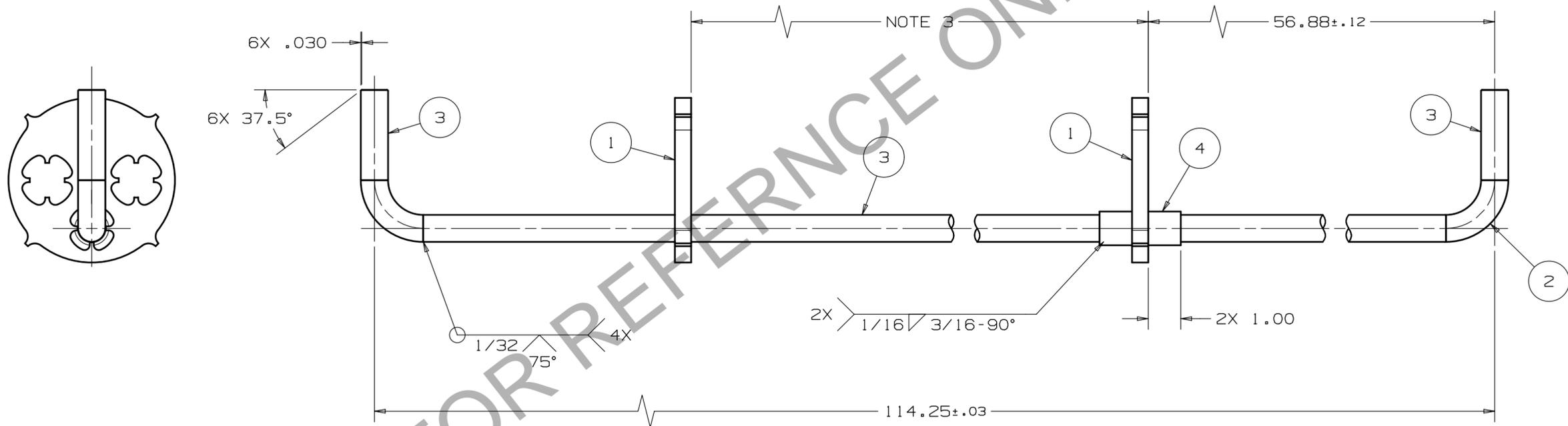


DESCRIPTION: 5K RETURN INTERNAL PIPING ASSEMBLY  
 PROJECT: PIP-11\_CMTF  
 CATEGORY: ASSEMBLY

REV	REVISION CONTROL DOCUMENT	DATES	SIGNATURES
-	F10136775---RCD		DRAWN APPROVED



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. LOOSE SPIDER, SEE F10136778 FOR LOCATION.
4. 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.
5. 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.

ITEM	FERMI #	PART NAME	QTY
4	FC0073288	PIPE, 3/4" SCH.10 304 SS	A/R
3	FC0073282	PIPE, 1/2" SCH.10 304 SS	A/R
2	FC0028303	ELBOW, PIPE-90, LONG, 1/2"x10S, 304 SS	2
1	F10126720	SPIDER	2

UNLESS OTHERWISE SPECIFIED					DRAWN	C.REID	DATE	27-Mar-2020
±.X	±.XX	±.XXX	±X/X	±X°	CHECKED		DATE	
.1	.02	.010	1/16	2.5°	APPROVED		DATE	
BREAK ALL SHARP EDGES, MAX: .015					USED ON			
DO NOT SCALE DRAWING					F10136778			
DIMENSIONS BASED ON: ASME Y14.5-2009					MATERIAL			
MAX MACHINE ALL SURFACES: 125√					SEE PARTS LIST			
DRAWING UNITS: INCHES					GROUP: Technical Division - Cryogenic Support   CAGE CODE: OUSR6			

<b>FERMI NATIONAL ACCELERATOR LABORATORY</b> UNITED STATES DEPARTMENT OF ENERGY			
NAME			
5K RETURN INTERNAL PIPING ASSEMBLY			
SCALE	SIZE	DRAWING NUMBER	SHEET
3:8	C	F10136775	1 of 1
REV			-

TEMPLATE VERSION: 2018.12.03