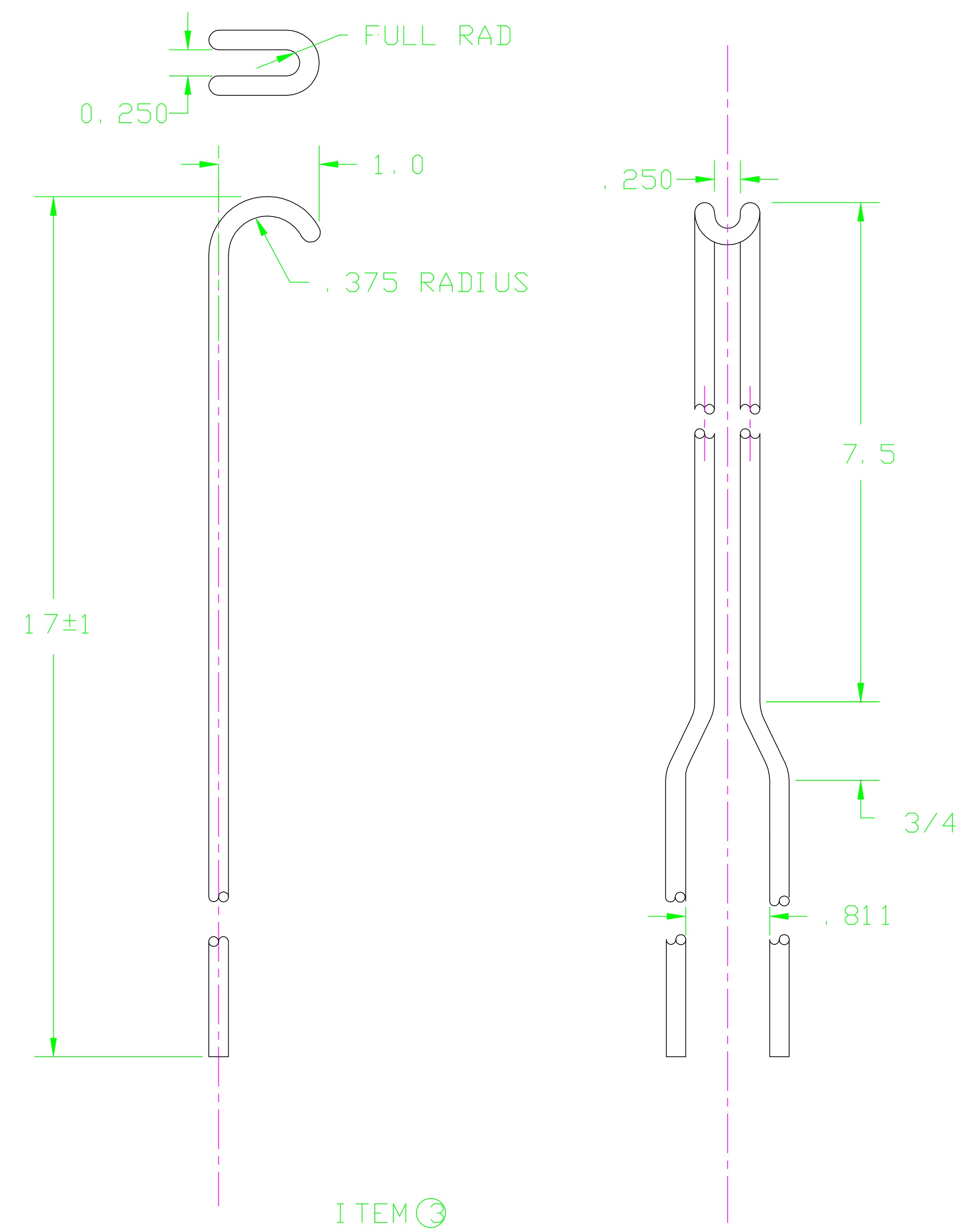


NOTES

1. BRAZE ITEMS 3 & 4 BEFORE WELDING INTO ITEMS 1 & 2. ITEMS 1 & 2 MUST NOT GO THRU BRAZE FURNACE.
2. BEND ITEM 3 APPROX. AS SHOWN FOR MAXIMUM CONTACT WITH ITEM 4.
3. BEND ARC FOR MAXIMUM CONTACT WITH VALVE HEAT CLIP (C-2709-56) AT TIME OF INCORPORATION INTO CESIATOR SUBASSEMBLY (D-2709-1)
4. TEST BRAZED SUB-ASSEMBLY FOR FULL FLOW THROUGH BENT TUBE (ITEM 3) BEFORE WELDING INTO FLANGE.

SLAC: PF795-649-92-R0 MODIFIED

REV.	DATE	DESCRIPTION	BY	APP'D.
1	10-88	ADDED TACK WELDS ON TUBE/FLANGE JOINTS	SPESE	
2	10-88	ADDED ITEM ④	SPESE	
3	6-89	CORRECTED LEAK GROOVE ORIENTATION	WAALER	
4	7-89	STRAIGHTENED HEATER TUBE	WAALER	
5	10-90	REVISED PARTS LIST FOR A VERSION	URLBE	
6	6-92	ADDED NOTE 4	URLBE	



ITEM	PART NO.	DESCRIPTION	QTY
6	1/4-3/16	REDUCING UNION-PT NO SS-400-6-3	1
5	C-2709-19	METAL SEAL MINI FLANGE VALVE	1
4	SST TUBE	1/4 OD X .049 WALL X 12 LONG	1
3	SST TUBE	3/16 OD X .049 WALL X 40 LONG	1
2	SST TUBE	3/8 OD X .049 WALL X 1/4 LONG	1
1	C-2709-15A	MOUNTING FLANGE	1

ITEM PART NO.		DESCRIPTION		QTY	
DRAWN BY		NUCLEAR PHYSICS LABORATORY		CESIATOR WELDMENT	
SPESE		UNIVERSITY OF ILLINOIS AT URBANA-CHAMPAIGN			
CHECKED BY		UNLESS OTHERWISE SPECIFIED		PART NO.	
		DIMENSIONS IN INCHES 2 PLACE DEC. ± .01		SCALE 1=1	
APPROVED BY		BREAK SHARP CORNERS 3 PLACES DEC. ± .003		FILE 15	
		FRACTIONAL ± 1/32" ANGULAR ± 30'		CHASSIS NO. OR MATERIAL LISTED	
				DATE 7-14-88	
				DWG. NO. D-2709-44A	