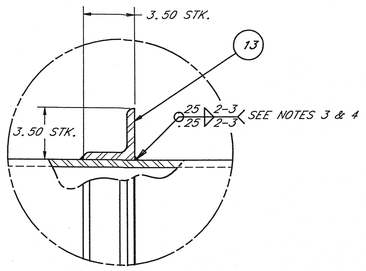
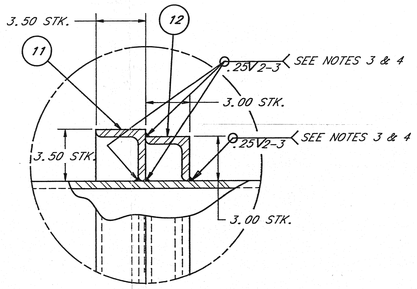
REV.	DESCRIPTION	DRAWN	DATE
		APPROVED	DATE
A	ADDED ITEM 18, FOR SURVEY LOCATIONS	RLW	4-28-94
		C NILA	6-22-94
B	ITEM 19 20 & 21 ADDED	G SMITH	8-3-94



VIEW A
SCALE: 1/4"=1"



VIEW B
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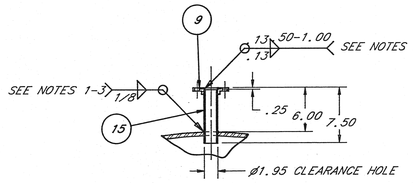
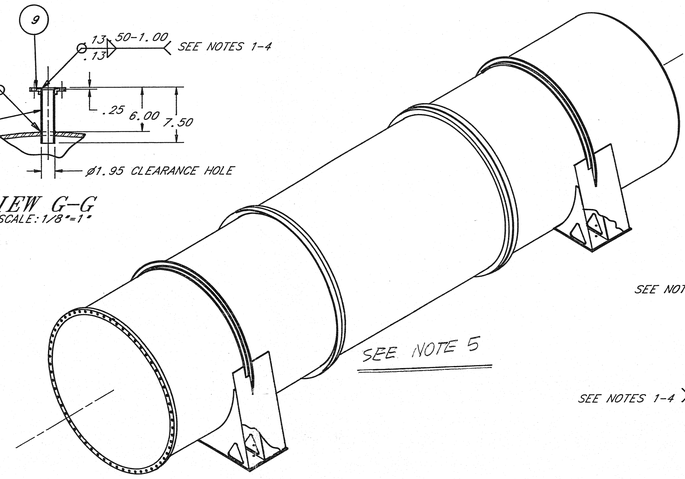
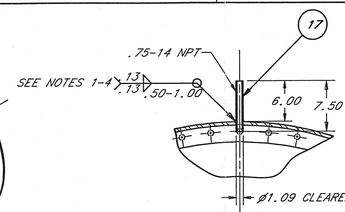
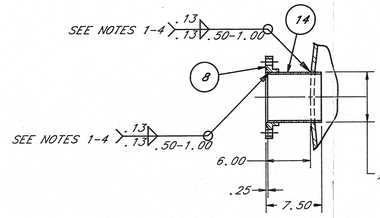


VIEW G-G
SCALE: 1/8"=1"

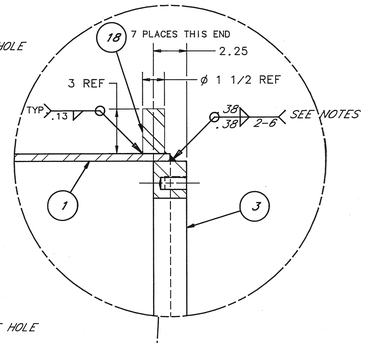


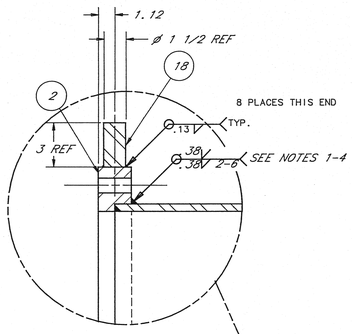


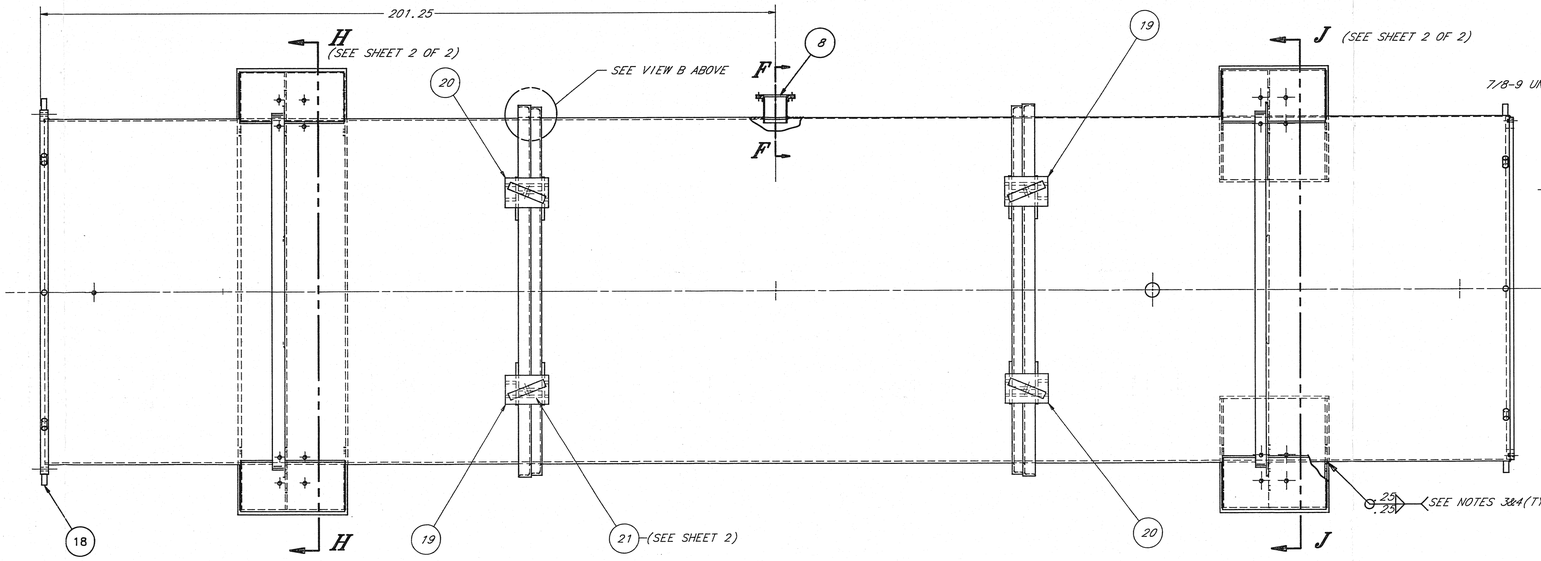
VIEW E-E
SCALE: 1/8"=1"

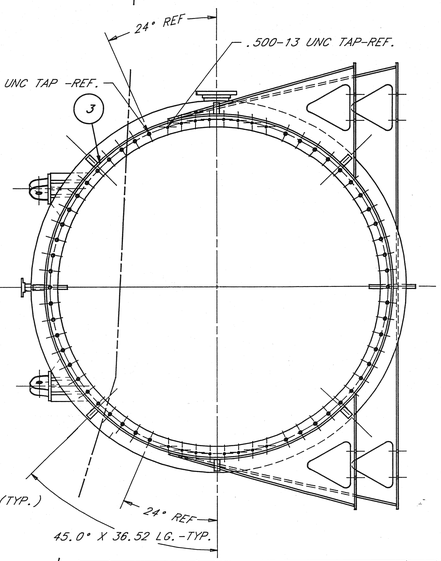


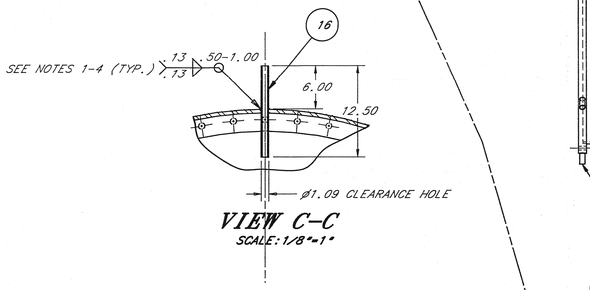
VIEW F-F
SCALE: 1/8"=1"



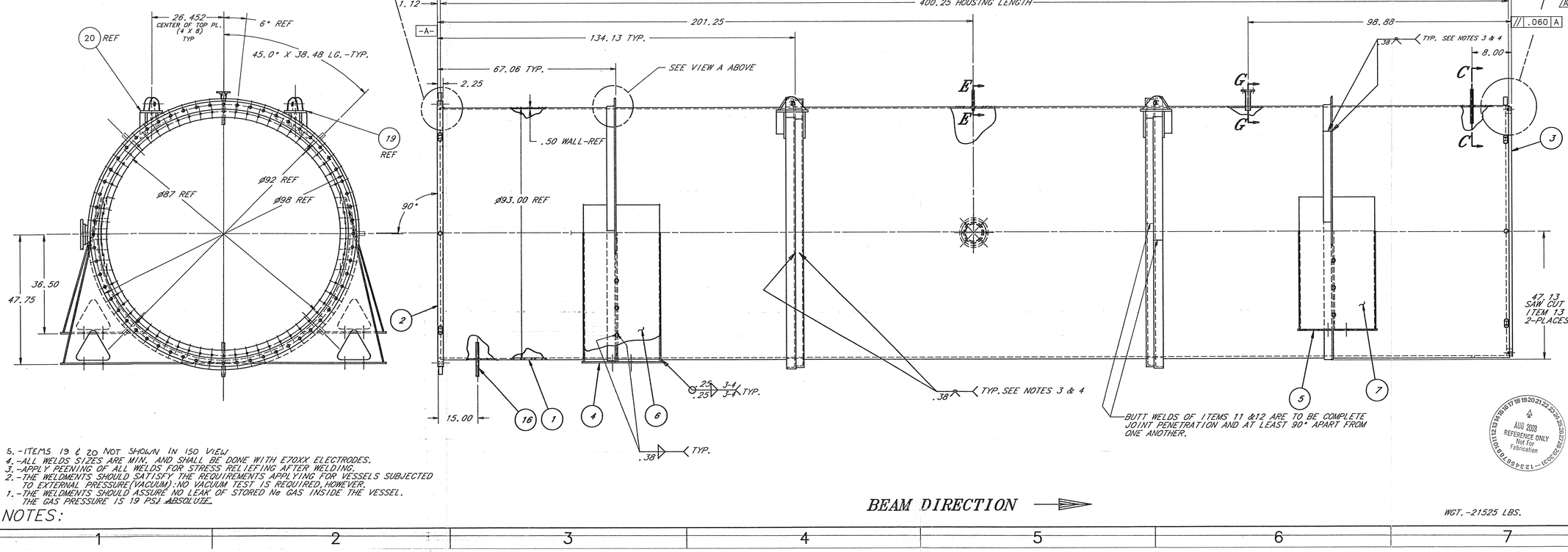








VIEW C-C
SCALE: 1/8"=1"



ITEM NO.	PART NO.	DESCRIPTION OR SIZE	QTY. REQ.
21		GUSSET - (SEE SHEET 2)	4
20	MD-327343	LIFTING LUG WELDMENT L.H.	2
19	MD-327340	LIFTING LUG WELDMENT R.H.	2
18		1 1/2ø X3.00 LG. ROUND C1018 CRS	15
17		3/4"NOM. THREADED PIPE SCH 80 1.050 O.D.X.154 WALLX 7.50 LG.-STEEL	1
16		3/4"NOM. PIPE SCH 80 1.050 O.D.X.154 WALLX 12.50 LG.-STEEL	2
15		1 1/2"NOM. PIPE SCH 40 1.900 O.D.X.145 WALL-STEEL	1
14		6"NOM. PIPE SCH 40 6.625 O.D.X.280 WALLX 7.25 LG.-STL	1
13		3 1/2X3 1/2X1/2 STRUCTURAL ANGLE-STEEL	2
12		3X3X1/2 STRUCTURAL ANGLE-STEEL	2
11		3 1/2X3 1/2X1/2 STRUCTURAL ANGLE-STEEL	2
10			
9	9211.550-MC-285962	FLANGE, WELDING 1 1/2" 150# MODIFICATIONS	1
8	9211.550-MC-285961	FLANGE, WELDING 6" 150# MODIFICATIONS	1
7	9211.600-MC-285935	SIDEPLATE, D.S.	1 LTH 1 RH
6	9211.600-MC-285933	SIDEPLATE, U.S.	1 LTH 1 RH
5	9211.600-MD-285816	SUPPORT WELDMENT, D.S.	2
4	9211.600-MD-285815	SUPPORT WELDMENT, U.S.	1
3	9211.550-ME-285814	VESSEL FLANGE, DOWNSTREAM	1
2	9211.550-ME-285813	VESSEL FLANGE, UPSTREAM	1
1	9211.600-MD-285972	HOUSING, VESSEL	1

PARTS LIST

UNLESS OTHERWISE SPECIFIED			ORIGINATOR	A. SZYMULANSKI	2-10-93
.XX	.XXX	ANGLES	DRAWN	R.L. WILLIAMS	2-10-93
± .03	± .005	± .25°	CHECKED	J.E. RAUCH	6-25-93
			APPROVED	ANDREW SZYMULANSKI & LINDA SEUTE	6-93

1. BREAK ALL SHARP EDGES .015 MAX.
2. DO NOT SCALE DRWG.
3. DIMENSIONING IN ACCORD WITH ANSI Y14.5M-1982
4. STD'S DIMENSIONS ARE IN INCHES.

USED ON 9213.150-ME-285811

MATERIAL SEE ABOVE

125 MAX. ALL MACHINED SURFACES

AUG 2008 REFERENCE ONLY Not For Fabrication

FERMI NATIONAL ACCELERATOR LABORATORY
UNITED STATES DEPARTMENT OF ENERGY

RD/MECHANICAL SUPPORT DEPT.
PRESSURE VESSELS, EXTERNAL
VESSEL WELDMENT, E781 RICH

SCALE	DRAWING NUMBER	SHEET NO.	REV.
3/4"=1'-0" & NOTED	9211.600-ME-285812	1 OF 2	B

WGT. -21525 LBS.

BEAM DIRECTION

NOTES:
5. -ITEMS 19 & 20 NOT SHOWN IN 150 VIEW
4. -ALL WELDS SIZES ARE MIN. AND SHALL BE DONE WITH E70XX ELECTRODES.
3. -APPLY PEENING OF ALL WELDS FOR STRESS RELIEFING AFTER WELDING.
2. -THE WELDMENTS SHOULD SATISFY THE REQUIREMENTS APPLYING FOR VESSELS SUBJECTED TO EXTERNAL PRESSURE(VACUUM):NO VACUUM TEST IS REQUIRED, HOWEVER.
1. -THE WELDMENTS SHOULD ASSURE NO LEAK OF STORED Ne GAS INSIDE THE VESSEL. THE GAS PRESSURE IS 19 PSI ABSOLUTE