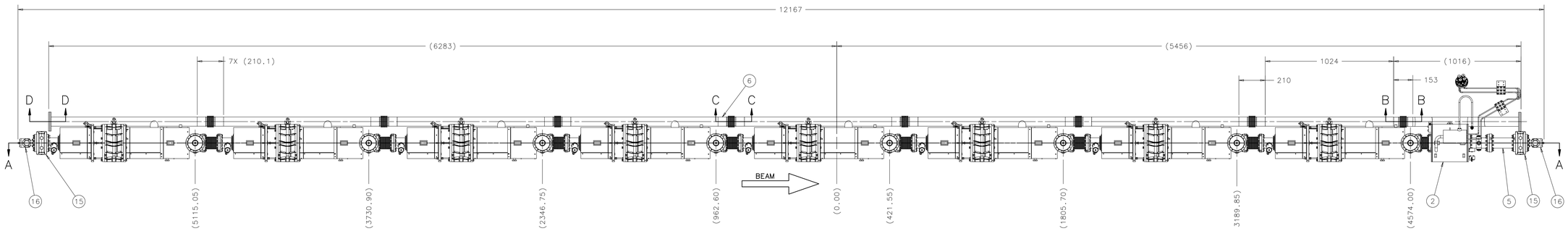
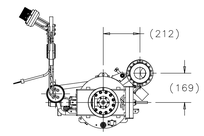
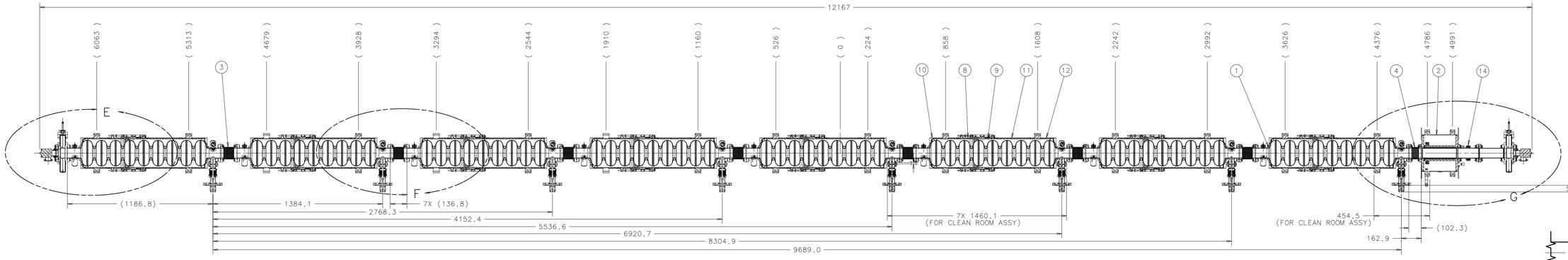
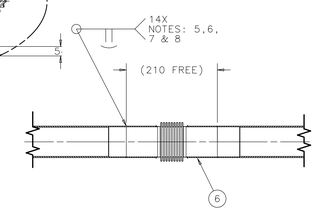
REVISION HISTORY					
CAD MAINTAINED. CHANGES SHALL BE INCORPORATED BY THE DESIGN ACTIVITY.					
ZONE	REV	DESCRIPTION	DATE	CHECKED	APPROVED
	A	INITIAL RELEASE-ER # ILC-			



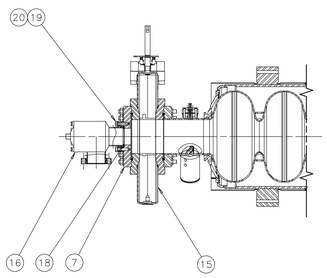




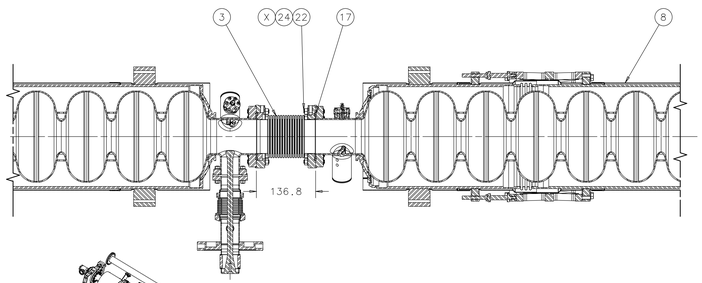
SECTION A-A



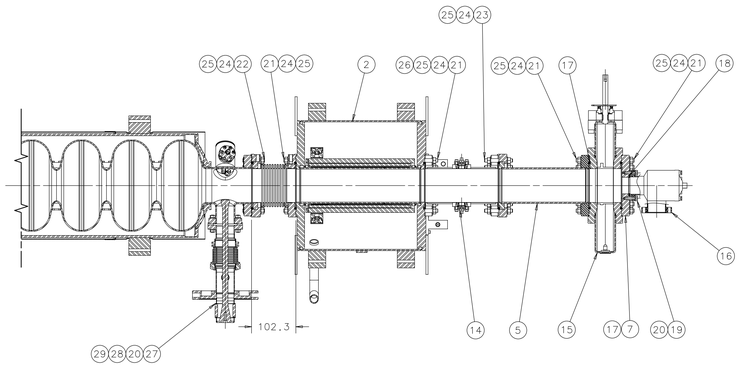
SECTION C-C
SCALE 1:5



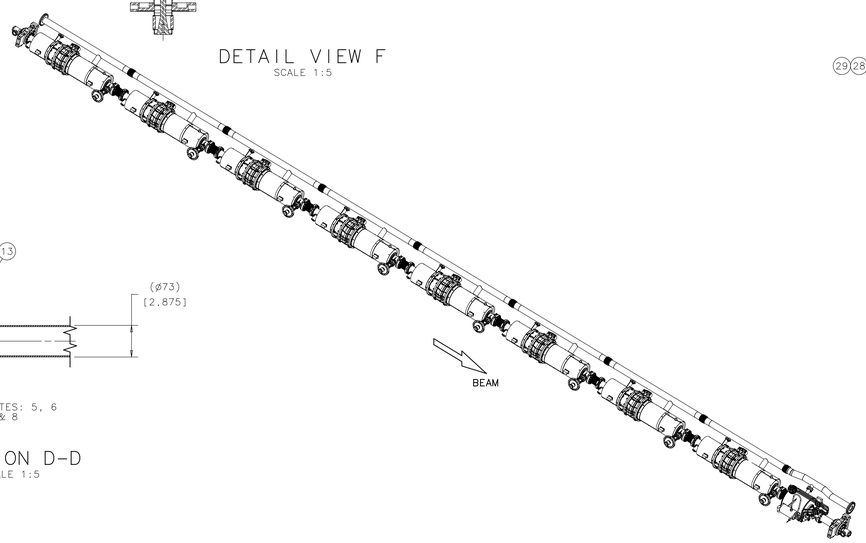
DETAIL VIEW E
SCALE 1:5

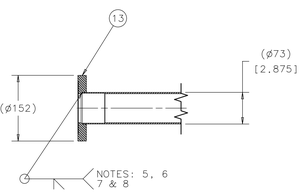


DETAIL VIEW F
SCALE 1:5

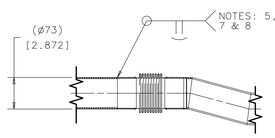


DETAIL VIEW G
SCALE 1:5





SECTION D-D
SCALE 1:5



SECTION B-B
SCALE 1:5

NOTES (UNLESS OTHERWISE SPECIFIED):

1. ALL DIMENSIONS, UNLESS SPECIFIED, ARE IN ROOM TENPERATURE.
2. ASSEMBLY PER FERMILAB ENGINEERING SPECIFICATION: 5520.000-ES-
3. TRIM AND CLEAN 2-PHASE PIPE BEFORE WELDING ITEMS #6. THE INSTALLATION DISTANCE IS FREE LENGTH FOR ITEM #6.
4. MAINTAIN A DIRT & GREASE - FREE WORKING ENVIRONMENT, KEEPS ALL PARTS AND ASSEMBLIES FREE OF DIRT, GREASE, OIL AND CHIPS.
5. FABRICATE ALL PIPING CONNECTION PER ASME B31.3, MORMAL FLUID SEVICES.
6. THE FOLLOWING DOCUMENTS SHALL BE SUPPLIED:
   A. WELDS PROCEDURE SPECIFICATION (WPS).
   B. PROCEDURE QUALIFICATION RECORDS (PQR).
   C. WELDER PERFORMANCE QUALIFICATION (WPQ).
   D. EXAMINATION REPORT.
7. WELD TO BE PERFORMED USING AN ARGON SHIELD, ROTARY WELDING TOOL WITH AN INNER ARGON SHIELD-50% ARGON/50% HELIUM,NO VISIBLE SIGNS OF OXIDATION ARE ALLOWED.
8. ALL CONTINUOUS WELDS TO BE VACUUM LEAK TIGHT, NO LEAK SHALL BE DETECTABLE ON THE MOST SENSITIVE SCALE OF A HELIUM LEAK DETECTOR WITH A MINIMUM SENSITIVITY OF 10^{-10} ATM. CC/SEC.
9. PROTECT ALL SEALING SURFACES FROM DENTS AND SCRATCHES.

ITEM	P.I.N.	DESCRIPTION	QTY
		PARTS LIST	
29	COM'L	HEX NUT M6-1.0, SILICONE BRONZE	128
28	COM'L	ROD THRD M6-1.0X 40, SS316	64
27	3964328A000	COUPLER TTF III, COLD ASSEMBLY	8
26	922495	PIN CORRECTOR-BPM	2
25	COM'L	WASHER M8, ST, STEEL 316	264
24	COM'L	HEX NUT M8-1.25, SILICONE BRONZE	456
23	COM'L	ROD THRD M8-1.25X 65, SS316	12
22	COM'L	ROD THRD M8-1.25X 50, SS316	180
21	COM'L	SET SCREW M8-1.25X 40, SS316	72
20	COM'L	WASHER M6, SS316	140
19	COM'L	HHS M6-1.0 X 25, SS316	12
18	COM'L	COPPER GASKET MDC P/N 191004	2
17	MB-439232	SEAL FOR NW78 FLANGE	21
16	COM'L	VAT VALVE ANGLE 54032-GE02-0002	2
15	COM'L	RF ALL METAL GATE VALVE	2
14	MC-460390	COLD BPM HOUSING ASSEMBLY	1
13	858525	FLANGE CF DEL SEAL-6*	1
12	792835	1-3GHZ MAGNETIC SHLD MAIN CPLR ASSY	8
11	792825	1-3GHZ MAGNETIC SHIELD DWNSTR ASSY	8
10	792655	1-3GHZ MAGNETIC SHIELD UPSTR ASSY	8
9	792815	1-3GHZ MAGNETIC SHIELD BT2 ASSY	8
8	792635	1-3GHZ MAGNETIC SHIELD BT1 ASSY	8
7	880125	FLANGE END-ADAPTOR	2
6	874615	BELLOWS 2-PHASE PIPE WELDMENT	7
5	874925	EXTENSION WELDMENT	1
4	873845	BELLOWS SHORT WELDMENT	1
3	870205	BELLOWS LONG WLDMT	7
2	858545	XFEL D-MAG WITH CORRECT ASSY	1
1	872825	G3 He VESSEL RF CAVITY ASSEMBLY	8

NEXT ASSY	USED ON
-	-
APPLICATION	

FINISH: N/A

MATERIAL: SEE PART LIST

UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN MILLIMETERS
INTERPRET DIM PER ASME Y14.5M-1994
BREAK ALL SHARP EDGES .75 MAX.
ALL MACH. SURFACES 3.2 MAX.

TOLERANCES: X ± 2, X ± 0.8, XX ± -, ANGLE ± 1°
THIRD ANGLE PROJECTION

DRAWN BY	Y. ORLOV	DATE 25MAY11
CHECKED BY		DATE
ENGINEERED BY		DATE
DATABASE	DESY EDMS	TEAM/GROUP
CAD	I-DEAS	SOLID MODEL NO. D0000000637823

FERMI NATIONAL ACCELERATOR LABORATORY
UNITED STATES DEPARTMENT OF ENERGY
P.O. BOX 500, BATAVIA, IL 60510-0500

TITLE
CRYOMODULE 2 COLD MASS CAVITY_STRING_CM2_ASSY

SIZE	CAGE CODE	DWG NO.	REV
A0	0U5R6	D0000000884475	A
SCALE 1:12.5	DO NOT SCALE DRAWING	SHEET 1 OF 1	