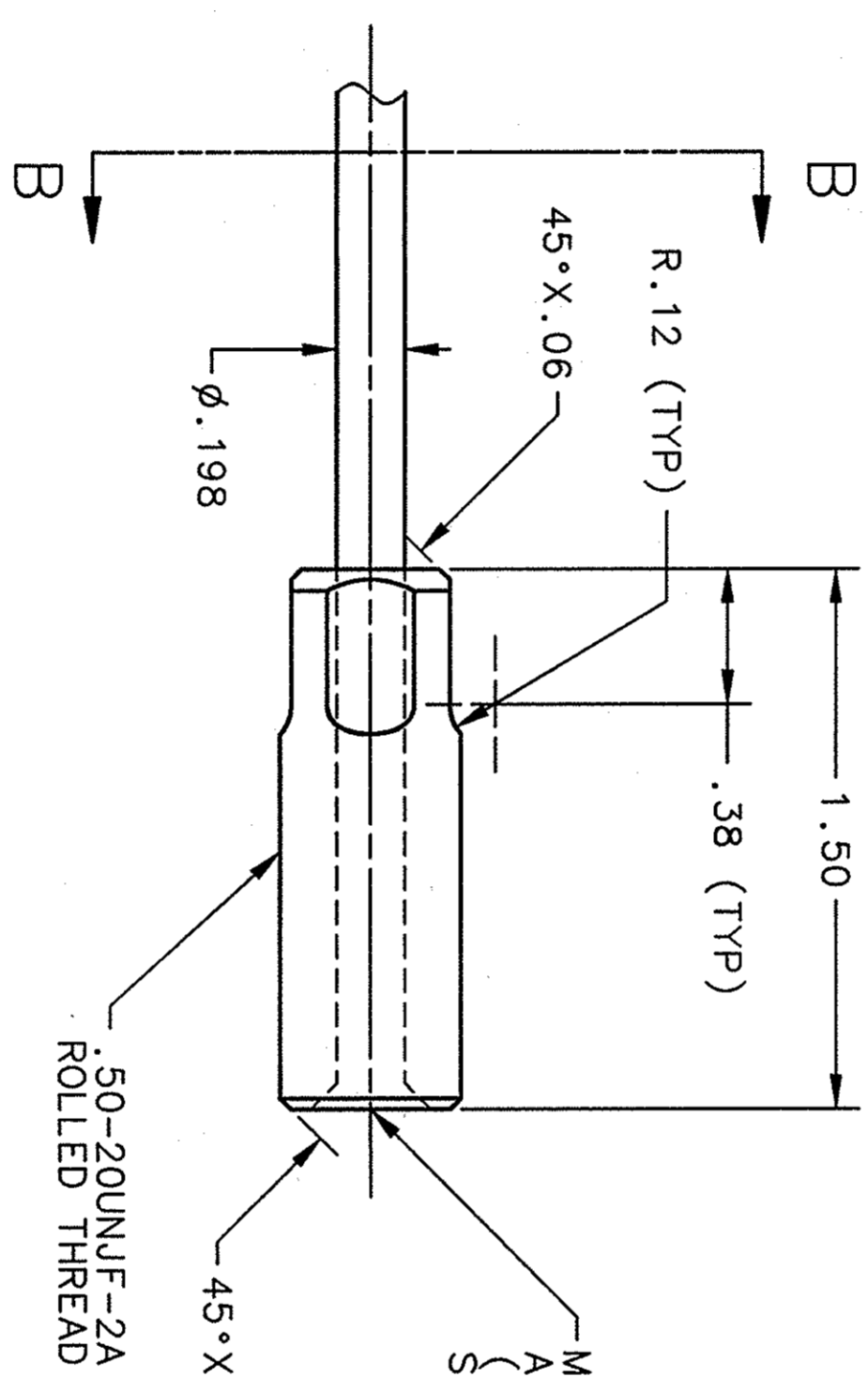
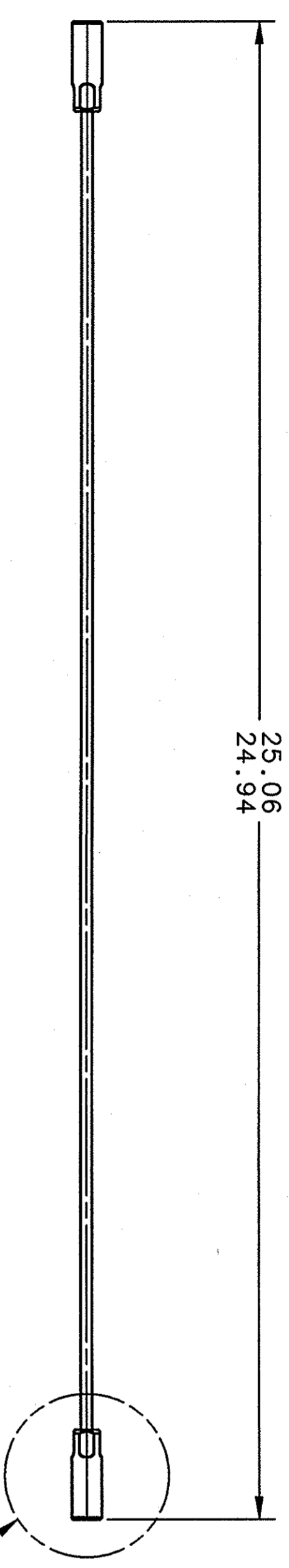


REVISION HISTORY				
ZONE	REV	DESCRIPTION	DATE	APPROVED
D3	A	ALTERED: 25.06/24.94 WAS 25.00	20AUG02	T E WHITLATCH
			JEH	<i>Reginald</i>

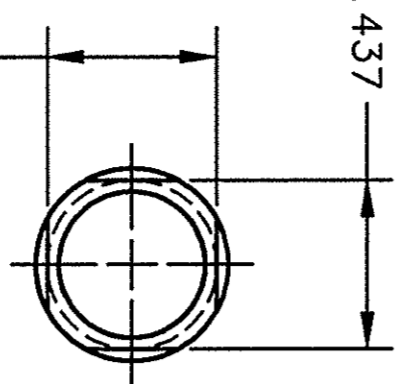


METHOD OF CONSTRUCTION / ATTACHMENT AT VENDORS OPTION (JLAB APPROVAL REQUIRED) SUGGESTED METHOD: NAVTECH FORM

MATERIAL: ROD  
 NITRONTIC 50 AUSTENITIC STAINLESS STEEL  
 MINIMUM YIELD STRENGTH OF 174 KSI  
 AT 0.2% TENSILE OFFSET (50% COLD DRAWN)  
 MATERIAL: ROD END  
 655 EVERDUR BRONZE  
 80KSI MIN. UTS  
 TESTING  
 ONE OUT OF 36 (RANDOM SAMPLE)  
 SHALL BE TESTED TO 3000#  
 TENSILE WITH LESS THAN 0.2% OFFSET

DETAIL A  
 SCALE: 2/1  
 BOTH ENDS

SECTION B-B  
 SCALE: 2/1  
 BOTH ENDS  
 (.437 (WRENCH FLATS)  
 (COLD GRIND, DO NOT ANNEAL)



DIM & TOL PER ANSI Y14.5 UNLESS OTHERWISE SPECIFIED TOLERANCES ARE IN INCHES FRACTIONS DECIMAL ANGLES ± 1/64 .XXX ± .005		CADD I.D. NO.: 1-DEAS PROJ: 115000 LBRY: 115630		Thomas Jefferson National Accelerator Facility UNITED STATES DEPARTMENT OF ENERGY	
MATERIAL SEE ABOVE		APPROVALS		DATE	
FINISH 125 UNLESS OTHERWISE NOTED		DRAWN J. HENRY		21DEC99	
DEBURR & BREAK ALL SHARP EDGES		CHECKED JAMES J TAKACS		11FEB00	
DO NOT SCALE DRAWING		APPROVED T WHITLATCH		11FEB00	
		APPROVED W J SCHNEIDER		11FEB00	
LINAC / CRYMODULE 1998 SPACEFRAME		SIZE DWG. NO. 115630-1009C		REV. A	
SCALE 1/2 & NOTED		USED ON ASSY NO. 115630-1001E		SHEET 1 OF 1	



4 3 2 1

DWG. NO. 115630-1009C SHEET 1 REV. A