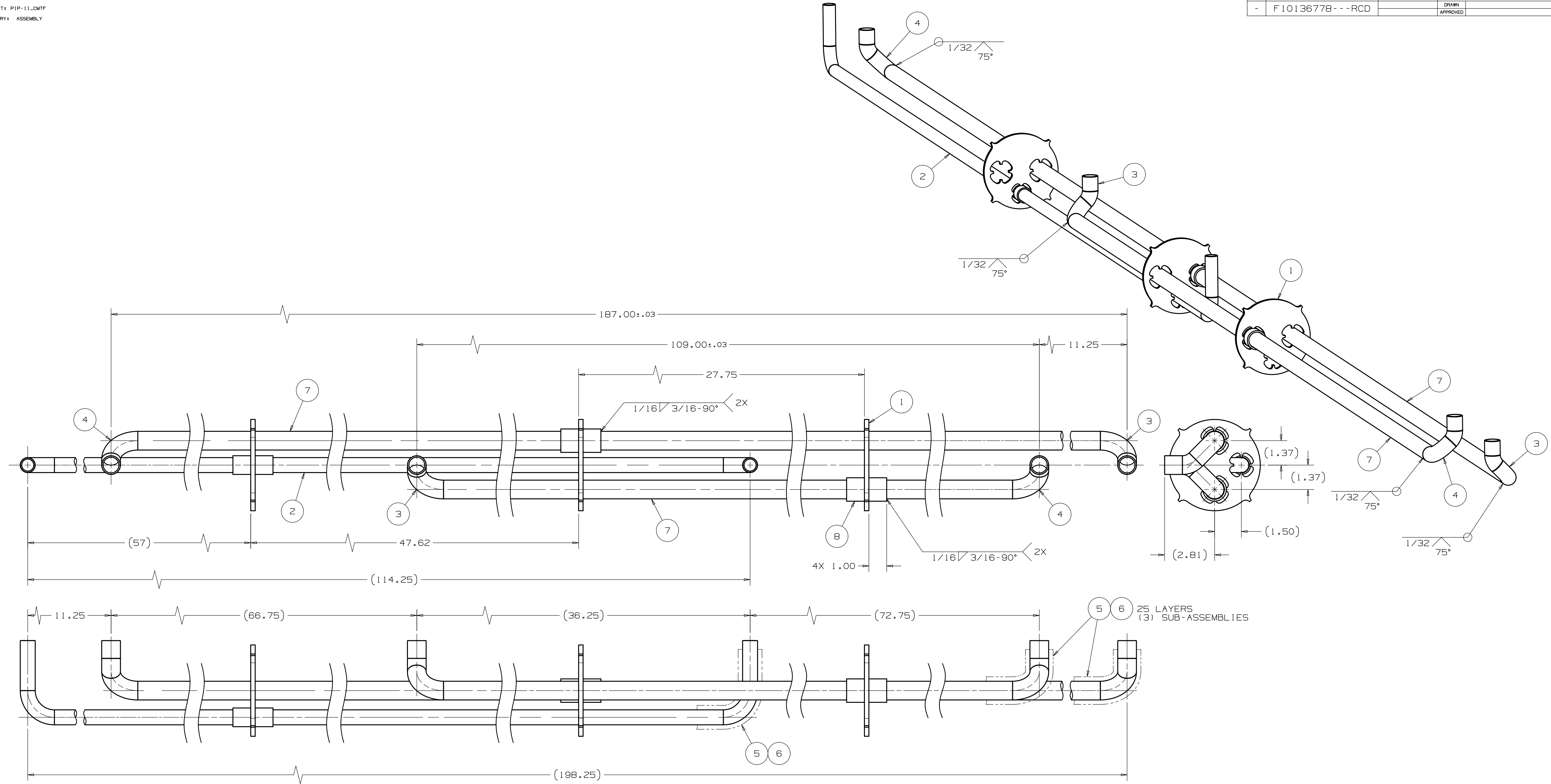


REV	REVISION CONTROL DOCUMENT	DATES	SIGNATURES
-	F10136778---RCD		



- NOTES (UNLESS OTHERWISE SPECIFIED):
1. ASSEMBLY MUST BE FREE OF DIRT, GREASE, OIL AND CHIPS.
 2. ASSEMBLY TO BE FREE OF ALL SHARP EDGES, CORNERS, AND BURRS.
 3. ALL WELDS TO BE VACUUM LEAK TIGHT. LEAK TEST: NO LEAK SHALL BE DETECTABLE ON THE MOST SENSITIVE SCALE OF A HELIUM LEAK DETECTOR WITH A MINIMUM SENSITIVITY OF 10⁻⁹ ATM. CC/SEC.
 4. WELDS TO COMPLY WITH MOST RECENT VERSION OF PROCESS PIPING CODE ASME B31.3 FOR NORMAL FLUID SERVICE. GROOVE WELDS TO BE COMPLETE PENETRATION. RELATED DOCUMENTATION OF MATERIALS, WELDING, AND IN-PROCESS INSPECTION MUST BE INCLUDED WITH THE FINAL PRODUCT DELIVERY.
 5. WELDS AS NOTED TO COMPLY WITH MOST RECENT VERSION OF PROCESS PIPING CODE ASME B31.3 FOR CATEGORY D FLUID SERVICE. GROOVE WELDS MAY BE PARTIAL PENETRATION. RELATED DOCUMENTATION OF MATERIALS MUST BE INCLUDED WITH THE FINAL PRODUCT DELIVERY.

ITEM	FERMI #	PART NAME	QTY
8	FC0075525	PIPE, 1" SCH.10 304SS	A/R
7	FC0073288	PIPE, 3/4" SCH.10 304 SS	A/R
6	FC0051571	MLI BLANKET SPACER MATERIAL - REEMAY SPUNBONDED POLYESTER	A/R
5	FC0051570	REFLECTOR, FLAT - ENERGY DOUBLER, CRYOSTAT	A/R
4	F10136953	PIPING SPOOL, ROLLING OFFSET, LEFT HAND	2
3	F10136779	PIPING SPOOL, ROLLING OFFSET, RIGHT HAND	2
2	F10136775	5K RETURN INTERNAL PIPING ASSEMBLY	1
1	F10126720	SPIDER	1

UNLESS OTHERWISE SPECIFIED		DRAWN	C. REID	DATE	31-Mar-2020
±.X	±.XX	±.XXX	±X/X	±"	
.1	.02	.005	1/16	2.5"	
BREAK ALL SHARP EDGES, MAX: .015		CHECKED		DATE	
DO NOT SCALE DRAWING		APPROVED		DATE	
DIMENSIONS BASED ON: ASME Y14.5-2009		USED ON	F10126703		
MAX MACHINE ALL SURFACES: 125√		MATERIAL	SEE PARTS LIST		
DRAWING UNITS: INCHES		GROUP	Technical Division - Design and Drafting	CASE CODE	OURS
THIRD ANGLE PROJECTION					

FERMI NATIONAL ACCELERATOR LABORATORY UNITED STATES DEPARTMENT OF ENERGY	
NAME: INTERNAL PIPING ASSEMBLY	
SCALE: 3:8	SIZE: D
DRAWING NUMBER: F10136778	SHEET: 1 of 1
REV: -	

TEMPLATE VERSION: 2018.12.03