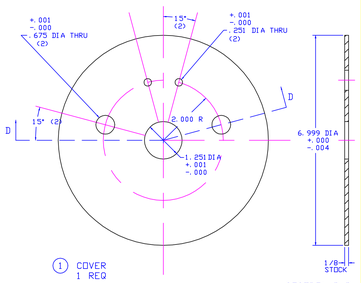
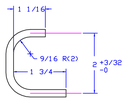
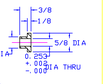
REV.	DATE	DESCRIPTION	BY	APP'D



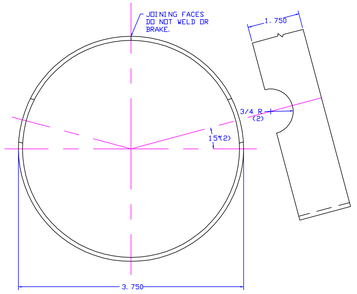
1 COVER
1 REQ



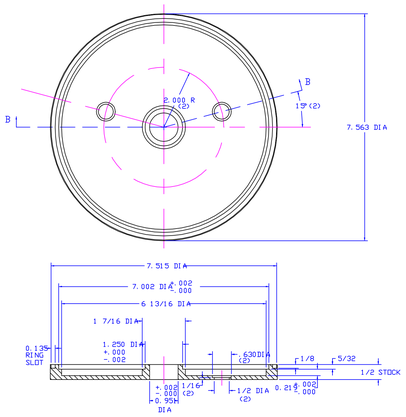
2 "U" TUBE
2 REQ



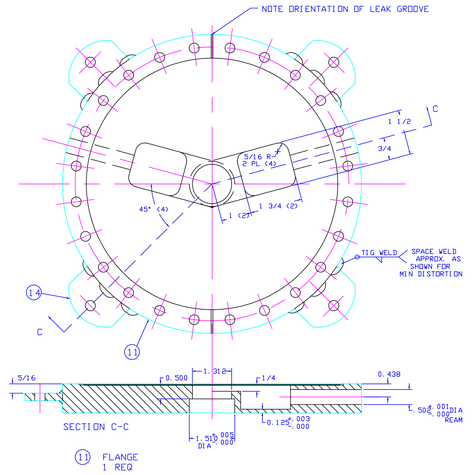
3 BOSS
2 REQ



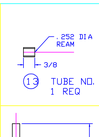
4 COLD RETAINER SHIELD
1 REQ



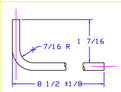
6 TANK
1 REQ



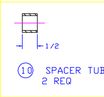
11 FLANGE
1 REQ



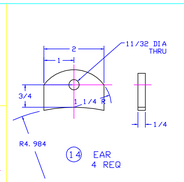
13 TUBE NO. 3
1 REQ



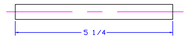
12 TUBE NO. 2
2 REQ



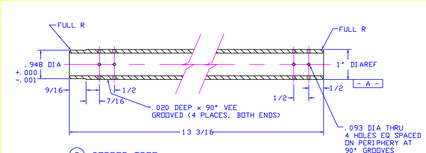
10 SPACER TUBE
2 REQ



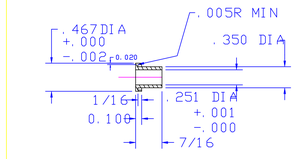
14 EAR
4 REQ



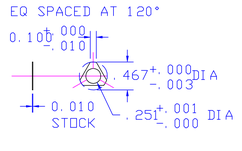
15 TUBE NO. 4
2 REQ



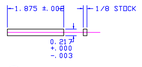
9 COPPER TREE
1 REQ



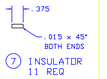
16 TUBE GUIDE
2 REQ
SCALE 1=1



17 TUBE SUPPORT
2 REQ
SCALE 1=1



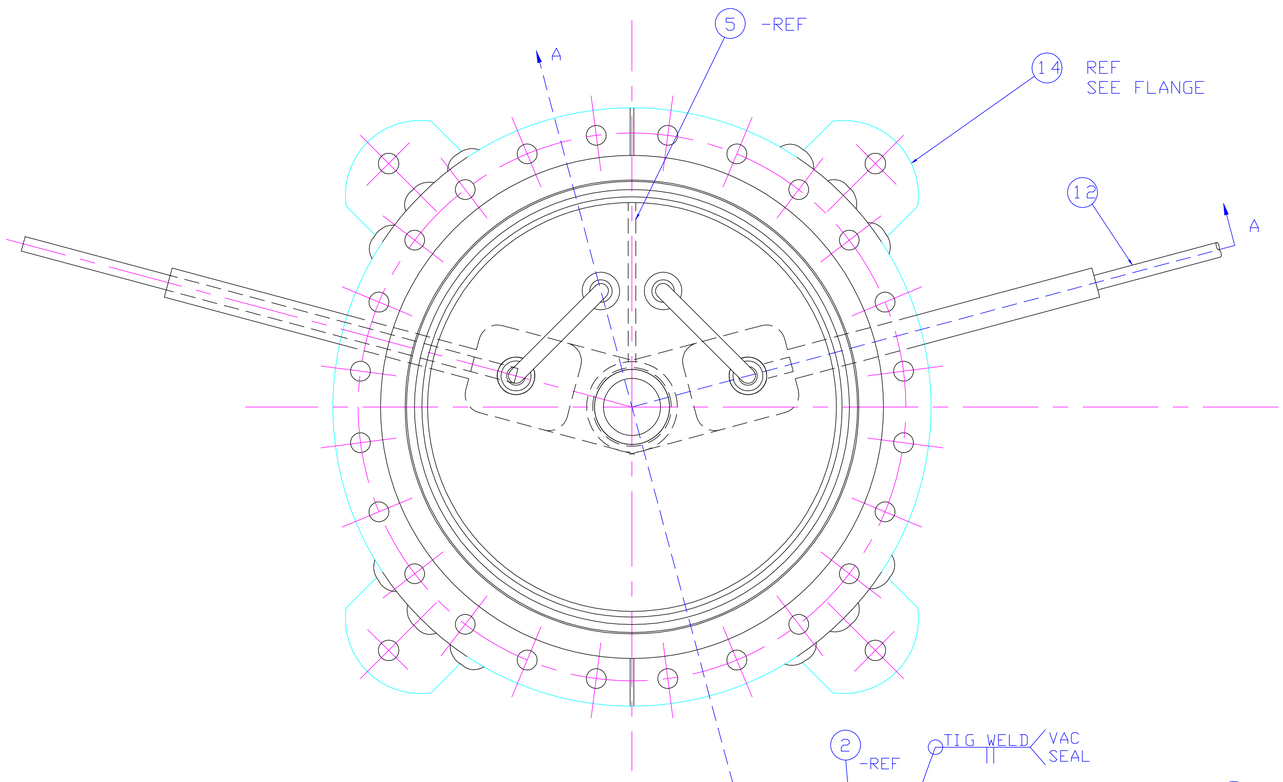
5 BAFFLE
1 REQ

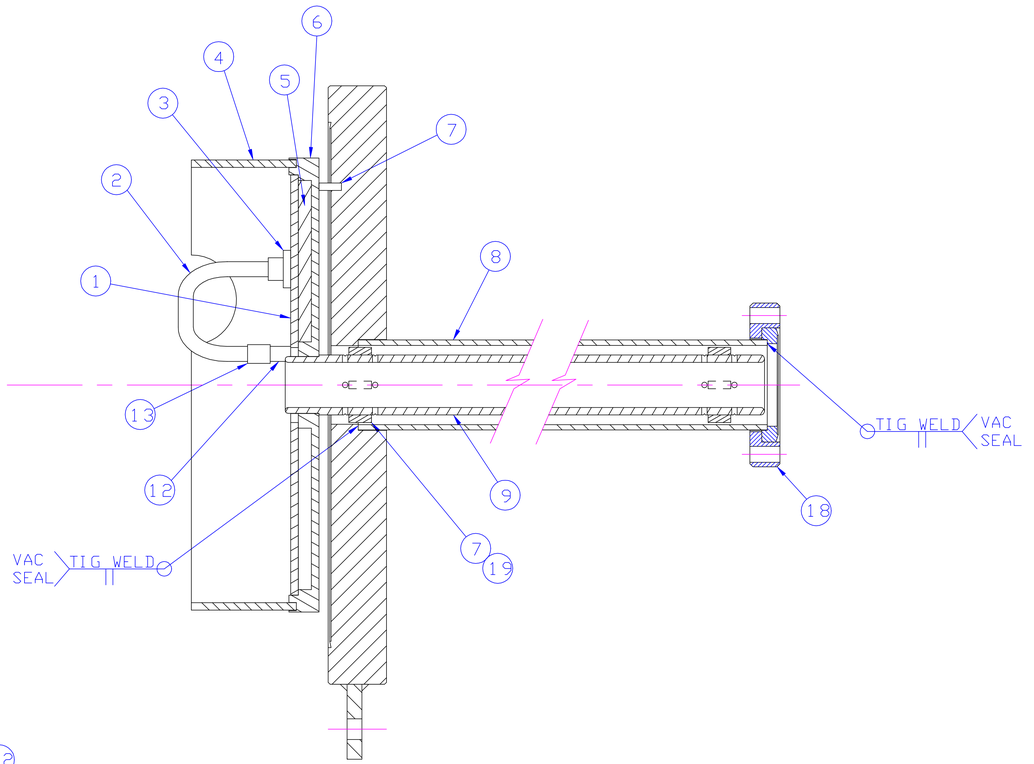


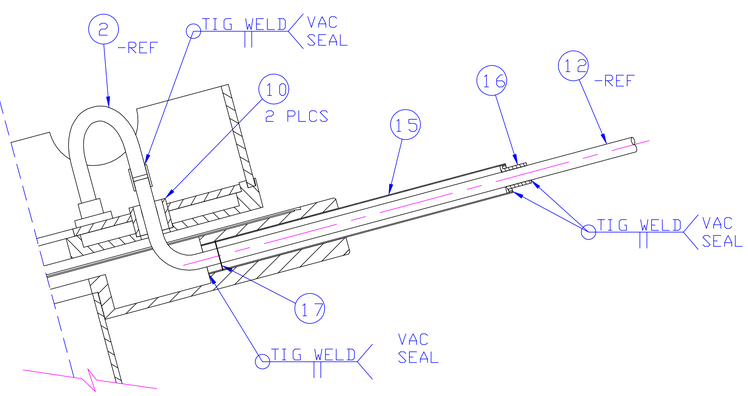
7 INSULATOR
11 REQ

8 TUBE
1 REQ

SCALE FOR INDIVIDUAL PARTS IS 1=2 EXCEPT PARTS 16 AND 17 WHICH ARE 1=1







SECTION A-A

NOTES

1. ITEM 7 - OMEGA ENGINEERING INC., STAMFORD, CONN, OR EQUAL
   ITEMS 11,20 - MDC VACUUM PRODUCTS CORP. HAYWARD, CA.

2. BRAZE OPERATION SEQUENCE
   BRAZE OPERATION #1 - TANK (ITEM 6) & BAFFLE (ITEM 5) & SPACER TUBE (ITEM 10) TACK WELD IN PLACE & BRAZE.
   BRAZE OPERATION #2 - TACK WELD ITEMS 1,2,3, IN PLACE AFTER ALIGNING TANK POSITION. ASSEMBLE BRAZE BRAZE OPERATION 2 TO BRAZE OPERATION 1. INSTALL TUBE (ITEM 9) INTO TANK ASSY & BRAZE ENTIRE UNIT IN DRY HYDROGEN FURNACE.
   USE ALLOY 65-35. VAC SEAL.

ITEM		DESCRIPTION	QTY
19		MOLYBDENUM WIRE .010 DIA	A/R
18	1/2 TUBE (2 3/4 DIA)	ROTATABLE CONFLAT FLANGE & INSERT #F275150R	1
17		TUBE SUPPORT .010 THK (HALF HARD 302 SST)	2
16		TUBE GUIDE 1/2 DIA BAR (304 SST	2
15		TUBE NO. 4 1/2 DIAx.016 WALL (304 SST)	2
14		EAR 1/4 THK (304 SST)	4
13		TUBE NO. 3 5/16 DIAx.030 WALL (304 SST)	2
12		TUBE NO. 2 1/4 DIAx.049 WALL (304 SST)	2
11	MAKE FROM #F100000	MODIFIED FLANGE (10" BLANK) (SST)	1
10		SPACER TUBE 5/8 DIA .065 WALL (304 SST)	1
9		COPPER TUBE 1" DIAx.125 WALL (OFHC CU)	1
8		TUBE 1 1/2DIAx.090 WALL (304 SST)	1
7	MAKE FROM #TRA 02018-15	THERMOCOUPLE INSULATOR	11
6		TANK 1/2" THK (304 SST)	1
5		BAFFLE 1/8" THK (304 SST)	1
4		COLD RETAINER SHIELD 1/8" THK (OFHC CU)	1
3		BOSS 5/8 DIA BAR (304 SST)	2
2		"U" TUBE 1/4 DIAx.049 WALL (304 SST)	2
1		COVER 1/8 THK (304 SST)	1

NOTE 1 applies to items 18, 11, and 7.

DRAWN BY: URIBE	NUCLEAR PHYSICS LABORATORY, UNIVERSITY OF ILLINOIS AT URBANA-CHAMPAIGN	NITROGEN TANK (PARTS)
CHECKED BY	UNLESS OTHERWISE SPECIFIED: DIMENSIONS IN INCHES 2 PLACE DEC. ±.01; BREAK SHARP CORNERS 3 PLACE DEC. ±.003; FRACTIONAL ±1/32" ANGULAR ±0°30'	PART NO. / NO. REQ'D. / CHASSIS NO. OR MATERIAL
APPROVED BY		SCALE 1=1; DATE 4-4-91; FILE 15; DWG. NO. E-2709-33