NOTES:
1. GROOVES TO HAVE A 32 FINISH
2. FLANGES TO HAVE 32 FINISH FROM THE ID TO THE INNER EDGE OF THE BOLT HOLEs
3. WELD AFTER MACHINING
4. MATE WITH ASSY(8)-4-10 & ASSY(8A)-3-4-10 TO PREVENT FOR WELDING
5. WELDS TO BE VACUUM TIGHT
WELDING & LEAK CHECK PROCEDURE

1. TACK WELD FLANGES ITEM 49 TO INNER & OUTER CYLINDERS
2. INSERT ITEM 1 & CHECK OVERALL DIMENSION & TACK WELD
3. TACK WELD BOTTOM FLANGES ITEM 49 TO CYLINDERS. CHECK OVERALL LENGTH & ALIGNMENT OF FLANGES BEFORE WELDING FLANGES & CYLINDERS.
4. WELD HP SUPPLY & RETURN PORTS ITEMS 1, 3 & 6 - USE ITEMS 7 & 8 TO POSITION ITEMS 5 & 6 - ITEMS 7 & 8 TO BE WELDED AFTER MACHINING - SEE GA-1-4-03
5. LEAK CHECK INNER & OUTER CYLINDER WALL WELDS USING BLANKOFF FLANGES ITEM 63 & 99 SUPPLY & RETURN PORTS
6. HOLES MAY BE SPOT DRILLED FROM BLANKOFF FLANGES
7. WELD TO BE VACUUM TIGHT

SEE DWG WD-1 & 2-4-0 FOR DETAILS

<table>
<thead>
<tr>
<th>MATERIAL</th>
<th>LEFT</th>
<th>RIGHT</th>
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<tr>
<td>ALLOY 7075</td>
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<td>ALLOY 7075</td>
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<tr>
<td>6061-T6</td>
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<tr>
<td>304SS</td>
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<tr>
<td>TUBE 375 OD X 653W X 3/4 X 304SS</td>
<td>TUBE 375 OD X 653W X 3/4 X 304SS</td>
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<tr>
<td>TUBE 400 OD X 600 304SS</td>
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<td>TUBE 300 OD X 255 X 600 304SS</td>
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DESIGNER: J. J. AREDELLI

ENGINEER: G. CHAMBER

WELDMENT ASSEMBLY WA-1-4-0
TOP FLANGE
MATERIAL: SEE WELDMENT ASSY(WA-1-4-D)
NOTE: 4 HOLES MAY BE SPOT DRILLED FROM ITEM 10/11 (WD-8-4-D)

BOTTOM FLANGE
MATERIAL: SEE WELDMENT ASSY(WA-1-4-D)
NOTE: 4 HOLES MAY BE SPOT DRILLED FROM ITEM 10/11 (WD-8-4-D)
TUBE (2)
MATERIAL: SEE WELDMENT ASSY (WA-1-4-E)

TUBE (3)
MATERIAL: SEE WELDMENT ASSY (WA-1-4-E)

FLANGE BOTTOM BLANKET (1)
MATERIAL: 507K X 7601IA 53314

FLANGE TOP BLANKET (2)
MATERIAL: 507K X 7601IA 53314

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WELDMENT DETAILS
WB-2-4-1
RELEASED 4-5-01
NOTE: WELD FITTINGS & SILVER SOLDER TUBING TO FITTINGS & ASSEMBLY TO BE VACUUM TIGHT
WHERE NOT NOTED, MIN BENDING RADIUS TO BE 3
NOTE: LEAK CHECK VDR WELDS & PORT BEFORE SOLIDING COIL TO TOP PLATE & LEAK CHECK COIL ASSY BEFORE SOLIDING TO TOP PLATE.

NOTE: USED ON MAIN ASSEMBLY FA-1-4-B

NOTE: RADIUS ALL SHARP EDGES

NOTE: USED ON MAIN ASSEMBLY FA-1-4-D
CERAMASEAL #9853-01-B

SS-12-VCR-3

CUTOFF LINE

VAC TIGHT

0.062

SS-12-VCR-4

SS-12-VCR-1

FEMALE NUT

ø0.250

CUTOFF LINE

SS-12-VCR-3

(2) REQD/FEED THRU

OCKET WELD GLAND

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LOW VOLTAGE
FEED THROUGH

SIZE
FSCM NO.
REV

A
SK-1-1-B
A

SCALE FULL
SHEET