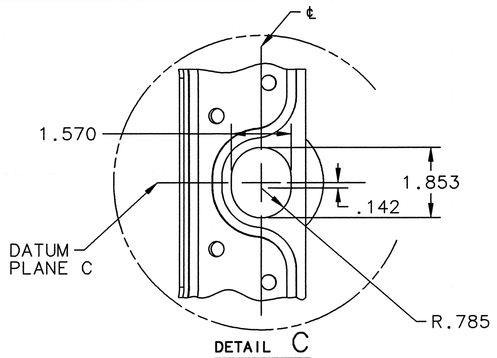
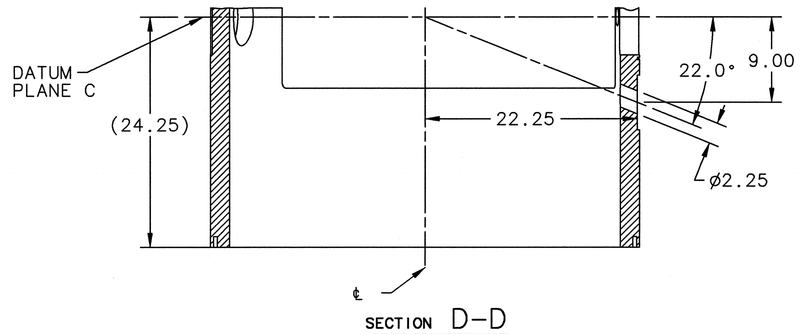
REVISION HISTORY				
ZONE	REV	DESCRIPTION	DATE	APPROVED
-	A	TITLE BLOCK TOLERANCE CHANGE	7-05-06	B.C.M
-	B	ADDED DIMENSIONS	8-09-06	B.C.M
-	C	ADDED DIMENSIONS UPDATED VIEWS TO AS BUILT	1-04-07	B.C.M



DETAIL C

(2 PLACE TOLERANCES APPLY FOR THIS VIEW)

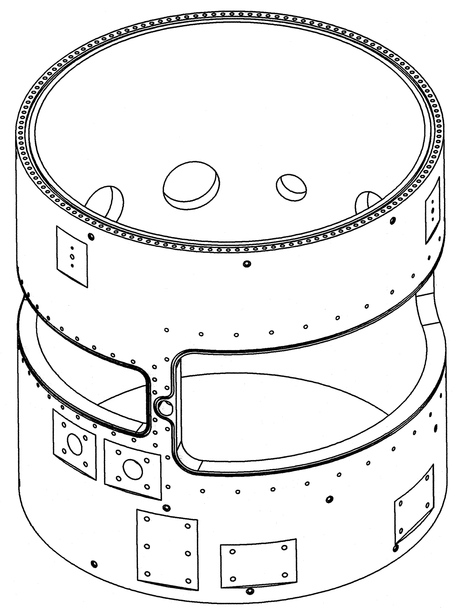
SCALE 1/2

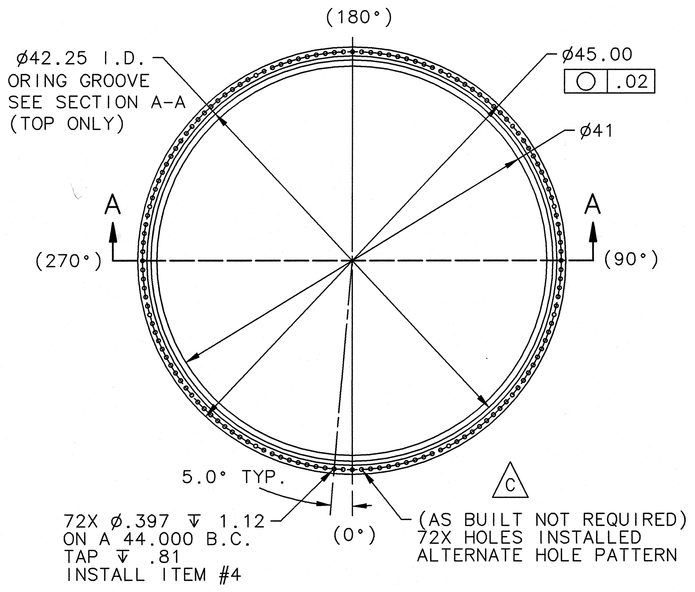


SECTION D-D

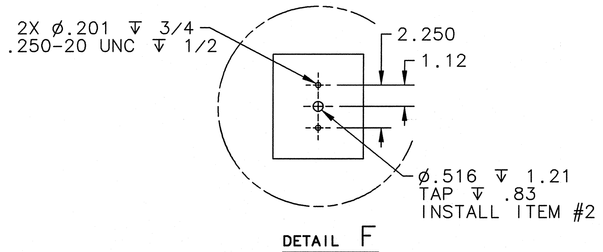
2 PLACES

(VIEW ROTATED)





TOP VIEW

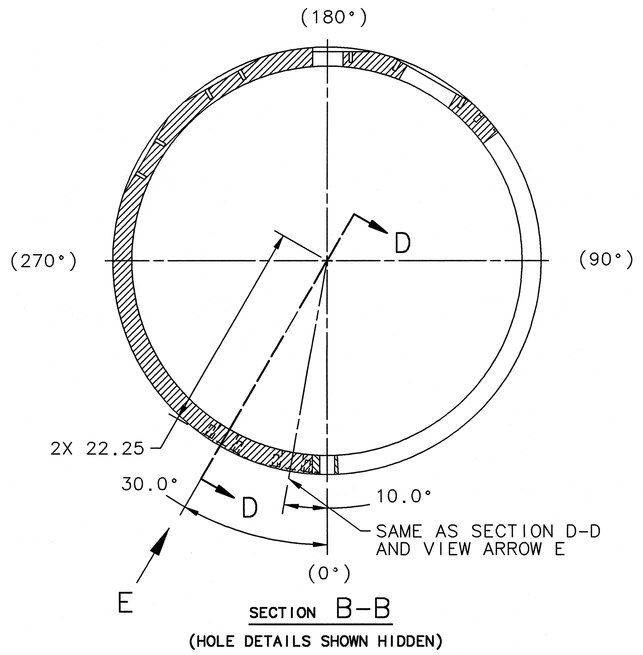


DETAIL F

3 PLACES EQUALLY SPACED 120 DEG. APART

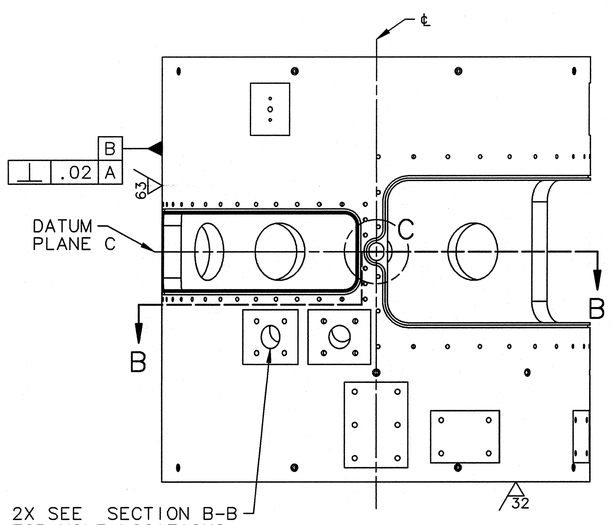
SEE SECTION A-A

SCALE 1/4

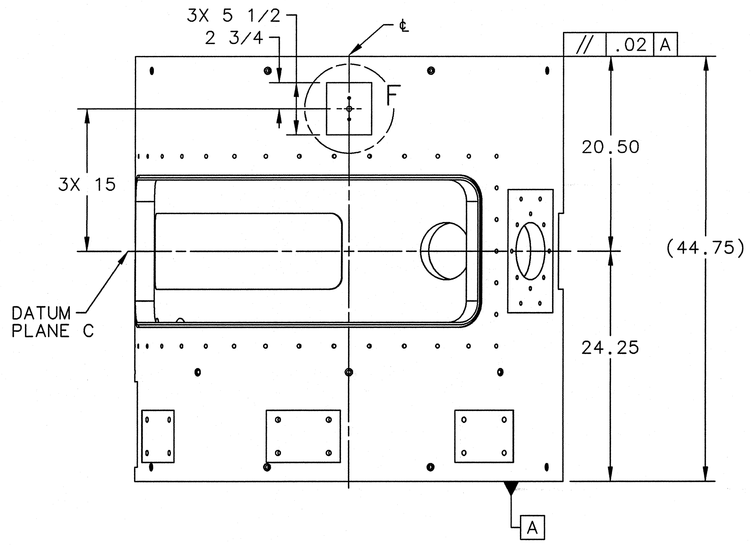


SECTION B-B

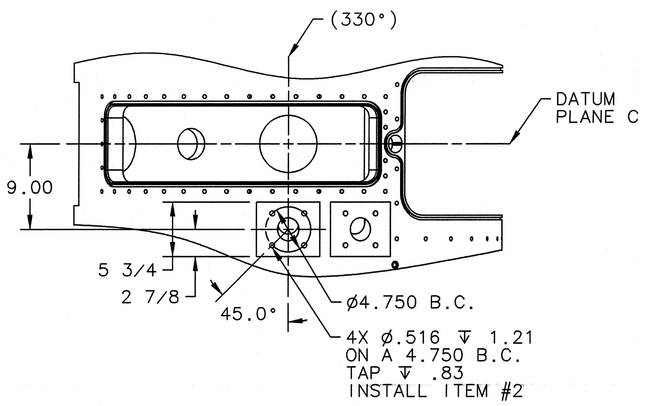
(HOLE DETAILS SHOWN HIDDEN)



FRONT VIEW



SIDE VIEW



VIEW ARROW E

2 PLACES

NOTES

1: MATERIAL IS 2219-T6 ALUMINUM WITH A MINIMUM 58 KSI TENSILE 40 KSI YIELD OD. ID. AND HEIGHT ROUGH MACHINED PROVIDED BY SCOT FORGE 1-800-435-6621.

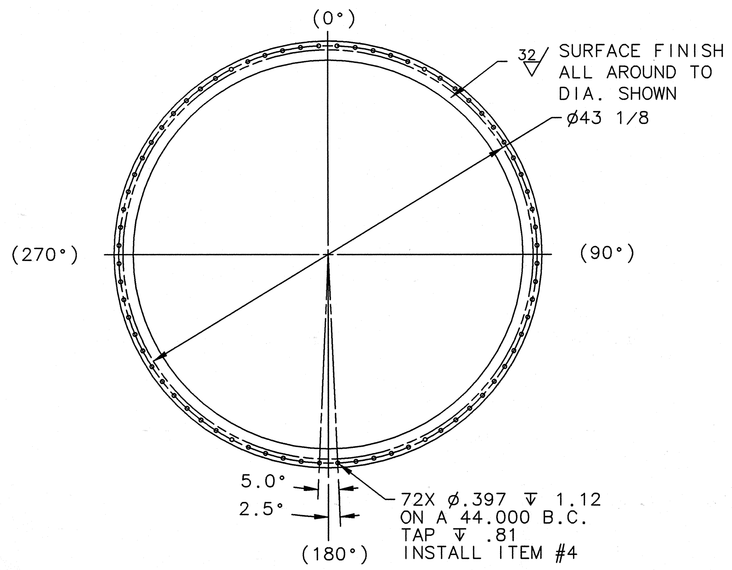
2: 2 PLACE TOLERANCE FOR THIS DIMENSION.

3: 3D MODEL CAN BE PROVIDED TO ASSIST MANUFACTURE. (DOVETAIL ANGLE IN ORING GROOVE NOT MODELED).

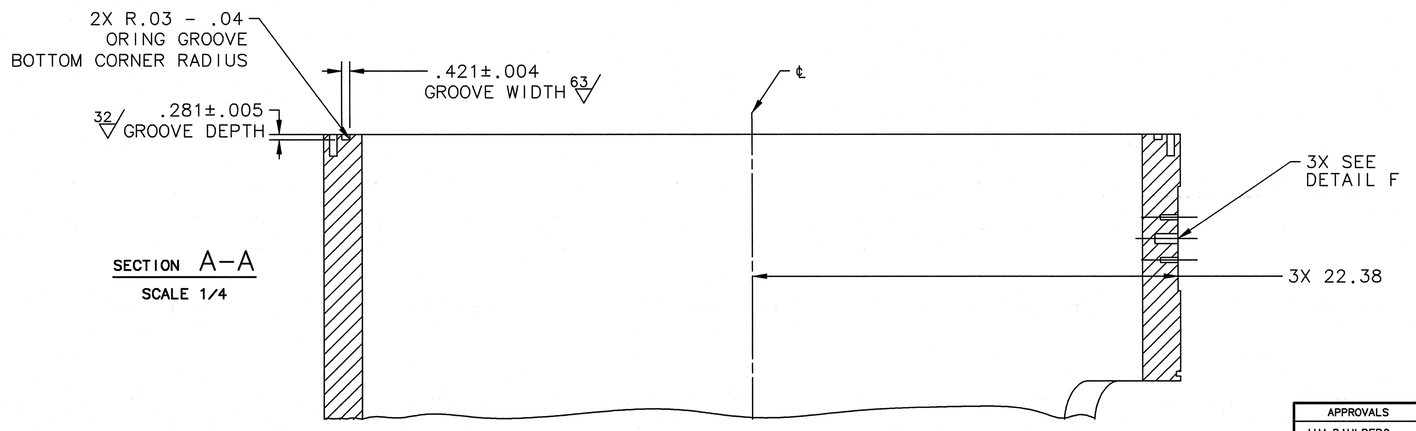
4: DRAWINGS TAKE PRECEDENCE OVER 3D MODELS.

5: SOME OBJECT LINES REMOVED FOR CLARITY.

6: HELIUM MASS SPECTROMETER VACUUM LEAK TEST MINIMUM SENSITIVITY OF (1X10E-9 SCC/SEC) NO DETECTABLE LEAK IS ALLOWED SEE LEAK CHECK ASSEMBLY 67153-56009.



C BOTTOM VIEW



SECTION A-A

SCALE 1/4

QTY REQD	ITEM NO.	PART OR IDENTIFYING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL SPECIFICATION	NOTES
8	5	1185-5CN625	HELICOIL 5/16-18 UNC	EMHART TECHNOLOGIES 1-203-924-9341	-
256	4	1185-6CN750	HELICOIL 3/8-16 UNC	EMHART TECHNOLOGIES 1-203-924-9341	-
12	3	1185-6CN562	HELICOIL 3/8-16 UNC	EMHART TECHNOLOGIES 1-203-924-9341	-
29	2	1185-8CN750	HELICOIL 1/2-13 UNC	EMHART TECHNOLOGIES 1-203-924-9341	-
21	1	H-28-6-.250	HEAD PRESS FIT BUSHING	CARRLANE 1-314-647-6200	-

PARTS LIST

A EACH SHEET OF MULTI-SHEET DRAWINGS SHALL ALWAYS HAVE THE SAME REVISION LEVEL.

APPROVALS	DATE
JIM DAHLBERG	6-29-06
MIKE SEELY	6-29-06
ROLF ENT	6-29-06
STEVEN LASSITER	7-5-06

DOCUMENT CONTROL STAMP

MATERIAL: 2219-T6 ALUMINUM (SCOT FORGE)

FINISH MACHINED SURFACES 63 UNLESS OTHERWISE NOTED

DEBURR & BREAK ALL SHARP EDGES

DO NOT SCALE DRAWING

DIM & TOL PER ASME Y14.5 UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ARE:
FRACTIONS ± 1/32 DECIMAL .X ± .25 .XX ± .01 .XXX ± .005 ANGLES ± .25°

THIRD ANGLE PROJECTION

TRACKING NO. 67150 67153

APPROVALS	DATE
DRAWN METZGER	6-29-06
CHECKED PAULO MEDEIROS	6-29-06
APPROVED MIKE FOWLER	6-29-06
APPROVED PAUL BRINDZA	6-29-06

Jefferson Lab
Thomas Jefferson National Accelerator Facility
NEWPORT NEWS, VIRGINIA
UNITED STATES DEPARTMENT OF ENERGY

HALL C
SCATTERING CHAMBER
FORGED RING

SIZE E | DWG. NO. 67153-E-56003 | REV. C

SCALE 1/8 | USED ON ASSY NO. 67153-56002 | SHEET 1 OF 3