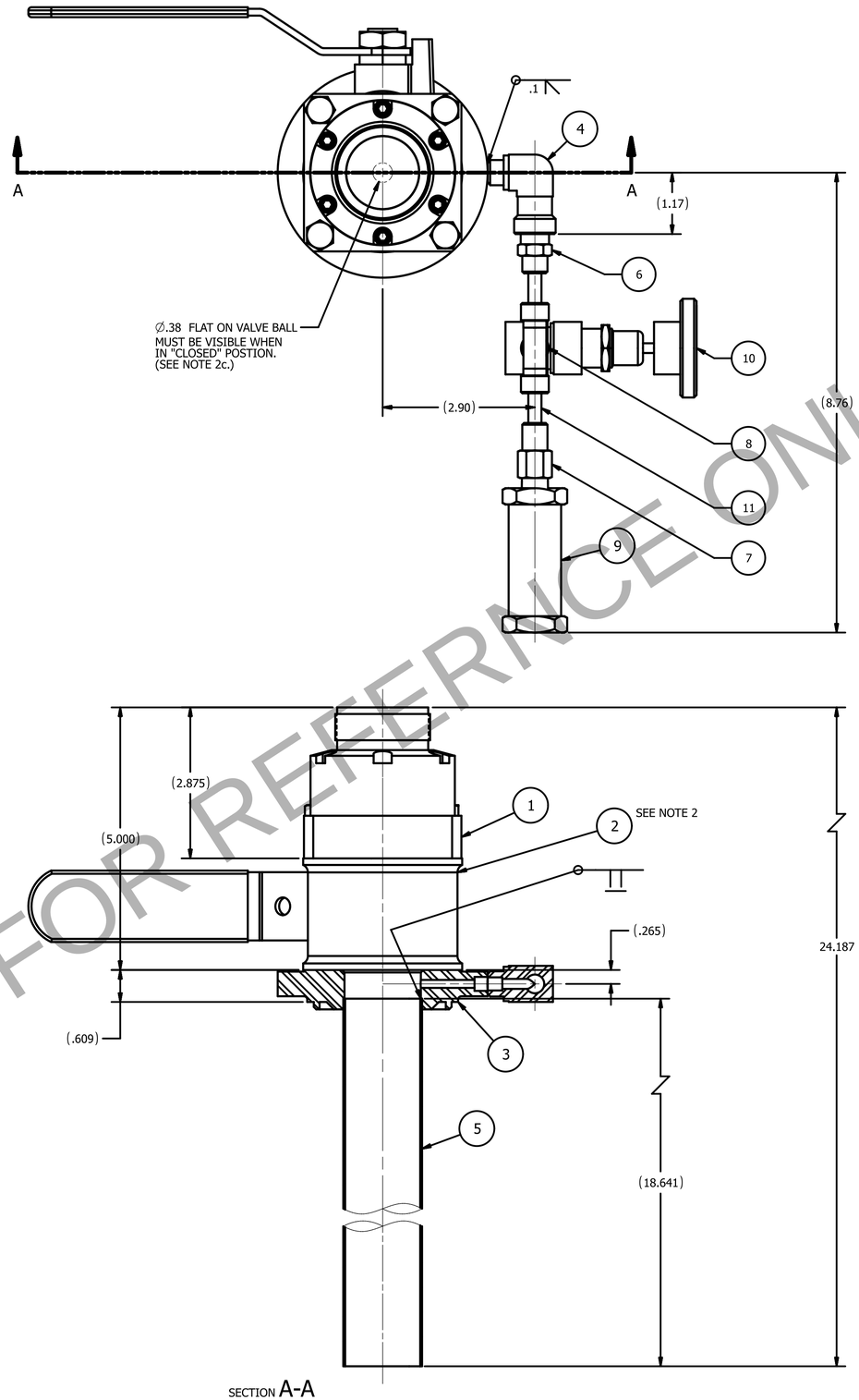
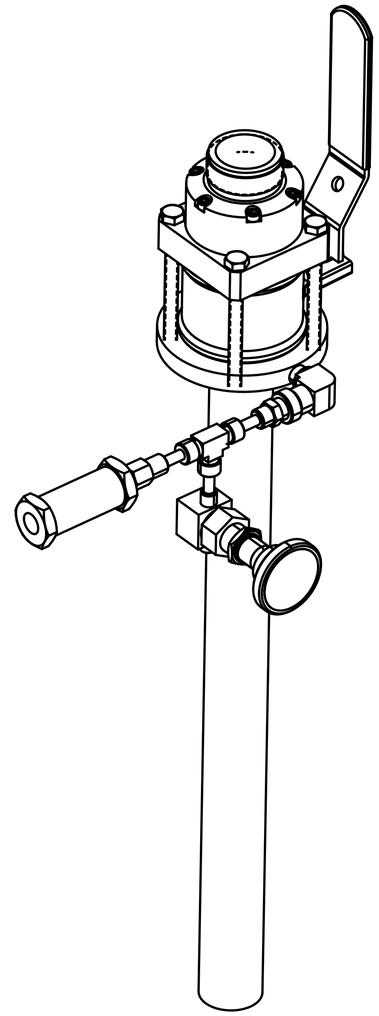
DESCRIPTION: BAYONET ASSEMBLY, 1-1/2" FEMALE W/BLEED & RELIEF VALVES
PROJECT: PIP-II_CMTF
CATEGORY: ASSEMBLY

REV	REVISION CONTROL DOCUMENT	DATES	SIGNATURES
-	F10143044---RCD		DRAWN
			APPROVED



SECTION A-A



NOTES (UNLESS OTHERWISE SPECIFIED):

1. DISCONNECT 4-BOLTS ON BALL VALVE ASSEMBLY (ITEMS 1&2) AND SET ASIDE FOR WELDING OF MODIFIED FEMALE ELBOW (ITEM 4) AND BAYONET TUBE (ITEM 5) TO VALVE FLANGE (ITEM 3). POSITION ELBOW INLINE WITH COUNTERBORED RELIEF HOLE IN THE 1-1/2" BALL VALVE FLANGE. ORIENT ANGULAR POSITION OF ELBOW BEFORE WELDING.

2. BALL VALVE MODIFICATIONS:
   a.) ELIMINATE THE 2 (TWO) END FLANGES AND 4 (FOUR) VALVE BODY 5/16-18 NUTS FROM THE VALVE ASSY (ITEM 3).
   b.) REUSE THE 4 (FOUR) VALVE BODY 5/16-18 x 3-1/2" LG BOLTS FOR THIS ASSEMBLY.
   c.) MODIFY THE VALVE BALL PER DRAWING NO 1650-MB-168063. REINSTALL THE MODIFIED BALL SO THAT THE Ø3/8" FLAT IS VISIBLE FROM THE TOP WHEN THE VALVE IS IN THE "CLOSED" POSITION. (SEE TOP VIEW).

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. ASSEMBLY MUST BE FREE OF DIRT, GREASE, OIL AND CHIPS.

6. ASSEMBLY TO BE FREE OF ALL SHARP EDGES, CORNERS, AND BURRS.

ITEM	FERMI NO	PART NAME	QTY
11	FC0077240	TUBE, 1/4" O.D. X .049" WALL 304SS	3
10	FC0062137	VALVE, 1/4" BELLOWS SEALED, TUBE SOCKET WELD, SWAGELOCK #SS-4BG-TW	1
9	FC0045107	VALVE, INLINE RELIEF, 1/4" BRASS	1
8	FC0022042	TUBE SOCKET WELD UNION TEE 1/4 INCH	1
7	FC0022019	TUBE SOCKET WELD FEMALE CONN. 1/4 INCH	1
6	FC0022004	TUBE SOCKET WELD MALE CONNECTOR 1/4 INCH	1
5	F10117232	TUBE, 1.500" OD X .035 W, 304 SST	1
4	F10040550	ELBOW, FEMALE TUBE-NPT, MODIFIED	1
3	F10040522	FLANGE, VALVE - PER DWG 1670-MB-213683	1
2	F10021449	ASSY, 1.50" VALVE - PER DWG 1650-168959	1
1	F10005289	ASSY, CHEVRON SEAL - PER DWG 1650-MC-168617	1

UNLESS OTHERWISE SPECIFIED

±.X	±.XX	±.XXX	±X/X	±X°
.1	.02	.005	1/16	1°

BREAK ALL SHARP EDGES, MAX: .015
DO NOT SCALE DRAWING
DIMENSIONS BASED ON: ASME Y14.5-2009
MAX MACHINE ALL SURFACES: 125
DRAWING UNITS: INCHES

THIRD ANGLE PROJECTION

DRAWN	C.REID	DATE 17-Aug-2020
CHECKED		DATE
APPROVED		DATE

USED ON: F10126703

MATERIAL: SEE PARTS LIST

GROUP: Technical Division - Design and Drafting CAGE CODE: 0USR6

FERMI NATIONAL ACCELERATOR LABORATORY
UNITED STATES DEPARTMENT OF ENERGY

NAME: BAYONET ASSEMBLY, 1-1/2" FEMALE W/BLEED & RELIEF VALVES

SCALE	SIZE	DRAWING NUMBER	SHEET	REV
3:4	D	F10143044	1 of 1	-

TEMPLATE VERSION: 2018.12.03