REVISIONS						
ZONE	REV	DESCRIPTION	CHANGED BY	DATE	CLASS REVIEW	APPROVED
---	A	ORIGINAL ISSUE	-------	--------	NR	---
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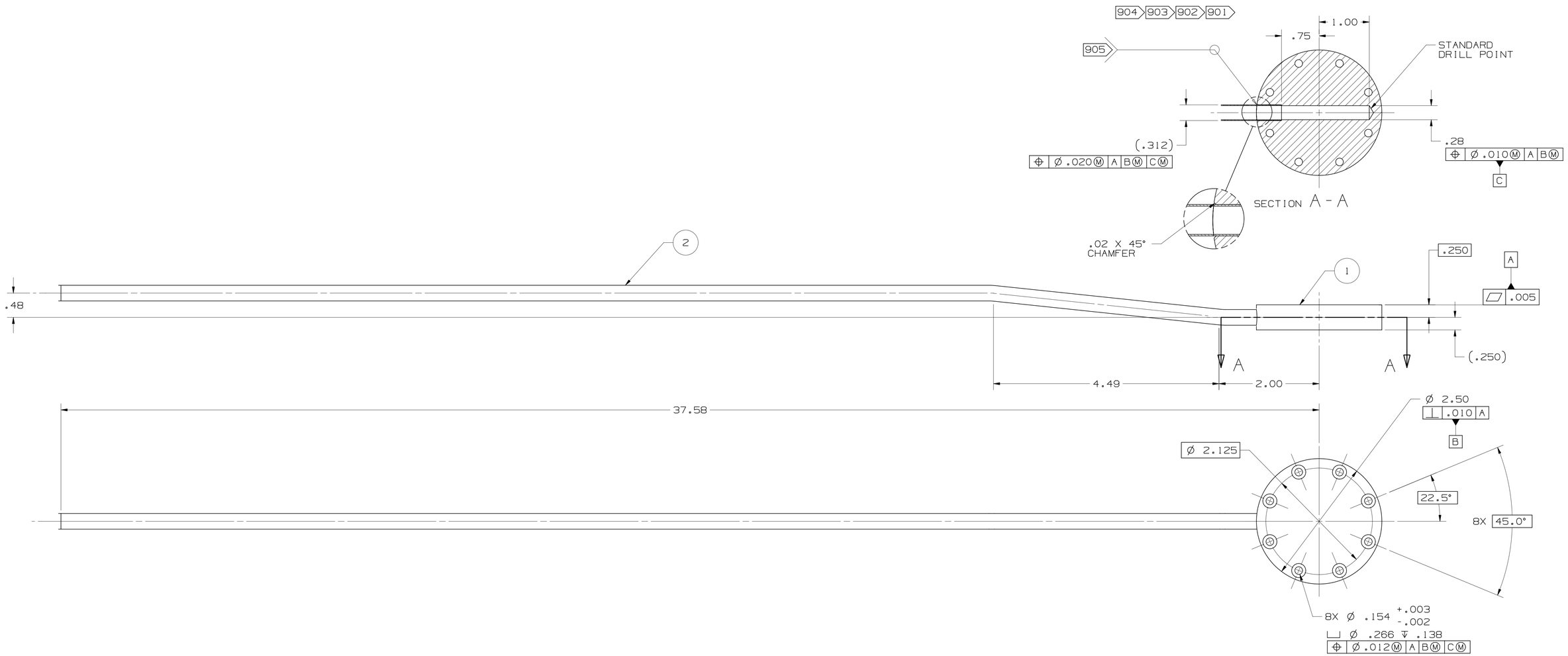

NOTES: UNLESS OTHERWISE SPECIFIED

101 ABBREVIATIONS PER ASME Y14.38-1999.
102 THOROUGHLY CLEAN PARTS TO REMOVE ALL OIL, GREASE, DIRT, CHIPS, ETC.
201 DIMENSIONING AND TOLERANCING PER ASME Y14.5M-1994.
203 SURFACE TEXTURE PER ASME B46.1-1995.
204 ALL INSIDE CORNERS TO BE R.010 MAX.
206 C'SINK ALL TAPPED HOLES 100°, TO MAJOR DIA.
208 REMOVE BURRS AND SHARP EDGES TO .010 MAX.
401 BAG AND TAG PART WITH DRAWING NUMBER & REVISION LETTER.
901 COPPER PLATE SURFACES PER ASTM B 254-92 ("STANDARD PRACTICE FOR PREPARATION OF AND ELECTROPLATING ON STAINLESS STEEL"), AND SAE/ASM 2418E ("COPPER PLATING"). THE GENERAL PLATING PROCESS SHALL BE THE UDYLITE BRIGHT ACID COPPER (UBAC) BATH PROCESS. A PRE-PLATE NICKEL STRIKE (.0002" TO .0004" THICK) IS PERMISSABLE. THE COPPER PLATING SHALL BE .001" TO .002" THICK. THE SURFACE FINISH OF THE COPPER PLATING SHALL BE NO WORSE THAN THE SUBSTRATE FINISH BEFORE PLATING. SMALL NODULES, FINES, STOPS, ROUGHNESS OR OTHER DEFECTS DUE TO THE PLATING PROCESS ARE NOT ACCEPTABLE.
902 ALL COPPER PLATED SURFACES SHALL BE PROTECTED FROM SCRATCHES, NICKS AND MARRING DURING SUBSEQUENT FABRICATION AND FINISHING OPERATIONS.
903 ALL DIMENSIONS APPLY BEFORE PLATING.
904 LEAK TEST PER SNS SPEC: SNS-104040200-EQ00008-R00
905 BRAZE PER MIL-B-7883C CLASS 2B. FURNACE BRAZE USING 50 Au - 50 Cu ALLOY.

PRELIMINARY
FOR INFORMATION OR REVIEW ONLY. DO NOT USE FOR PROCUREMENT OR FABRICATION. DRAWING CONTENT SUBJECT TO FUTURE CHANGE.

DATE 3-5-2002

SNS DWG No. 104050000-I8E-8200-B904-R00

QTY REQD	PART OR IDENTIFYING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL SPECIFICATION	ITEM NO
1		TUBE, .312 O.D. X .016 WALL	304 STAINLESS STEEL	2
1		ROUND BAR	OFE COPPER	1

PARTS LIST/BILL OF MATERIAL

DRAWING LEVEL: PRODUCTION

UNCLASSIFIED

UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES.
TOLERANCES ARE:
DECIMALS .X: ±.1 .XX: ±.01 .XXX: ±.005
ANGULAR: ±.25°
MACHINED FINISH: 125

155Y521882 ---------- NEXT ASSEMBLY USED ON
APPLICATION

TASK CONTRACTOR

CAD SYSTEM & VER. UG V16.0.4

SEE FINAL DESIGN AUTHORIZATION SHEET FOR SIGNATURES. SHEET IS FILED BY DRAWING NUMBER AT THE SNS PROJECT OFFICE.

	APPROVALS	DATE	GROUP
DESIGNED	M. CATANACH	6-6-01	SNS-3
DRAWN	H. SALAZAR	8-8-01	SNS-3
CHECKED			
ENGINEERING	S. ELLIS	6-6-01	SNS-3
VACUUM			
PHYSICS			
APPROVED			

Los Alamos National Laboratory
Los Alamos, New Mexico 87545
SNS DIVISION

PROJECT: SNS

DTL
FARADAY CUP/DEGRADER
HEAT EXCHANGER WELDMENT

SIZE	CAGE CODE	DWG NO. & CAD FILENAME	REV
D	88516	155Y521904	-A

SCALE 1/1 DO NOT SCALE SHEET 1 OF 1