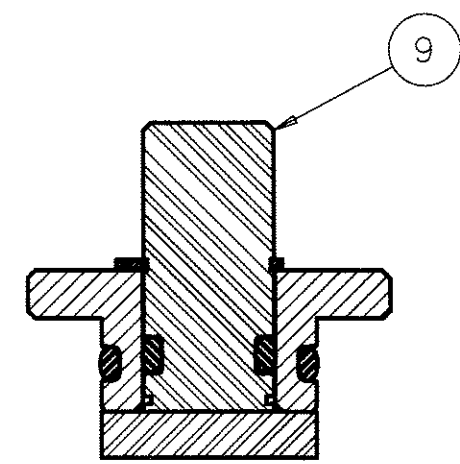
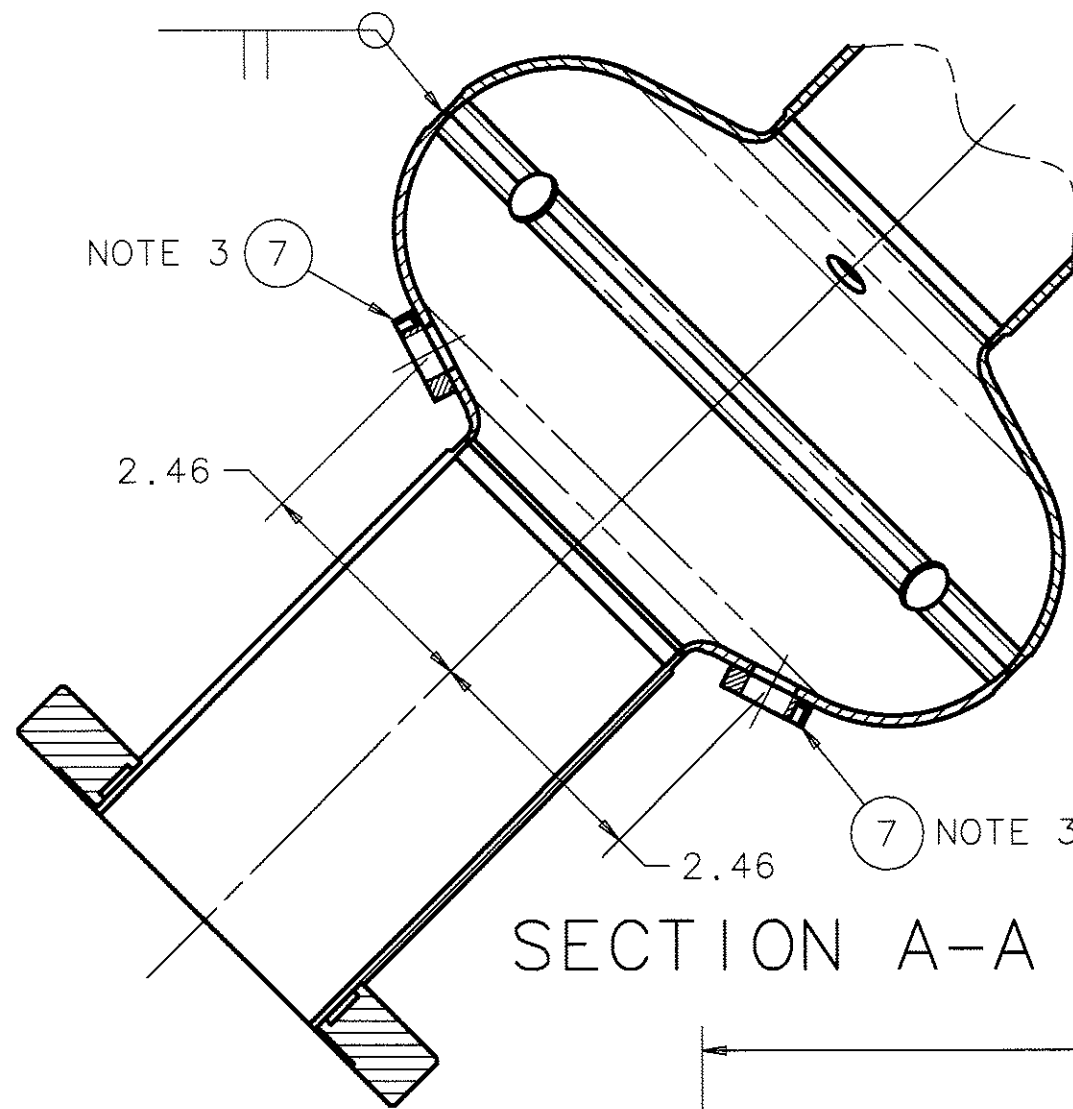
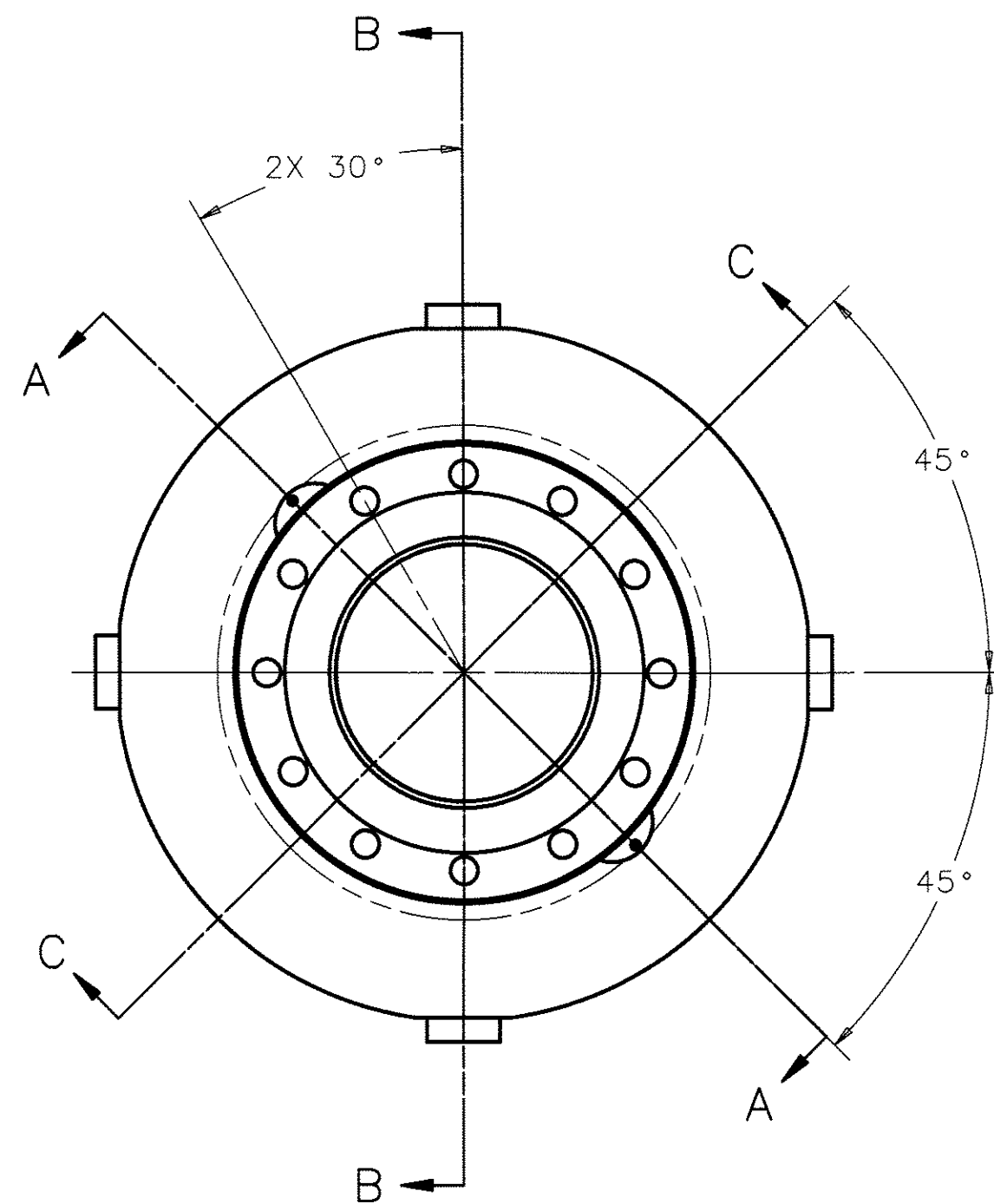


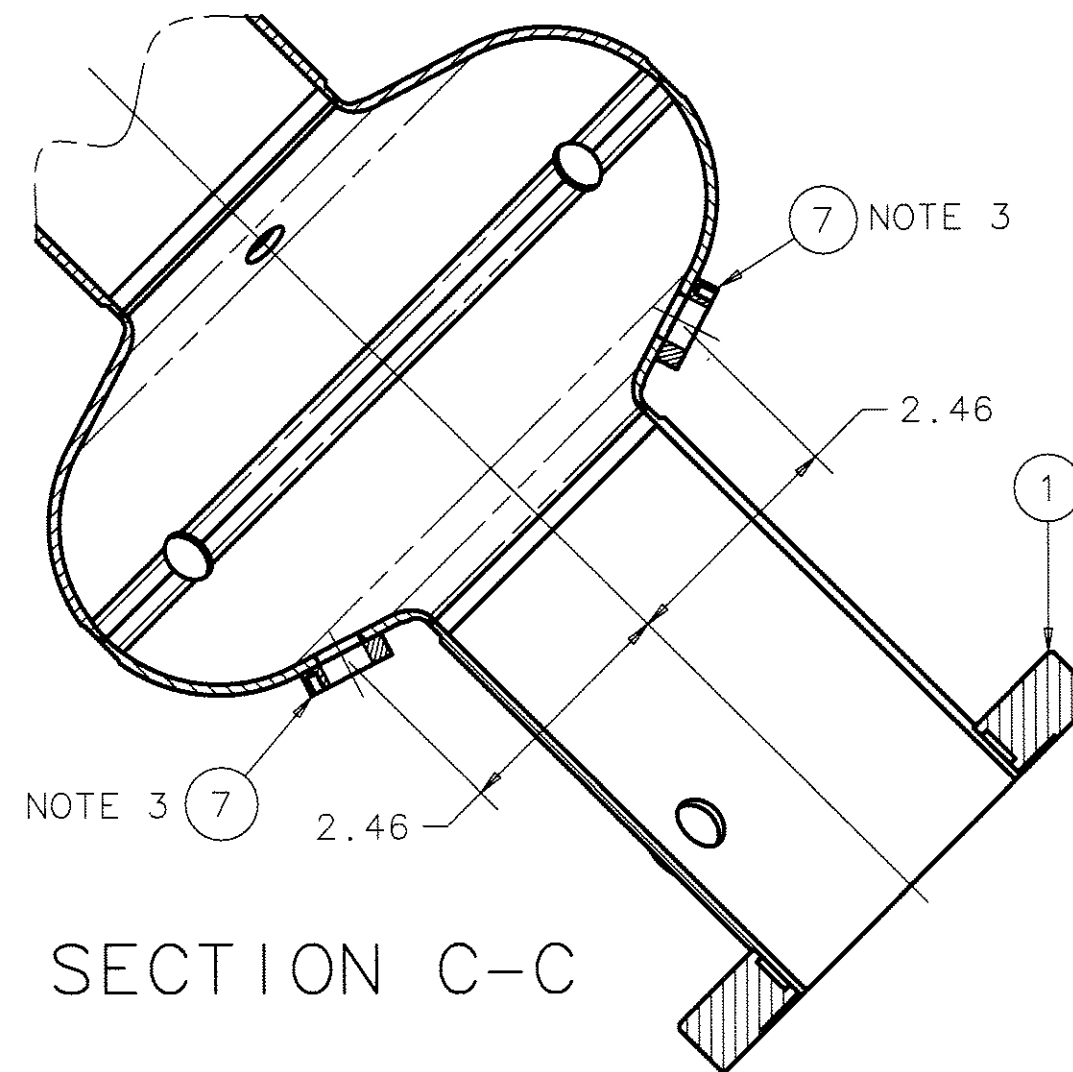
SAMPLE WELDMENT ASSY MOD1
INSTALL
SCALE 2:1
(6 PLACES)



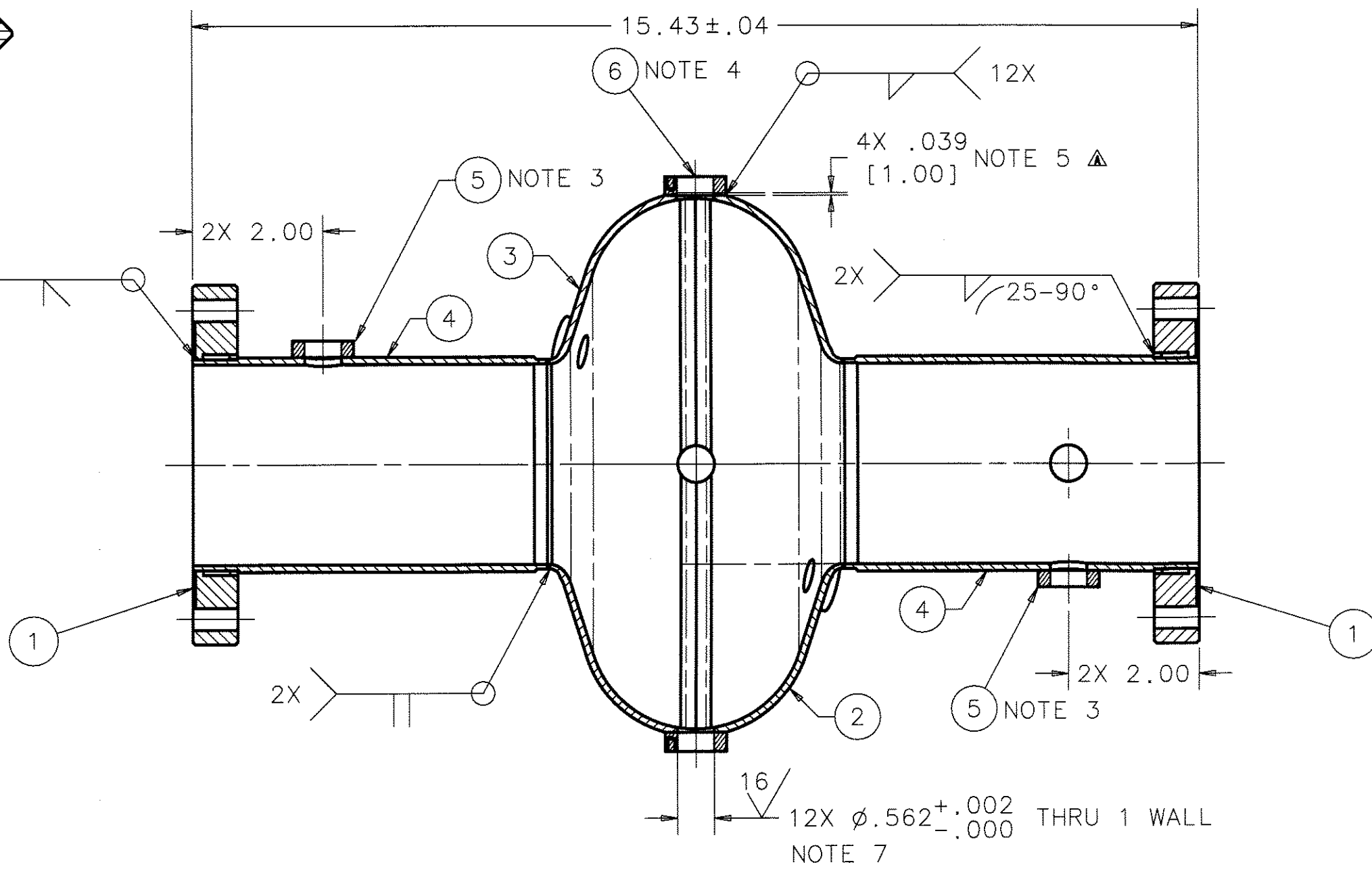
SAMPLE WELDMENT ASSY MOD2
SCALE 2:1
(6 PLACES)



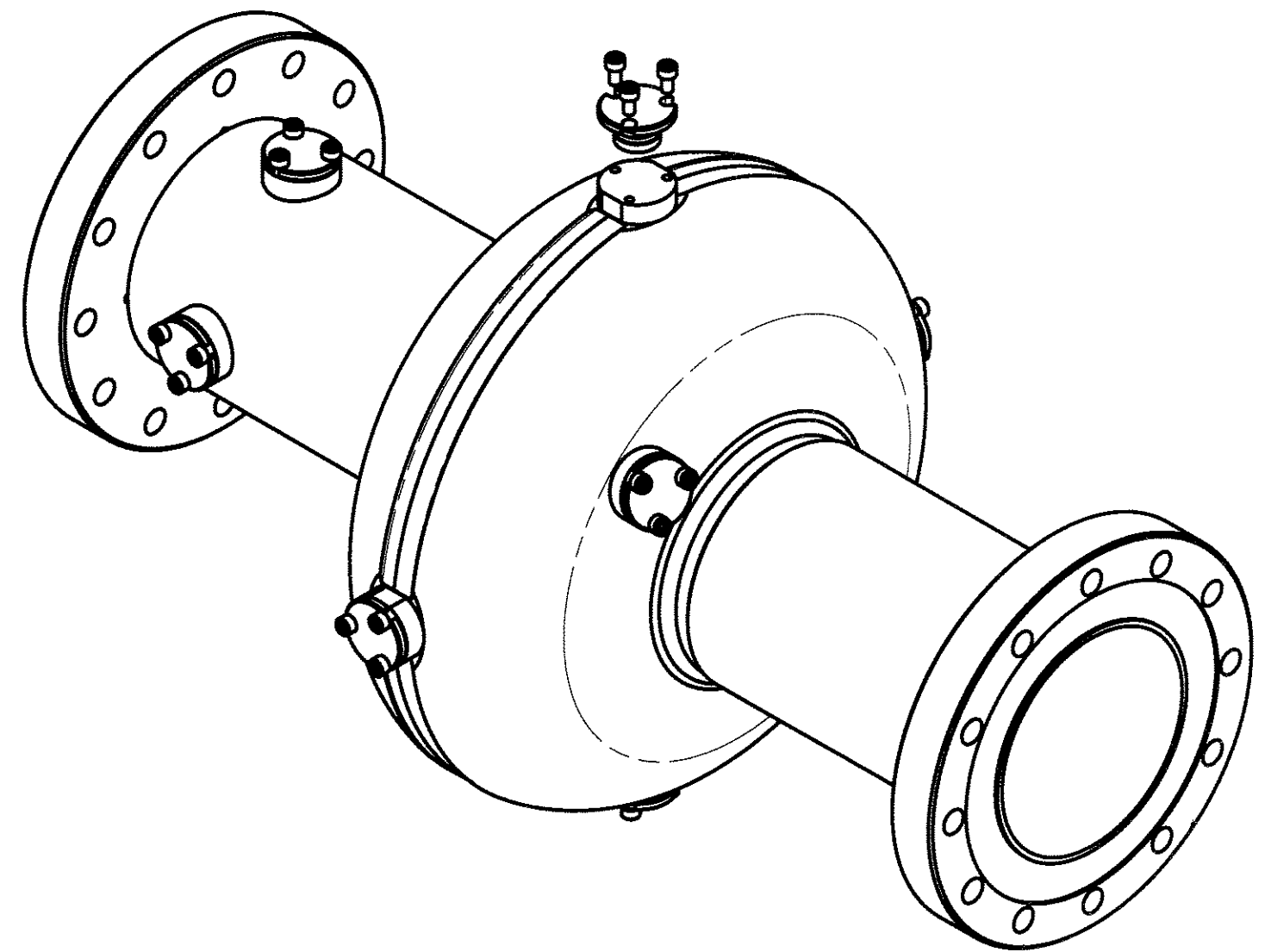
SECTION A-A



SECTION C-C



SECTION B-B



- NOTES (UNLESS OTHERWISE SPECIFIED):
1. ASSEMBLY MUST BE FREE OF DIRT, GREASE, OIL AND CHIPS.
 2. ALL WELDS TO BE FREE OF ALL SHARP EDGES, CORNERS, AND BURRS.
 3. BOSS SPEC: WELD ITEMS 5 & 7 TO ITEMS 2,3 & 4 PRIOR TO ASSEMBLY.
 4. WELD SINGLE-CELL CAVITY TOGETHER PER DESY SPEC. MHF-SL 09-2005 AND FERMI ES-371090.
 5. SPOT FACE AT EQUATOR BOSS LOCATIONS: MAXIMUM MATERIAL REMOVAL NOT TO EXCEED 1MM FROM LARGEST DIAMETER.
 6. FULL PENETRATION WELD OVER THICKNESS OF ALL BOSSES.
 7. DRILL ALL (12) Ø.562 THRU HOLES AFTER WELDING BOSSES IN PLACE.

REV	DESCRIPTION	DRAWN	DATE
		APPROVED	DATE
-	INITIAL RELEASE ER# 9661		
A	ECO #9866 REVISED NOTES, ADDED 4X .039 DIM & RELATED NOTE.	J. KURNAT <i>[Signature]</i>	25AUG2010 <i>[Signature]</i>

10	COML	SHCS #6-32 X 1/4" LG 18-8SS	36
9	MB-481502	SAMPLE-WELDMENT-ASSY MOD2	6
8	MB-481499	SAMPLE-WELDMENT-ASSY MOD1	6
7	MB-481250	BOSS - HALF CELL	4
6	MB-481249	BOSS - CAVITY EQUATOR	4
5	MB-481247	BOSS - BEAM TUBE	4
4	MB-481246	BEAM TUBE	2
3	MD-457527	MALE HALF CELL	1
2	MD-457526	FEMALE HALF CELL	1
1	MD-457524	BEAM FLANGE	2
ITEM	PART NO.	DESCRIPTION OR SIZE	QTY.

PARTS LIST				
UNLESS OTHERWISE SPECIFIED				
.XX	.XXX	ANGLE	ORIGINATOR	C.COOPER
± .02	± .001	± 1°	DRAWN	M.KRAMP
1. BREAK ALL SHARP EDGES			CHECKED	D.ARNOLD
2. DO NOT SCALE DRAWING.			APPROVED	C.COOPER
3. DIMENSIONS BASED UPON			USED ON	
4. MAX. ALL MACH. SURFACES			MATERIAL	
5. DRAWING UNITS: U.S. INCH			SEE PARTS LIST	

FERMI NATIONAL ACCELERATOR LABORATORY
UNITED STATES DEPARTMENT OF ENERGY

IB4 - ICPA
1.3GHZ SINGLE-CELL
TEST CAVITY - WELDMENT

SCALE	DRAWING NUMBER	SHEET	REV
1:2	5520.000-MD-481252	1 OF 1	A
CREATED WITH : Ideas12NXSeries		GROUP: TD/DDCIS-DESIGN-COMPUTING	