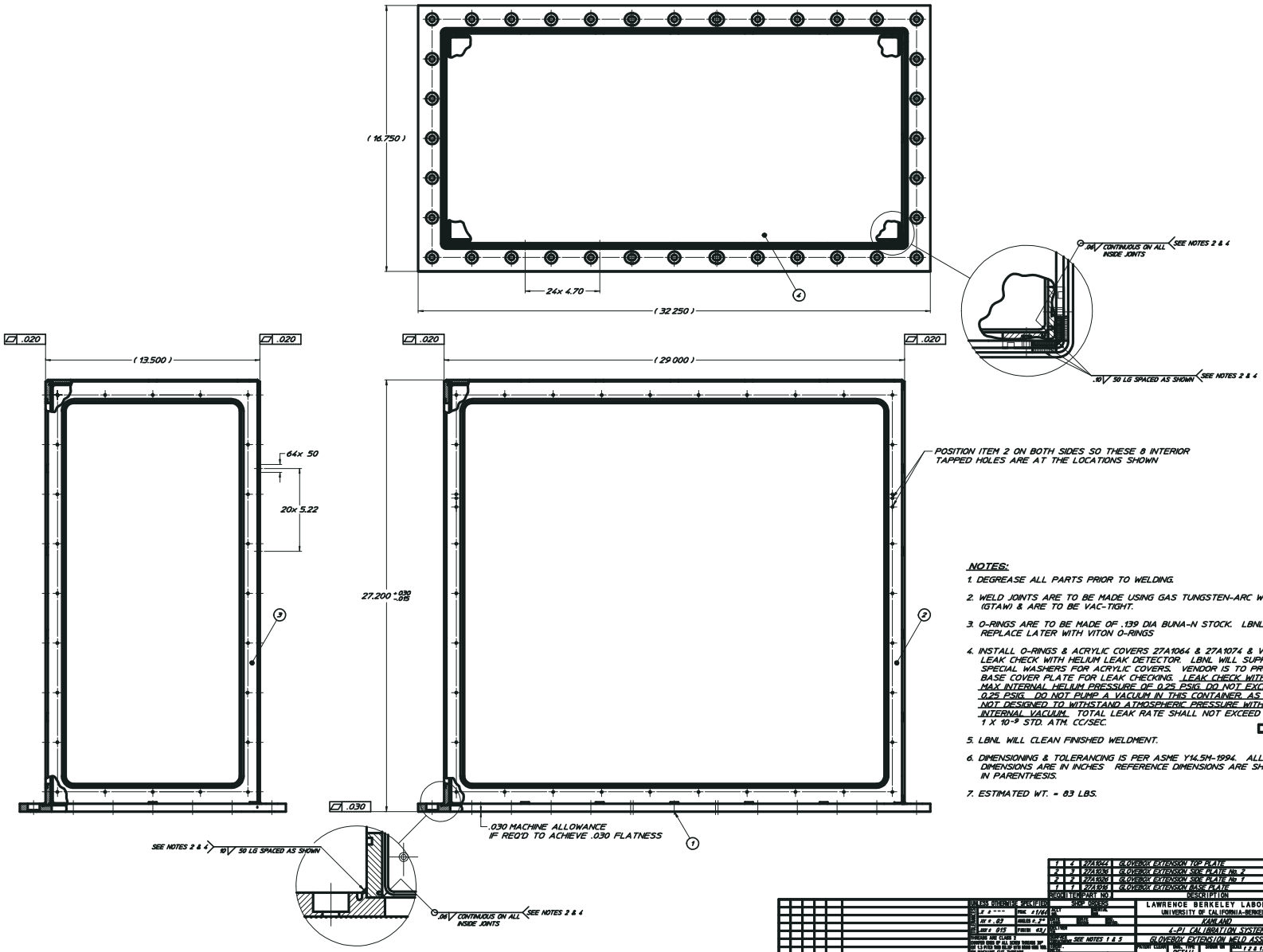

NOTES:

1. DEGREASE ALL PARTS PRIOR TO WELDING.
2. WELD JOINTS ARE TO BE MADE USING GAS TUNGSTEN-ARC WELDING (GTAW) & ARE TO BE VAC-TIGHT.
3. O-RINGS ARE TO BE MADE OF .139 DIA BUNA-N STOCK. LBNL WILL REPLACE LATER WITH VITON O-RINGS
4. INSTALL O-RINGS & ACRYLIC COVERS 27A1064 & 27A1074 & VACUUM LEAK CHECK WITH HELIUM LEAK DETECTOR. LBNL WILL SUPPLY SPECIAL WASHERS FOR ACRYLIC COVERS. VENDOR IS TO PROVIDE BASE COVER PLATE FOR LEAK CHECKING. LEAK CHECK WITH A MAX INTERNAL HELIUM PRESSURE OF 0.25 PSIG. DO NOT EXCEED 0.25 PSIG. DO NOT PUMP A VACUUM IN THIS CONTAINER. AS IT IS NOT DESIGNED TO WITHSTAND ATMOSPHERIC PRESSURE WITH AN INTERNAL VACUUM. TOTAL LEAK RATE SHALL NOT EXCEED 1×10^{-9} STD. ATM. CC/SEC.
5. LBNL WILL CLEAN FINISHED WELDMENT.
6. DIMENSIONING & TOLERANCING IS PER ASME Y14.5M-1994. ALL DIMENSIONS ARE IN INCHES. REFERENCE DIMENSIONS ARE SHOWN IN PARENTHESIS.
7. ESTIMATED WT. = 83 LBS.

27A1056

QTY	ITEM	PART NO	DESCRIPTION
1	4	27A1044	GLOVEBOX EXTENSION TOP PLATE
2	3	27A1063	GLOVEBOX EXTENSION SIDE PLATE No. 2
2	2	27A1073	GLOVEBOX EXTENSION SIDE PLATE No. 1
1	1	27A1015	GLOVEBOX EXTENSION BASE PLATE

UNLESS OTHERWISE SPECIFIED: X ± .1 ANGLES ± 2° XX ± .03 FRACS ± 1/64 XXX ± .015 DECS ±0.3

TOLERANCE AND CLASS A: MACHINE FINISH OF ALL BORES, MACHINE CUT FLATNESS, THE BLUE OR BLACK BORE THE MACHINE CUT THREADS

GENERAL NOTES: DRILL AND MILL BE MACHINED WITH CHAMFER, DEBURR, AND FREE OF SHARP EDGES

CONFORMS TO ASME Y14.5 & ASME B

SHOP: 10/03/95

DRAWN: SEE NOTES 1 & 5

APPROVED: J. B. ABBOTT 10/03/95

M. E. NEEDER 10/03/95

LAWRENCE BERKELEY LABORATORY
UNIVERSITY OF CALIFORNIA-BERKELEY
KANLAND
L-PI CALIBRATION SYSTEM
GLOVEBOX EXTENSION WELD ASSEMBLY

SCALE: DETAIL

SIZE: A

CODE IDENT NO. 95127

DRAWING NO. 27A1056

REV

REVISION CODE | DATE | CHANGES