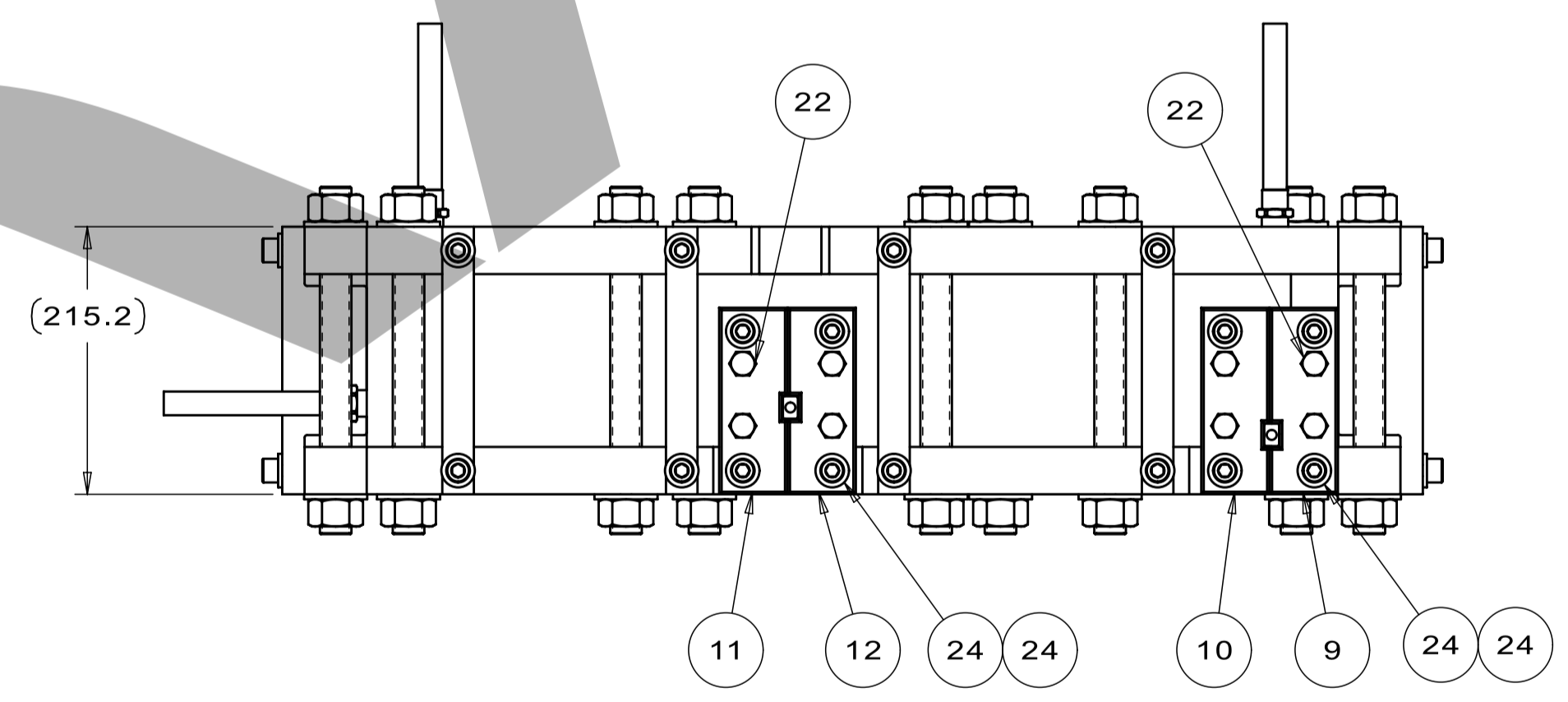
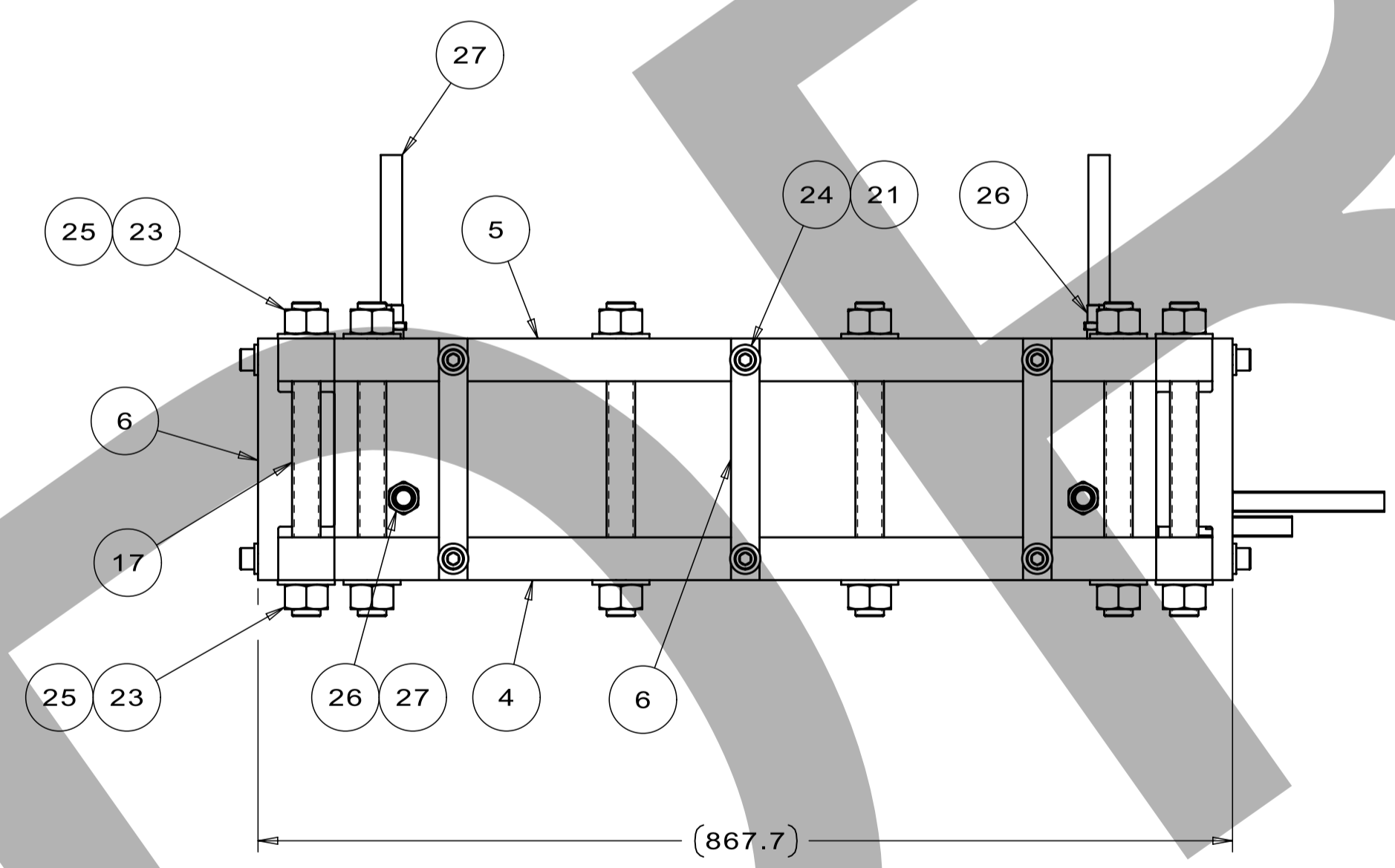
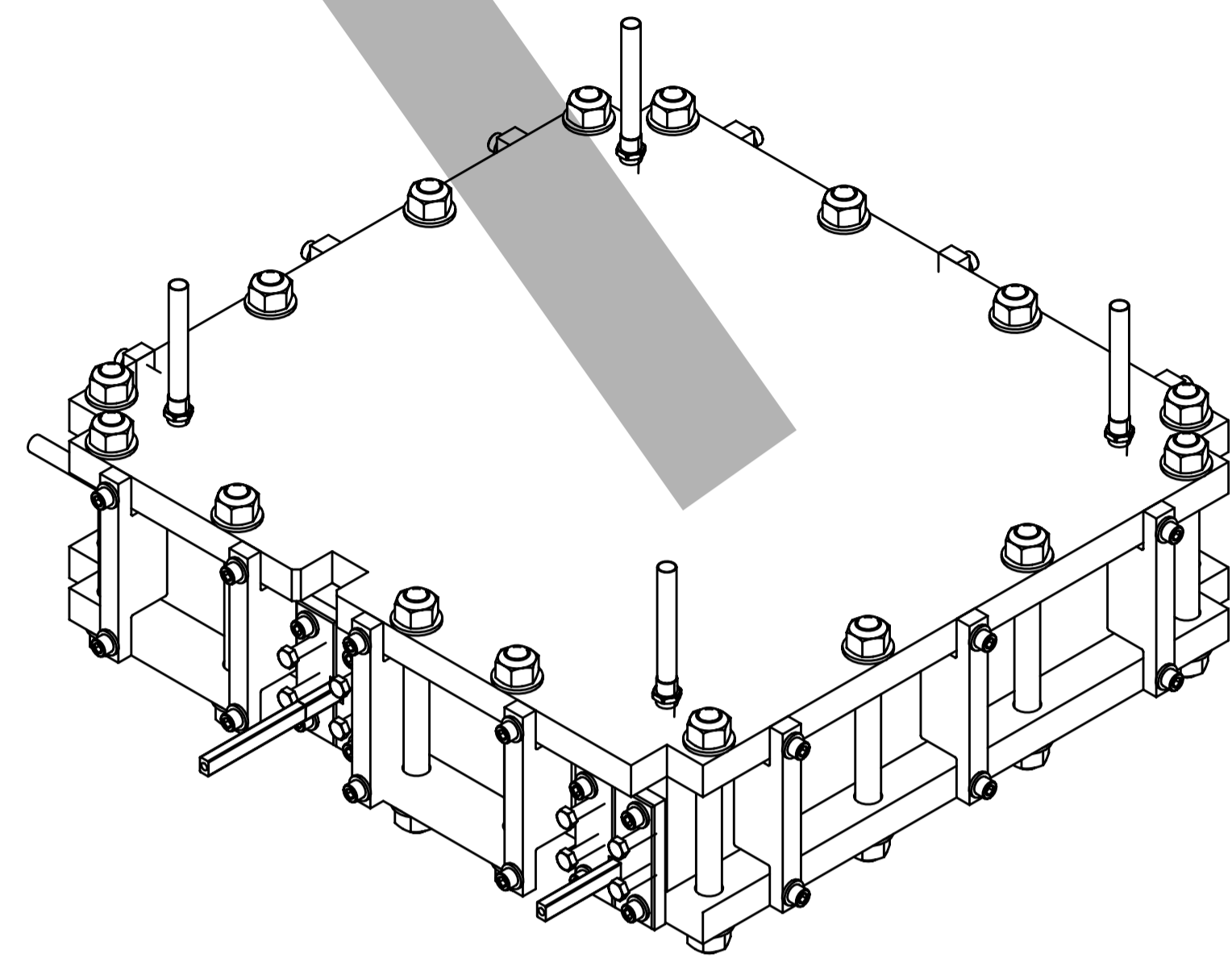
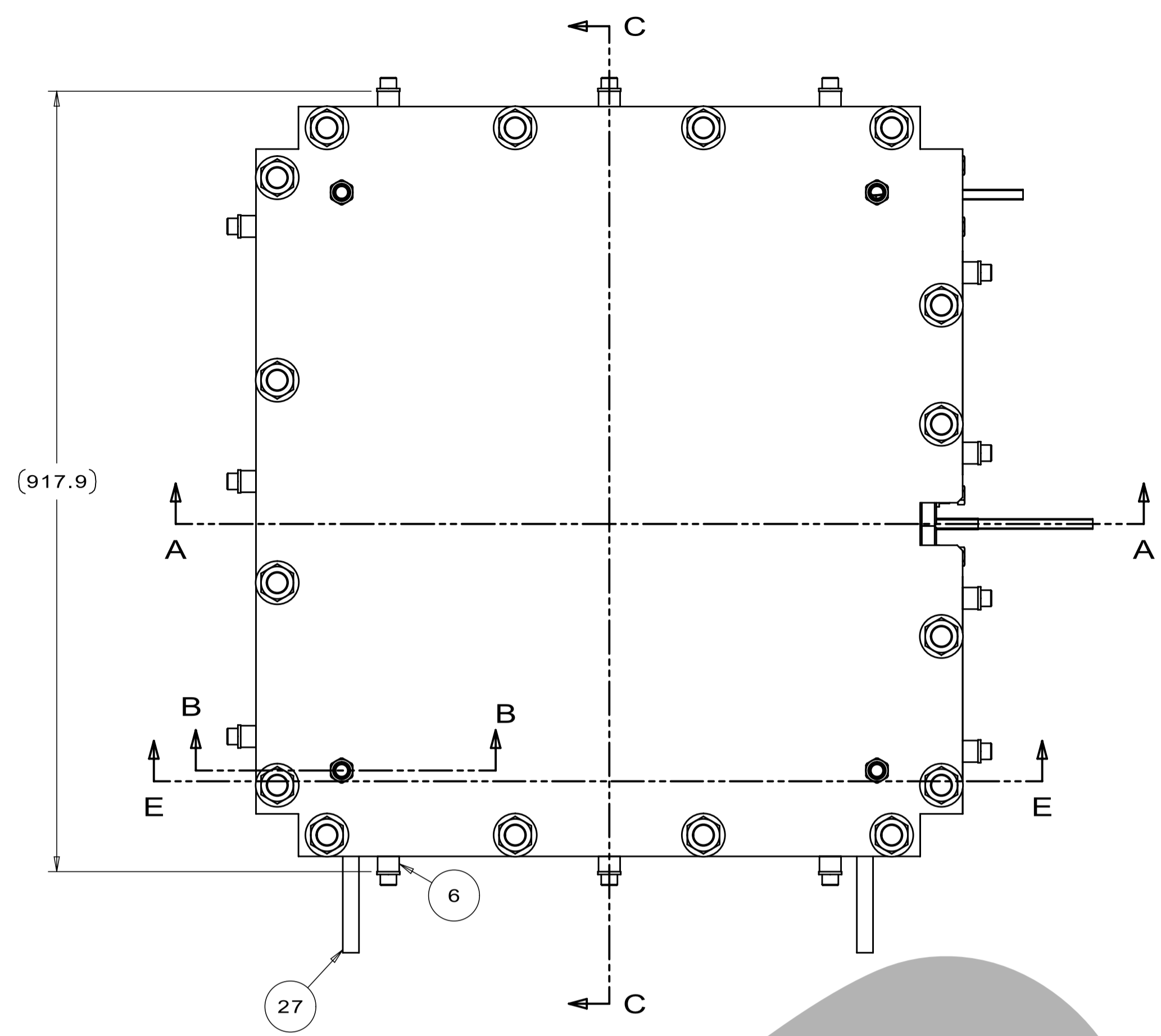


REV	REVISION CONTROL DOCUMENT	DATES	SIGNATURES
-	F10204164--RCD		



VIEWS SHOWN ON THIS SHEET ARE THE UPPER COIL F10182796

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. SEE SHEET 3 FOR INSTALLING THE TOP SHIM PLATE ASSEMBLY.
4. COIL IMPREGNATION TRAVELER (OCA, OCB): XXXXXX OAK RIDGE SNS PULSED DIPOLE.

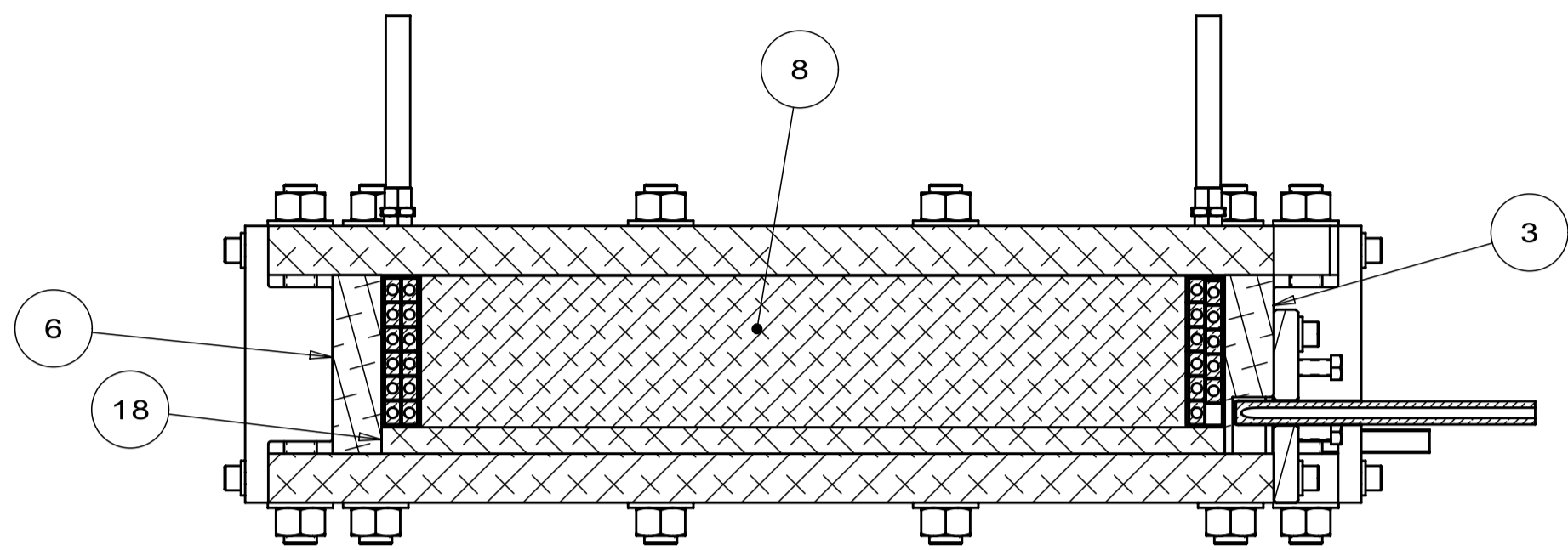
ITEM	FERMI #	PART NAME	QTY
27	FC0075389	TUBE, COPPER, .750 DIA x .032 WALL x 6.0 LG	6
26	FC0073455	ADAPTER, MALE, 5/8C x 1/2 MPT, MUELLER W 01139	6
25	FC0015899	WASHER, 1-1.062x2x0.16, G2S, BO	32
24	FC0015896	WASHER, 1/2-0.531x1.062x0.13, G2S, BO	34
23	FC0014709	NUT-HEX, 1-8x0.8594, G8S	32
22	FC0009695	HHCS, 1/2-13x1.75LGxFT, G8S, ZYC	8
21	FC0005268	SHCS, 1/2-13x1.5LGxFT, G8S, BO	26
20	FC0005267	SHCS, 1/2-13x1.375LGxFT, G8S, BO	8
19	FC0005164	SHCS, 3/8-16x1LGxFT, G8S, BO	4
18	F10204995	PLATE, COIL RISER, PULSED DIPOLE CURING FIXTURE, PULSED DIPOLE, ORNL	1
17	F10204974	THREADED ROD, CURING FIXTURE, PULSED DIPOLE, ORNL	16
16	F10204954	LEAD PLATE OUTER 2, LOWER COIL, CURING FIXTURE, PULSED DIPOLE, ORNL	1
15	F10204953	LEAD PLATE OUTER 1, LOWER COIL, CURING FIXTURE, PULSED DIPOLE, ORNL	1
14	F10204952	LEAD PLATE INNER 2, LOWER COIL, CURING FIXTURE, PULSED DIPOLE, ORNL	1
13	F10204951	LEAD PLATE INNER 1, LOWER COIL, CURING FIXTURE, PULSED DIPOLE, ORNL	1
12	F10204880	LEAD PLATE OUTER 2, UPPER COIL, CURING FIXTURE, PULSED DIPOLE, ORNL	1
11	F10204879	LEAD PLATE OUTER 1, UPPER COIL, CURING FIXTURE, PULSED DIPOLE, ORNL	1
10	F10204878	LEAD PLATE INNER 2, UPPER COIL, CURING FIXTURE, PULSED DIPOLE, ORNL	1
9	F10204877	LEAD PLATE INNER 1, UPPER COIL, CURING FIXTURE, PULSED DIPOLE, ORNL	1
8	F10204773	CENTER BLOCK, SPLIT, CURING FIXTURE, PULSED DIPOLE, ORNL	1
7	F10204772	SIDE PLATE WITH FILLER HOLES, CURING FIXTURE, PULSED DIPOLE, ORNL	1
6	F10204771	CLAMP, SIDE PLATE, CURING FIXTURE, PULSED DIPOLE, ORNL	13
5	F10204770	TOP PLATE, CURING FIXTURE, PULSED DIPOLE, ORNL	1
4	F10204768	BOTTOM PLATE, CURING FIXTURE, PULSED DIPOLE, ORNL	1
3	F10204767	SIDE PLATE, CURING FIXTURE, PULSED DIPOLE, ORNL	1
2	F10204765	FRONT PLATE, CURING FIXTURE, PULSED DIPOLE, ORNL	1
1	F10204763	REAR PLATE, CURING FIXTURE, PULSED DIPOLE, ORNL	1

UNLESS OTHERWISE SPECIFIED		DRAWN	J.VANDER MEULEN	DATE	05-Dec-2023
±X	±XX	±XXX	±X	CHECKED	DATE
2	0.3	0.12	N/A	APPROVED	DATE
BREAK ALL SHARP EDGES, MAX: 0.5		USED ON			
DO NOT SCALE DRAWING		MATERIAL			
DIMENSIONS BASED ON: ASME Y14.5M-2009		SEE PARTS LIST			
MAX MACHINE ALL SURFACES, Ra: 3.2		GROUP: Technical Division - Design and Drafting			
DRAWING UNITS: MM		CAGE CODE: OUSRS			

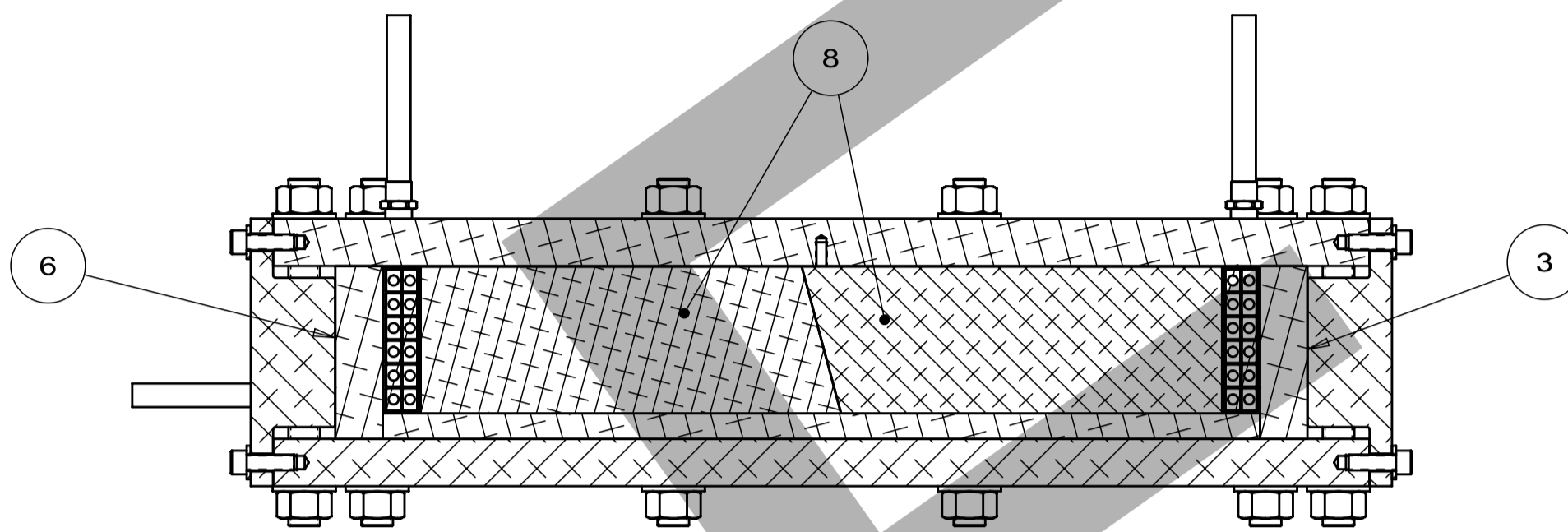
		<b>FERMI NATIONAL ACCELERATOR LABORATORY</b> UNITED STATES DEPARTMENT OF ENERGY	
ORNL PULSED DIPOLE CURING FIXTURE			
SCALE	SIZE	DRAWING NUMBER	SHEET
1:5 & AS NOTED	A1	F10204164	1 OF 2

SNS S02040000-M8U-8820-A10079

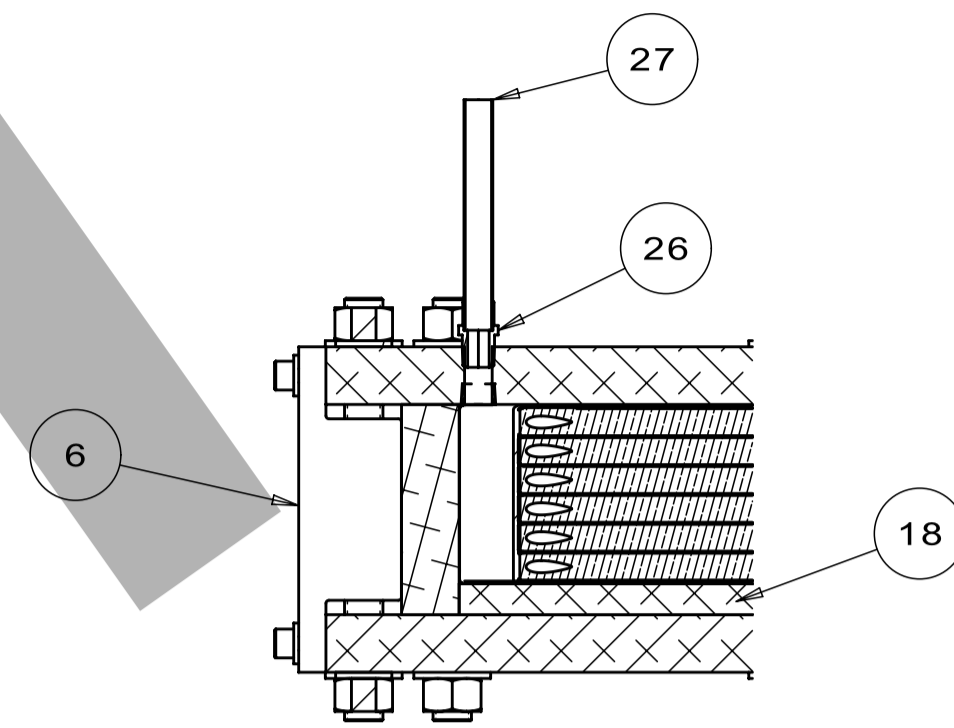
REV	REVISION CONTROL DOCUMENT	DATES	DRAWN	SIGNATURES
-	F10204164--RCD		APPROVED	



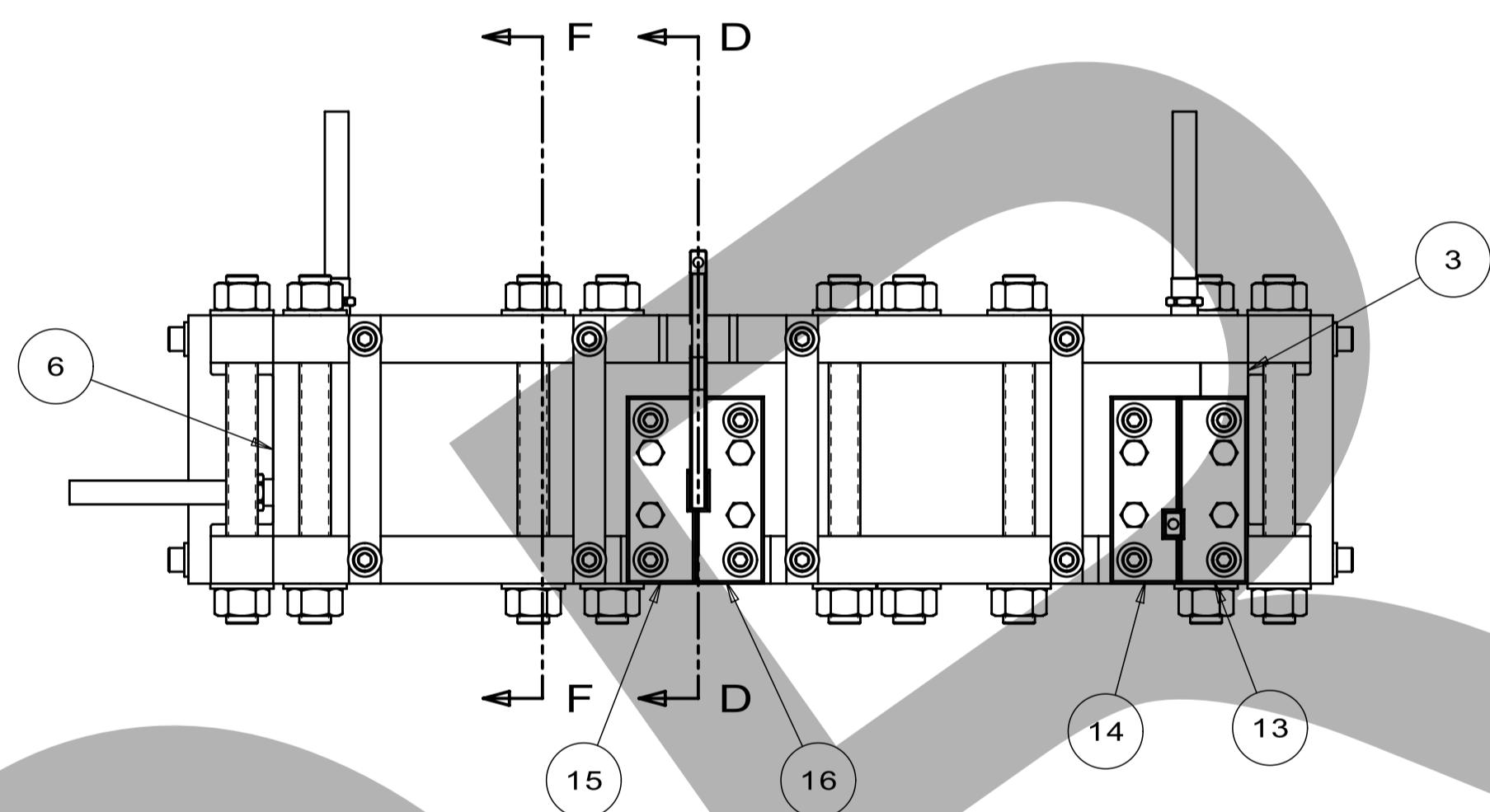
**SECTION A-A**  
 FOR UPPER COIL  
 F10182796



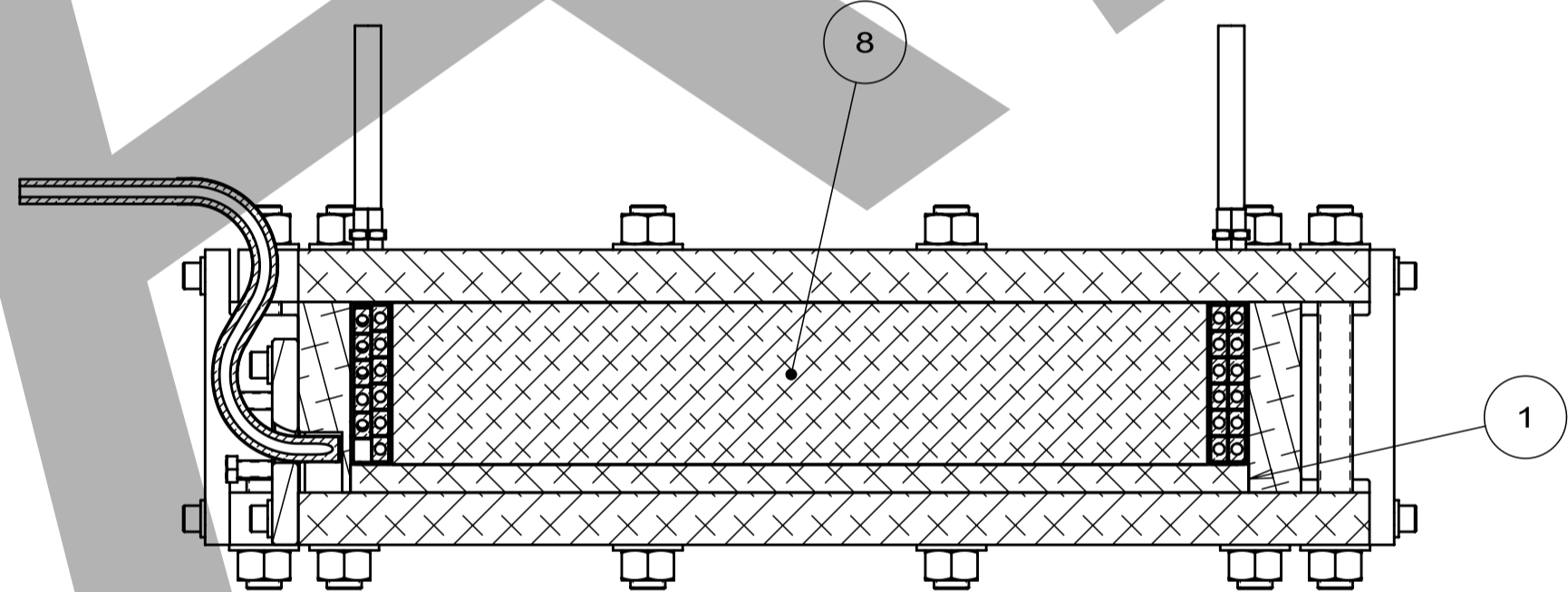
**SECTION C-C**  
 FOR UPPER COIL  
 F10182796



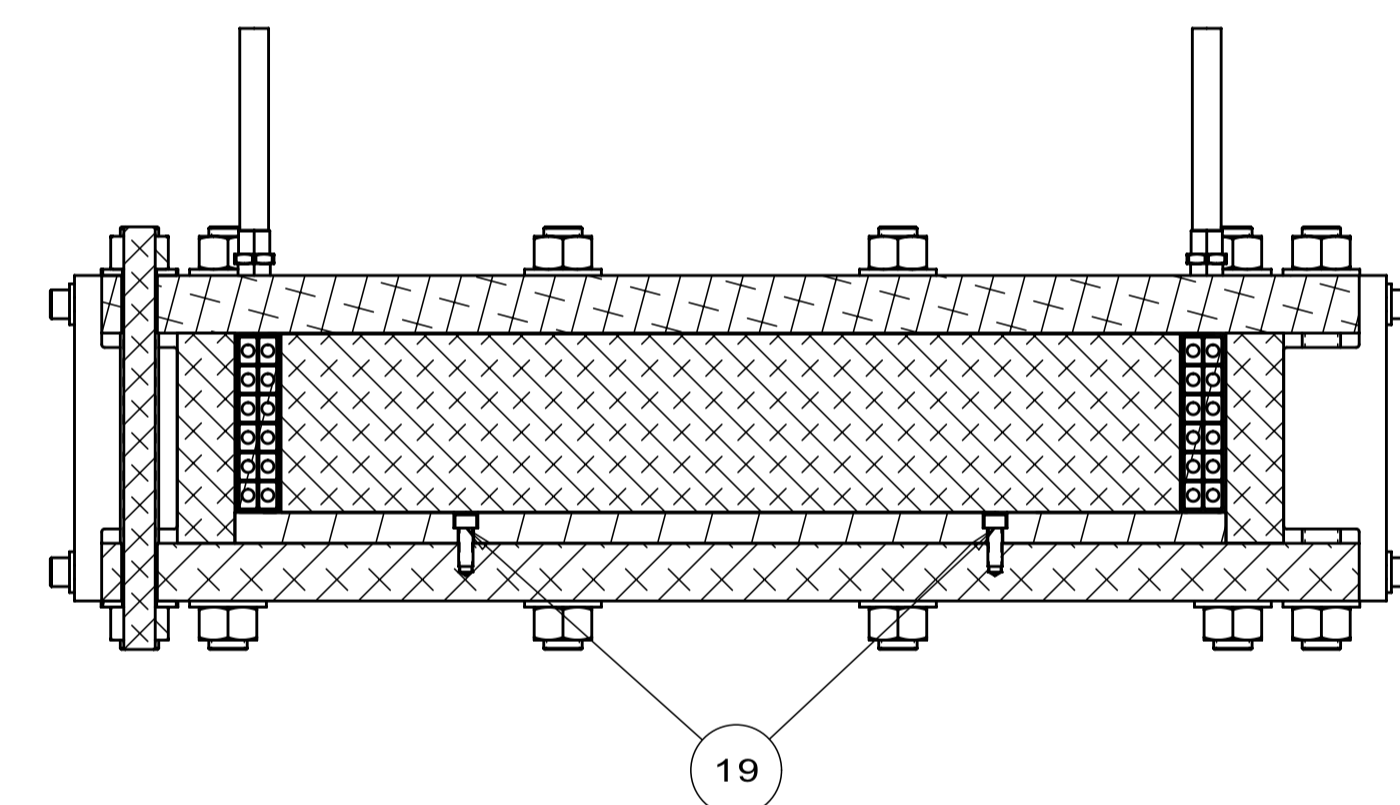
**SECTION B-B**



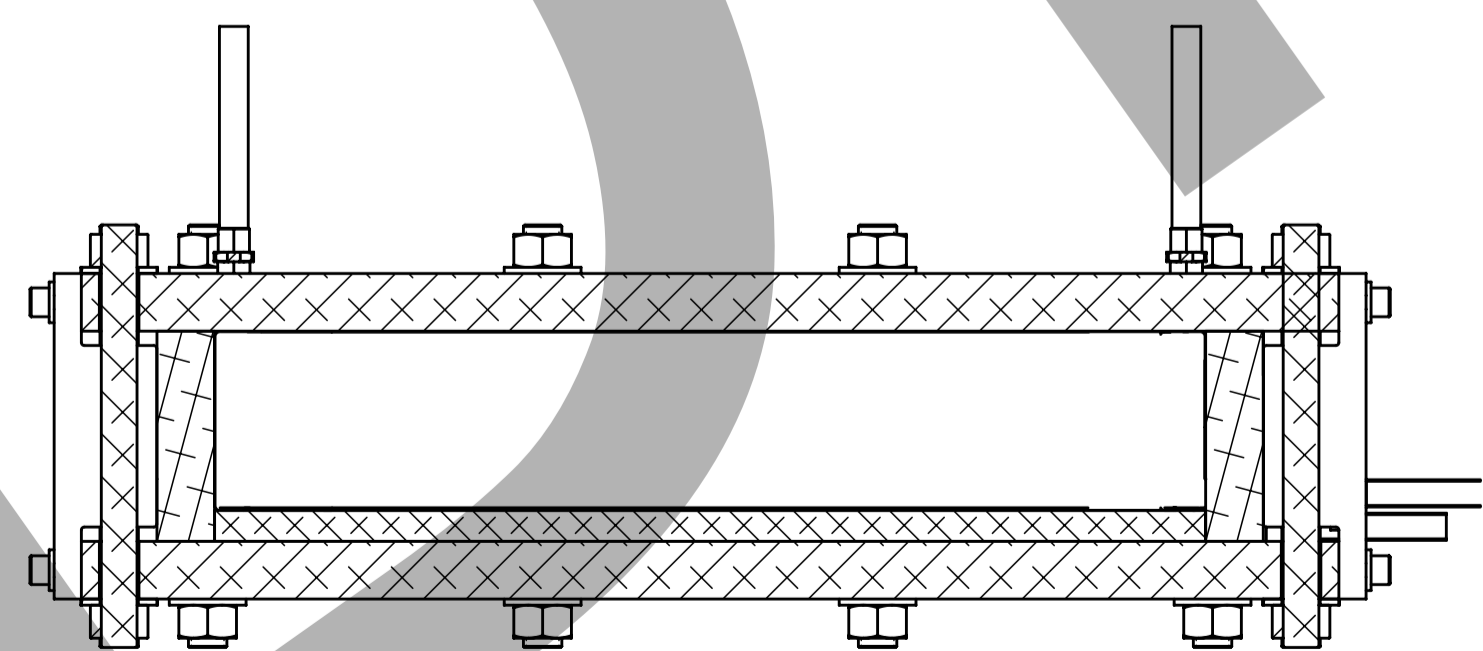
**FOR LOWER COIL**  
 F10182797



**SECTION D-D**  
 FOR LOWER COIL  
 F10182797



**SECTION F-F**  
 FOR BOTH COILS

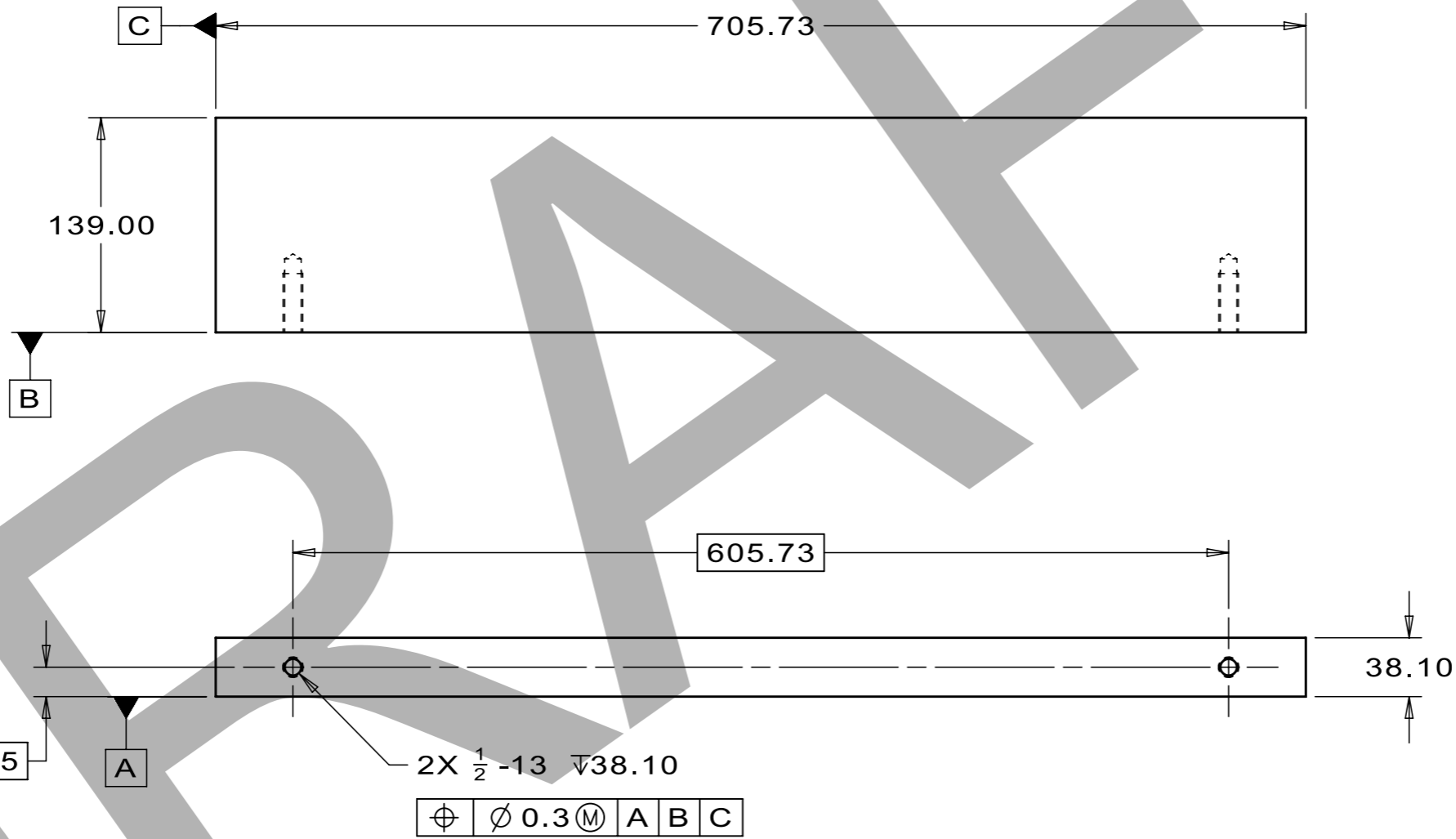


**SECTION E-E**  
 FOR UPPER COIL  
 F10182796

UNLESS OTHERWISE SPECIFIED				DRAWN	J.VANDER MEULEN	DATE	05-Dec-2023	FERMILAB		FERMI NATIONAL ACCELERATOR LABORATORY UNITED STATES DEPARTMENT OF ENERGY	
±X	±XX	±XXX	±X <sup>o</sup>	CHECKED		DATE		ORNL PULSED DIPOLE CURING FIXTURE			
2	0.3	0.12	N/A	1"	APPROVED						
BREAK ALL SHARP EDGES, MAX: 0.5				USED ON				SCALE: 1:5 & AS NOTED			
DO NOT SCALE DRAWING				MATERIAL							
DIMENSIONS BASED ON: ASME Y14.5M-2009				GROUP: Technical Division - Design and Drafting		CAGE CODE: OUSRB					
MAX MACHINE ALL SURFACES, Ra: 3.2				THIRD ANGLE PROJECTION							
DRAWING UNITS: MM											

DESCRIPTION: REAR PLATE, CURING FIXTURE, PULSED DIPOLE, ORNL  
 PROJECT: ORNL-STS\_Magnets  
 CATEGORY: PLATE

REV	REVISION CONTROL DOCUMENT	DATES		SIGNATURES	
-	F10204763---RCD			DRAWN	
				APPROVED	



NOTES:(UNLESS OTHERWISE SPECIFIED)

- PART MUST BE FREE OF DIRT, GREASE, OIL AND CHIPS.
- PART TO BE FREE OF ALL SHARP EDGES, CORNERS, AND BURRS.
- TRAILING ZEROS DENOTE TOLERANCE.

SNS S02040000-M8U-8820-A10080

UNLESS OTHERWISE SPECIFIED				
±X	±X.X	±X.XX	±X/X	±X°
2	0.3	0.12	N/A	1°

BREAK ALL SHARP EDGES, MAX: 0.5  
 DO NOT SCALE DRAWING  
 DIMENSIONS BASED ON: ASME Y14.5M-2009  
 MAX MACHINE ALL SURFACES, Ra: 3.2  
 DRAWING UNITS: MM

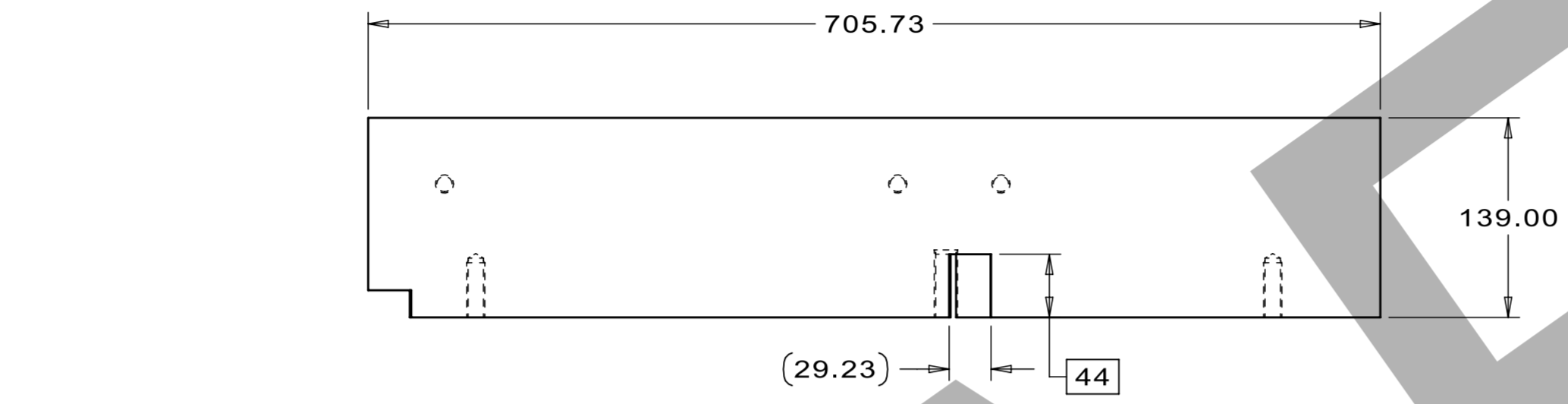
THIRD ANGLE PROJECTION

DRAWN	J.HELSLEY	DATE	04-Dec-2023
CHECKED		DATE	
APPROVED		DATE	
USED ON	F10204164		
MATERIAL	6061-T651 ALUMINUM (2.00" STOCK PLATE)		
GROUP:	Technical Division - Design and Drafting	CAGE CODE:	OU5R6

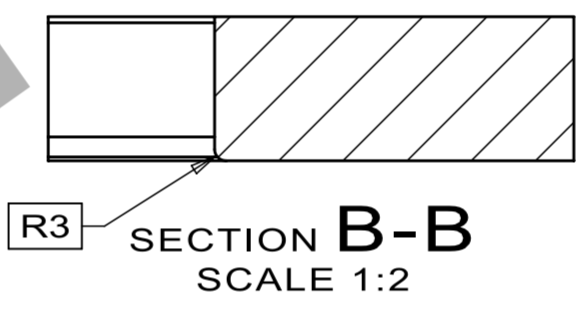
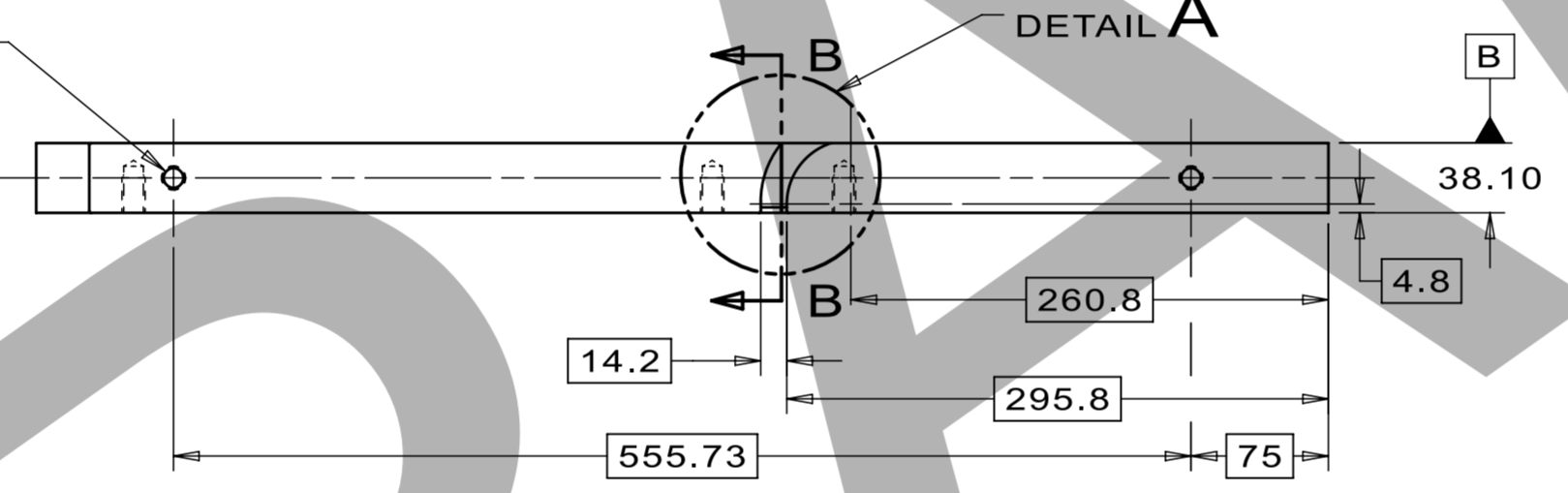
		<b>FERMI NATIONAL ACCELERATOR LABORATORY</b> UNITED STATES DEPARTMENT OF ENERGY			
		NAME REAR PLATE, CURING FIXTURE, PULSED DIPOLE, ORNL			
SCALE 1:4	SIZE A3	DRAWING NUMBER F10204763	SHEET 1 OF 1	REV -	

TEMPLATE VERSION: 2021.08.02

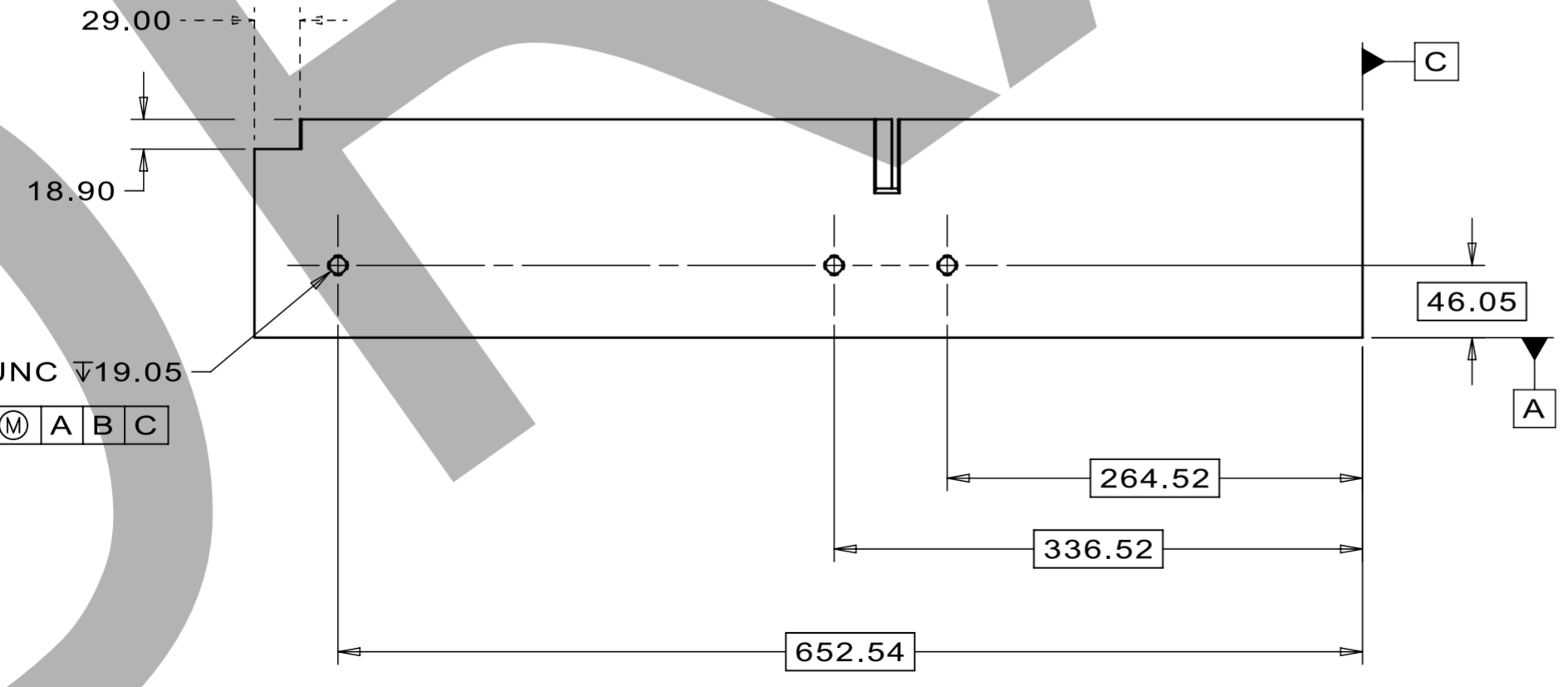
REV	REVISION CONTROL DOCUMENT	DATES	SIGNATURES
-	F10204765---RCD		DRAWN APPROVED



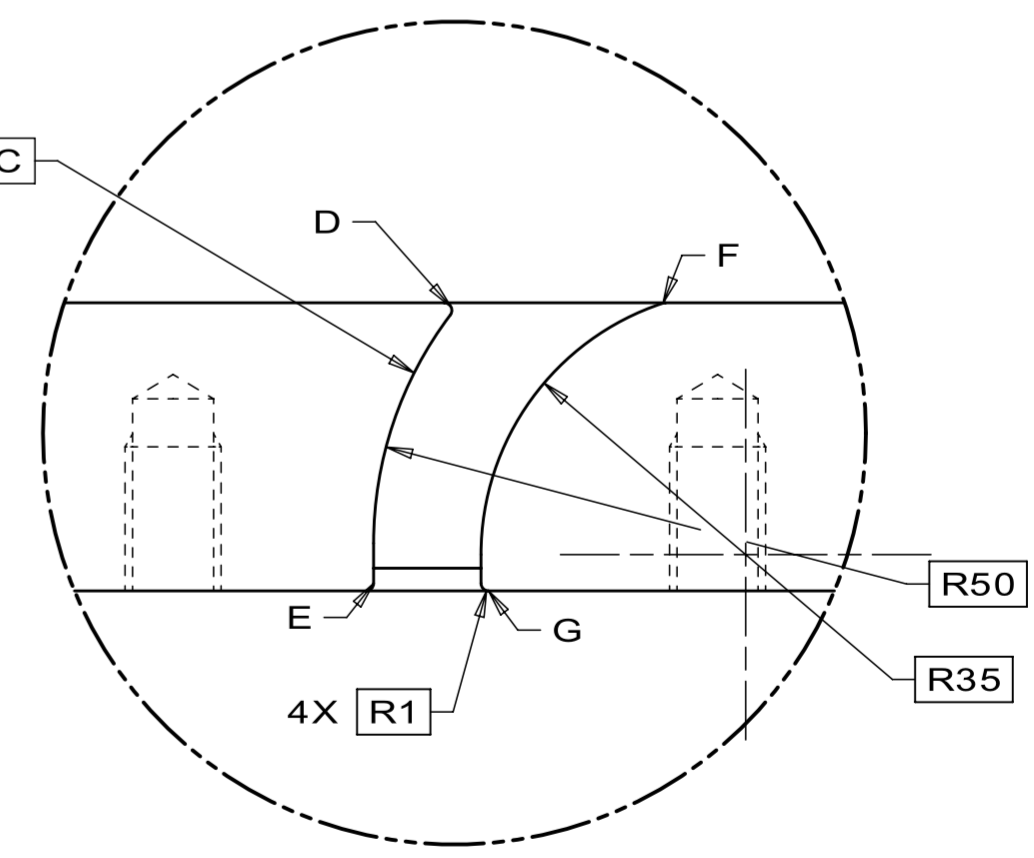
2X 1/2 -13 UNC ∇38.1  
 ⊕ ∅ 0.3 M A B C



3X 1/2 -13 UNC ∇19.05  
 ⊕ ∅ 0.3 M A B C



∩ 0.05 M A B C  
 D ↔ E  
 F ↔ G



NOTES:(UNLESS OTHERWISE SPECIFIED)

- PART MUST BE FREE OF DIRT, GREASE, OIL AND CHIPS.
- PART TO BE FREE OF ALL SHARP EDGES, CORNERS, AND BURRS.
- TRAILING ZEROS DENOTE TOLERANCE.

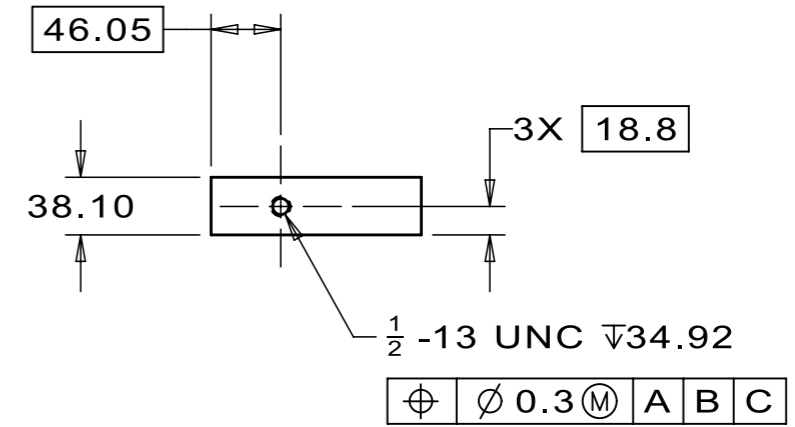
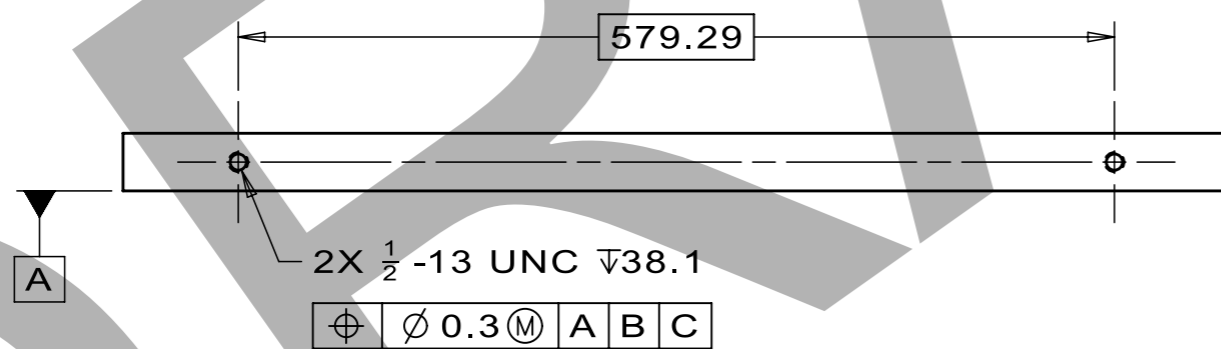
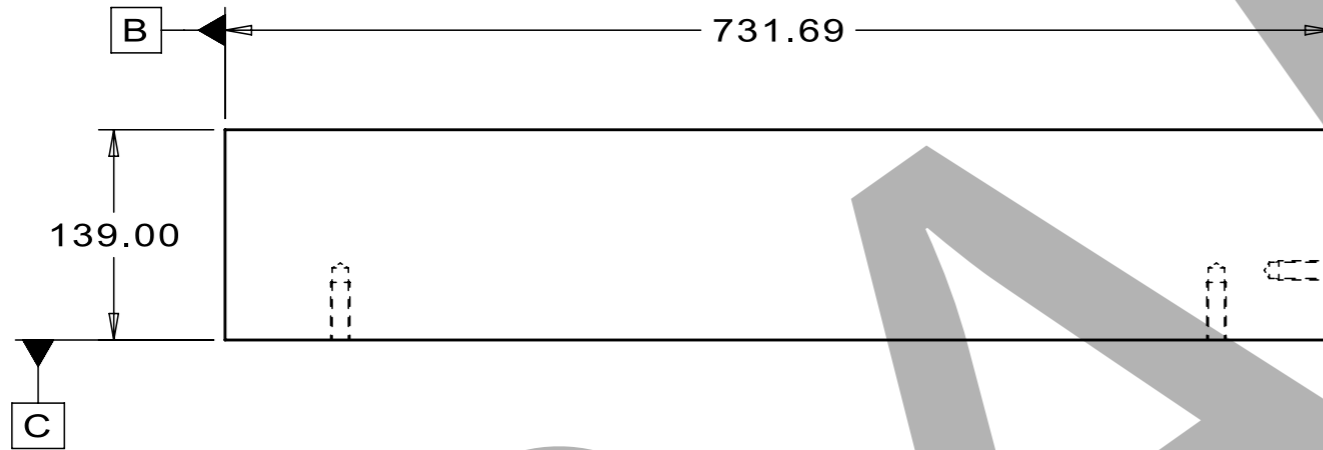
SNS S02040000-M8U-8820-A10081

UNLESS OTHERWISE SPECIFIED					DRAWN	J.HELSELY	DATE	04-Dec-2023	 <b>FERMI NATIONAL ACCELERATOR LABORATORY</b> UNITED STATES DEPARTMENT OF ENERGY			
±X	±X.X	±X.XX	±X/X	±X°	CHECKED		DATE					
2	0.3	0.12	N/A	1°	APPROVED		DATE					
BREAK ALL SHARP EDGES, MAX: 0.5 DO NOT SCALE DRAWING DIMENSIONS BASED ON: ASME Y14.5M-2009 MAX MACHINE ALL SURFACES, Ra: 3.2 DRAWING UNITS: MM					USED ON F10204164			NAME FRONT PLATE, CURING FIXTURE, PULSED DIPOLE, ORNL				
 THIRD ANGLE PROJECTION					MATERIAL 6061-T651 ALUMINUM, UNS A96061			SCALE 1:4	SIZE A2	DRAWING NUMBER F10204765	SHEET 1 OF 1	REV -
GROUP: Technical Division - Design and Drafting					CAGE CODE: OJ5R6							

TEMPLATE VERSION: 2021.08.02

DESCRIPTION: SIDE PLATE, CURING FIXTURE, PULSED DIPOLE, ORNL  
 PROJECT: ORNL-STS\_Magnets  
 CATEGORY: PLATE

REV	REVISION CONTROL DOCUMENT	DATES	SIGNATURES	
-	F10204767---RCD		DRAWN	
			APPROVED	



NOTES:(UNLESS OTHERWISE SPECIFIED)

- PART MUST BE FREE OF DIRT, GREASE, OIL AND CHIPS.
- PART TO BE FREE OF ALL SHARP EDGES, CORNERS, AND BURRS.
- TRAILING ZEROS DENOTE TOLERANCE.

SNS S02040000-M8U-8820-A10082

UNLESS OTHERWISE SPECIFIED				
$\pm$ X	$\pm$ X.X	$\pm$ X.XX	$\pm$ X/X	$\pm$ X°
2	0.3	0.12	N/A	1°

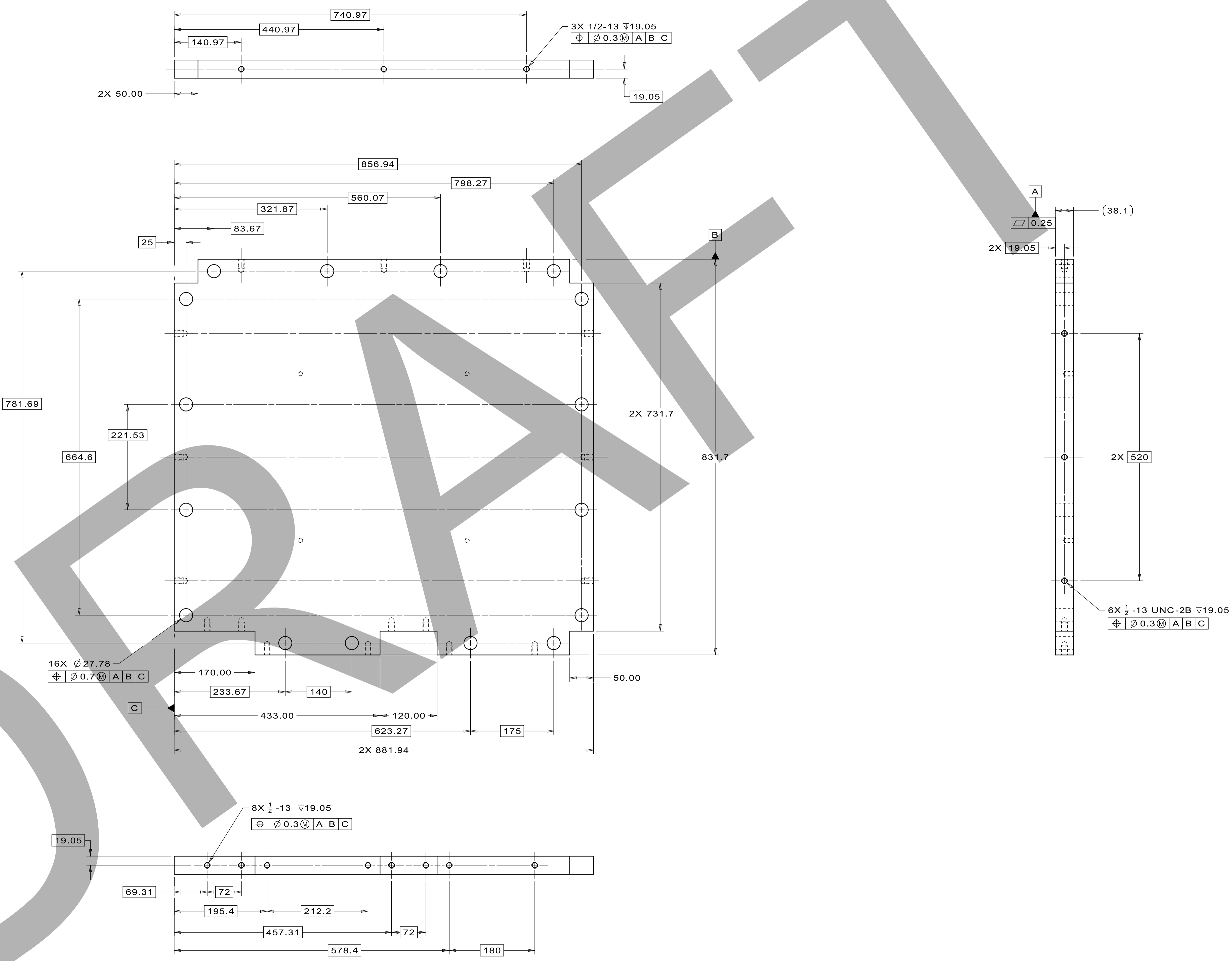
BREAK ALL SHARP EDGES, MAX: 0.5  
 DO NOT SCALE DRAWING  
 DIMENSIONS BASED ON: ASME Y14.5M-2009  
 MAX MACHINE ALL SURFACES, Ra: 3.2  
 DRAWING UNITS: MM

THIRD ANGLE PROJECTION

DRAWN	J.HELSLEY	DATE	04-Dec-2023
CHECKED		DATE	
APPROVED		DATE	
USED ON	F10204164		
MATERIAL	6061-T651 ALUMINUM, UNS A96061 (2.00" STOCK PLATE)		
GROUP:	Technical Division - Design and Drafting	CAGE CODE:	OU5R6

		<b>FERMI NATIONAL ACCELERATOR LABORATORY</b> UNITED STATES DEPARTMENT OF ENERGY			
		NAME SIDE PLATE, CURING FIXTURE, PULSED DIPOLE, ORNL			
SCALE	SIZE	DRAWING NUMBER	SHEET	REV	
1:5	A3	F10204767	1 OF 1	-	

TEMPLATE VERSION: 2021.08.02

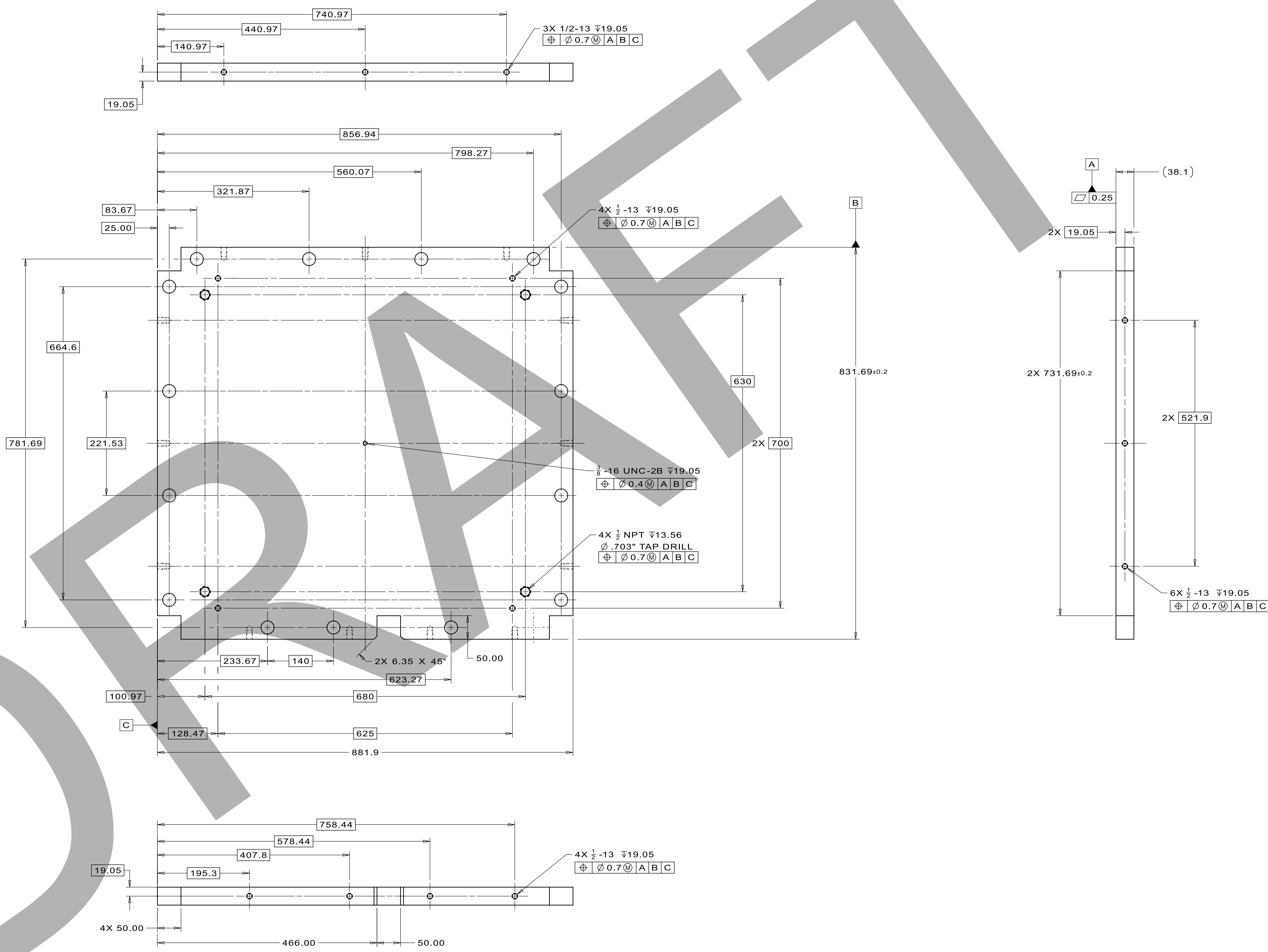


- NOTES: (UNLESS OTHERWISE SPECIFIED)
- PART MUST BE FREE OF DIRT, GREASE, OIL AND CHIPS.
  - PART TO BE FREE OF ALL SHARP EDGES, CORNERS AND BURRS.
  - APPROXIMATE WEIGHT: 70.1KG (154.5LBS)

UNLESS OTHERWISE SPECIFIED		DRAWN	J.VANDER MEULEN	DATE	05-Dec-2023
±X	±XX	±XXX	±XX	±X	
2	0.3	0.12	N/A	1"	
BROKE ALL SHARP EDGES, MAX: 0.5					
DO NOT SCALE DRAWING					
DIMENSIONS BASED ON: ASME Y14.5M-2009					
MAX MACHINE ALL SURFACES, Ra: 3.2					
DRAWING UNITS: MM					
MATERIAL		F10204164		NAME	
6061-T651 ALUMINUM		2.00" THICK PLATE		BOTTOM PLATE, CURING FIXTURE, PULSED DIPOLE, ORNL	
SCALE	SIZE	DRAWING NUMBER	SHEET	REV	
1:4	A1	F10204768	1 OF 1	-	

SNS S02040000-M8U-8820-A10083

REV	REVISION CONTROL DOCUMENT	DATES	DRAWN	SIGNATURES
-	F10204770--RCD		APPROVED	



- NOTES: (UNLESS OTHERWISE SPECIFIED)
- PART MUST BE FREE OF DIRT, GREASE, OIL AND CHIPS.
  - PART TO BE FREE OF ALL SHARP EDGES, CORNERS AND BURRS.
  - APPROXIMATE WEIGHT: 73 KG (161LBS)

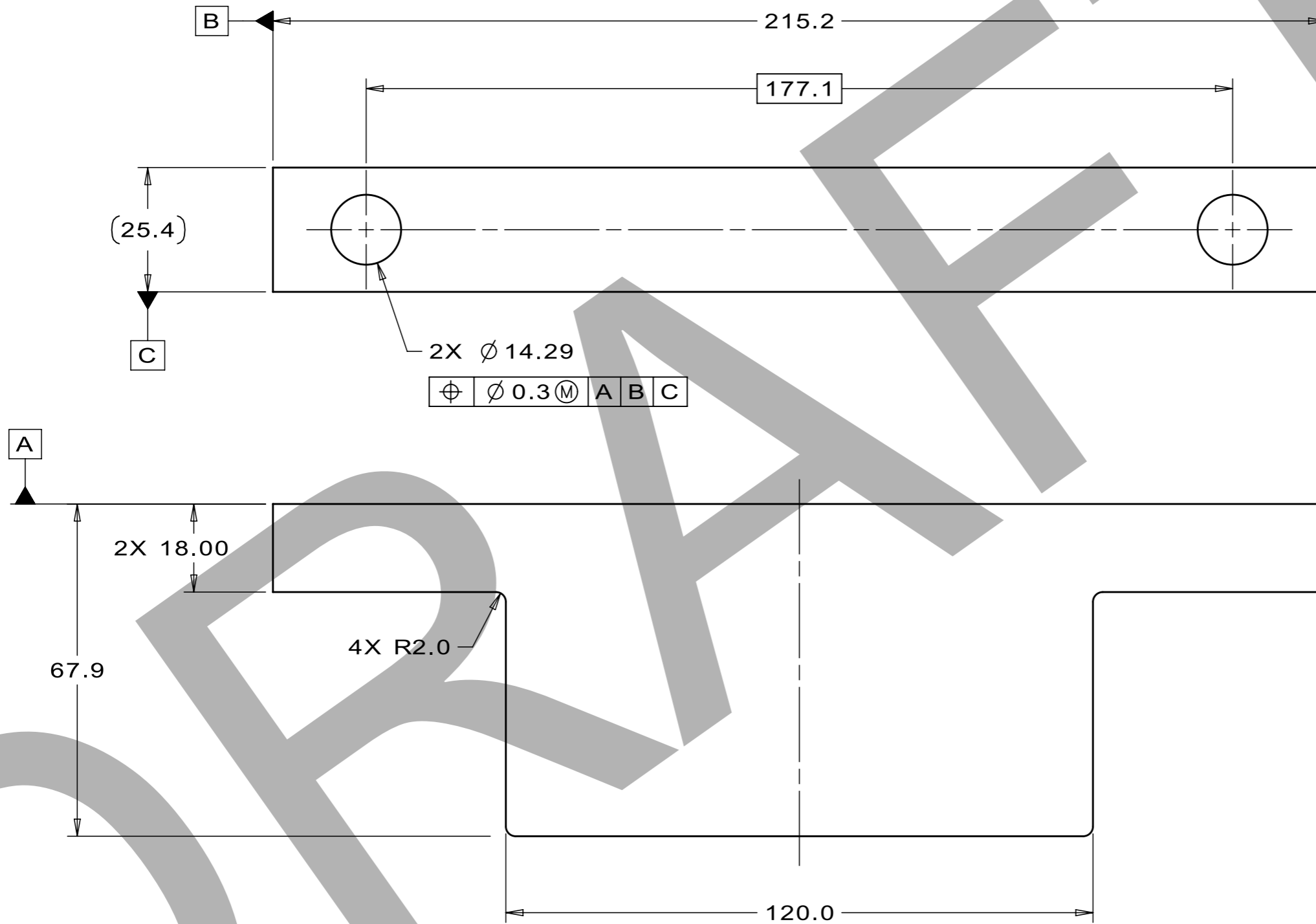
UNLESS OTHERWISE SPECIFIED					DRAWN	J.VANDER MEULEN	DATE	05-Dec-2023
±X	±X.X	±X.XX	±X.XX	±X"	CHECKED		DATE	
1	0.3	0.12	N/A	1"	APPROVED		DATE	
BREAK ALL SHARP EDGES, MAX: 0.5 DO NOT SCALE DRAWING DIMENSIONS BASED ON: ASME Y14.5M-2009 MAX MACHINE ALL SURFACES, Ra: 3.2 DRAWING UNITS: MM					USED ON		NAME	
					F10204164		FERMI NATIONAL ACCELERATOR LABORATORY UNITED STATES DEPARTMENT OF ENERGY	
MATERIAL					6061-T651 ALUMINUM 2.00" THICK STOCK		TOP PLATE, CURING FIXTURE, PULSED DIPOLE, ORNL	
SCALE			1:4	SIZE	A1	DRAWING NUMBER	F10204770	SHEET
								1 OF 1
								REV
								-

SNS S02040000-M8U-8820-A10084

TEMPLATE VERSION: 2021.08.02

DESCRIPTION: CLAMP, SIDE PLATE, CURING FIXTURE, PULSED DIPOLE, ORNL  
 PROJECT: ORNL-STS\_Magnets  
 CATEGORY: PLATE

REV	REVISION CONTROL DOCUMENT	DATES	SIGNATURES	
-	F10204771---RCD		DRAWN	
			APPROVED	



NOTES:(UNLESS OTHERWISE SPECIFIED)

- PART MUST BE FREE OF DIRT, GREASE, OIL AND CHIPS.
- PART TO BE FREE OF ALL SHARP EDGES, CORNERS, AND BURRS.
- TRAILING ZEROS DENOTE TOLERANCE.

UNLESS OTHERWISE SPECIFIED				
$\pm X$	$\pm X.X$	$\pm X.XX$	$\pm X/X$	$\pm X^\circ$
2	0.3	0.12	N/A	1°

BREAK ALL SHARP EDGES, MAX: 0.5  
 DO NOT SCALE DRAWING  
 DIMENSIONS BASED ON: ASME Y14.5M-2009  
 MAX MACHINE ALL SURFACES, Ra: 3.2  
 DRAWING UNITS: MM

THIRD ANGLE PROJECTION

DRAWN	J.HELSLEY	DATE	04-Dec-2023
CHECKED		DATE	
APPROVED		DATE	
USED ON	F10204164		
MATERIAL	6061-T651 ALUMINUM (1.00" STOCK PLATE)		
GROUP:	Technical Division - Design and Drafting		CAGE CODE: OU5R6

		<b>FERMI NATIONAL ACCELERATOR LABORATORY</b> UNITED STATES DEPARTMENT OF ENERGY			
		NAME CLAMP, SIDE PLATE, CURING FIXTURE, PULSED DIPOLE, ORNL			
SCALE	SIZE	DRAWING NUMBER	SHEET	REV	
1:1	A3	F10204771	1 OF 1	-	

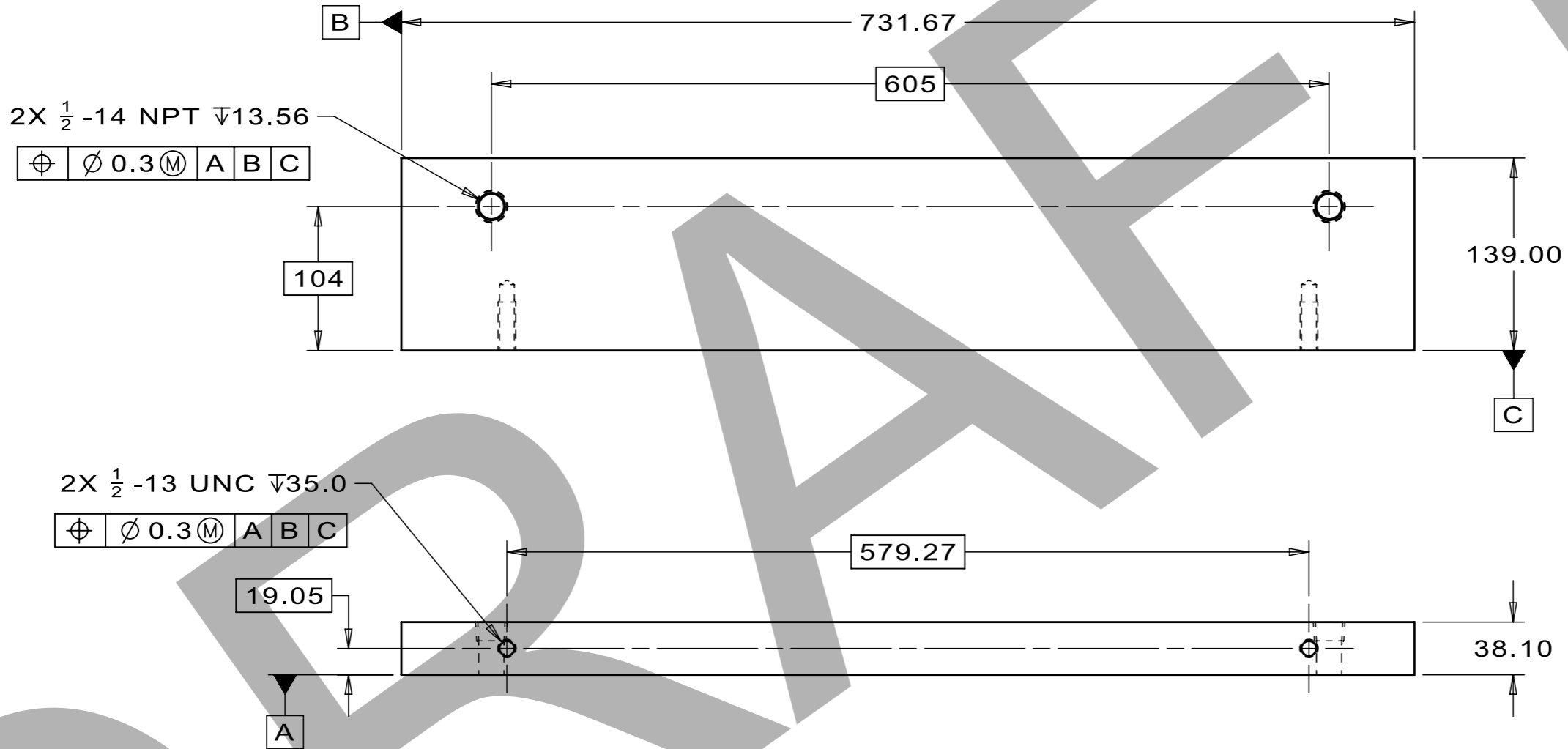
SNS S02040000-M8U-8820-A10085

TEMPLATE VERSION: 2021.08.02



DESCRIPTION: SIDE PLATE WITH FILLER HOLES, CURING FIXTURE, PULSED DIPOLE, ORNL  
 PROJECT: ORNL-STS\_Magnets  
 CATEGORY: PLATE

REV	REVISION CONTROL DOCUMENT	DATES	SIGNATURES	
-	F10204772---RCD		DRAWN	
			APPROVED	



NOTES:(UNLESS OTHERWISE SPECIFIED)

- PART MUST BE FREE OF DIRT, GREASE, OIL AND CHIPS.
- PART TO BE FREE OF ALL SHARP EDGES, CORNERS, AND BURRS.
- TRAILING ZEROS DENOTE TOLERANCE.

SNS S02040000-M8U-8820-A10086

UNLESS OTHERWISE SPECIFIED				
±X	±X.X	±X.XX	±X/X	±X°
2	0.3	0.12	N/A	1°

BREAK ALL SHARP EDGES, MAX: 0.5  
 DO NOT SCALE DRAWING  
 DIMENSIONS BASED ON: ASME Y14.5M-2009  
 MAX MACHINE ALL SURFACES, Ra: 3.2  
 DRAWING UNITS: MM

THIRD ANGLE PROJECTION

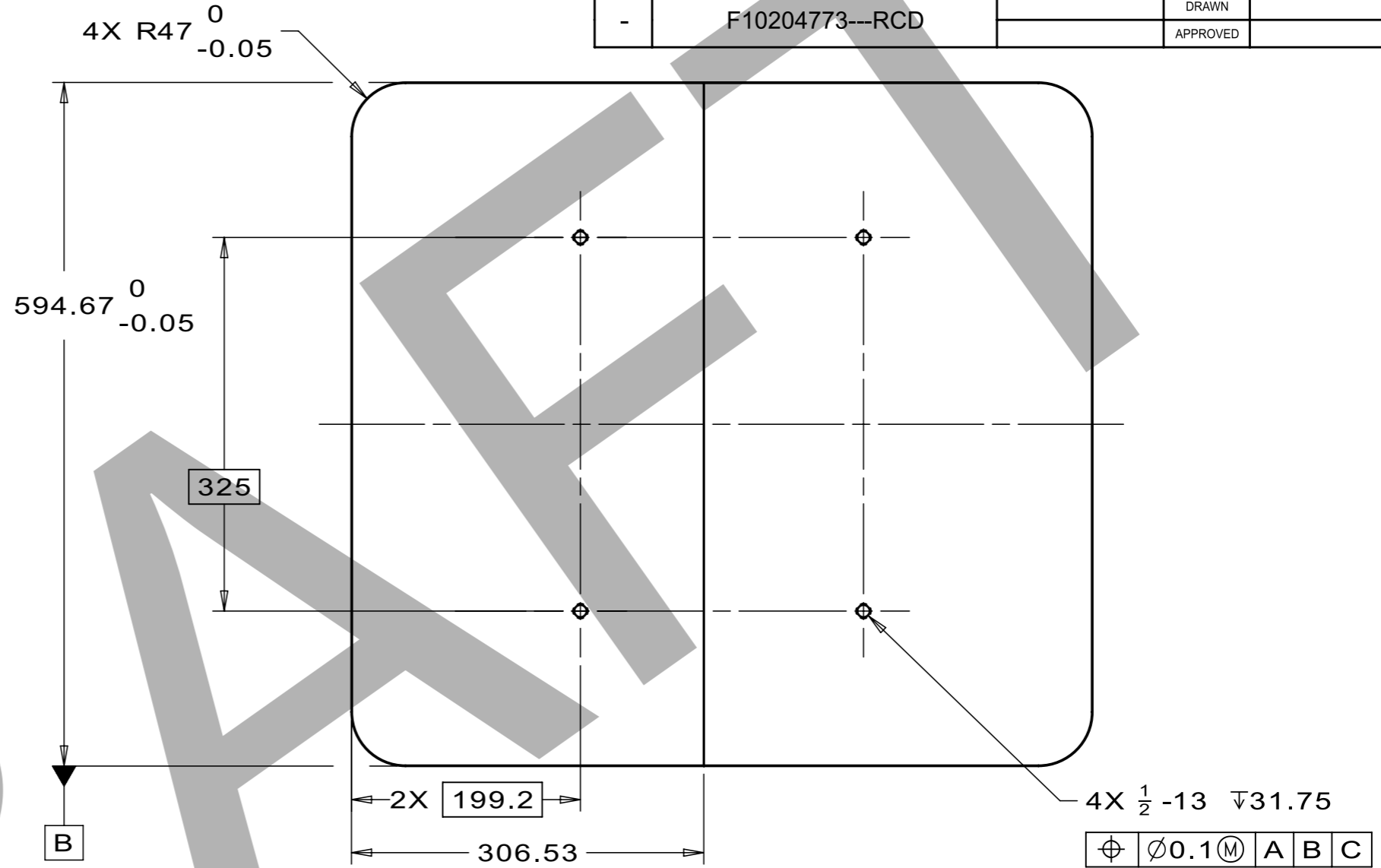
DRAWN	J.HELSLEY	DATE	04-Dec-2023
CHECKED		DATE	
APPROVED		DATE	
USED ON	F10204164		
MATERIAL	6061-T651 ALUMINUM, UNS A96061 (2.00" STOCK PLATE)		
GROUP:	Technical Division - Design and Drafting	CAGE CODE:	OU5R6

<b>FERMI NATIONAL ACCELERATOR LABORATORY</b> UNITED STATES DEPARTMENT OF ENERGY			
NAME			
SIDE PLATE WITH FILLER HOLES, CURING FIXTURE, PULSED DIPOLE, ORNL			
SCALE	SIZE	DRAWING NUMBER	SHEET
1:5	A3	F10204772	1 OF 1
			REV
			-

TEMPLATE VERSION: 2021.08.02

DESCRIPTION: CENTER BLOCK, SPLIT, CURING FIXTURE, PULSED DIPOLE, ORNL  
 PROJECT: ORNL-STS\_Magnets  
 CATEGORY: BLOCK

REV	REVISION CONTROL DOCUMENT	DATES	SIGNATURES	
-	F10204773---RCD		DRAWN	
			APPROVED	



NOTES (UNLESS OTHERWISE SPECIFIED):

- PART MUST BE FREE OF DIRT, GREASE, OIL, AND CHIPS.
- PART MUST BE FREE OF SHARP EDGES CORNERS AND BURRS.
- MACHINE ANGLE FIRST, MAKING SURE THERE IS COMPLETE CONTACT AT THE ANGLE PRIOR TO FINAL MACHINING. MACHINE THE TWO HALVES TOGETHER AS ONE TO MAINTAIN THE DIMENSIONS REQUIRED AND TO ELIMINATE ANY POSSIBILITIES OF STEPS AT THE ANGLE CONTACT.
- DO NOT BREAK SHARP EDGES ALL AROUND 75° ANGLE EDGES.
- APPROXIMATE WEIGHT: 352.8KG (388.9 EACH HALF)

UNLESS OTHERWISE SPECIFIED				
+X	+X.X	+X.XX	+X/X	+X°
2	0.3	0.12	N/A	1°

BREAK ALL SHARP EDGES, MAX: 0.5  
 DO NOT SCALE DRAWING  
 DIMENSIONS BASED ON: ASME Y14.5M-2009  
 MAX MACHINE ALL SURFACES, Ra: 3.2  
 DRAWING UNITS: MM

THIRD ANGLE PROJECTION

DRAWN	J.VANDER MEULEN	DATE	05-Dec-2023
CHECKED		DATE	
APPROVED		DATE	
USED ON	F10204164		
MATERIAL	6061-T6 ALUMINUM		
GROUP:	Technical Division - Design and Drafting		CAGE CODE: OU5R6

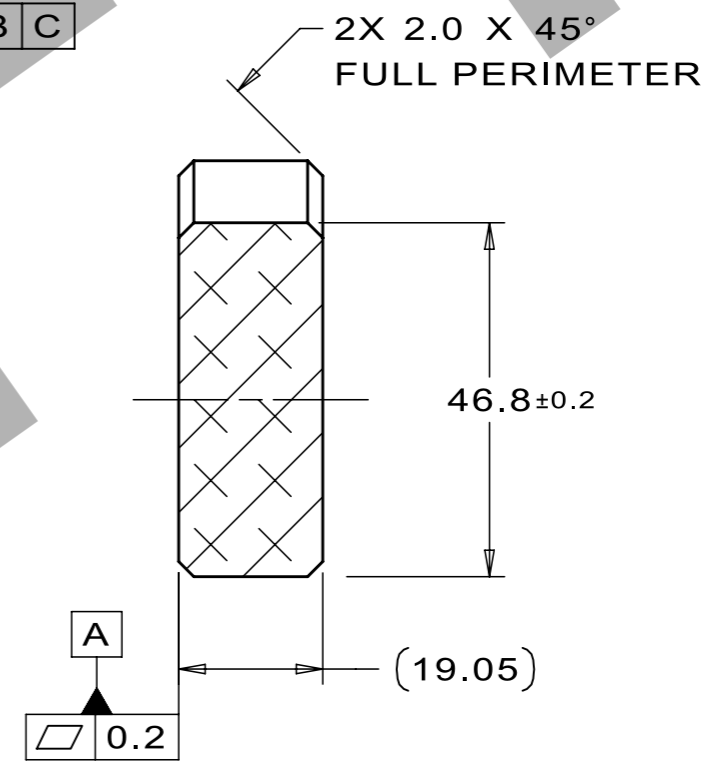
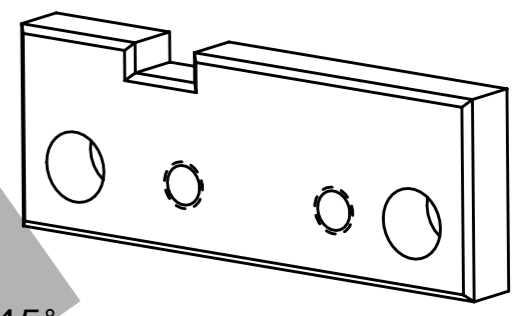
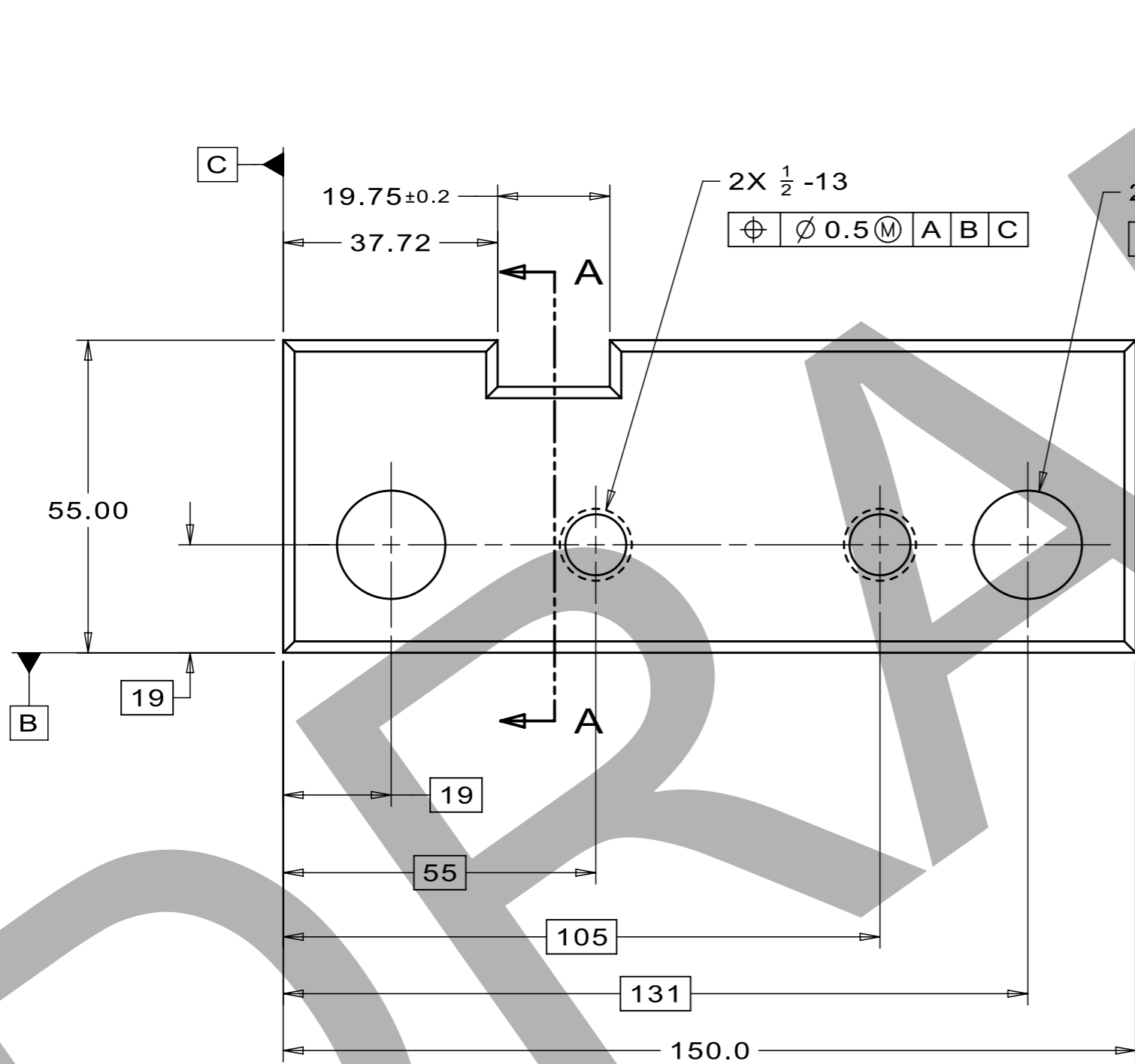
 <b>FERMI NATIONAL ACCELERATOR LABORATORY</b> UNITED STATES DEPARTMENT OF ENERGY				
				NAME <b>CENTER BLOCK, SPLIT, CURING FIXTURE, PULSED DIPOLE, ORNL</b>
SCALE	SIZE	DRAWING NUMBER	SHEET	REV
1:5	A3	F10204773	1 OF 1	-

TEMPLATE VERSION: 2021.08.06

SNS S02040000-M8U-8820-A10087

DESCRIPTION: LEAD PLATE INNER 1, UPPER COIL, CURING FIXTURE, PULSED DIPOLE, ORNL  
 PROJECT: ORNL-STS\_Magnets  
 CATEGORY: PLATE

REV	REVISION CONTROL DOCUMENT	DATES	SIGNATURES	
-	F10204877---RCD		DRAWN	
			APPROVED	



NOTES: (UNLESS OTHERWISE SPECIFIED)

- PART MUST BE FREE OF DIRT, GREASE, OIL AND CHIPS.
- PART TO BE FREE OF ALL SHARP EDGES, CORNERS AND BURRS.
- TRAILING ZEROS DENOTE TOLERANCE.

UNLESS OTHERWISE SPECIFIED				
±X	±X.X	±X.XX	±X/X	±X°
2	0.3	0.12	N/A	1°

BREAK ALL SHARP EDGES, MAX: 0.5  
 DO NOT SCALE DRAWING  
 DIMENSIONS BASED ON: ASME Y14.5M-2009  
 MAX MACHINE ALL SURFACES, Ra: 3.2  
 DRAWING UNITS: MM

THIRD ANGLE PROJECTION

DRAWN	J.HELSLEY	DATE	05-Dec-2023
CHECKED		DATE	
APPROVED		DATE	
USED ON	F10204164		
MATERIAL	6061-T651 ALUMINUM .75" THICK STOCK		
GROUP:	Technical Division - Design and Drafting	CAGE CODE:	OU5R6

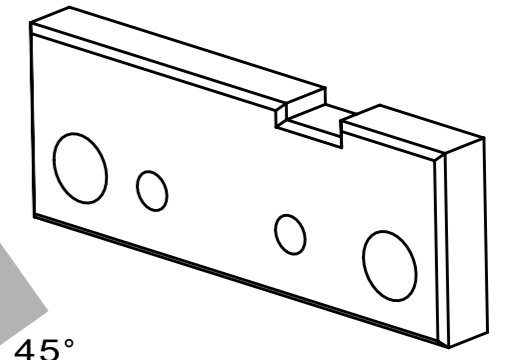
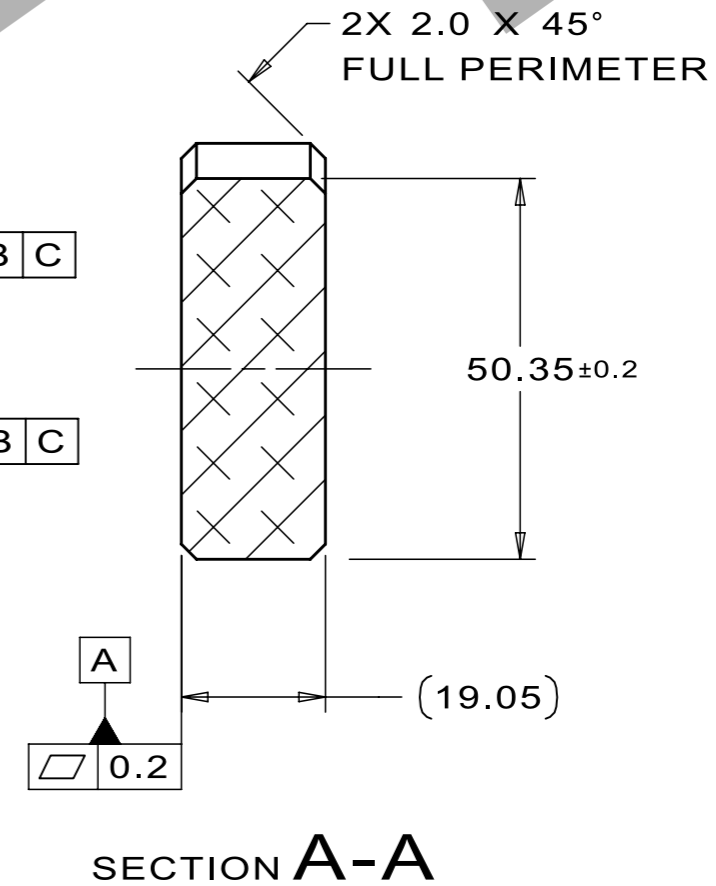
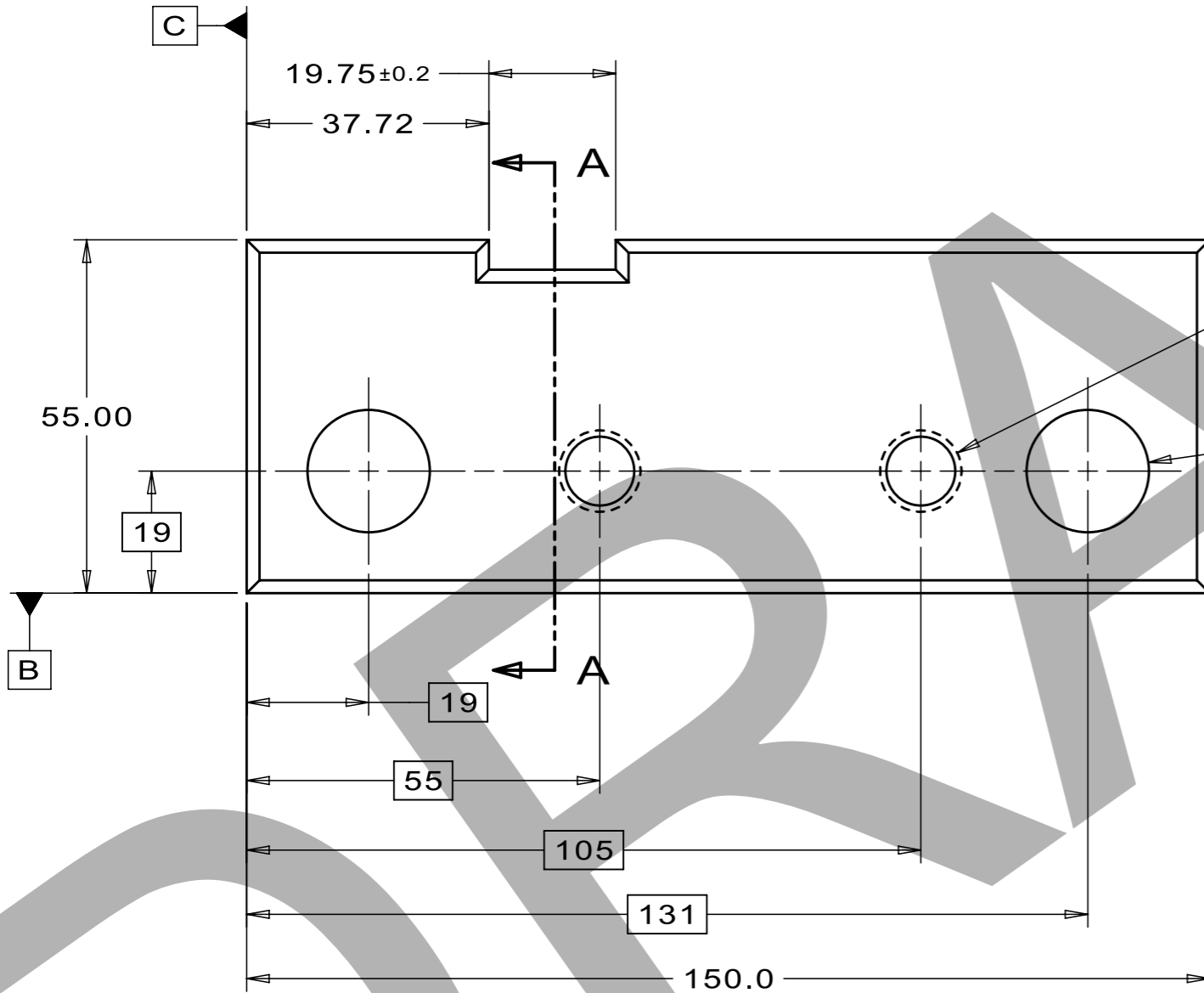
<b>FERMI NATIONAL ACCELERATOR LABORATORY</b> UNITED STATES DEPARTMENT OF ENERGY			
NAME LEAD PLATE INNER 1, UPPER COIL, CURING FIXTURE, PULSED DIPOLE, ORNL			
SCALE 1:1	SIZE A3	DRAWING NUMBER F10204877	SHEET 1 OF 1
			REV -

SNS S02040000-M8U-8820-A10088

TEMPLATE VERSION: 2021.08.02

DESCRIPTION: LEAD PLATE INNER 2, UPPER COIL, CURING FIXTURE, PULSED DIPOLE, ORNL  
 PROJECT: ORNL-STS\_Magnets  
 CATEGORY: PLATE

REV	REVISION CONTROL DOCUMENT	DATES	SIGNATURES	
-	F10204878---RCD		DRAWN	
			APPROVED	

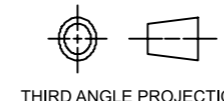


NOTES: (UNLESS OTHERWISE SPECIFIED)

- PART MUST BE FREE OF DIRT, GREASE, OIL AND CHIPS.
- PART TO BE FREE OF ALL SHARP EDGES, CORNERS AND BURRS.
- TRAILING ZEROS DENOTE TOLERANCE.

UNLESS OTHERWISE SPECIFIED				
±X	±X.X	±X.XX	±X/X	±X°
2	0.3	0.12	N/A	1°

BREAK ALL SHARP EDGES, MAX: 0.5  
 DO NOT SCALE DRAWING  
 DIMENSIONS BASED ON: ASME Y14.5M-2009  
 MAX MACHINE ALL SURFACES, Ra: 3.2  
 DRAWING UNITS: MM



DRAWN	J.HELSELEY	DATE	05-Dec-2023
CHECKED		DATE	
APPROVED		DATE	
USED ON	F10204164		
MATERIAL	6061-T651 ALUMINUM .75 THICK STOCK		
GROUP:	Technical Division - Design and Drafting	CAGE CODE:	OU5R6

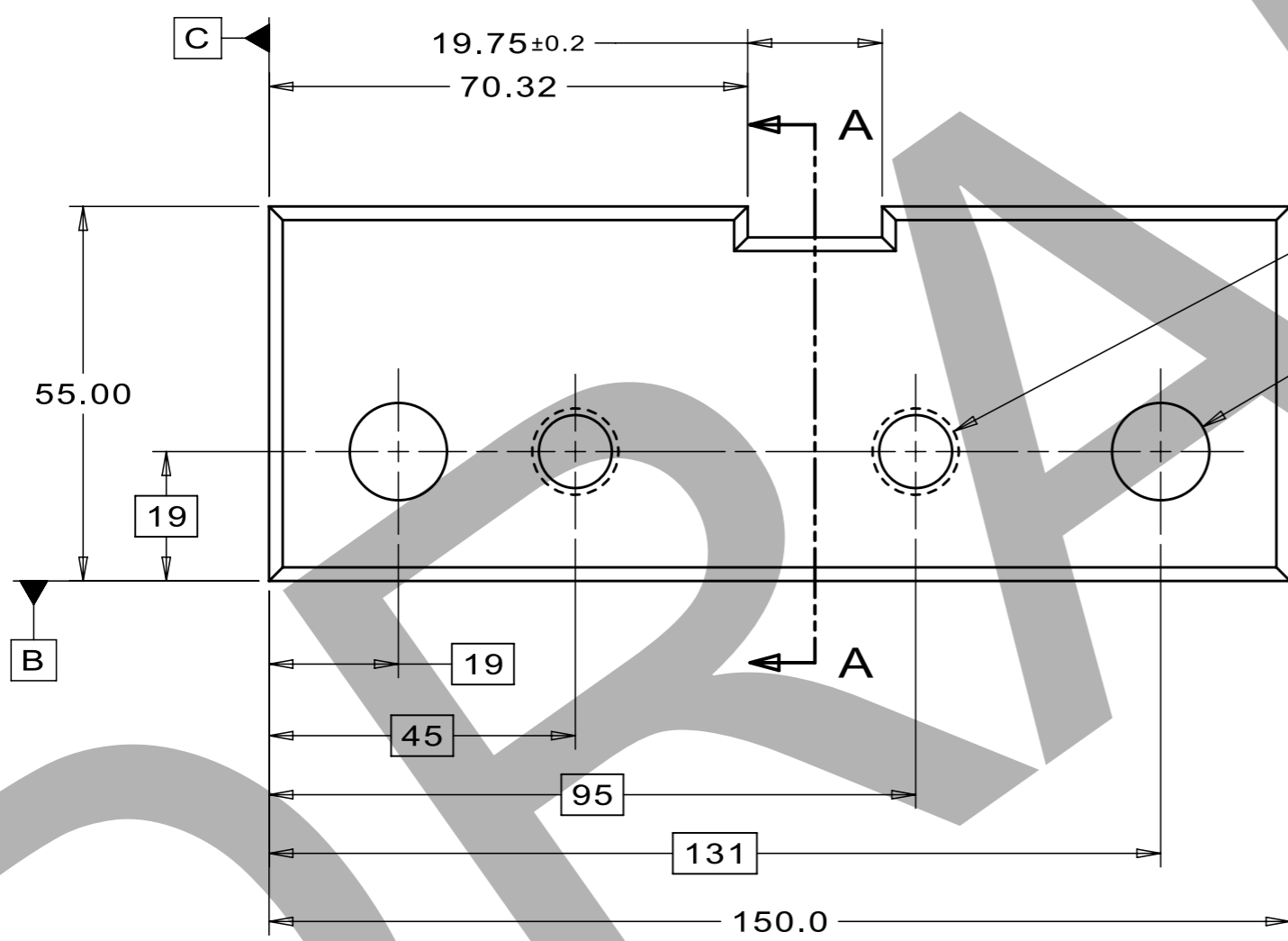
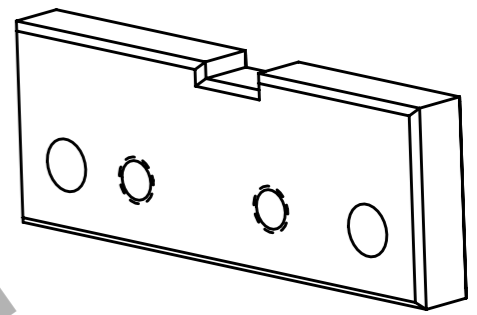
<b>FERMI NATIONAL ACCELERATOR LABORATORY</b> UNITED STATES DEPARTMENT OF ENERGY			
NAME LEAD PLATE INNER 2, UPPER COIL, CURING FIXTURE, PULSED DIPOLE, ORNL			
SCALE 1:1	SIZE A3	DRAWING NUMBER F10204878	SHEET 1 OF 1
		REV -	

SNS S02040000-M8U-8820-A10089

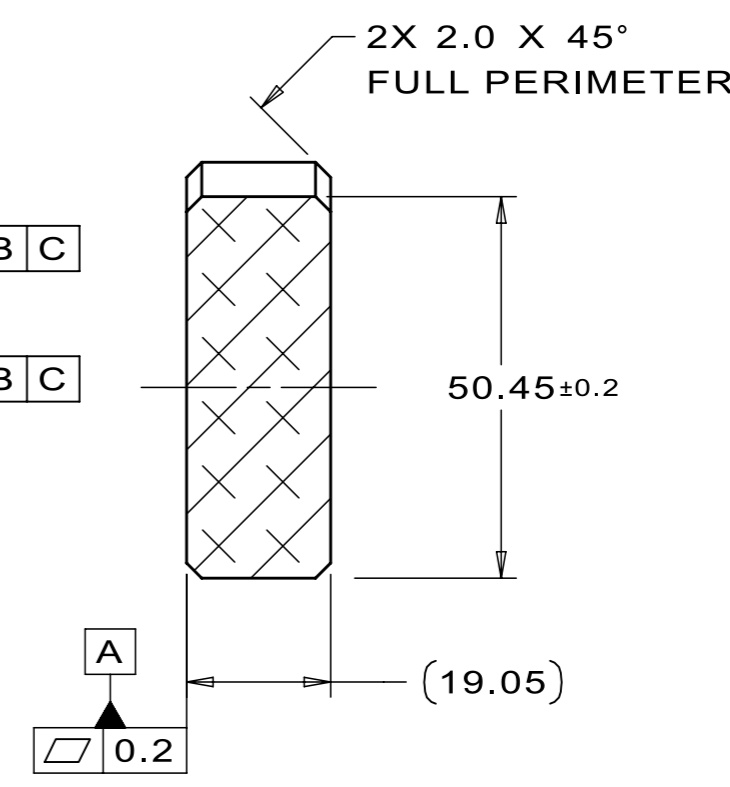
TEMPLATE VERSION: 2021.08.02

DESCRIPTION: LEAD PLATE OUTER 1, UPPER COIL, CURING FIXTURE, PULSED DIPOLE, ORNL  
 PROJECT: ORNL-STS\_Magnets  
 CATEGORY: PLATE

REV	REVISION CONTROL DOCUMENT	DATES	SIGNATURES	
-	F10204879---RCD		DRAWN	
			APPROVED	



2X 1/2 -13	⊕	∅ 0.5 (M)	A	B	C
2X ∅ 14.29	⊕	∅ 0.3 (M)	A	B	C



SECTION A-A

NOTES: (UNLESS OTHERWISE SPECIFIED)

- PART MUST BE FREE OF DIRT, GREASE, OIL AND CHIPS.
- PART TO BE FREE OF ALL SHARP EDGES, CORNERS AND BURRS.
- TRAILING ZEROS DENOTE TOLERANCE.

SNS S02040000-M8U-8820-A10090

UNLESS OTHERWISE SPECIFIED				
±X	±X.X	±X.XX	±X/X	±X°
2	0.3	0.12	N/A	1°

BREAK ALL SHARP EDGES, MAX: 0.5  
 DO NOT SCALE DRAWING  
 DIMENSIONS BASED ON: ASME Y14.5M-2009  
 MAX MACHINE ALL SURFACES, Ra: 3.2  
 DRAWING UNITS: MM

THIRD ANGLE PROJECTION

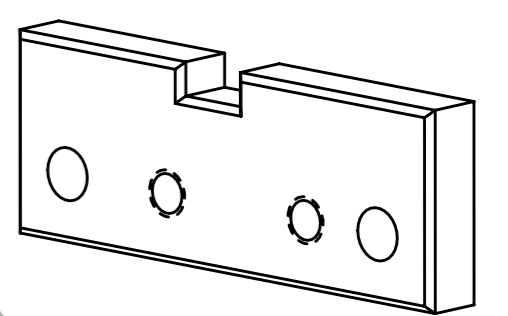
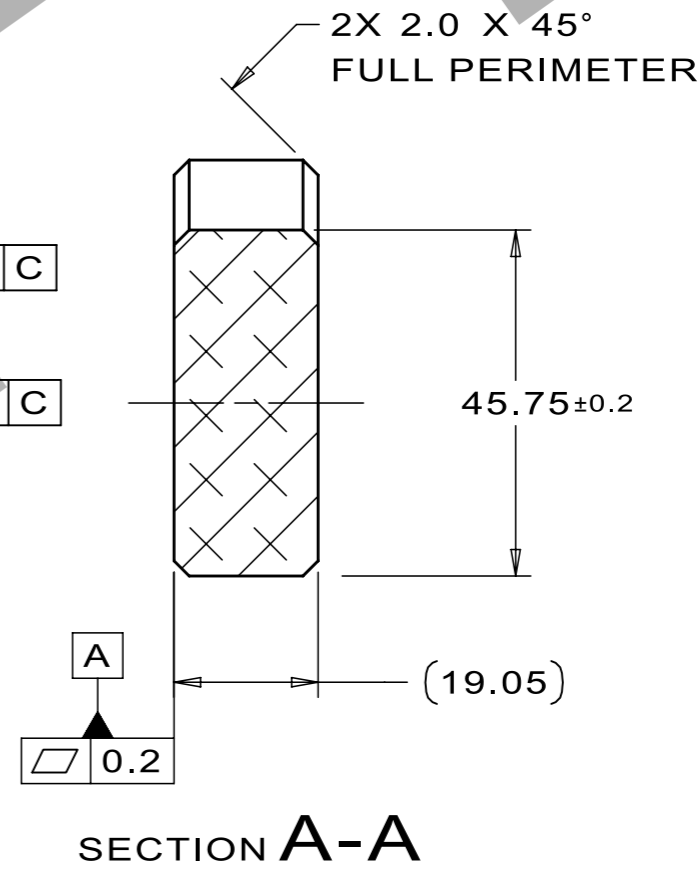
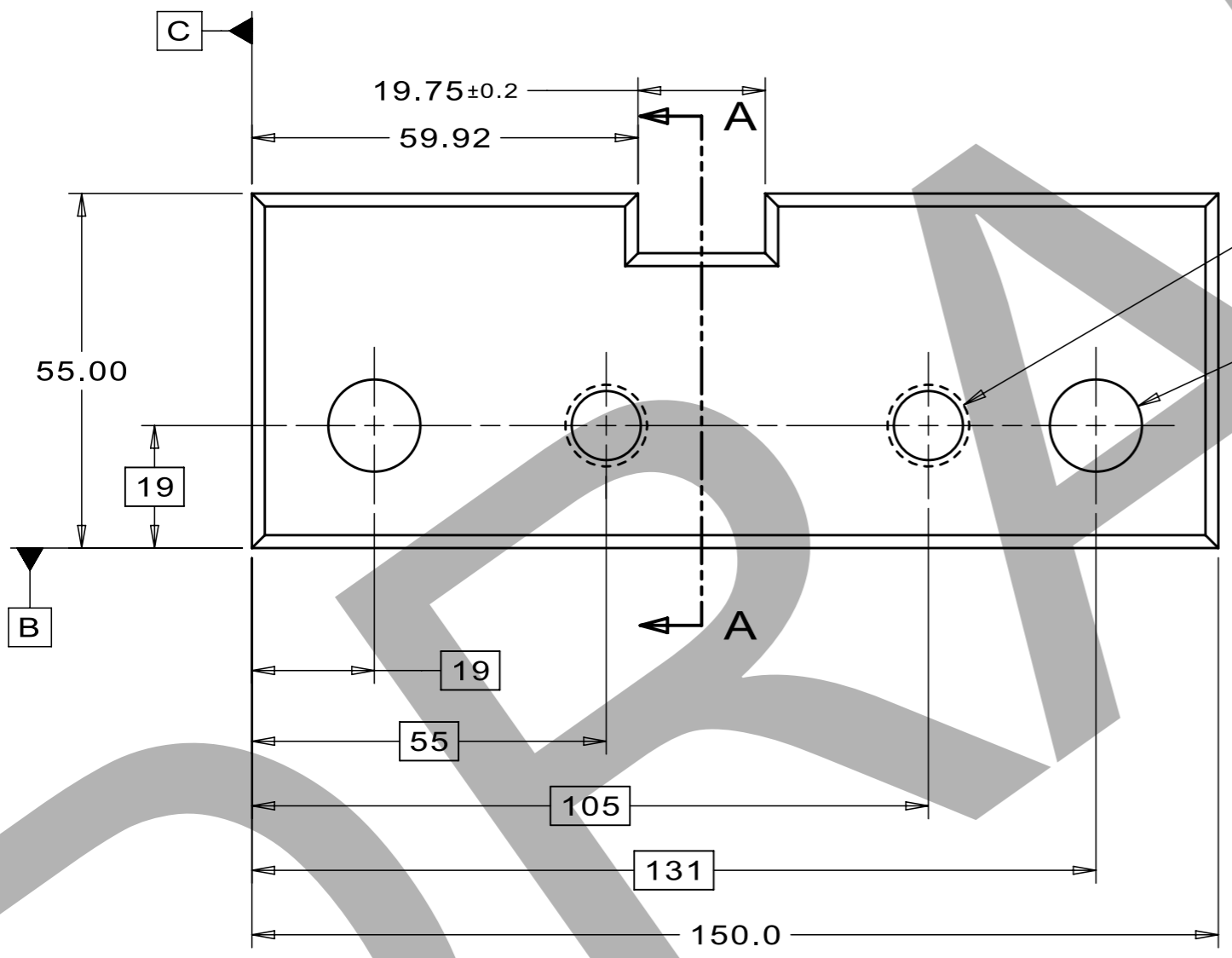
DRAWN	J.HELSELEY	DATE	06-Dec-2023
CHECKED		DATE	
APPROVED		DATE	
USED ON	F10204164		
MATERIAL	6061-T651 ALUMINUM .75" THICK STOCK		
GROUP:	Technical Division - Design and Drafting	CAGE CODE:	OU5R6

<b>FERMI NATIONAL ACCELERATOR LABORATORY</b> UNITED STATES DEPARTMENT OF ENERGY				
				NAME <b>LEAD PLATE OUTER 1, UPPER COIL, CURING FIXTURE, PULSED DIPOLE, ORNL</b>
SCALE 1:1	SIZE A3	DRAWING NUMBER F10204879	SHEET 1 OF 1	REV -

TEMPLATE VERSION: 2021.08.02

DESCRIPTION: LEAD PLATE OUTER 2, UPPER COIL, CURING FIXTURE, PULSED DIPOLE, ORNL  
 PROJECT: VTS-Upgrades  
 CATEGORY: PLATE

REV	REVISION CONTROL DOCUMENT	DATES	SIGNATURES	
-	F10204880---RCD		DRAWN	
			APPROVED	



NOTES: (UNLESS OTHERWISE SPECIFIED)

- PART MUST BE FREE OF DIRT, GREASE, OIL AND CHIPS.
- PART TO BE FREE OF ALL SHARP EDGES, CORNERS AND BURRS.
- TRAILING ZEROS DENOTE TOLERANCE.

UNLESS OTHERWISE SPECIFIED				
±X	±X.X	±X.XX	±X/X	±X°
2	0.3	0.12	N/A	1°

BREAK ALL SHARP EDGES, MAX: 0.5  
 DO NOT SCALE DRAWING  
 DIMENSIONS BASED ON: ASME Y14.5M-2009  
 MAX MACHINE ALL SURFACES, Ra: 3.2  
 DRAWING UNITS: MM

THIRD ANGLE PROJECTION

DRAWN	J.HELSEY	DATE	06-Dec-2023
CHECKED		DATE	
APPROVED		DATE	
USED ON	F10204164		
MATERIAL	6061-T651 ALUMINUM .75" THICK STOCK		
GROUP:	Technical Division - Design and Drafting	CAGE CODE:	OU5R6

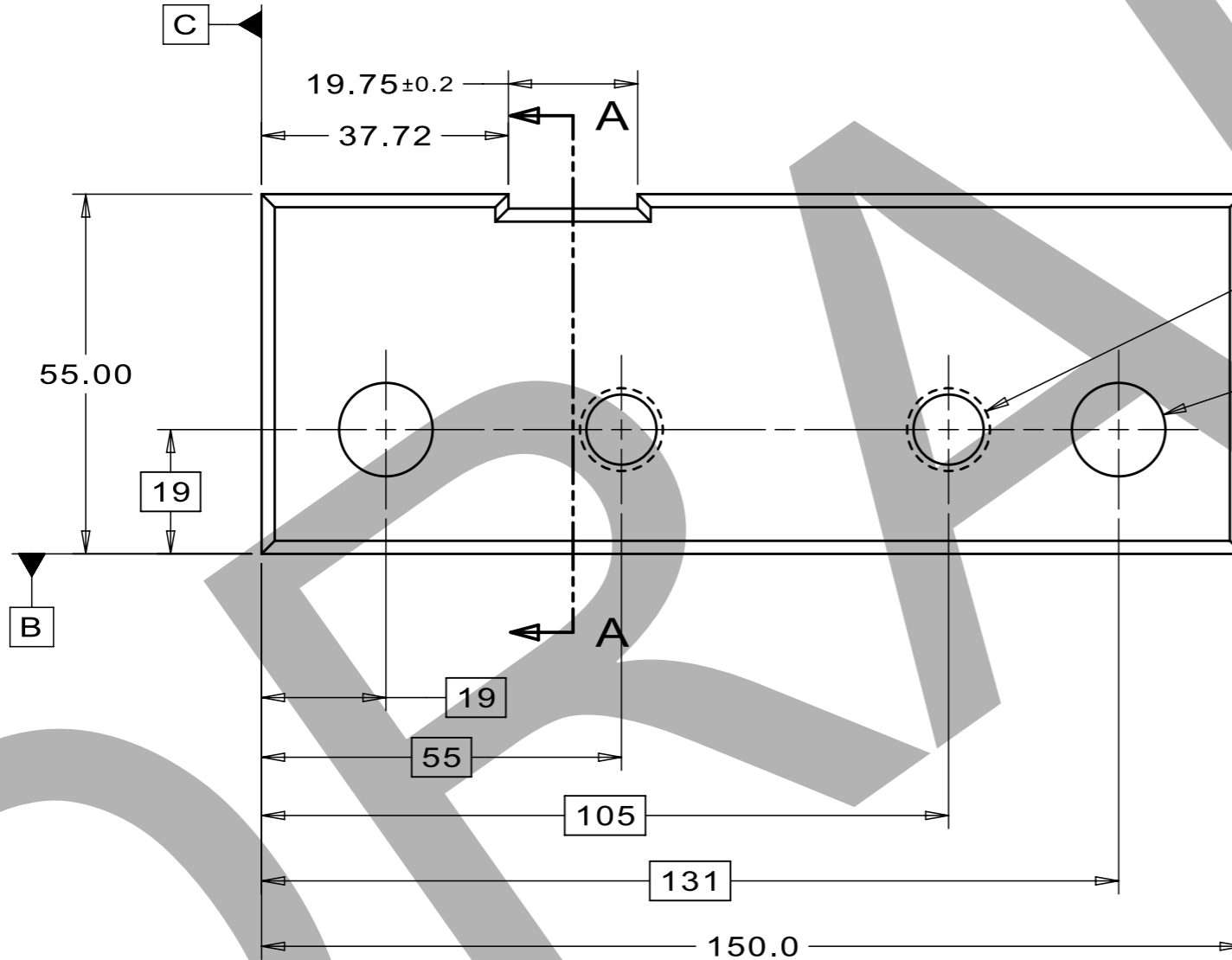
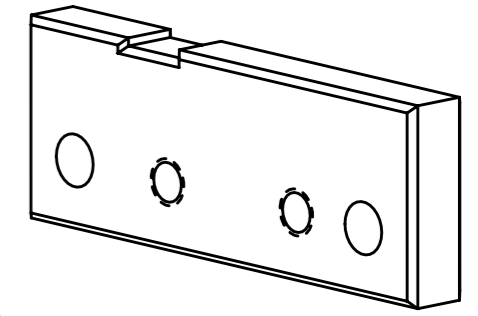
<b>FERMI NATIONAL ACCELERATOR LABORATORY</b> UNITED STATES DEPARTMENT OF ENERGY				
				NAME <b>LEAD PLATE OUTER 2, UPPER COIL, CURING FIXTURE, PULSED DIPOLE, ORNL</b>
SCALE	SIZE	DRAWING NUMBER	SHEET	REV
1:1	A3	F10204880	1 OF 1	-

SNS S02040000-M8U-8820-A10091

TEMPLATE VERSION: 2021.08.02

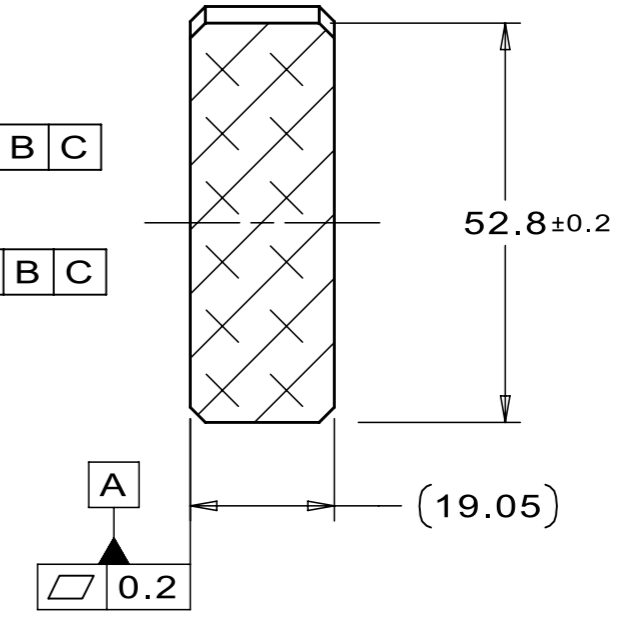
DESCRIPTION: LEAD PLATE INNER 1, LOWER COIL, CURING FIXTURE, PULSED DIPOLE, ORNL  
 PROJECT: ORNL-STS\_Magnets  
 CATEGORY: PLATE

REV	REVISION CONTROL DOCUMENT	DATES	SIGNATURES	
-	F10204951---RCD		DRAWN	
			APPROVED	



2X 2.0 X 45°  
FULL PERIMETER

- 2X 1/2 -13  
⊕ ∅ 0.5 (M) A B C
- 2X ∅ 14.29  
⊕ ∅ 0.3 (M) A B C



SECTION A-A

NOTES: (UNLESS OTHERWISE SPECIFIED)

- PART MUST BE FREE OF DIRT, GREASE, OIL AND CHIPS.
- PART TO BE FREE OF ALL SHARP EDGES, CORNERS AND BURRS.
- TRAILING ZEROS DENOTE TOLERANCE.

SNS S02040000-M8U-8820-A10092

UNLESS OTHERWISE SPECIFIED				
±X	±X.X	±X.XX	±X/X	±X°
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BREAK ALL SHARP EDGES, MAX: 0.5  
 DO NOT SCALE DRAWING  
 DIMENSIONS BASED ON: ASME Y14.5M-2009  
 MAX MACHINE ALL SURFACES, Ra: 3.2  
 DRAWING UNITS: MM

THIRD ANGLE PROJECTION

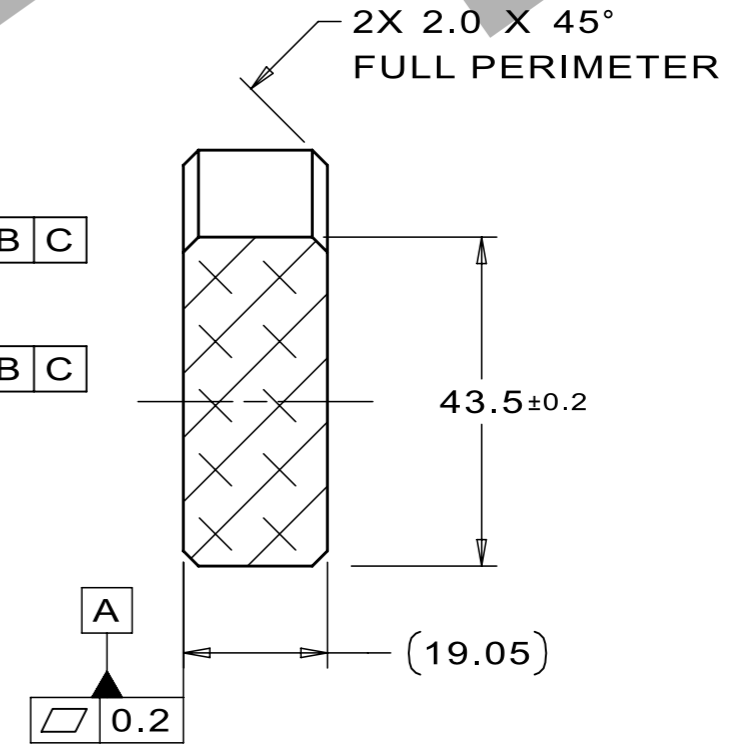
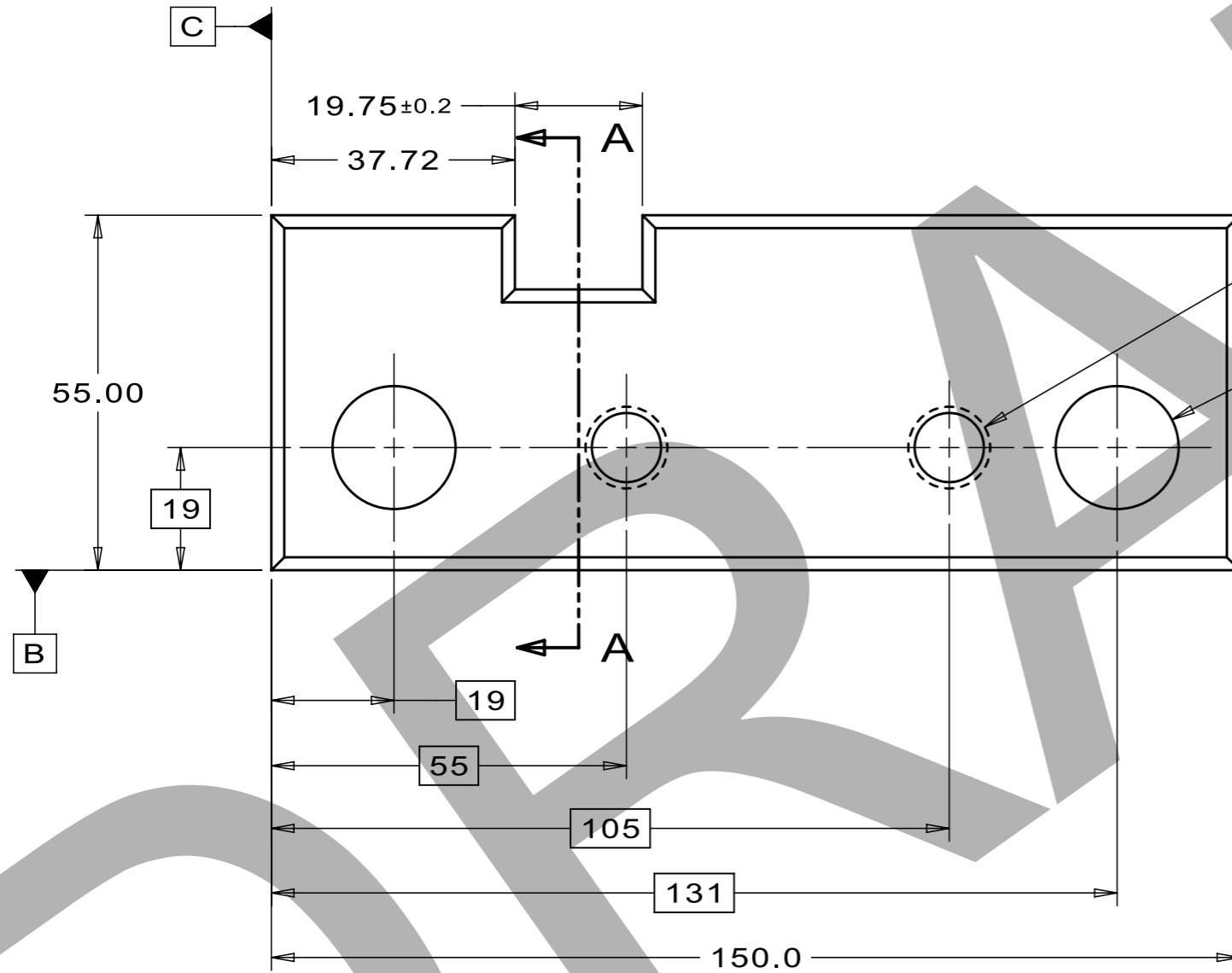
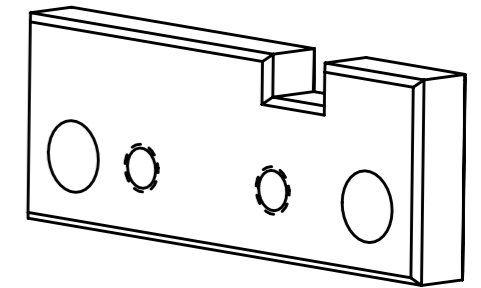
DRAWN	J.HELSELEY	DATE	06-Dec-2023
CHECKED		DATE	
APPROVED		DATE	
USED ON	F10133318		
MATERIAL	6061-T651 ALUMINUM .75" THICK STOCK		
GROUP:	Technical Division - Design and Drafting		CAGE CODE: OU5R6

<b>FERMI NATIONAL ACCELERATOR LABORATORY</b> UNITED STATES DEPARTMENT OF ENERGY			
NAME LEAD PLATE INNER 1, LOWER COIL, CURING FIXTURE, PULSED DIPOLE, ORNL			
SCALE 1:1	SIZE A3	DRAWING NUMBER F10204951	SHEET 1 OF 1
		REV -	

TEMPLATE VERSION: 2021.08.02

DESCRIPTION: LEAD PLATE INNER 2, LOWER COIL, CURING FIXTURE, PULSED DIPOLE, ORNL  
 PROJECT: ORNL-STS\_Magnets  
 CATEGORY: PLATE

REV	REVISION CONTROL DOCUMENT	DATES	SIGNATURES	
-	F10204952---RCD		DRAWN	
			APPROVED	



SECTION A-A

NOTES: (UNLESS OTHERWISE SPECIFIED)

- PART MUST BE FREE OF DIRT, GREASE, OIL AND CHIPS.
- PART TO BE FREE OF ALL SHARP EDGES, CORNERS AND BURRS.
- TRAILING ZEROS DENOTE TOLERANCE.

UNLESS OTHERWISE SPECIFIED				
±X	±X.X	±X.XX	±X/X	±X°
2	0.3	0.12	N/A	1°

BREAK ALL SHARP EDGES, MAX: 0.5  
 DO NOT SCALE DRAWING  
 DIMENSIONS BASED ON: ASME Y14.5M-2009  
 MAX MACHINE ALL SURFACES, Ra: 3.2  
 DRAWING UNITS: MM

THIRD ANGLE PROJECTION

DRAWN	J.HELSELY	DATE	06-Dec-2023
CHECKED		DATE	
APPROVED		DATE	
USED ON	F10133318		
MATERIAL	6061-T651 ALUMINUM .75 THICK STOCK		
GROUP:	Technical Division - Design and Drafting	CAGE CODE:	OU5R6

				FERMI NATIONAL ACCELERATOR LABORATORY UNITED STATES DEPARTMENT OF ENERGY			
NAME							A
LEAD PLATE INNER 2, LOWER COIL, CURING FIXTURE, PULSED DIPOLE, ORNL							
SCALE	SIZE	DRAWING NUMBER		SHEET	REV		
1:1	A3	F10204952		1 OF 1	-		

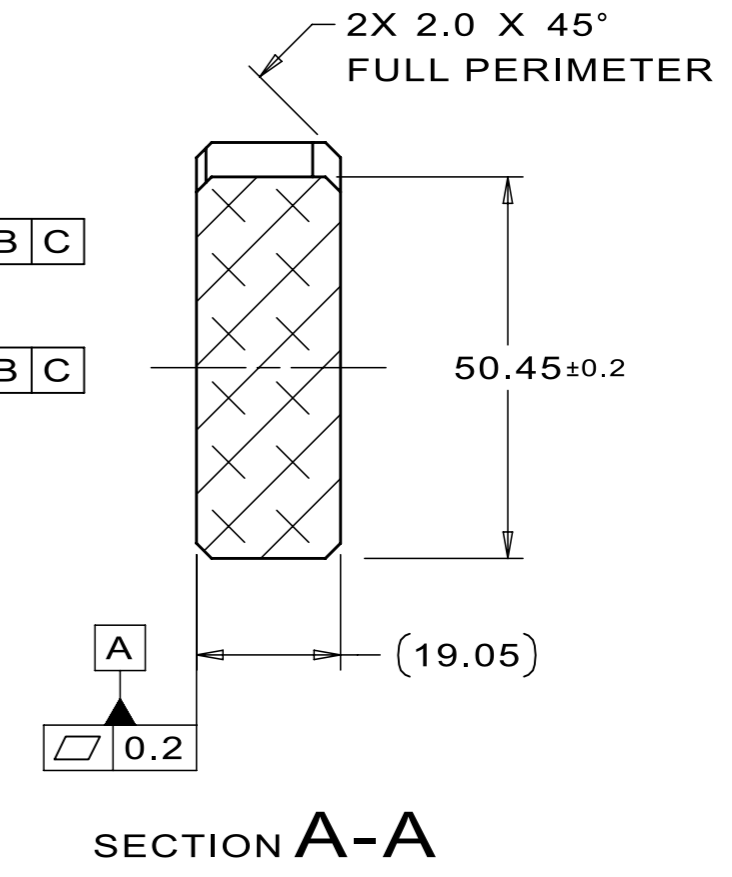
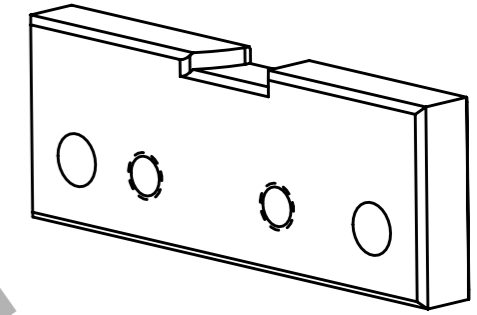
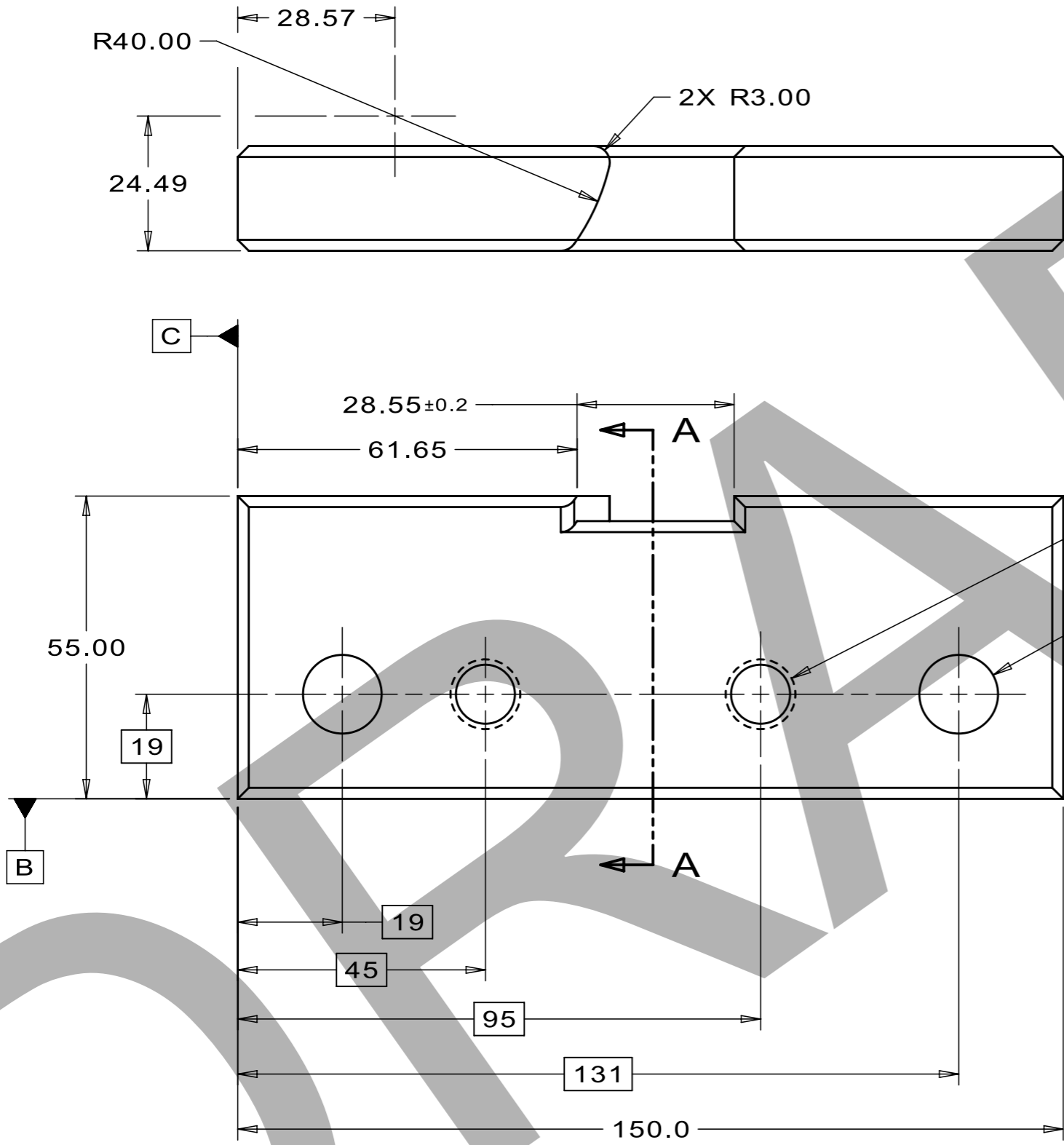
SNS S02040000-M8U-8820-A10093

TEMPLATE VERSION: 2021.08.02



DESCRIPTION: LEAD PLATE OUTER 1, LOWER COIL, CURING FIXTURE, PULSED DIPOLE, ORNL  
 PROJECT: ORNL-STS\_Magnets  
 CATEGORY: PLATE

REV	REVISION CONTROL DOCUMENT	DATES	SIGNATURES	
-	F10204953---RCD		DRAWN	
			APPROVED	



NOTES: (UNLESS OTHERWISE SPECIFIED)

- PART MUST BE FREE OF DIRT, GREASE, OIL AND CHIPS.
- PART TO BE FREE OF ALL SHARP EDGES, CORNERS AND BURRS.
- TRAILING ZEROS DENOTE TOLERANCE.

UNLESS OTHERWISE SPECIFIED				
±X	±X.X	±X.XX	±X/X	±X°
2	0.3	0.12	N/A	1°

BREAK ALL SHARP EDGES, MAX: 0.5  
 DO NOT SCALE DRAWING  
 DIMENSIONS BASED ON: ASME Y14.5M-2009  
 MAX MACHINE ALL SURFACES, Ra: 3.2  
 DRAWING UNITS: MM

THIRD ANGLE PROJECTION

DRAWN	J.HELSELEY	DATE	06-Dec-2023
CHECKED		DATE	
APPROVED		DATE	
USED ON	F10133318		
MATERIAL	6061-T651 ALUMINUM .75" THICK STOCK		
GROUP:	Technical Division - Design and Drafting	CAGE CODE:	OU5R6

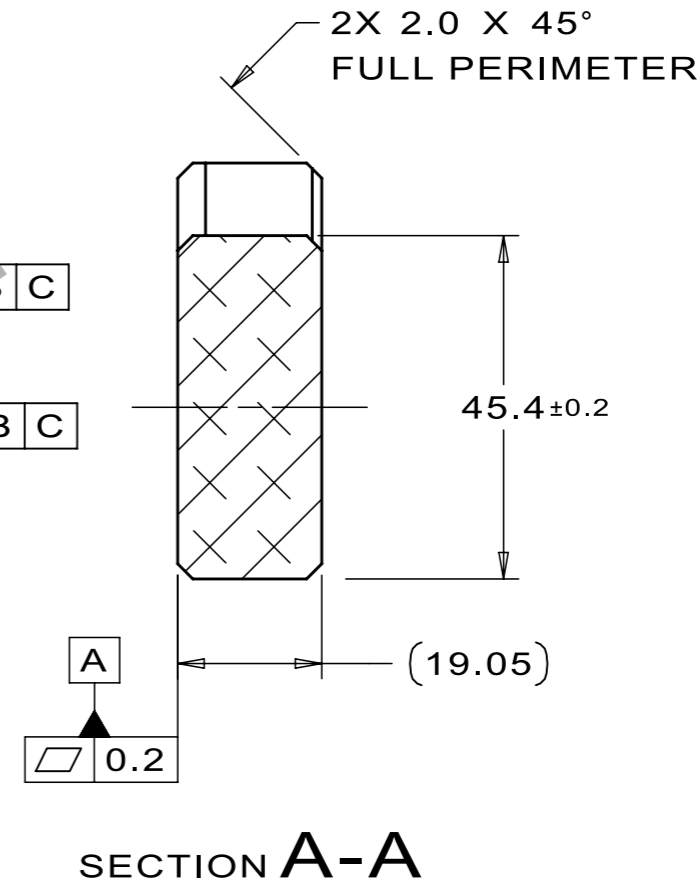
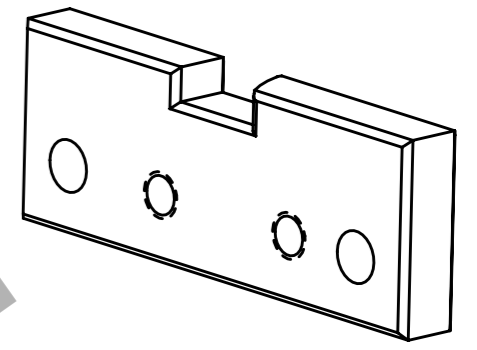
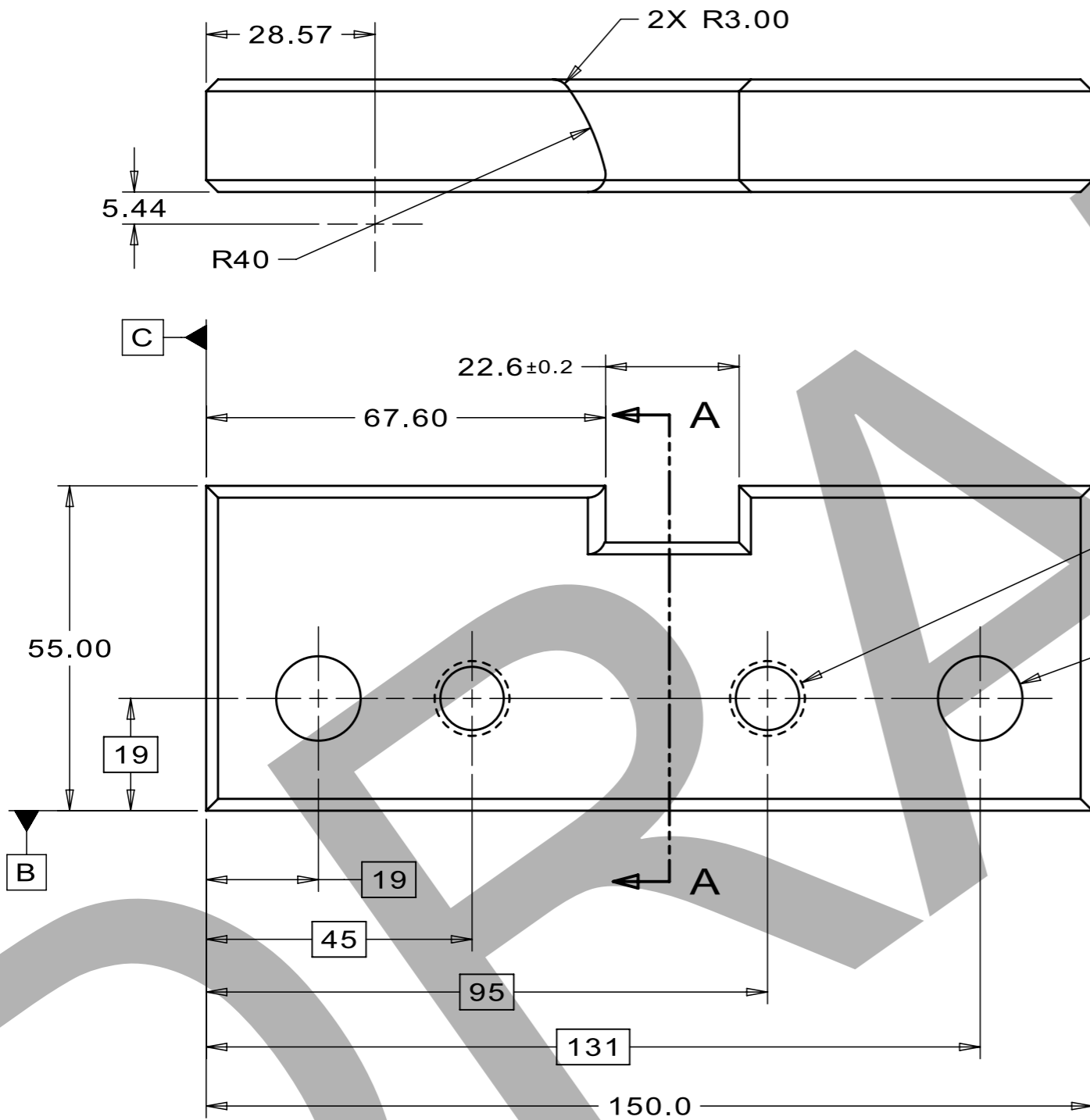
<b>FERMI NATIONAL ACCELERATOR LABORATORY</b> UNITED STATES DEPARTMENT OF ENERGY			
NAME <b>LEAD PLATE OUTER 1, LOWER COIL, CURING FIXTURE, PULSED DIPOLE, ORNL</b>			
SCALE	SIZE	DRAWING NUMBER	SHEET
1:1	A3	F10204953	1 OF 1
			REV
			-

SNS S02040000-M8U-8820-A10094

TEMPLATE VERSION: 2021.08.02

DESCRIPTION: LEAD PLATE OUTER 2, LOWER COIL, CURING FIXTURE, PULSED DIPOLE, ORNL  
 PROJECT: ORNL-STS\_Magnets  
 CATEGORY: PLATE

REV	REVISION CONTROL DOCUMENT	DATES	SIGNATURES	
-	F10204954---RCD		DRAWN	
			APPROVED	



NOTES: (UNLESS OTHERWISE SPECIFIED)

- PART MUST BE FREE OF DIRT, GREASE, OIL AND CHIPS.
- PART TO BE FREE OF ALL SHARP EDGES, CORNERS AND BURRS.
- TRAILING ZEROS DENOTE TOLERANCE.

UNLESS OTHERWISE SPECIFIED				
±X	±X.X	±X.XX	±X/X	±X°
2	0.3	0.12	N/A	1°

BREAK ALL SHARP EDGES, MAX: 0.5  
 DO NOT SCALE DRAWING  
 DIMENSIONS BASED ON: ASME Y14.5M-2009  
 MAX MACHINE ALL SURFACES, Ra: 3.2  
 DRAWING UNITS: MM

THIRD ANGLE PROJECTION

DRAWN	J.HELSELEY	DATE	07-Dec-2023
CHECKED		DATE	
APPROVED		DATE	
USED ON	F10133318		
MATERIAL	6061-T651 ALUMINUM .75" THICK STOCK		
GROUP:	Technical Division - Design and Drafting	CAGE CODE:	OU5R6

<b>FERMI NATIONAL ACCELERATOR LABORATORY</b> UNITED STATES DEPARTMENT OF ENERGY			
NAME LEAD PLATE OUTER 2, LOWER COIL, CURING FIXTURE, PULSED DIPOLE, ORNL			
SCALE 1:1	SIZE A3	DRAWING NUMBER F10204954	SHEET 1 OF 1
		REV -	

SNS S02040000-M8U-8820-A10095

TEMPLATE VERSION: 2021.08.02

4

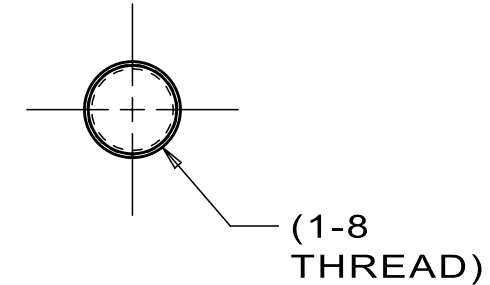
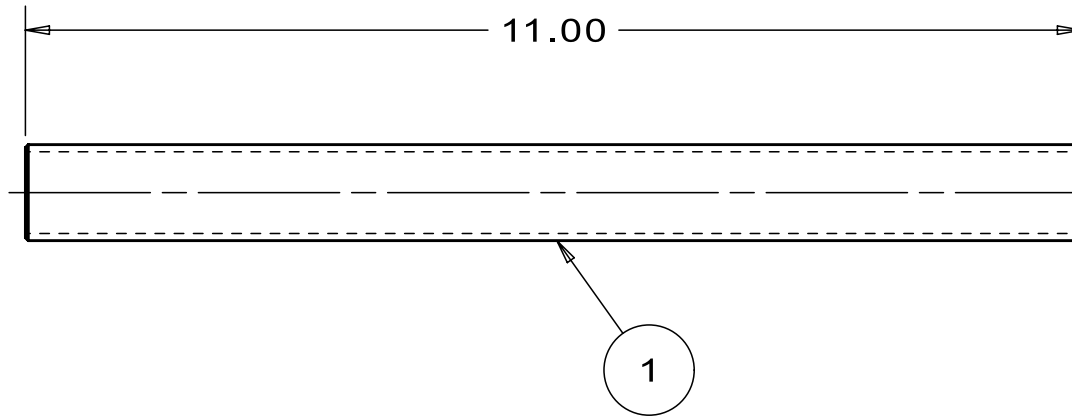
3

2

1

DESCRIPTION: THREADED ROD, CURING FIXTURE, PULSED DIPOLE, ORNL  
PROJECT: ORNL-STs\_Magnets  
CATEGORY: ROD

REV	REVISION CONTROL DOCUMENT	DATES	SIGNATURES	
-	F10204974---RCD		DRAWN	
			APPROVED	

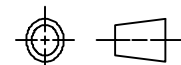



1	FC0075154	THREADED ROD, 1-8x6 FT LG, B.O. STL, GR B7	A/R
ITEM	FERMILAB #	PART NAME	QTY

**PARTS LIST**

NOTES: (UNLESS OTHERWISE SPECIFIED)

- PART MUST BE FREE OF DIRT, GREASE, OIL AND CHIPS.
- PART TO BE FREE OF ALL SHARP EDGES, CORNERS AND BURRS.
- TRAILING ZEROS DENOTE TOLERANCE.

UNLESS OTHERWISE SPECIFIED					DRAWN	J.VANDER MEULEN	DATE	13-Dec-2023
±.X	±.XX	±.XXX	±X/X	±X°	CHECKED		DATE	
.1	.02	.005	1/16	1°	APPROVED		DATE	
BREAK ALL SHARP EDGES, MAX: .015 DO NOT SCALE DRAWING DIMENSIONS BASED ON: ASME Y14.5-2009 MAX MACHINE ALL SURFACES, Ra: 125 DRAWING UNITS: INCHES					USED ON			
 THIRD ANGLE PROJECTION					F10204164			
					MATERIAL			
					SEE PARTS LIST			
GROUP: Technical Division - Design and Drafting					CAGE CODE: OU5R6			

 <b>FERMI NATIONAL ACCELERATOR LABORATORY</b> UNITED STATES DEPARTMENT OF ENERGY					NAME			
					THREADED ROD, CURING FIXTURE, PULSED DIPOLE, ORNL			
SCALE	SIZE	DRAWING NUMBER		SHEET	REV			
1:2	B	F10204974		1 of 1	-			

SNS S02040000-M8U-8820-A10096

4

3

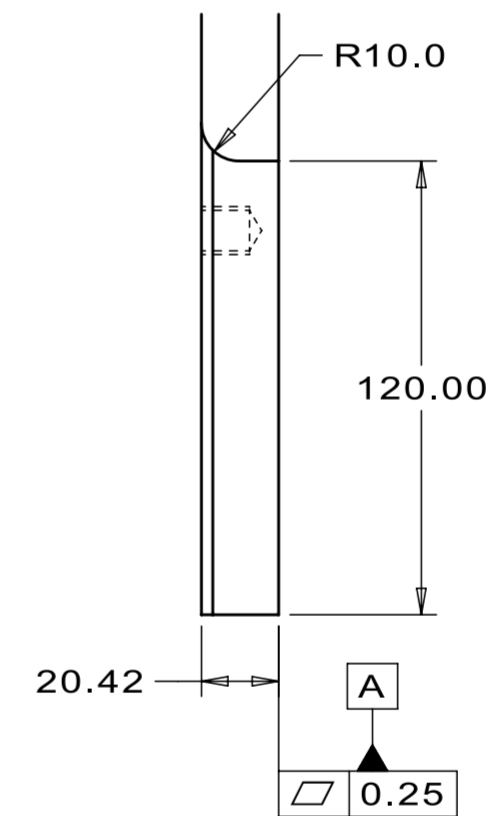
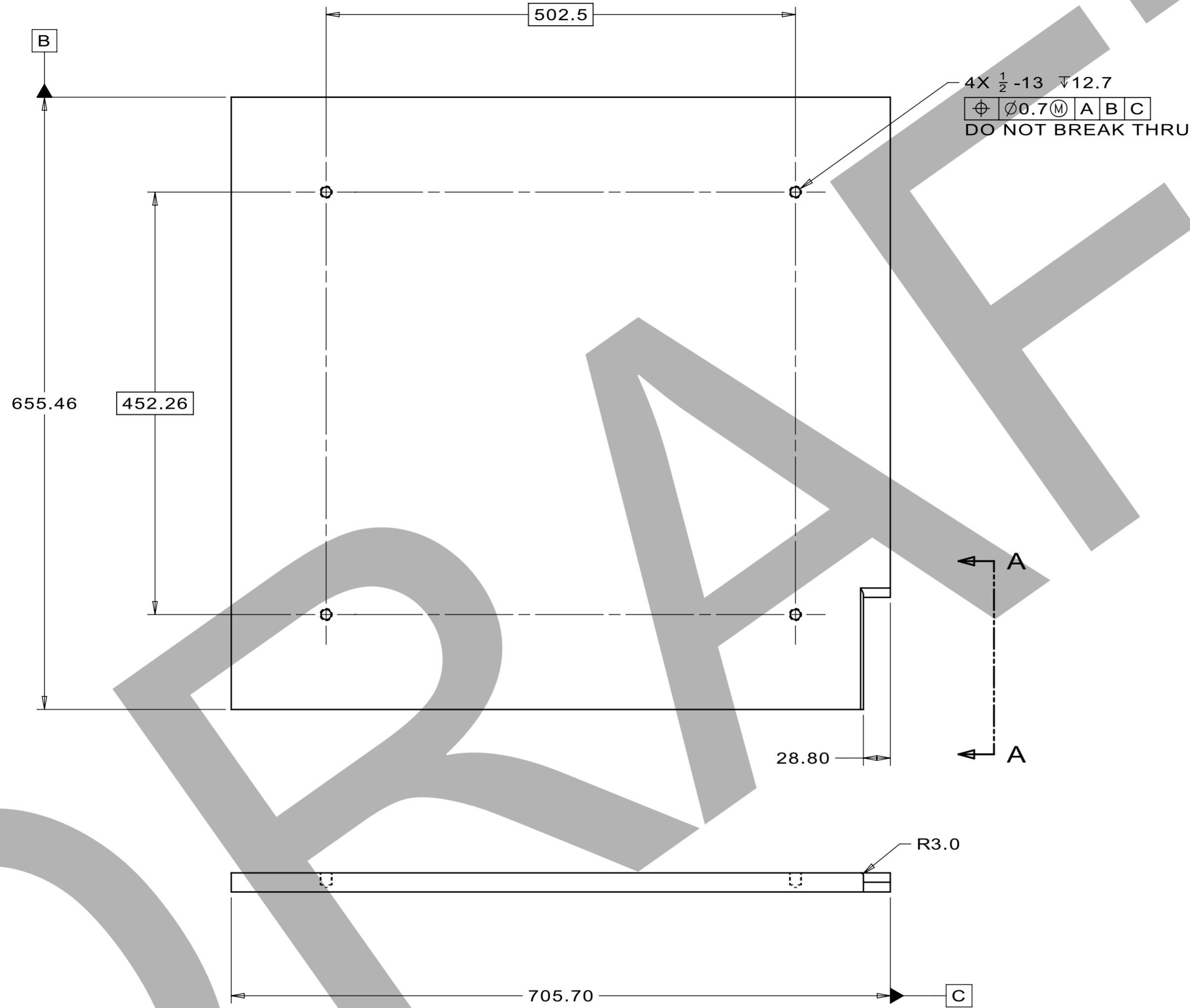
2

1

TEMPLATE VERSION: 2021.08.02

DESCRIPTION: PLATE, COIL RISER, PULSED DIPOLE CURING FIXTURE, ORNL  
 PROJECT: ORNL-STS\_Magnets  
 CATEGORY: PLATE

REV	REVISION CONTROL DOCUMENT	DATES	SIGNATURES
-	F10204995---RCD		DRAWN APPROVED



SECTION A-A  
SCALE 1:2

NOTES (UNLESS OTHERWISE SPECIFIED):

- PART MUST BE FREE OF DIRT, GREASE, OIL, AND CHIPS.
- PART MUST BE FREE OF SHARP EDGES, CORNERS, AND BURRS.
- APPROXIMATE WEIGHT: 23.3KG (51.4LBS)

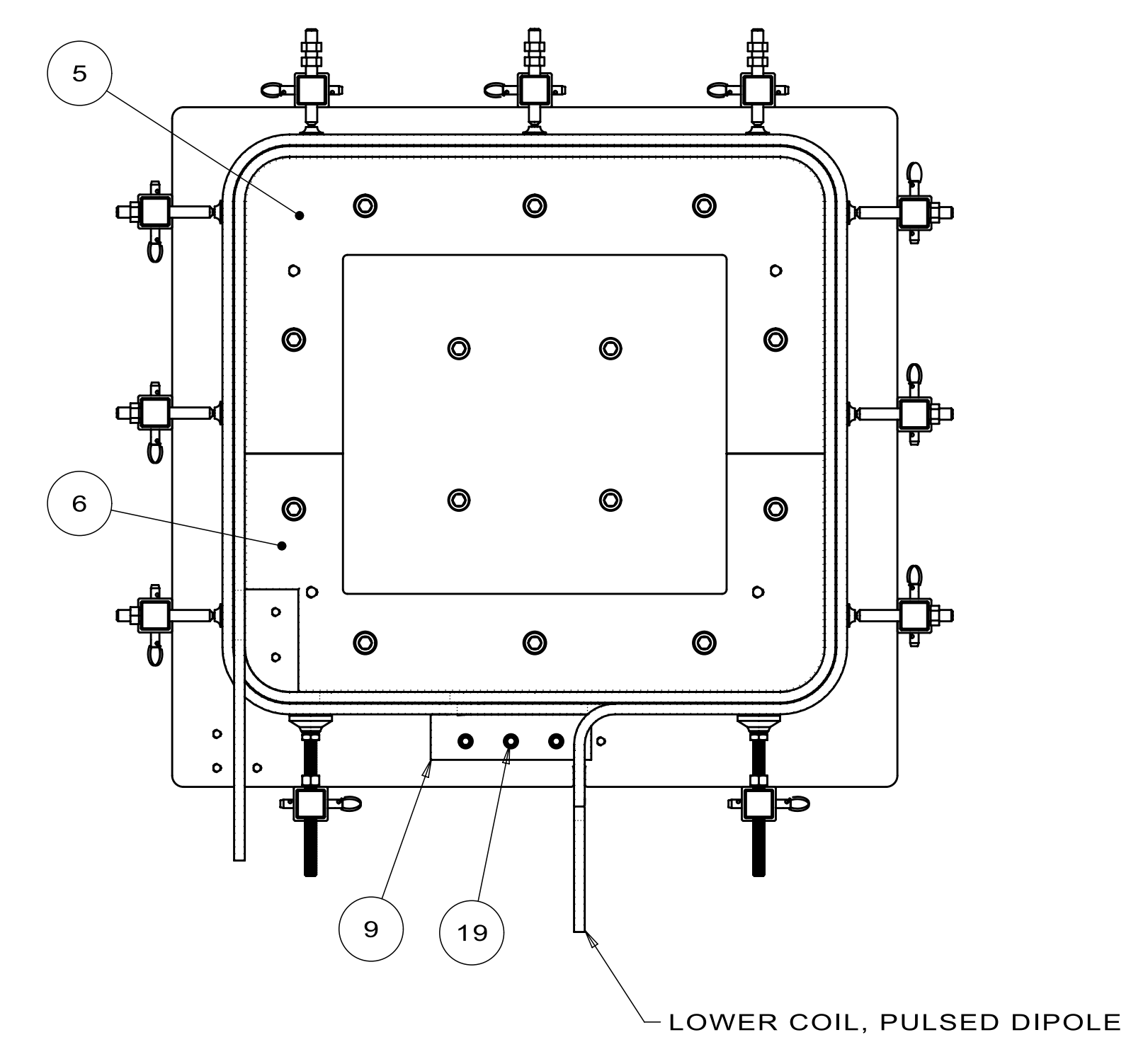
SNS S02040000-M8U-8820-A10097

UNLESS OTHERWISE SPECIFIED					DRAWN	J.VANDER MEULEN	DATE	13-Dec-2023
±X	±X.X	±X.XX	±X/X	±X'	CHECKED		DATE	
2	0.3	0.12	N/A	1'	APPROVED		DATE	
BREAK ALL SHARP EDGES, MAX: 0.5 DO NOT SCALE DRAWING DIMENSIONS BASED ON: ASME Y14.5M-2009 MAX MACHINE ALL SURFACES, Ra: 3.2 DRAWING UNITS: MM					USED ON			
 THIRD ANGLE PROJECTION					F10204164			
					MATERIAL 6061-T6 ALUMINUM			
GROUP: Technical Division - Design and Drafting					CAGE CODE: OJ5R6			

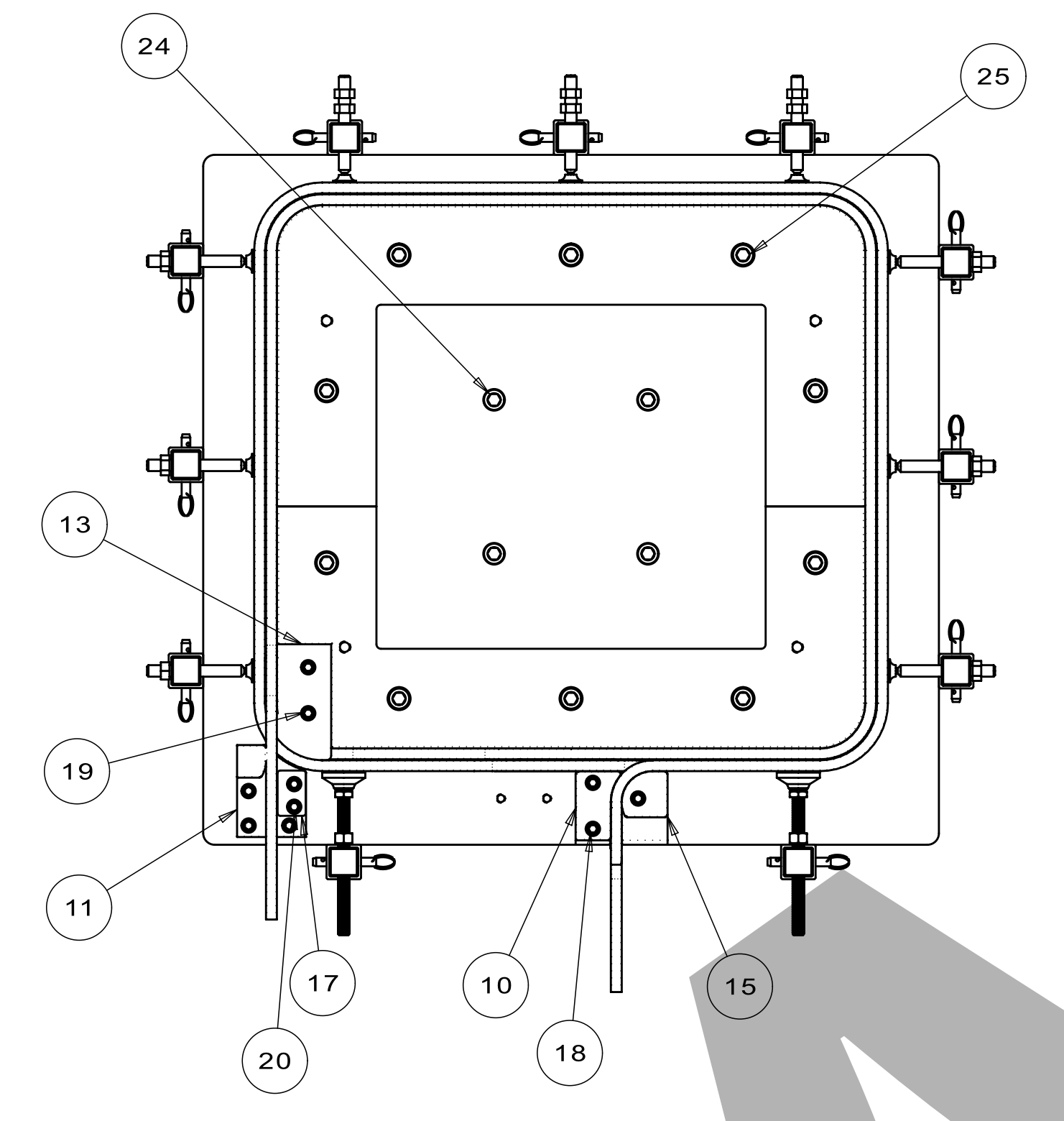
 FERMI NATIONAL ACCELERATOR LABORATORY UNITED STATES DEPARTMENT OF ENERGY			
NAME PLATE, COIL RISER, PULSED DIPOLE CURING FIXTURE, ORNL			
SCALE 1:4 & AS SHOWN	SIZE A2	DRAWING NUMBER F10204995	SHEET 1 of 1
		REV -	

TEMPLATE VERSION: 2021.08.06

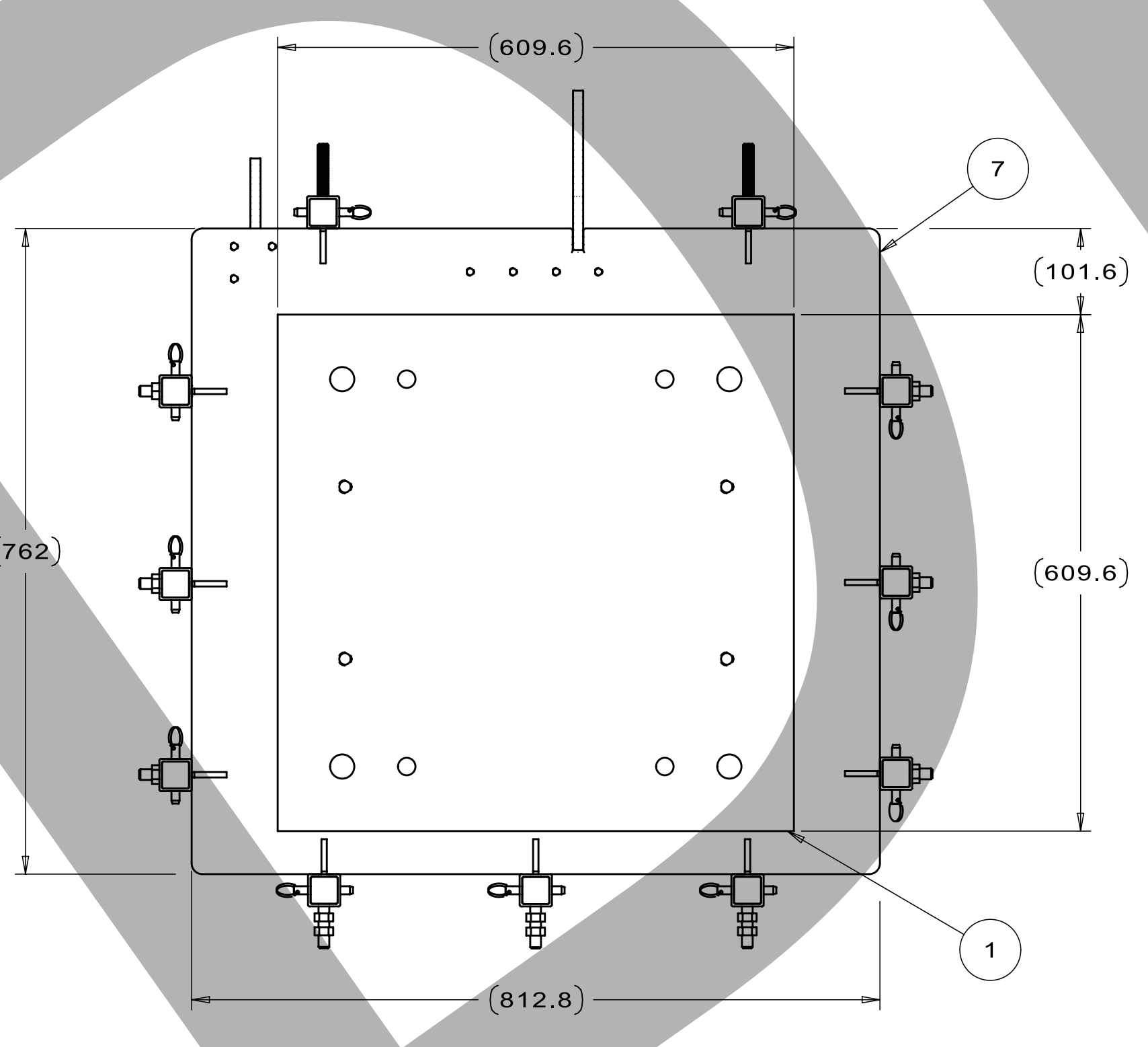
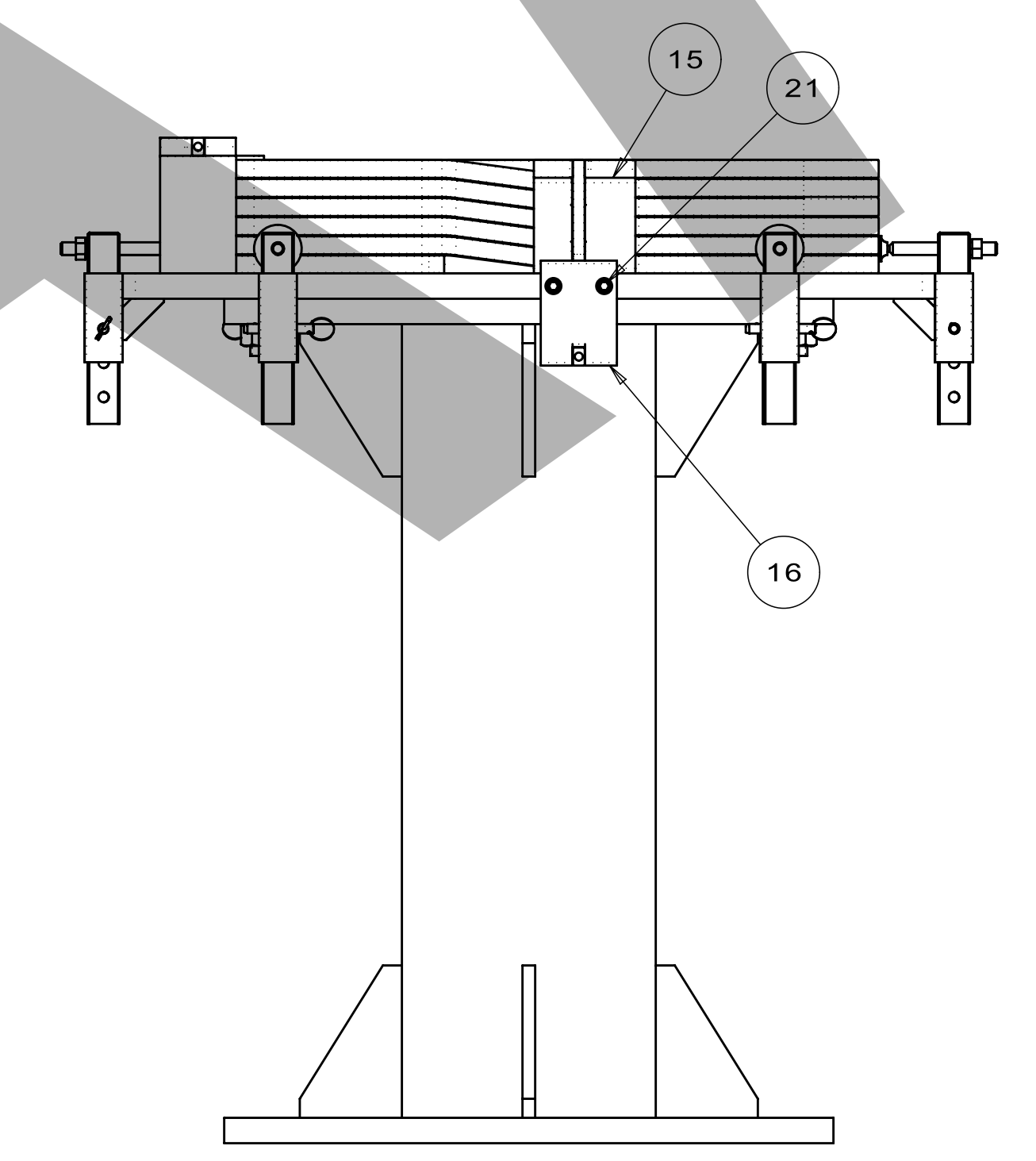
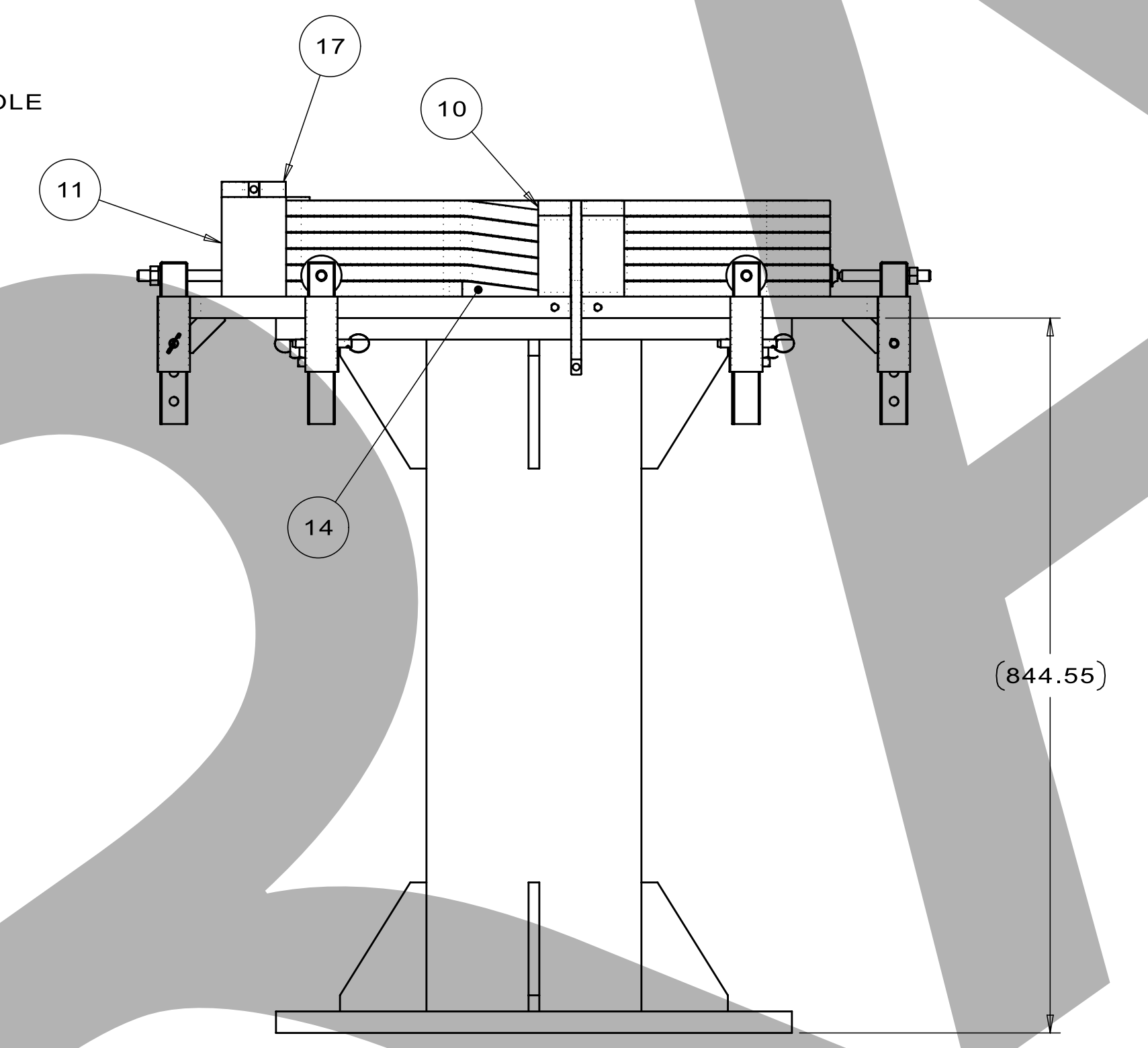
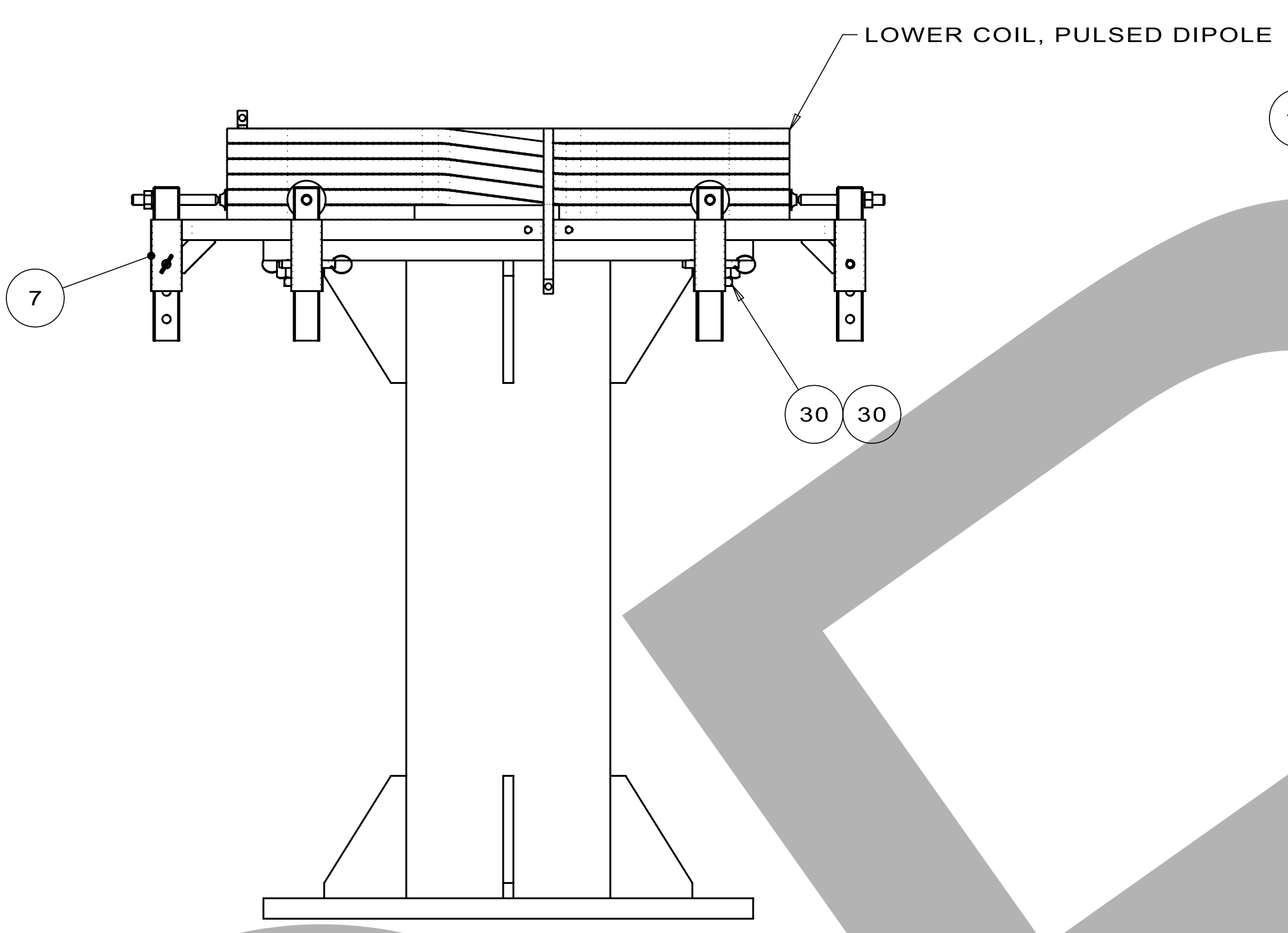
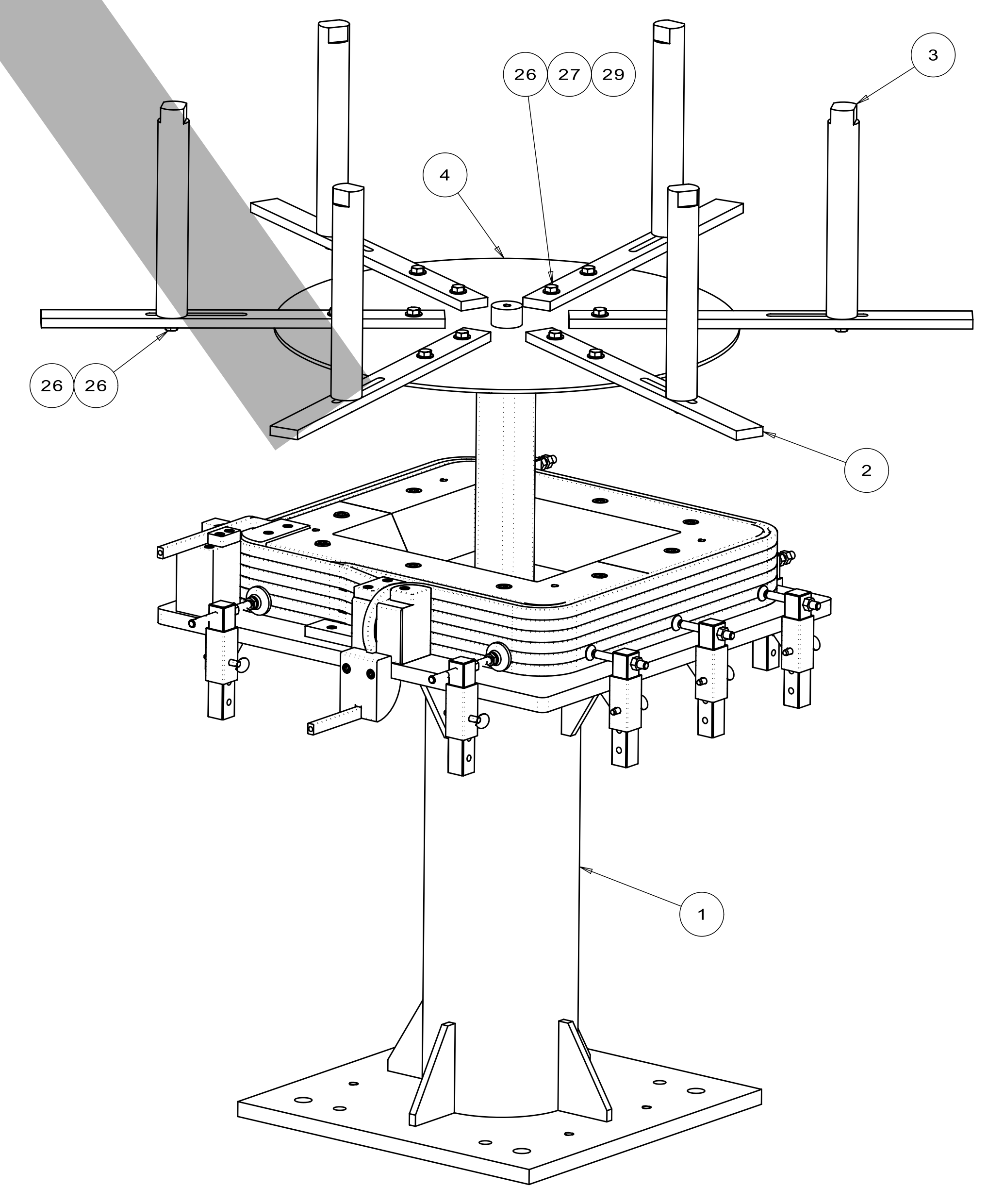
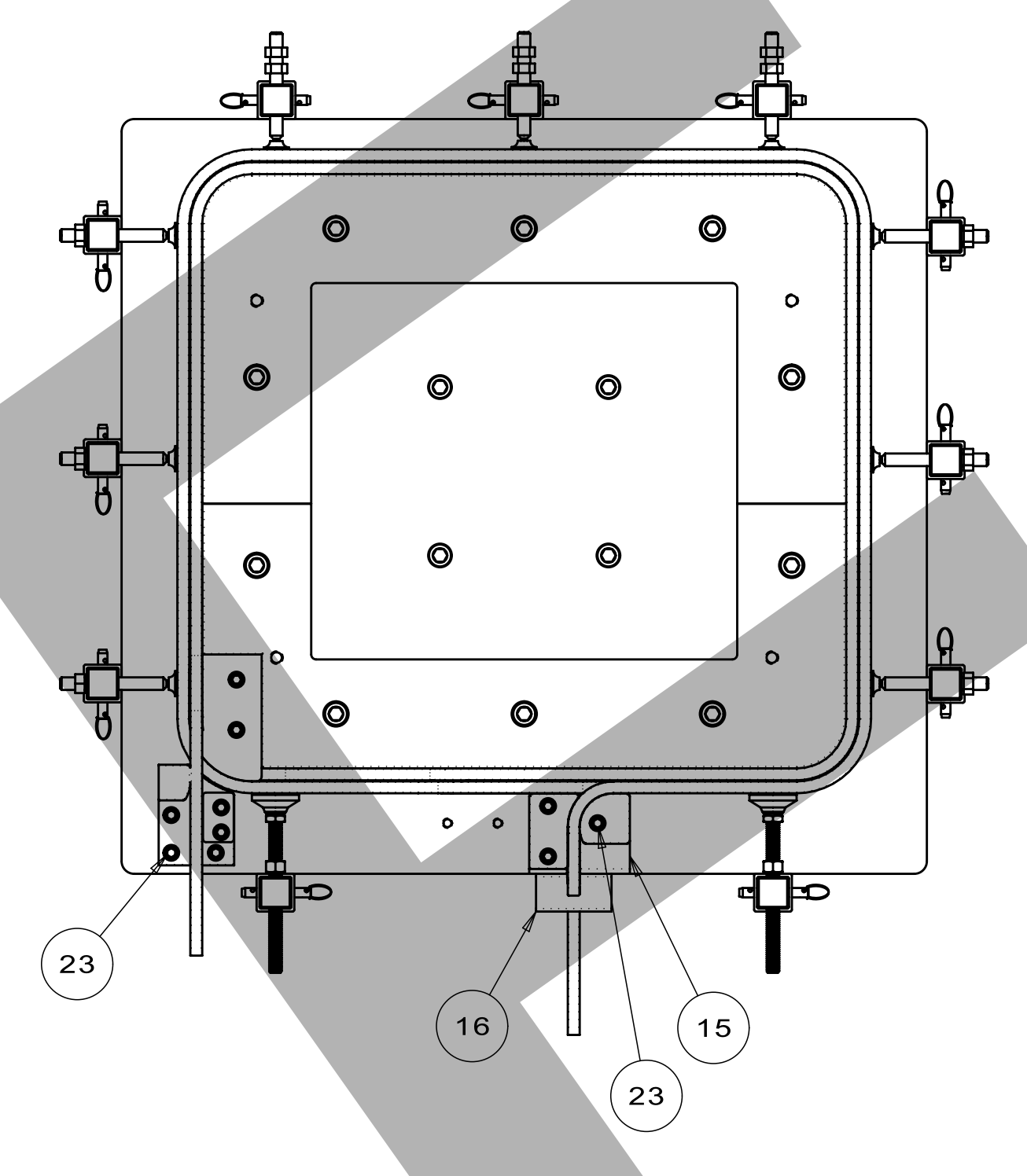
**LOWER COIL BEGINNING**  
ITEMS 1-4, 26, 27 & 29  
HIDDEN FOR CLARITY



**LOWER COIL STEP 2**  
ITEMS 1-4, 26, 27 & 29  
HIDDEN FOR CLARITY



**LOWER COIL STEP 3**  
ITEMS 1-4, 26, 27 & 29  
HIDDEN FOR CLARITY



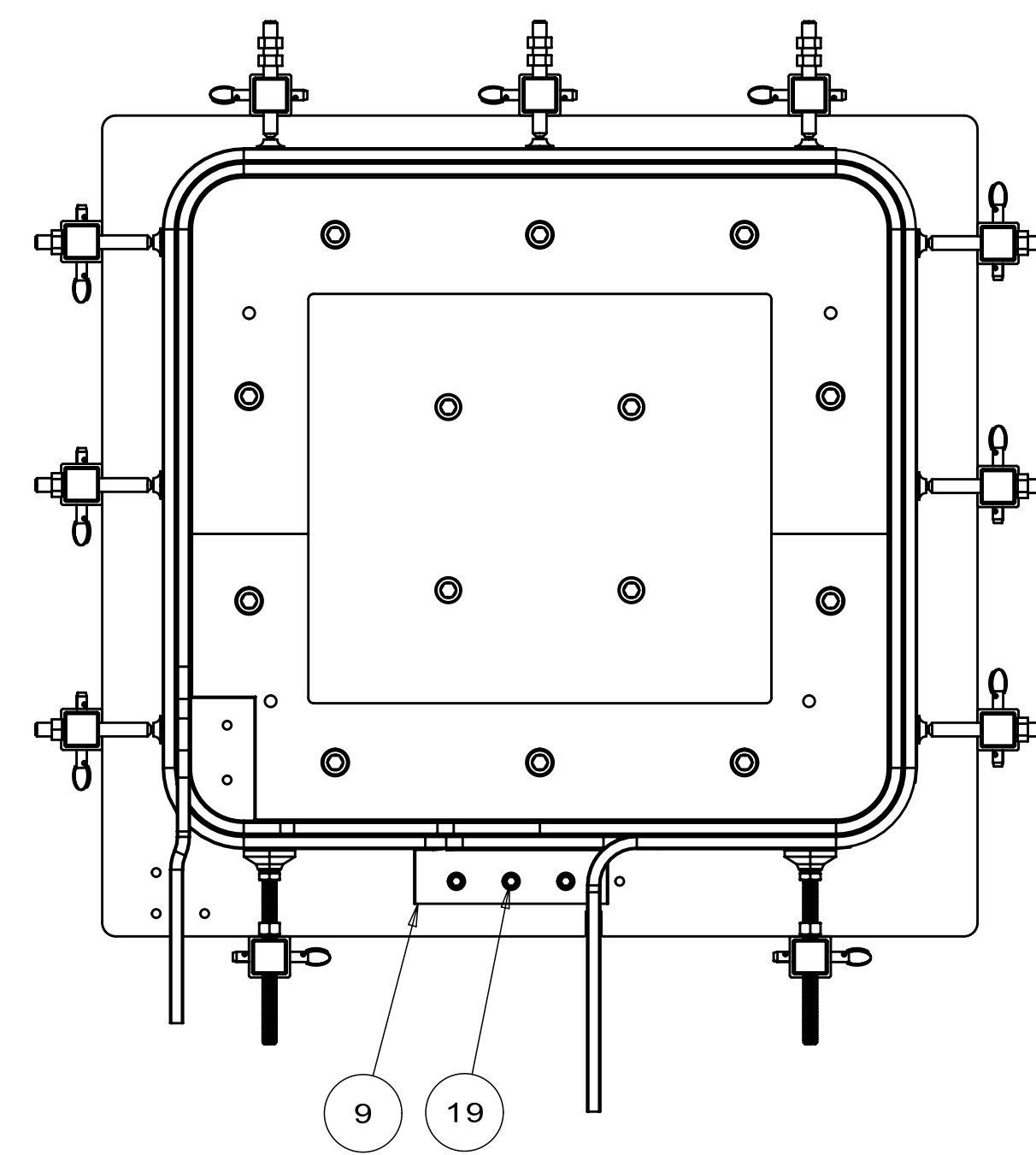
- NOTES: (UNLESS OTHERWISE SPECIFIED)
1. ASSEMBLY MUST BE FREE OF DIRT, GREASE, OIL AND CHIPS.
  2. ASSEMBLY TO BE FREE OF ALL SHARP EDGES, CORNERS AND BURRS.
  3. WINDING TO FOLLOW TRAVELER #XXXXXXX.

ITEM	FERMI #	PART NAME	QTY
30	FC0043045	HHCS, 1-8x2.5LGxFT, G8S	4
29	FC0015768	WASHER, 1/2-0.531x1.082x0.078, G8S, UC	30
28	FC0014648	NUT-HEX, 1-8x0.8594, G5S, Z	4
27	FC0014638	NUT-HEX, 1/2-13x0.4375, G5S, Z	12
26	FC0009696	HHCS, 1/2-13x2LGxFT, G8S, ZYC	18
25	FC0005357	SHCS, 5/8-11x4.75LGx1.75T, G8S, BO	10
24	FC0005345	SHCS, 5/8-11x4.75LGx1.75T, G8S, BO	4
23	FC0005182	SHCS, 3/8-16x1.25LGx1.25T, G8S, BO	4
22	FC0005179	SHCS, 3/8-16x2.25LGx1.25T, G8S, BO	1
21	FC0005171	SHCS, 3/8-16x2.25LGx1.25T, G8S, BO	2
20	FC0005168	SHCS, 3/8-16x1.5LGxFT, G8S, BO	5
19	FC0005166	SHCS, 3/8-16x1.25LGxFT, G8S, BO	5
18	FC0005164	SHCS, 3/8-16x1LGxFT, G8S, BO	2
17	F10205966	CLAMP, INNER LEAD BEND, LOWER COIL, ORNL PULSED DIPOLE WINDING	1
16	F10205948	OUTER LEAD END BEND, LOWER COIL, ORNL PULSED DIPOLE WINDING	1
15	F10205827	STAND, OUTER LEAD BEND, LOWER COIL, ORNL PULSED DIPOLE WINDING	1
14	F10205821	SPACE SAVER, OUTER TRANSITION, ORNL PULSED DIPOLE WINDING	1
13	F10205761	EXTENTION, CENTER BLOCK RH, ORNL PULSED DIPOLE WINDING	1
12	F10205754	CLAMP, INNER LEAD BEND, UPPER COIL, ORNL PULSED DIPOLE WINDING	1
11	F10205753	STAND, INNER LEAD BEND, ORNL PULSED DIPOLE WINDING	1
10	F10205743	CLAMP, OUTER LEAD EXIT, ORNL PULSED DIPOLE WINDING	1
9	F10205552	WEDGE, OUTER LAYER TRANSITION, ORNL PULSED DIPOLE WINDING	1
8	F10205551	STAND, OUTER LEAD BEND, UPPER COIL, ORNL PULSED DIPOLE WINDING	1
7	F10205310	CLAMPING ASSEMBLY, PULSED DIPOLE WINDING, ORNL STS	1
6	F10205216	CENTER BLOCK RH, PULSED DIPOLE WINDING, ORNL STS	1
5	F10205215	CENTER BLOCK LH, PULSED DIPOLE WINDING, ORNL STS	1
4	F10132248	SPOOL RACK WELDMENT, ORNL CHICANE	1
3	F10176786	ROD, SPOOL RACK, ORNL CHICANE	6
2	F10176731	BAR, SPOOL RACK, ORNL CHICANE	6
1	F00369767	LHC IR QUAD LONG TOOLING COLDMASS/CRYOSTAT STATION 33.25" SUPPORT STAND	1

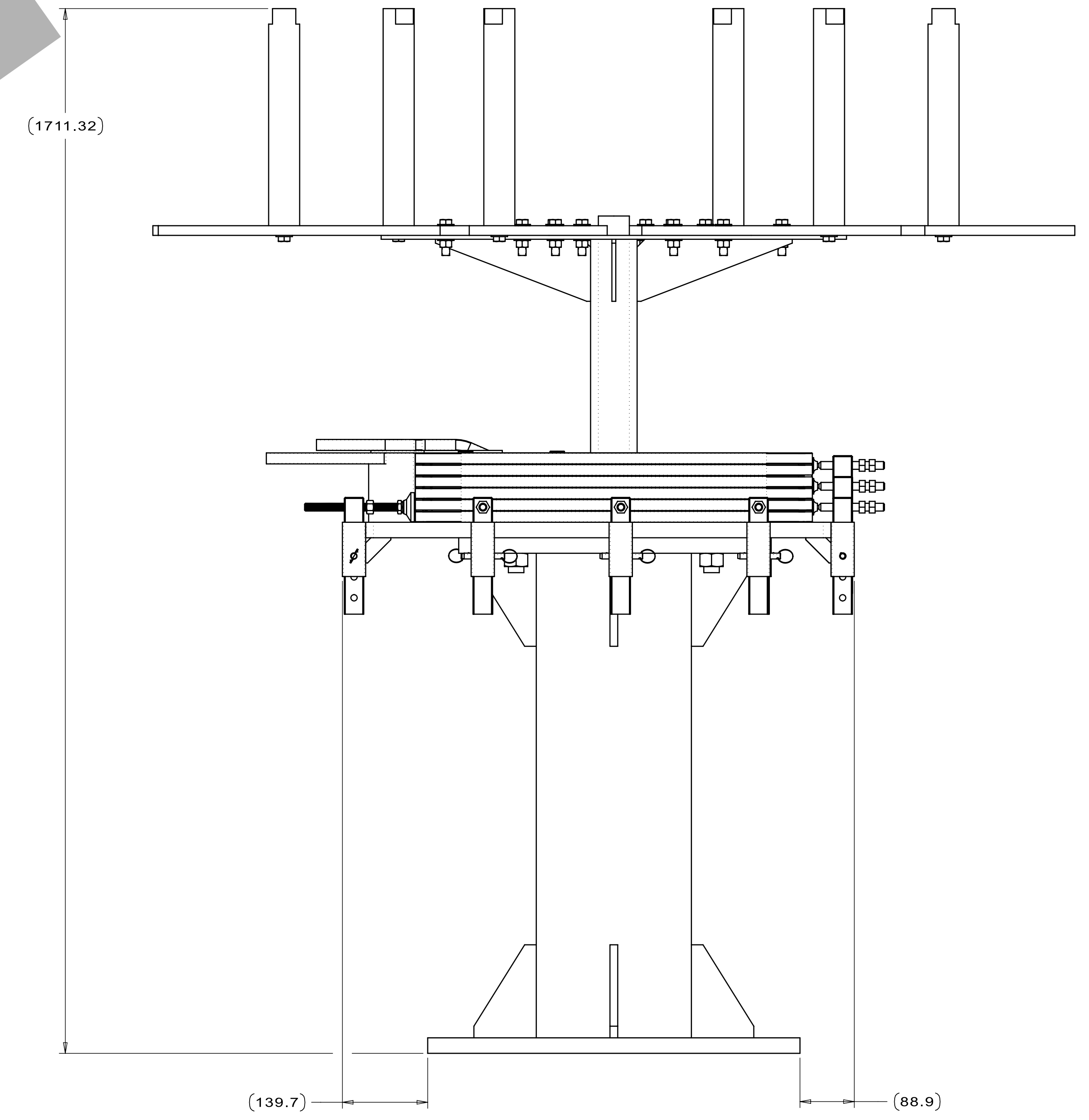
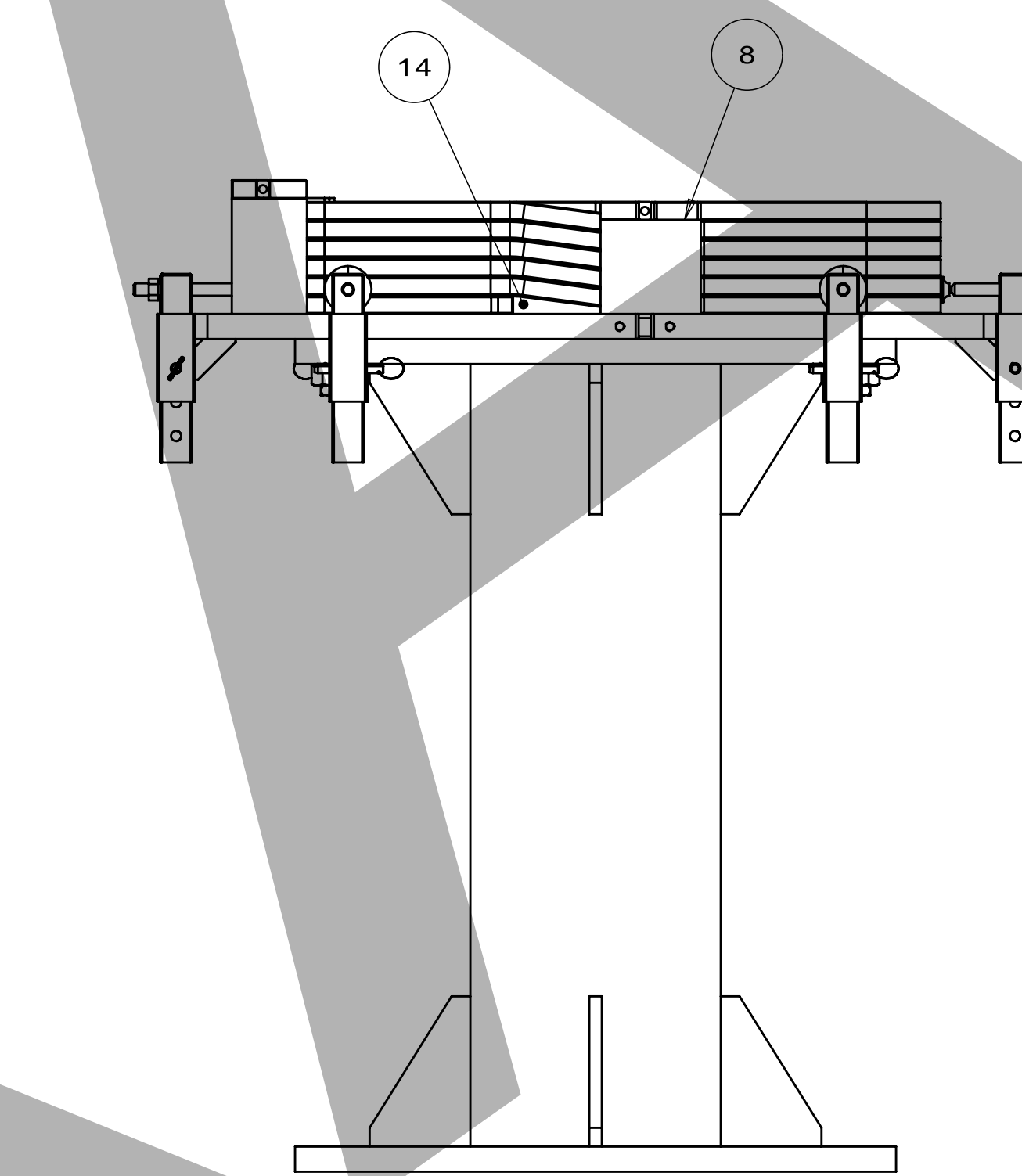
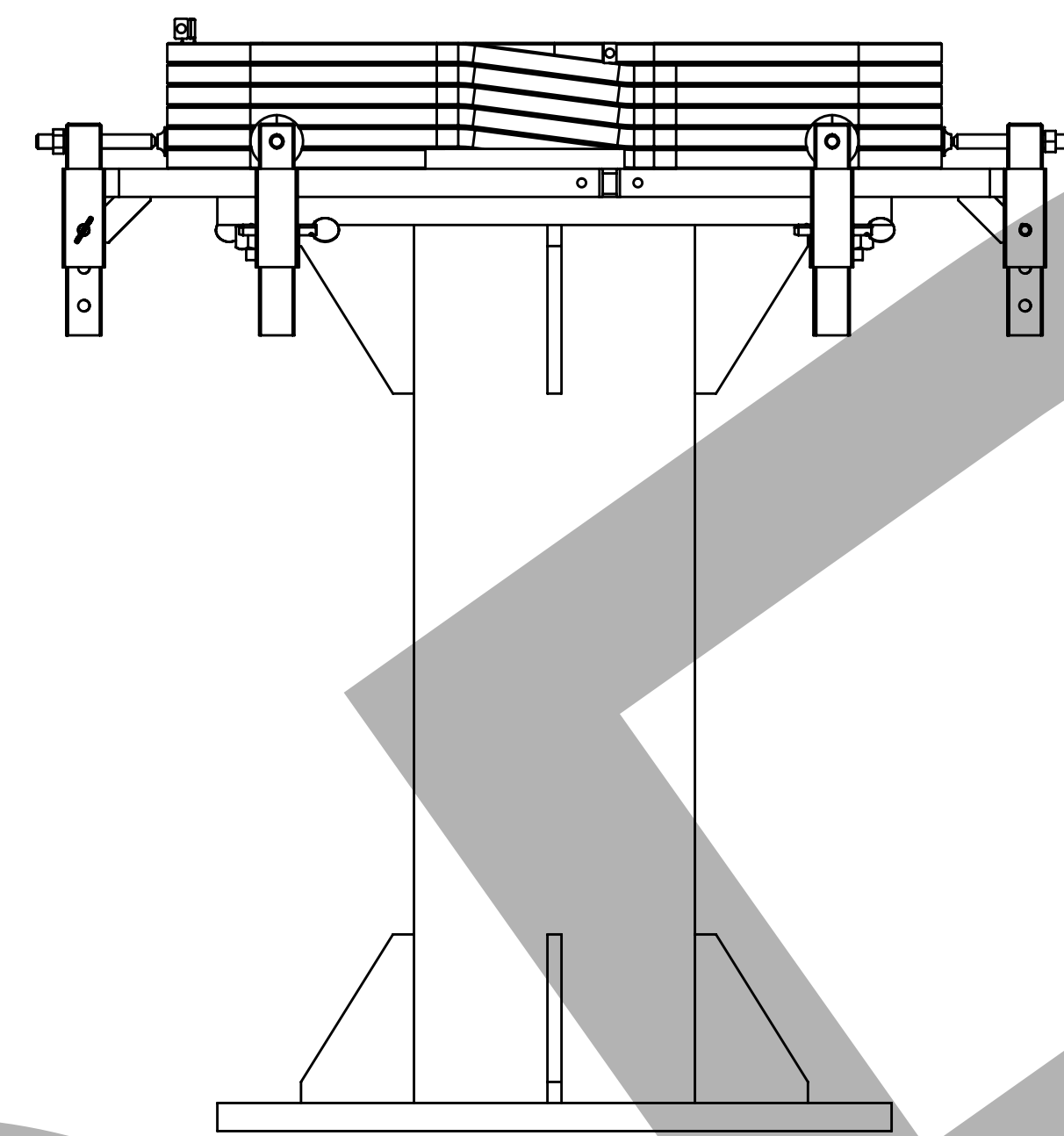
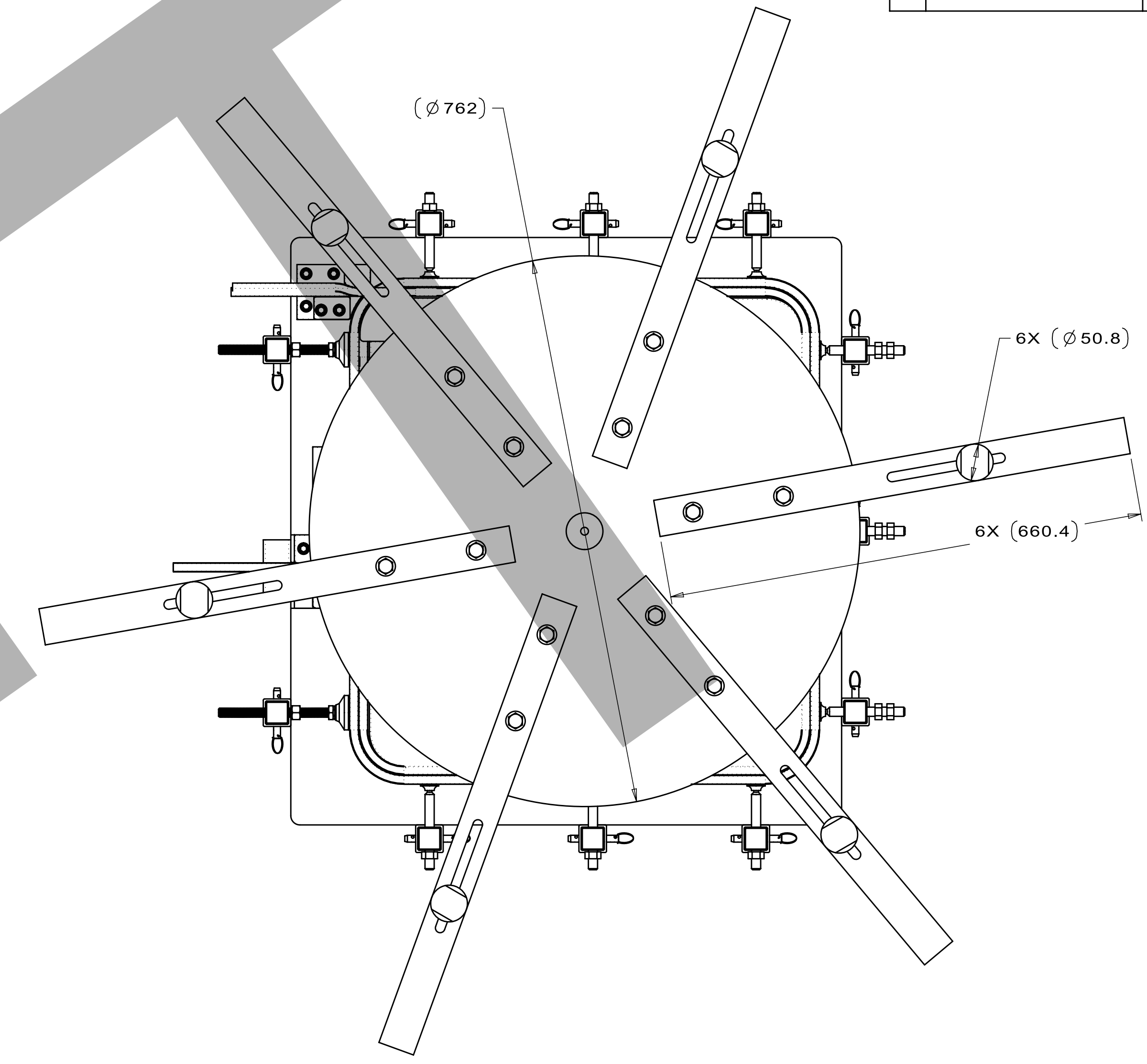
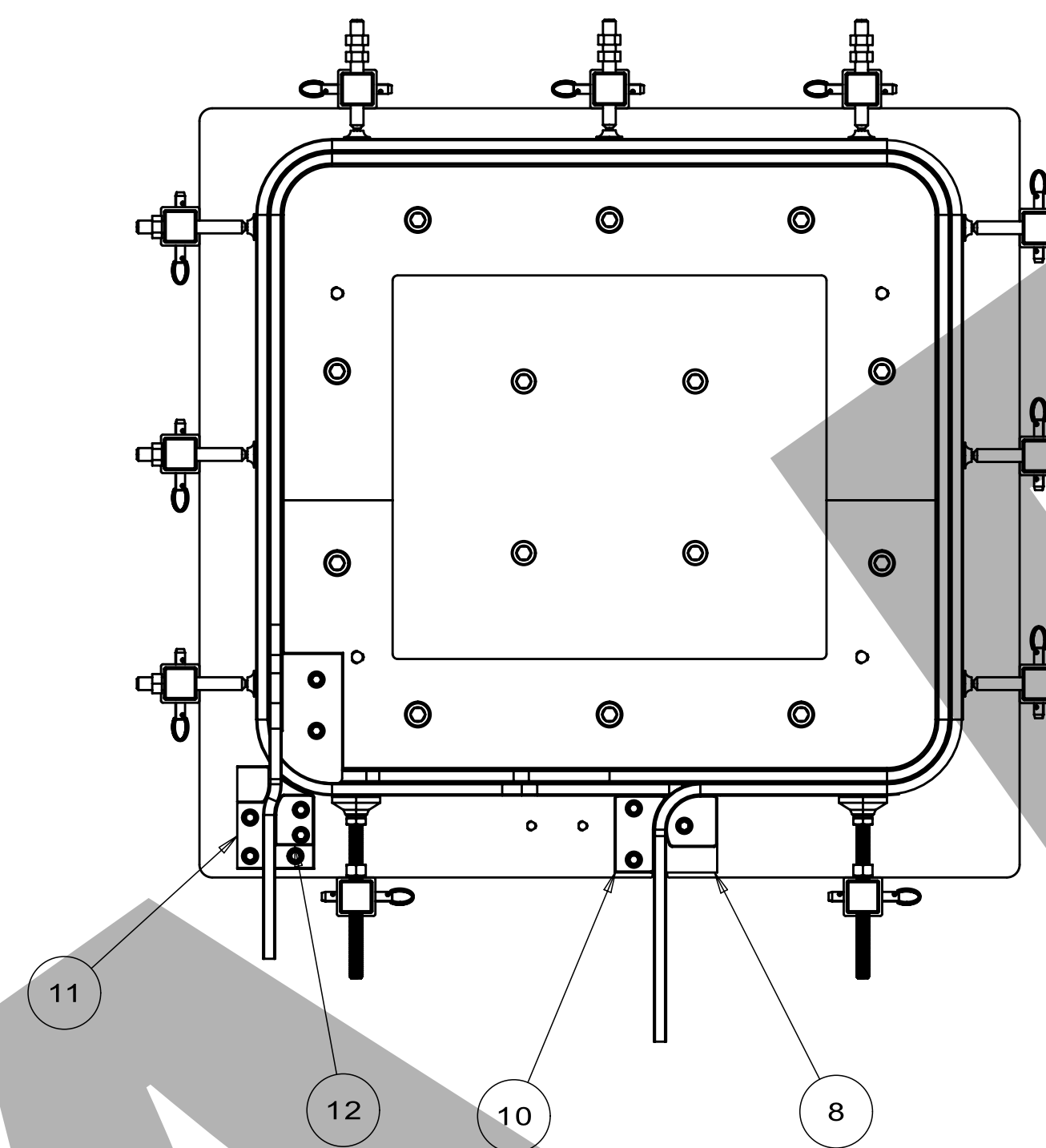
UNLESS OTHERWISE SPECIFIED		DESIGN	J VANDER MEULEN	DATE	27-Mar-2024
BY	AKK	CHKD		DATE	
2	S3	S12	NA	1	
DO NOT SCALE DRAWING		DIMENSIONS BASED ON ASME Y14.36-2009			
MAX MACHINE ALL SURFACES, Ra: 3.2		DRAWING UNITS: MM			
TOLERANCE DECIMAL: 0.251, 0.502		TOLERANCE ANGLES: 0.125, 0.25			
MATERIAL		SEE PARTS LIST		SCALE 1:6 & AS SHOWN	
FINISH		SEE PARTS LIST		DRAWING NUMBER F10205208	
TYPICAL ANGLE PROTECTION		SEE PARTS LIST		SHEET 1 of 2	
TYPICAL ANGLE PROTECTION		SEE PARTS LIST		REV -	

REV	REVISION CONTROL DOCUMENT	DATES	DESIGN	SIGNATURES
-	F10205208--RCD		APPROVED	

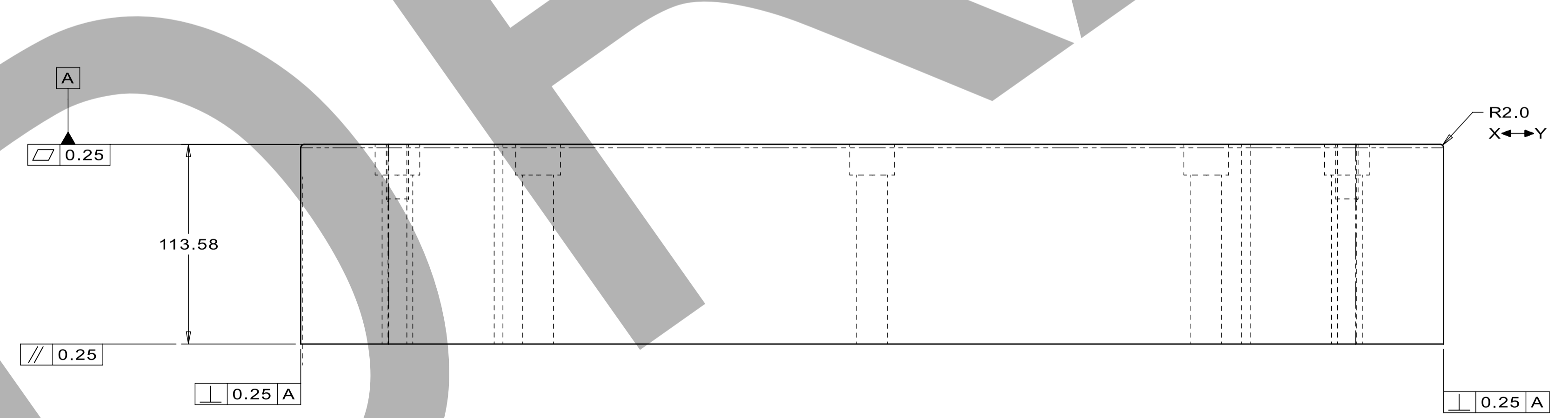
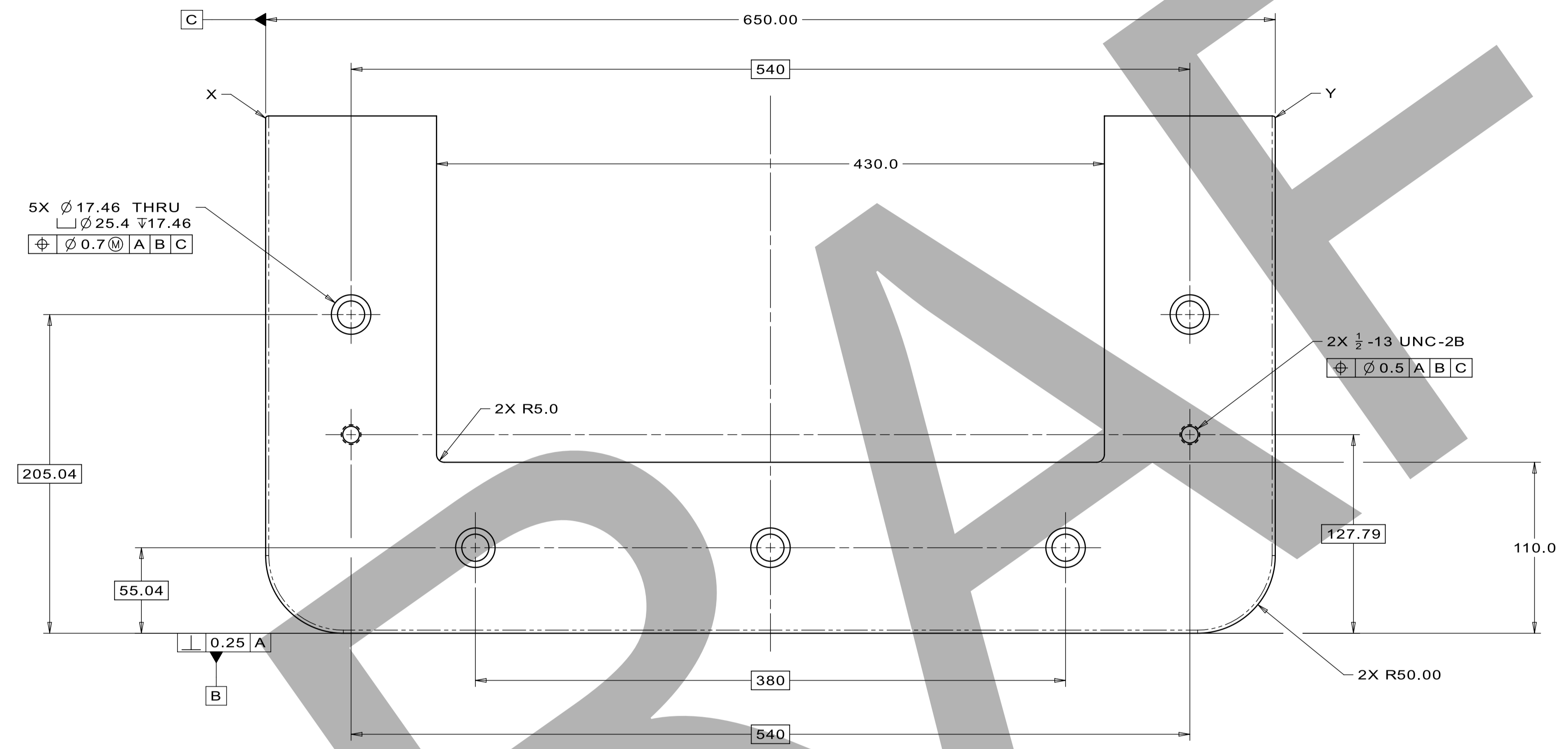
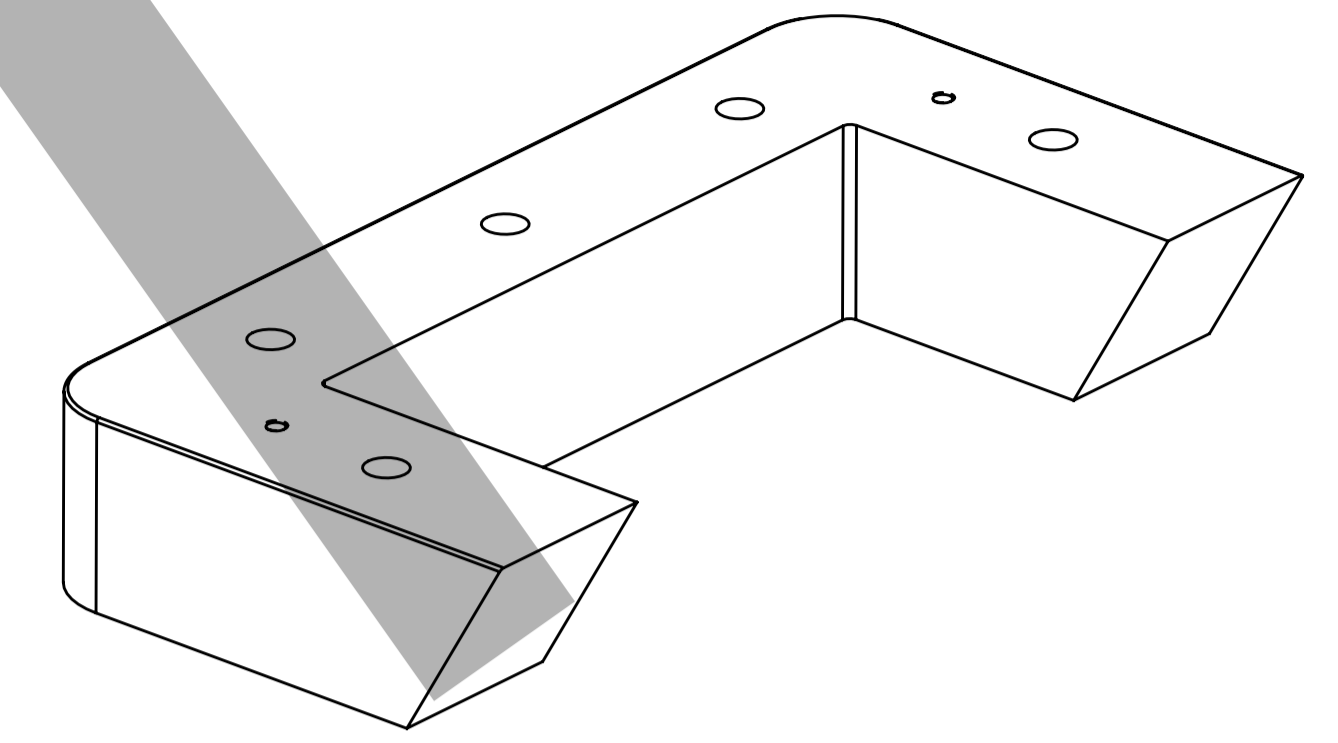
UPPER COIL BEGINNING  
ITEMS 1-4, 26, 27 & 29  
HIDDEN FOR CLARITY



UPPER COIL END  
ITEMS 1-4, 26, 27 & 29  
HIDDEN FOR CLARITY



REV	REVISION CONTROL DOCUMENT	DATES	SIGNATURES
-	F10205215--RCD		



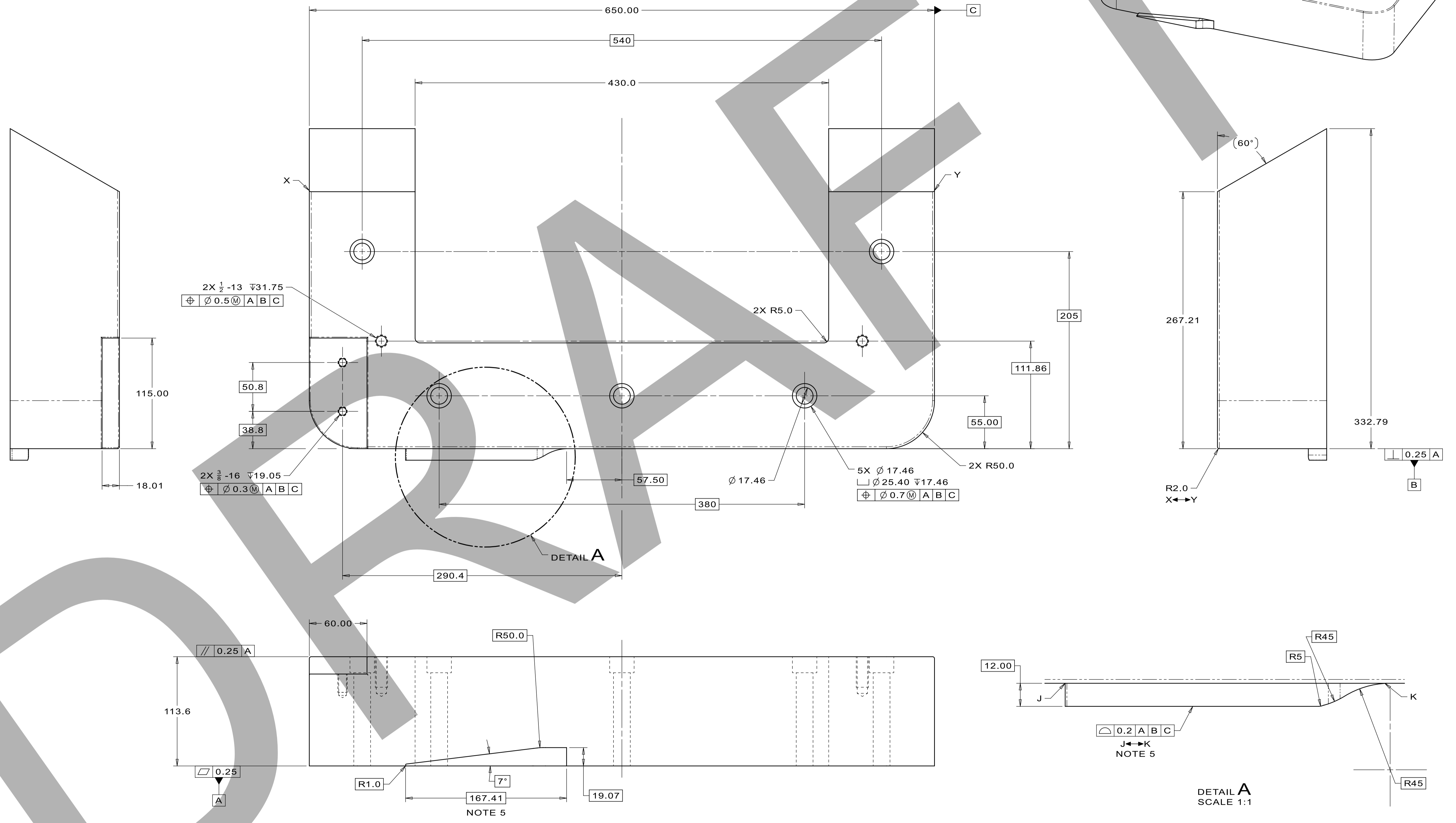
- NOTES: (UNLESS OTHERWISE SPECIFIED)
- PART MUST BE FREE OF DIRT, GREASE, OIL AND CHIPS.
  - PART TO BE FREE OF ALL SHARP EDGES, CORNERS AND BURRS.
  - TRAILING ZEROS DENOTE TOLERANCE.
  - APPROXIMATE WEIGHT 98.7 KG (217.5 LBS).

UNLESS OTHERWISE SPECIFIED					DRAWN	J.VANDER MEULEN	DATE	15-Nov-2023
±X	±X	±XX	±XX	±X"	CHECKED		DATE	
2	0.3	0.12	N/A	1"	APPROVED		DATE	
BREAK ALL SHARP EDGES, MAX: 0.5 DO NOT SCALE DRAWING DIMENSIONS BASED ON: ASME Y14.5M-2009 MAX MACHINE ALL SURFACES, Ra: 3.2 DRAWING UNITS: MM					USED ON		F10205208	
MATERIAL					ASTM A36 STEEL, UNS K02600		SCALE	
GROUP: Technical Division - Design and Drafting					CAGE CODE: OUSR6		1:2	
THIRD ANGLE PROJECTION					DRAWING NUMBER		F10205215	
					SHEET		1 OF 1	
					REV		-	

SNS | S02040000-M8U-8820-A10062

TEMPLATE VERSION: 2021.08.02

REV	REVISION CONTROL DOCUMENT	DATES	DRAWN	SIGNATURES
-	F10205216--RCD		APPROVED	



- NOTES: (UNLESS OTHERWISE SPECIFIED)
- PART MUST BE FREE OF DIRT, GREASE, OIL AND CHIPS.
  - PART TO BE FREE OF ALL SHARP EDGES, CORNERS AND BURRS.
  - TRAILING ZEROS DENOTE TOLERANCE.
  - APPROXIMATE WEIGHT: 98 KG (216 LBS)
  - REFER TO CAD MODEL FOR RAMP SHOWN IN DETAIL A.

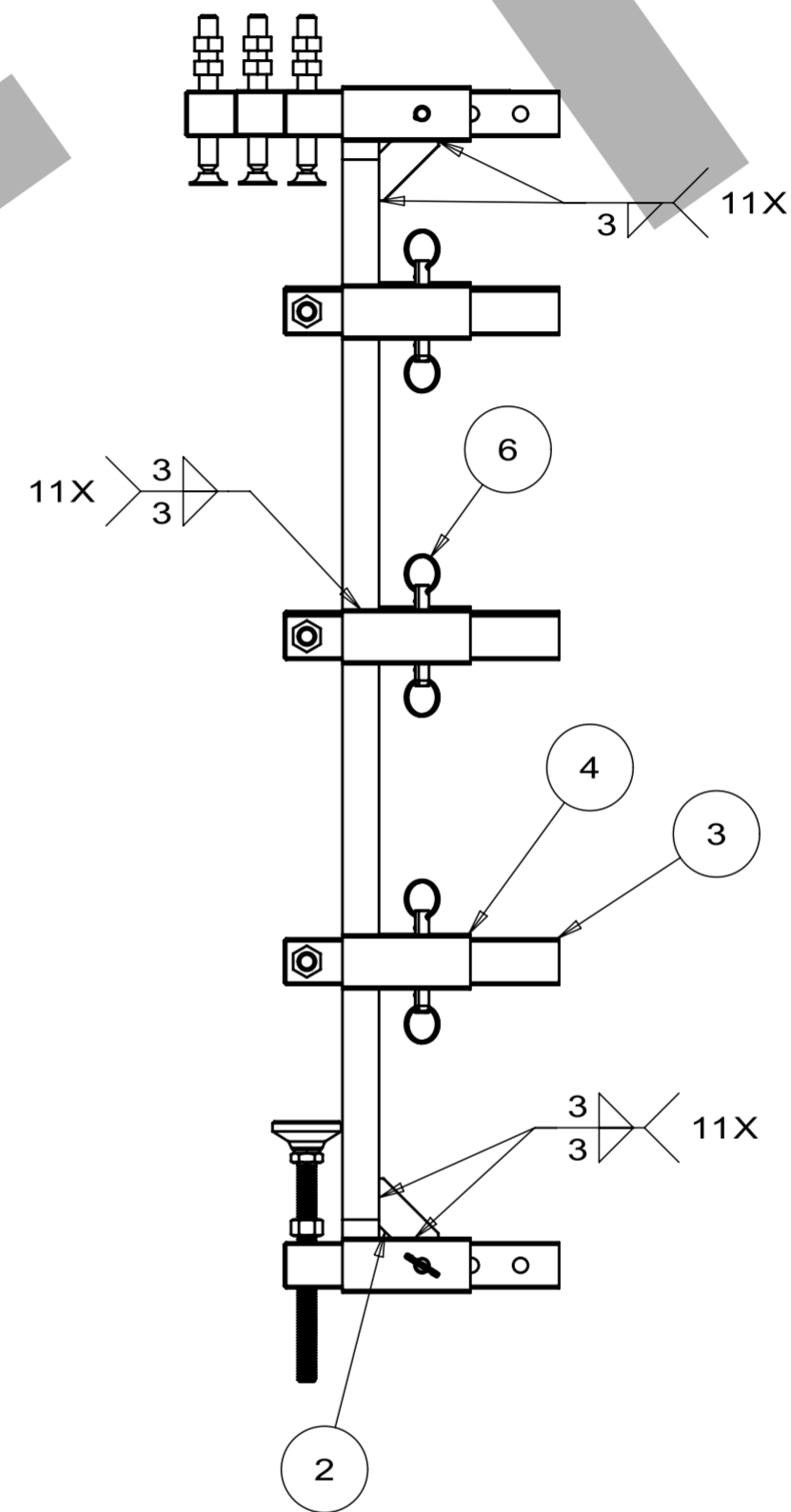
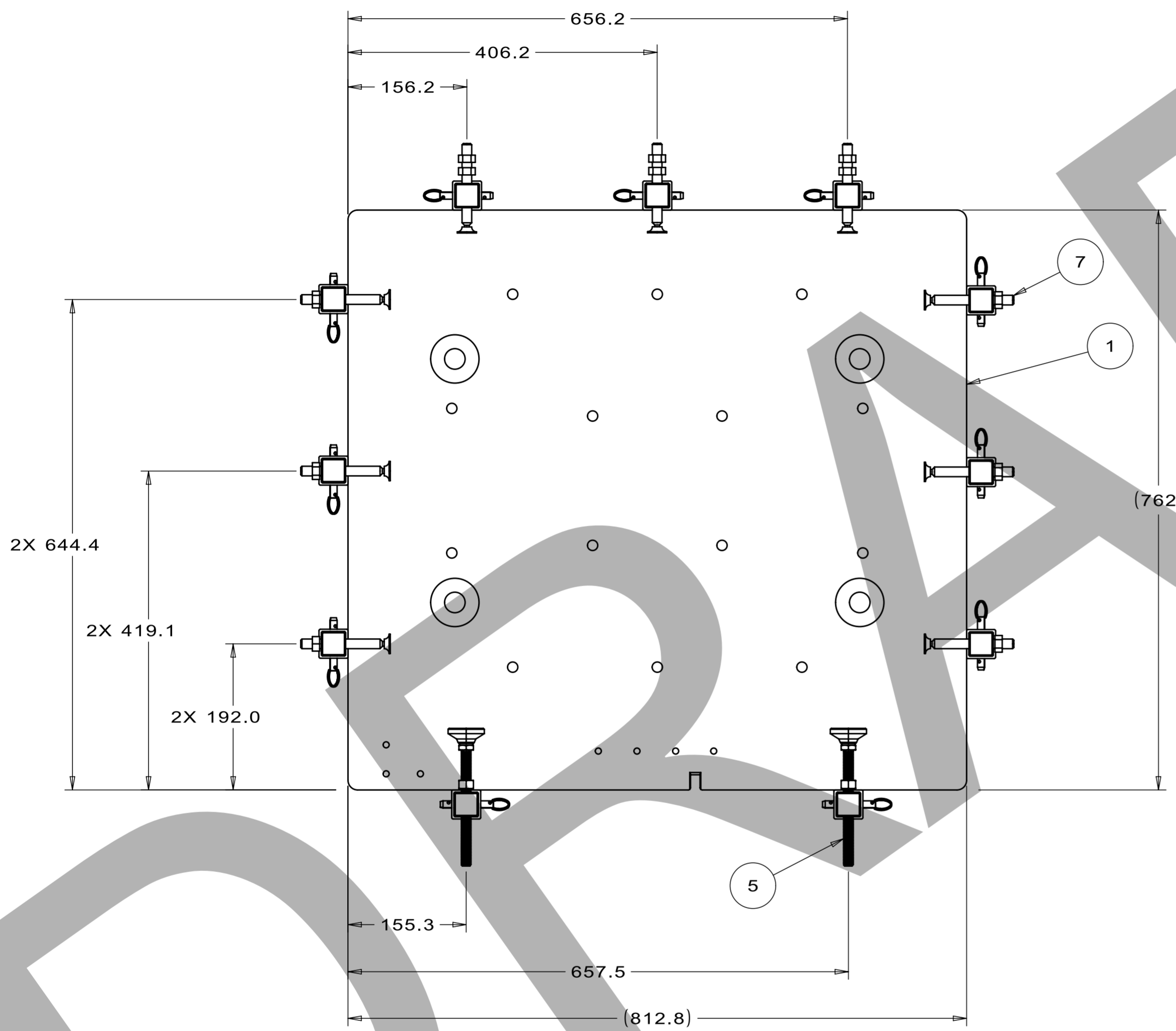
UNLESS OTHERWISE SPECIFIED				DRAWN	J.VANDER MEULEN	DATE	15-Nov-2023
±X	±XX	±XXX	±X'	CHECKED		DATE	
2	0.3	0.12	N/A	APPROVED		DATE	
BREAK ALL SHARP EDGES, MAX: 0.5 DO NOT SCALE DRAWING DIMENSIONS BASED ON: ASME Y14.5M-2009 MAX MACHINE ALL SURFACES, Ra: 3.2 DRAWING UNITS: MM				USED ON		F10205208	
MATERIAL				ASTM A36 STEEL, UNS K02600			
GROUP: Technical Division - Design and Drafting				CAGE CODE: OUSR6			
SCALE		1:2 & AS SHOWN	SIZE	DRAWING NUMBER		F10205216	
SHEET		1 OF 1		REV		-	

SNS | S02040000-M8U-8820-A10063

TEMPLATE VERSION: 2021.08.02



REV	REVISION CONTROL DOCUMENT	DATES	SIGNATURES
-	F10205310--RCD		DRAWN APPROVED



NOTES:(UNLESS OTHERWISE SPECIFIED)

- PART MUST BE FREE OF DIRT, GREASE, OIL AND CHIPS.
- PART TO BE FREE OF ALL SHARP EDGES, CORNERS, AND BURRS.
- TRAILING ZEROS DENOTE TOLERANCE.

ITEM	FERMI NO	PART NAME	QTY
7	FC0111383	SPINDLE ASSEMBLY, 1/2"-13, 4.6"LG STEEL	9
6	FC0083003	QUICK RELEASE PIN, 3/8" OD, 2" LENGTH, SS316	11
5	FC0076852	SWIVEL LEVELING MOUNT, 1/2"-13 THREAD, STEEL	2
4	F10205422	SQUARE TUBE B, CLAMPING TOOL, ORNL PULSED DIPOLE WINDING	11
3	F10205420	INSERT B, CLAMPING TOOL, ORNL PULSED DIPOLE WINDING	11
2	F10205312	GUSSET, PULSED DIPOLE WINDING, ORNL STS	11
1	F10205311	BASE PLATE, PULSED DIPOLE WINDING, ORNL STS	1

UNLESS OTHERWISE SPECIFIED					DRAWN	J.VANDER MEULEN	DATE	20-Nov-2023
±X	±X.X	±X.XX	±X/X	±X'	CHECKED		DATE	
2	0.3	0.12	N/A	1'	APPROVED		DATE	

BREAK ALL SHARP EDGES, MAX: 0.5  
 DO NOT SCALE DRAWING  
 DIMENSIONS BASED ON: ASME Y14.5M-2009  
 MAX MACHINE ALL SURFACES, Ra: 3.2  
 DRAWING UNITS: MM

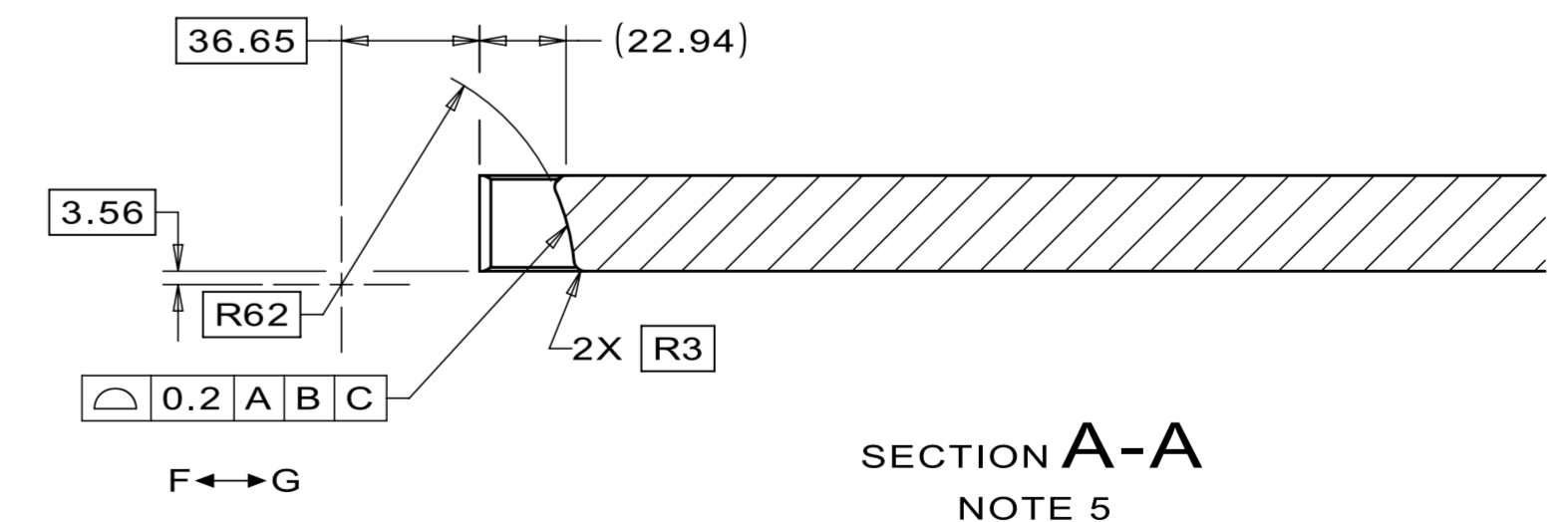
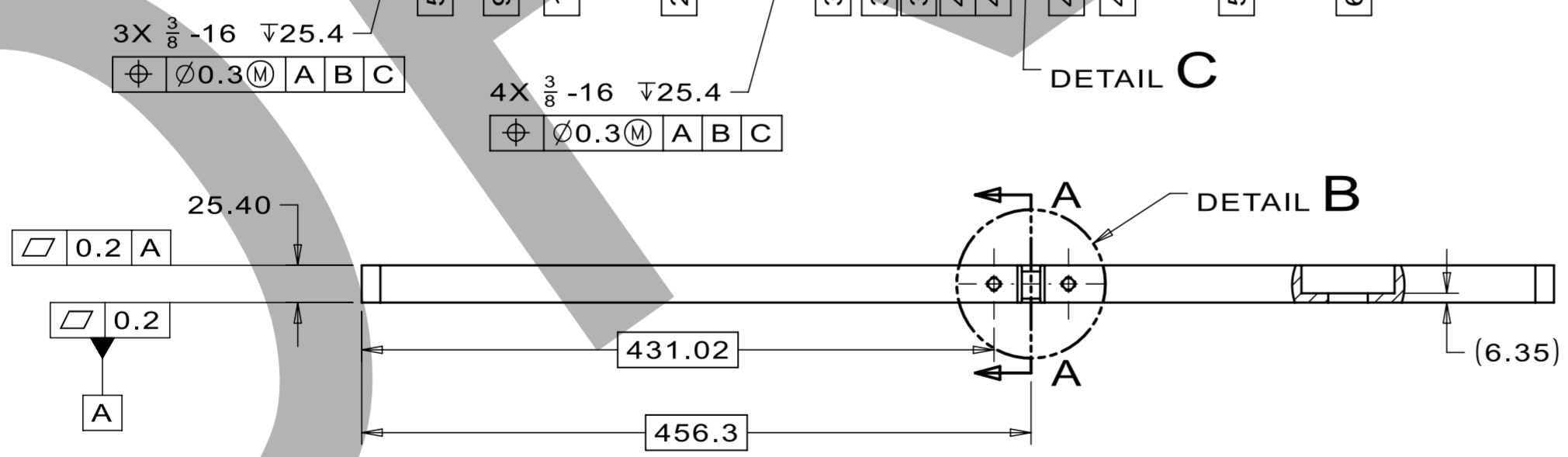
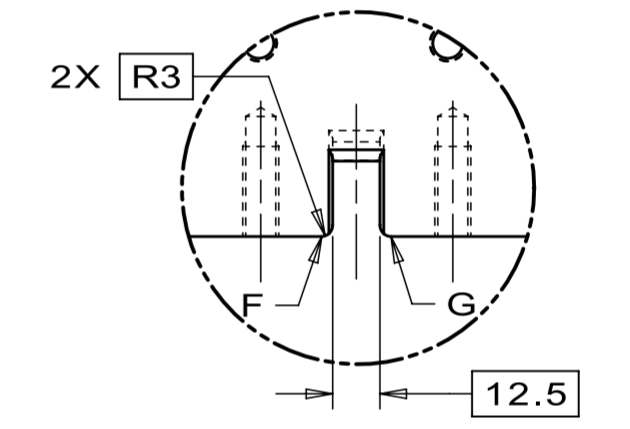
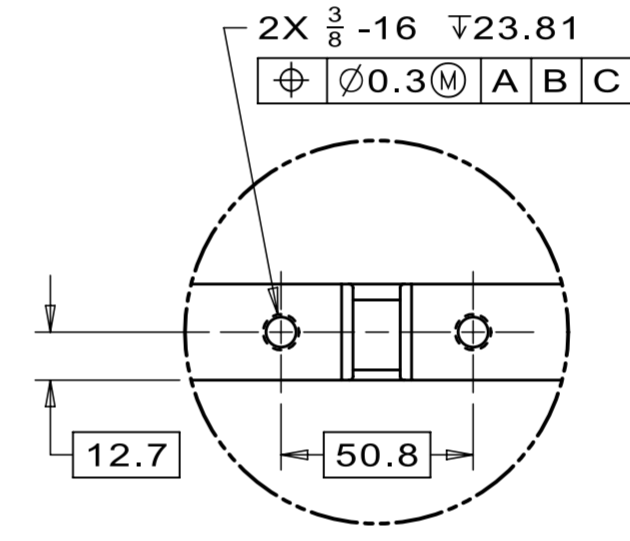
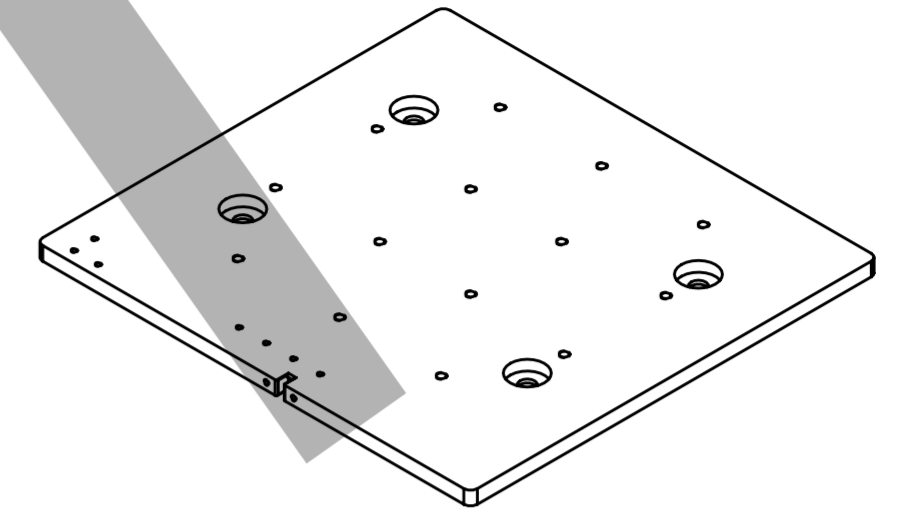
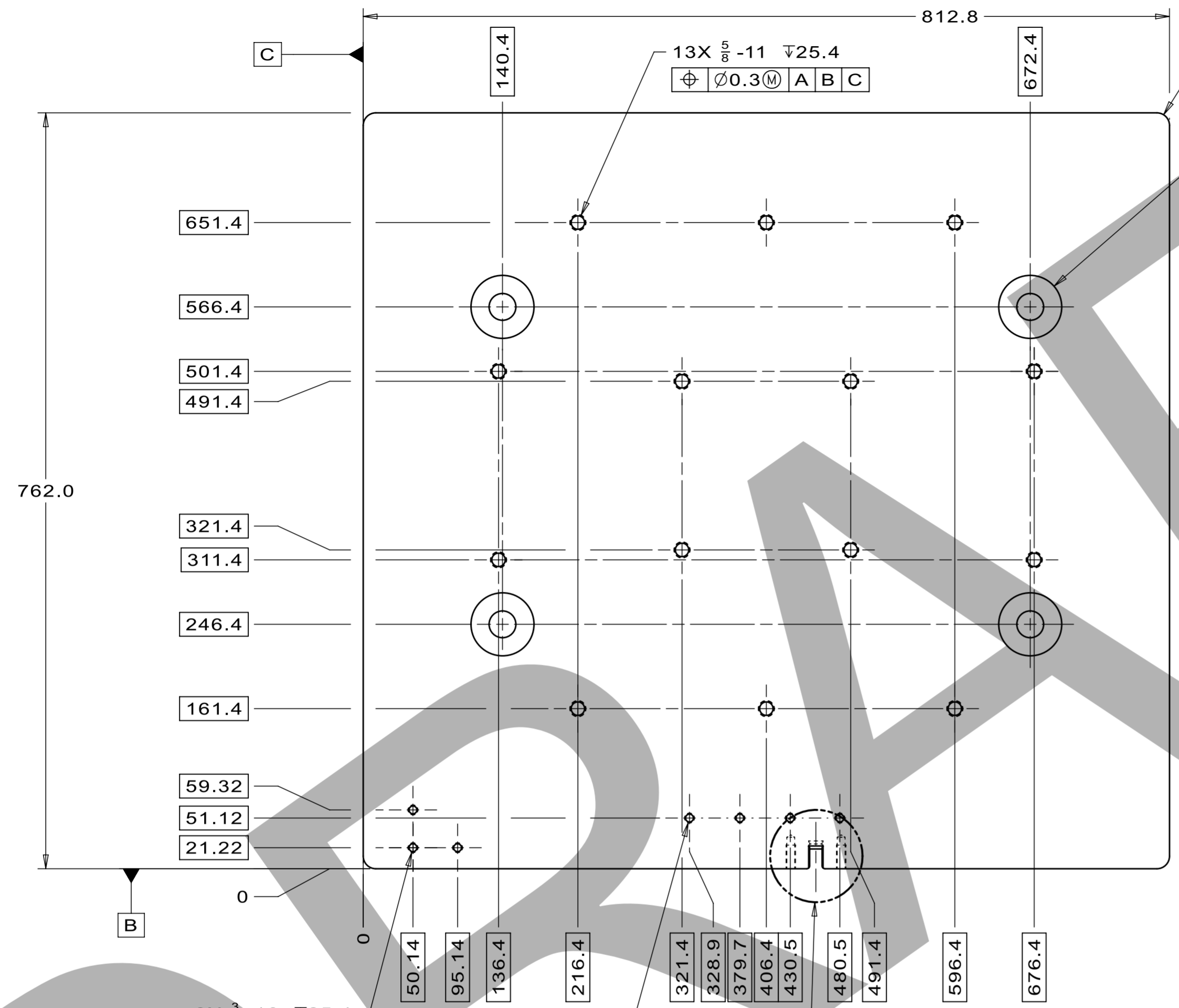
THIRD ANGLE PROJECTION

 <b>FERMI NATIONAL ACCELERATOR LABORATORY</b> UNITED STATES DEPARTMENT OF ENERGY			
<b>CLAMPING ASSEMBLY, PULSED DIPOLE WINDING, ORNL STS</b>			
SCALE 1:5	SIZE A2	DRAWING NUMBER F10205310	SHEET 1 of 1
GROUP: Technical Division - Design and Drafting		CAGE CODE: OJ5R6	REV -

SNS S02040000-M8U-8820-A10064

TEMPLATE VERSION: 2021.08.06

REV	REVISION CONTROL DOCUMENT	DATES	SIGNATURES
-	F10205311--RCD		DRAWN APPROVED



- NOTES (UNLESS OTHERWISE SPECIFIED):
- PART MUST BE FREE OF DIRT, GREASE, OIL AND CHIPS.
  - PART TO BE FREE OF ALL SHARP EDGES, CORNERS, AND BURRS.
  - TRAILING ZEROS DENOTE TOLERANCE.
  - APPROXIMATE WEIGHT 119.4 KG (263.3 LBS).
  - REFER TO CAD MODEL FOR SLOT SHOWN IN DETAILS AND SECTION VIEWS.

SNS S0204000-M8U-8820-A10065

UNLESS OTHERWISE SPECIFIED					DRAWN	J.VANDER MEULEN	DATE	15-Nov-2023
$\pm X.X$	$\pm X.XX$	$\pm X.XXX$	$\pm X/100$	$\pm X'$	CHECKED		DATE	
2	0.3	0.12	N/A	1'	APPROVED		DATE	
BREAK ALL SHARP EDGES, MAX: 0.5 DO NOT SCALE DRAWING DIMENSIONS BASED ON: ASME Y14.5M-2009 MAX MACHINE ALL SURFACES, Ra: 3.2 DRAWING UNITS: MM					USED ON			
<p>THIRD ANGLE PROJECTION</p>					F10205310			
					MATERIAL			
					CARBON STEEL ALLOY, CLASS 12.9			
GROUP: Technical Division - Design and Drafting					CAGE CODE: OJ5R6			

<p>FERMI NATIONAL ACCELERATOR LABORATORY          UNITED STATES DEPARTMENT OF ENERGY</p>			
NAME			
BASE PLATE, PULSED DIPOLE WINDING, ORNL STS			
SCALE	SIZE	DRAWING NUMBER	SHEET
1:4 & AS NOTED	A2	F10205311	1 of 1
REV			-

TEMPLATE VERSION: 2021.08.06

4

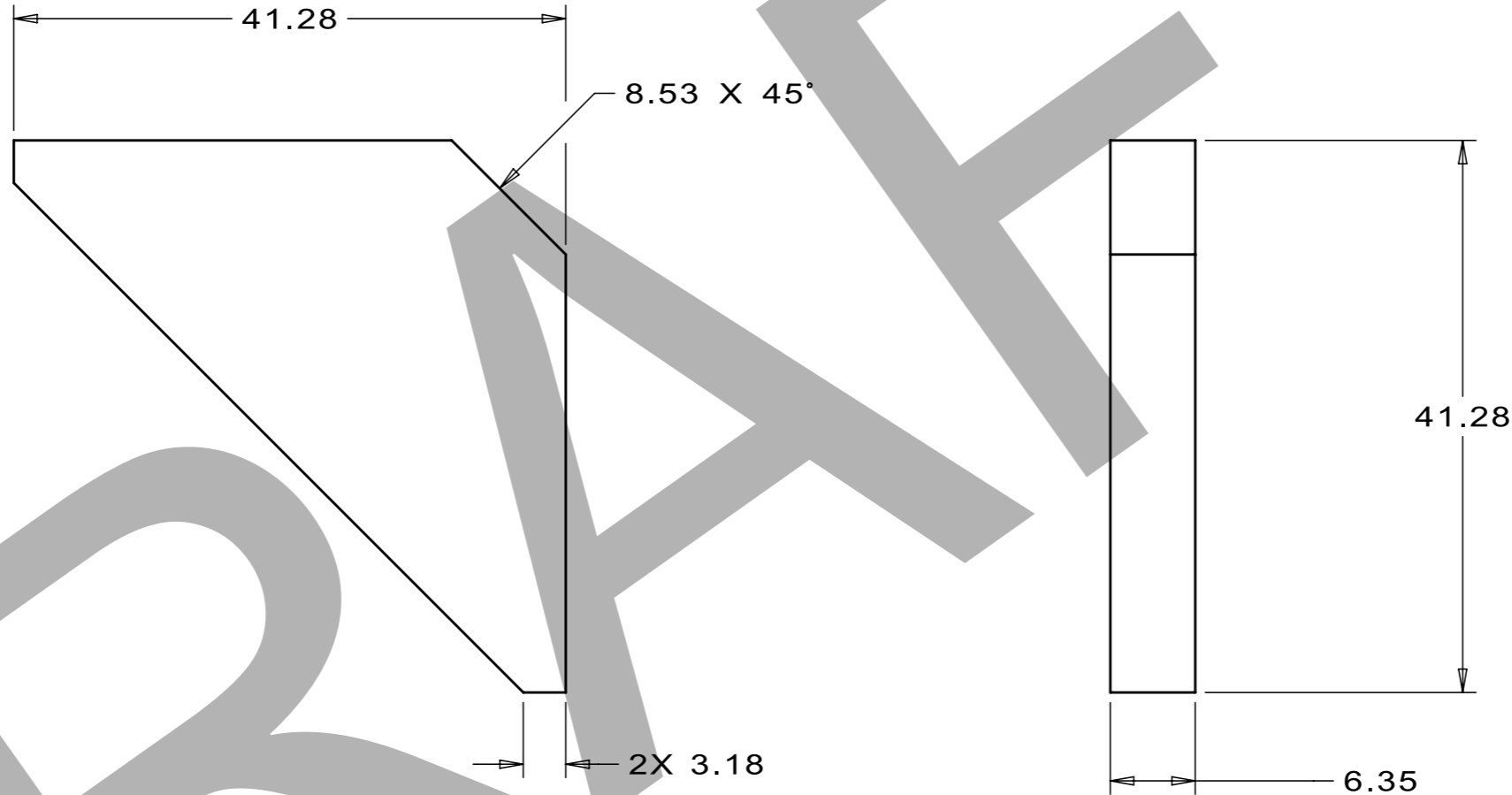
3

2

1

DESCRIPTION: GUSSET, PULSED DIPOLE WINDING, ORNL STS  
PROJECT: ORNL-STs\_Magnets  
CATEGORY: GUSSET

REV	REVISION CONTROL DOCUMENT	DATES	SIGNATURES	
-	F10205312---RCD		DRAWN	
			APPROVED	



NOTES (UNLESS OTHERWISE SPECIFIED):

- PART MUST BE FREE OF DIRT, GREASE, OIL, AND CHIPS.
- PART MUST BE FREE OF SHARP EDGES, CORNERS, AND BURRS.

TEMPLATE VERSION: 2021.06.06

SNS S02040000-M8U-8820-A10066

UNLESS OTHERWISE SPECIFIED				
+X	+X.X	+X.XX	+X/X	+X"
2	0.3	0.12	N/A	1"

BREAK ALL SHARP EDGES, MAX: 0.5  
DO NOT SCALE DRAWING  
DIMENSIONS BASED ON: ASME Y14.5M-2009  
MAX MACHINE ALL SURFACES, Ra: 3.2  
DRAWING UNITS: MM

THIRD ANGLE PROJECTION

DRAWN	J.VANDER MEULEN	DATE	17-Nov-2023
CHECKED		DATE	
APPROVED		DATE	
USED ON	F10205310		
MATERIAL	1018 STEEL		
GROUP:	Technical Division - Design and Drafting		CAGE CODE: OU5R6

		<b>FERMI NATIONAL ACCELERATOR LABORATORY</b> UNITED STATES DEPARTMENT OF ENERGY			
		NAME GUSSET, PULSED DIPOLE WINDING, ORNL STS			
SCALE 2:1	SIZE A3	DRAWING NUMBER F10205312	SHEET 1 OF 1	REV -	

4

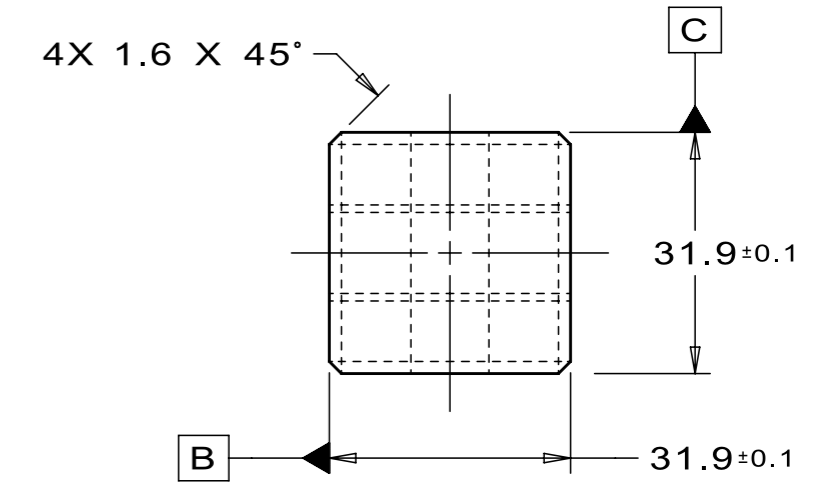
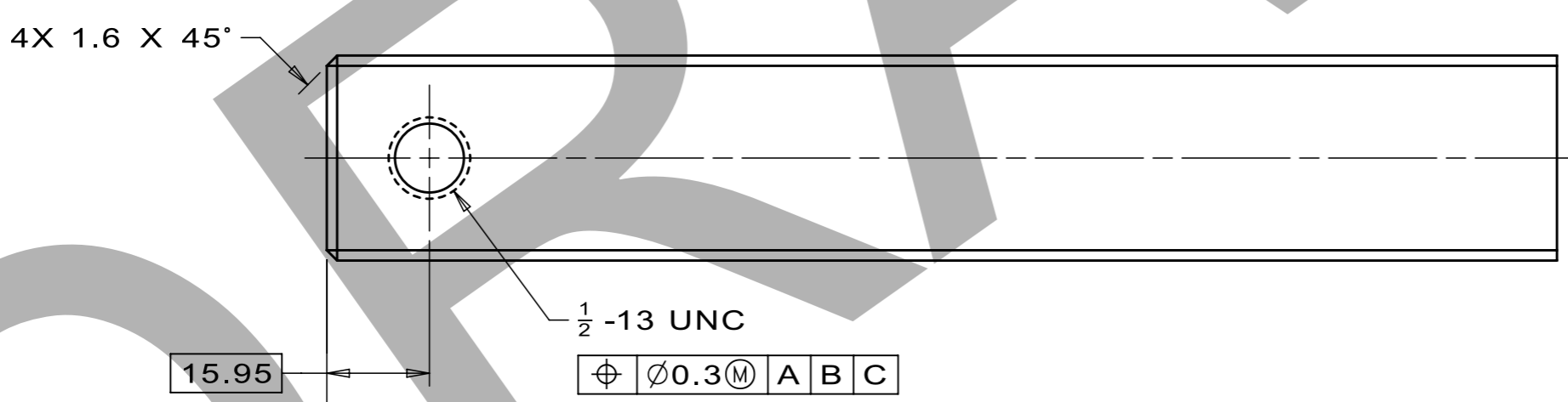
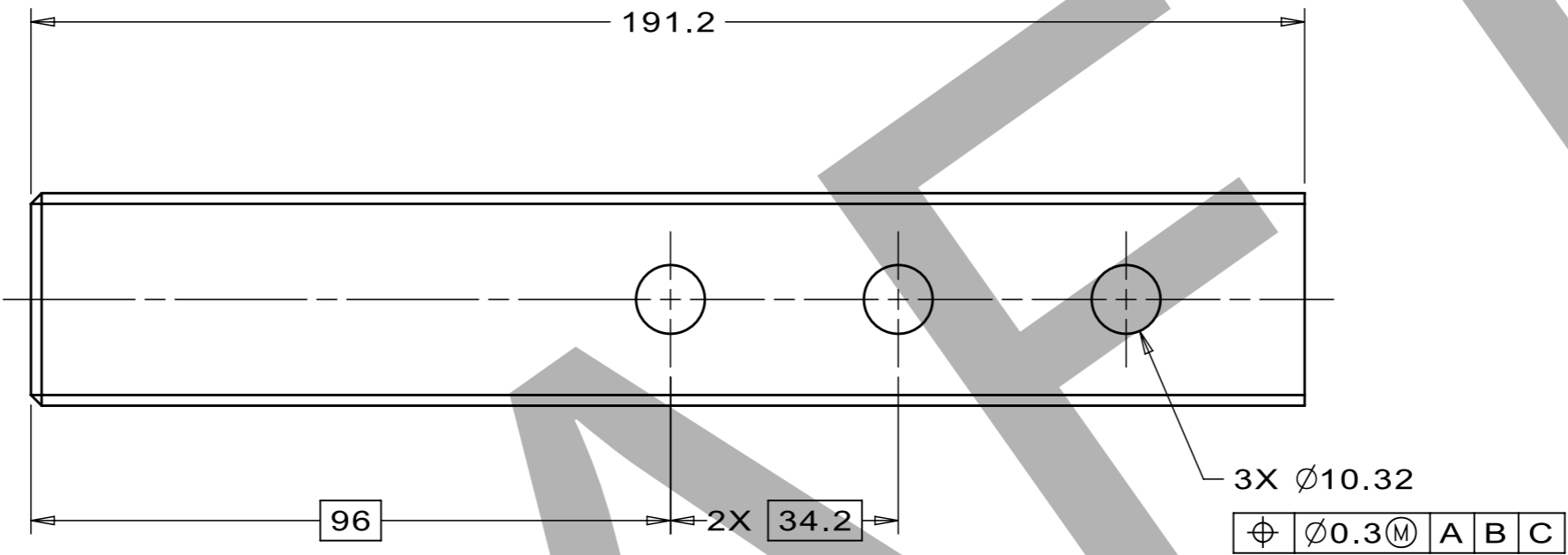
3

2

1

DESCRIPTION: INSERT B, CLAMPING TOOL, ORNL PULSED DIPOLE WINDING  
 PROJECT: ORNL-STS\_Magnets  
 CATEGORY: POST

REV	REVISION CONTROL DOCUMENT	DATES	SIGNATURES	
-	F10205420---RCD		DRAWN	
			APPROVED	



NOTES (UNLESS OTHERWISE SPECIFIED):

- PART MUST BE FREE OF DIRT, GREASE, OIL, AND CHIPS.
- PART MUST BE FREE OF SHARP EDGES, CORNERS, AND BURRS.

UNLESS OTHERWISE SPECIFIED				
+X	+X.X	+X.XX	+X/X	+X"
2	0.3	0.12	N/A	1"

BREAK ALL SHARP EDGES, MAX: 0.5  
 DO NOT SCALE DRAWING  
 DIMENSIONS BASED ON: ASME Y14.5M-2009  
 MAX MACHINE ALL SURFACES, Ra: 3.2  
 DRAWING UNITS: MM

THIRD ANGLE PROJECTION

DRAWN	J.VANDER MEULEN	DATE	17-Nov-2023
CHECKED		DATE	
APPROVED		DATE	
USED ON	F10205310		
MATERIAL	ASTM A36 STEEL		
GROUP:	Technical Division - Design and Drafting		CAGE CODE: OU5R6

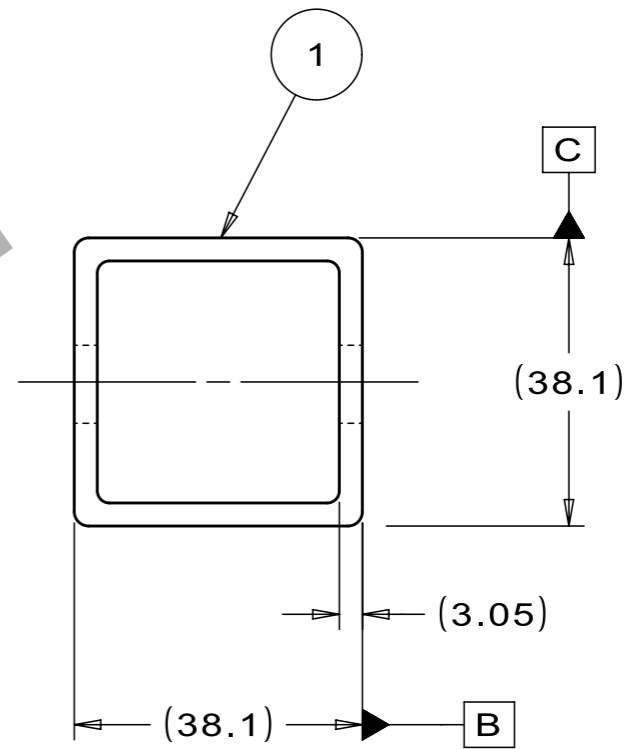
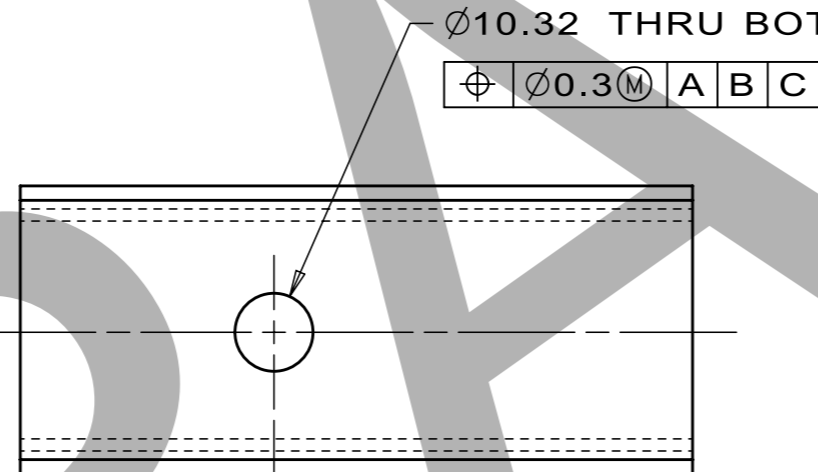
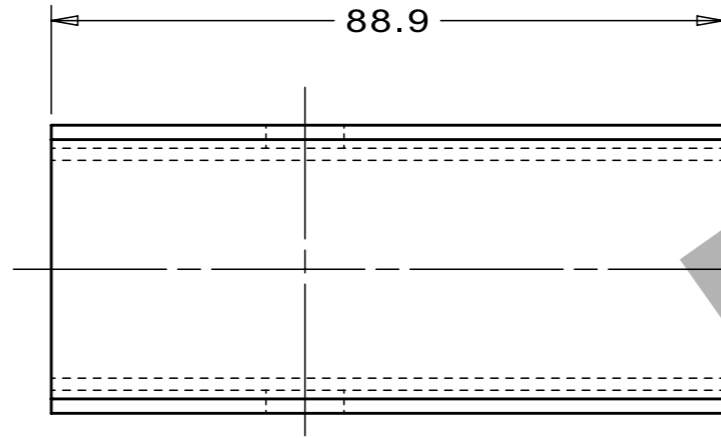
<b>FERMI NATIONAL ACCELERATOR LABORATORY</b> UNITED STATES DEPARTMENT OF ENERGY			
NAME INSERT B, CLAMPING TOOL, ORNL PULSED DIPOLE WINDING			
SCALE 1:1	SIZE A3	DRAWING NUMBER F10205420	SHEET 1 OF 1
		REV -	

TEMPLATE VERSION: 2021.06.06

SNS S02040000-M8U-8820-A10067

DESCRIPTION: SQUARE TUBE B, CLAMPING TOOL, ORNL PULSED DIPOLE WINDING  
 PROJECT: ORNL-STS\_Magnets  
 CATEGORY: TUBE

REV	REVISION CONTROL DOCUMENT	DATES	SIGNATURES	
-	F10205422---RCD		DRAWN	
			APPROVED	



ITEM	VENDOR #	FERMI #	PART NAME	QTY
1	McMASTER-CARR 6527K374 OR EQV.	FC0111390	SQUARE TUBING 1.5"x 1.5"x6' X .2"WALL X 12"LG LC STEEL	1

NOTES (UNLESS OTHERWISE SPECIFIED):

- PART MUST BE FREE OF DIRT, GREASE, OIL, AND CHIPS.
- PART MUST BE FREE OF SHARP EDGES, CORNERS, AND BURRS.

UNLESS OTHERWISE SPECIFIED					DRAWN	J.VANDER MEULEN	DATE	17-Nov-2023
+X	+X.X	+X.XX	+X/X	+X"	CHECKED		DATE	
2	0.3	0.12	N/A	1"	APPROVED		DATE	
BREAK ALL SHARP EDGES, MAX: 0.5					USED ON			
DO NOT SCALE DRAWING					F10205310			
DIMENSIONS BASED ON: ASME Y14.5M-2009					MATERIAL			
MAX MACHINE ALL SURFACES, Ra: 3.2					SEE PARTS LIST			
DRAWING UNITS: MM					GROUP: Technical Division - Design and Drafting			
THIRD ANGLE PROJECTION					CAGE CODE: OU5R6			

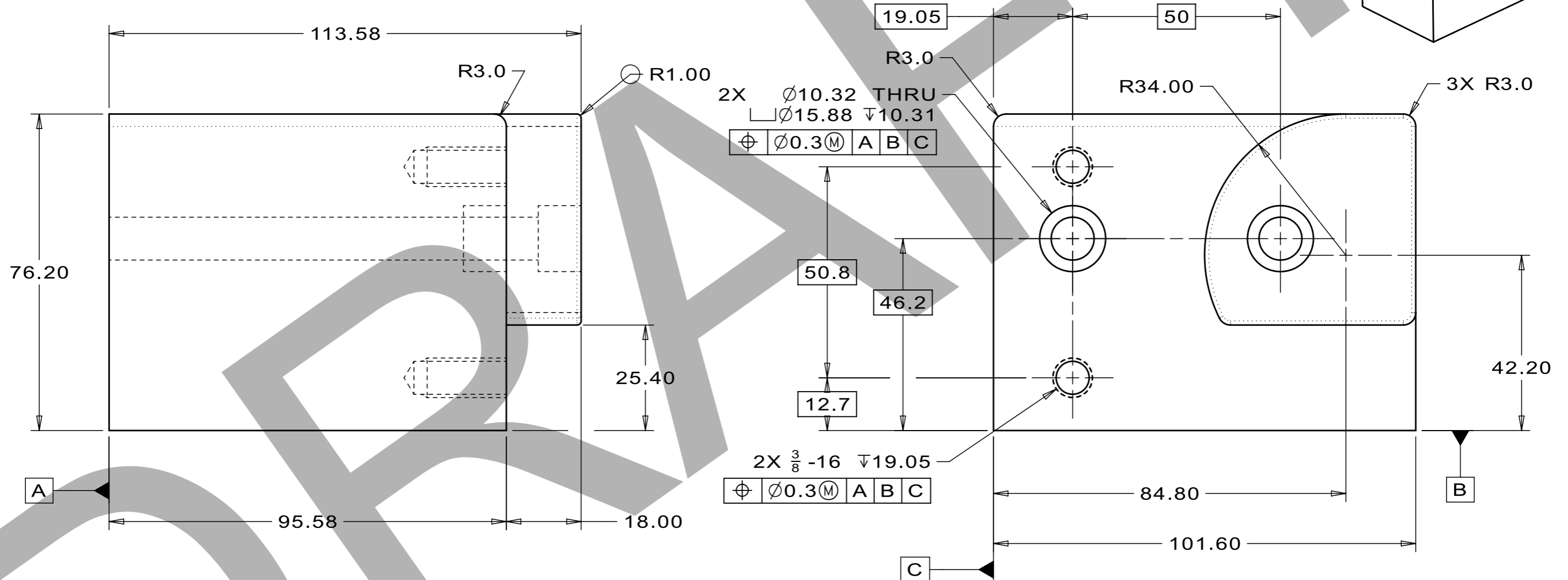
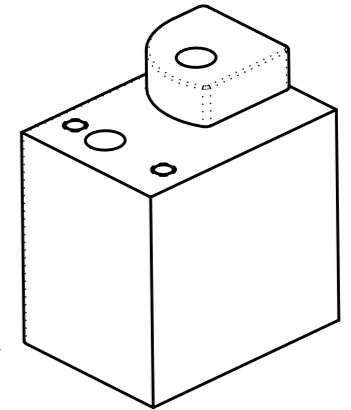
PARTS LIST					F10205310		F10205422	
					<b>FERMI NATIONAL ACCELERATOR LABORATORY</b> UNITED STATES DEPARTMENT OF ENERGY		NAME <b>SQUARE TUBE B, CLAMPING TOOL, ORNL PULSED DIPOLE WINDING</b>	
SCALE	SIZE	DRAWING NUMBER	SHEET	REV	1:1	A3	F10205422	1 OF 1

SNS S02040000-M8U-8820-A10068

TEMPLATE VERSION: 2021.08.06

DESCRIPTION: STAND, OUTER LEAD BEND, UPPER COIL, ORNL PULSED DIPOLE WINDING  
 PROJECT: ORNL-STS\_Magnets  
 CATEGORY: BLOCK

REV	REVISION CONTROL DOCUMENT	DATES	SIGNATURES	
-	F1020551---RCD		DRAWN	
			APPROVED	



NOTES (UNLESS OTHERWISE SPECIFIED):

- PART MUST BE FREE OF DIRT, GREASE, OIL, AND CHIPS.
- PART MUST BE FREE OF SHARP EDGES, CORNERS, AND BURRS.
- TRAILING ZEROS DENOTE TOLERANCE.
- APPROXIMATE WEIGHT: 5.96KG (13.2LBS)

SNS S02040000-M8U-8820-A10069

UNLESS OTHERWISE SPECIFIED				
+X	+X.X	+X.XX	+X/X	+X"
2	0.3	0.12	N/A	1"

BREAK ALL SHARP EDGES, MAX: 0.5  
 DO NOT SCALE DRAWING  
 DIMENSIONS BASED ON: ASME Y14.5M-2009  
 MAX MACHINE ALL SURFACES, Ra: 3.2  
 DRAWING UNITS: MM

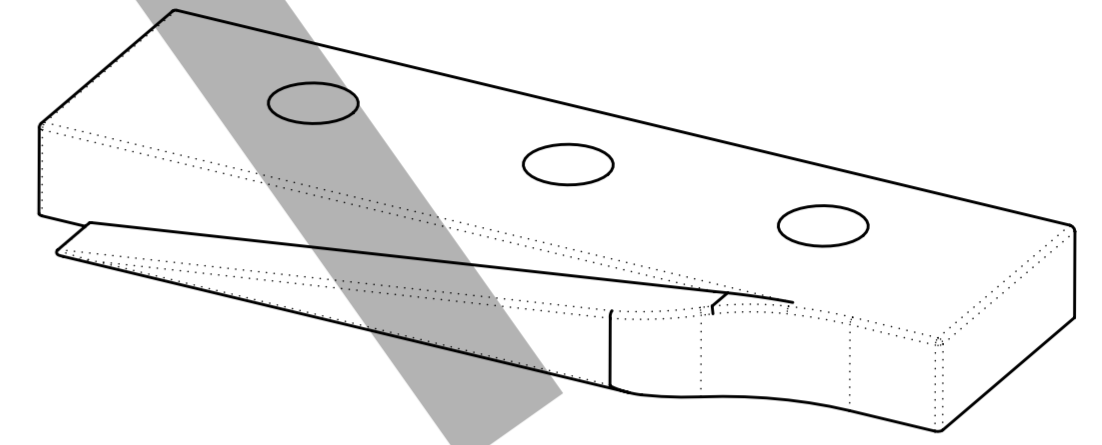
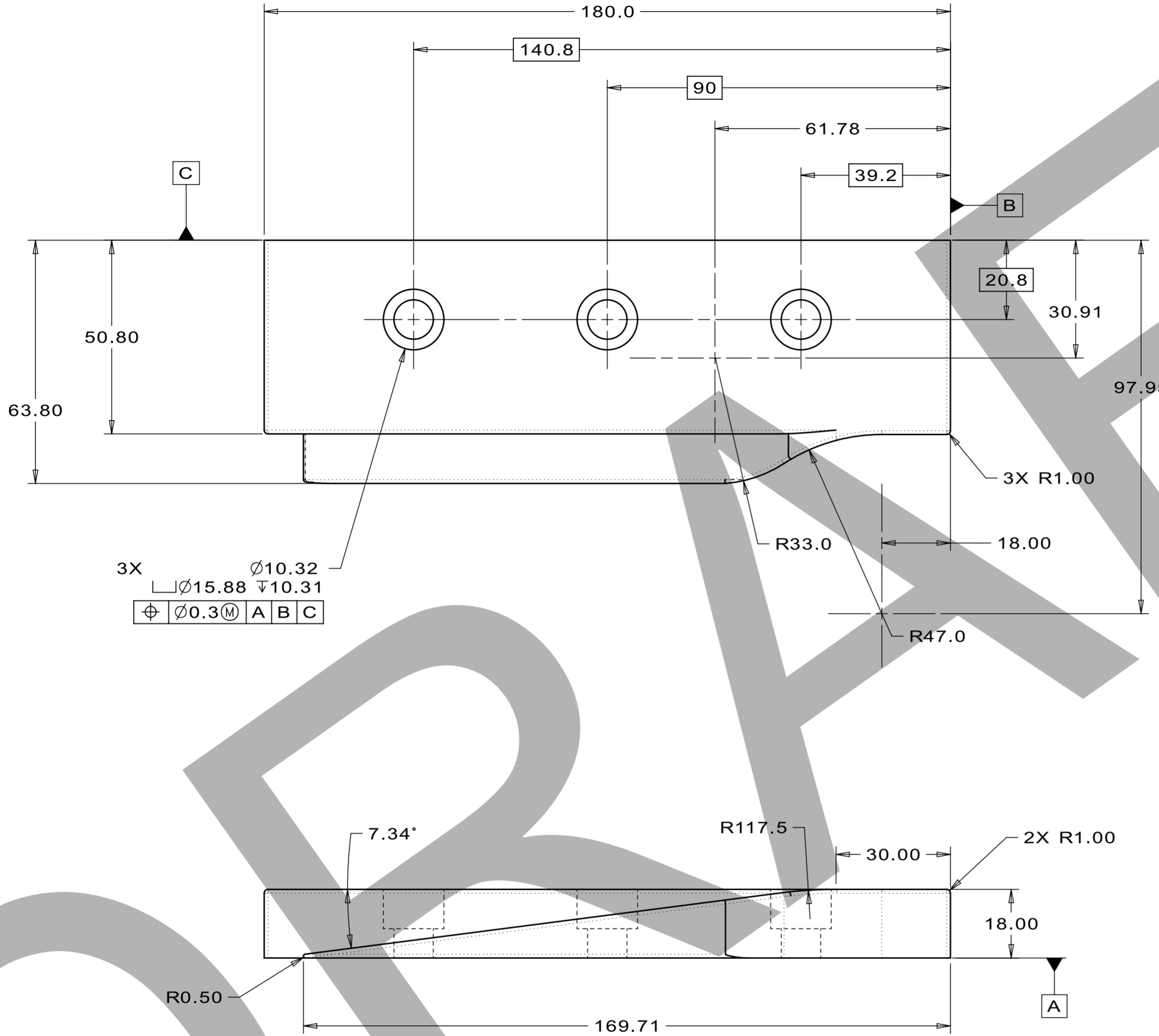
THIRD ANGLE PROJECTION

DRAWN	J.VANDER MEULEN	DATE	17-Nov-2023
CHECKED		DATE	
APPROVED		DATE	
USED ON	F10205208		
MATERIAL	ASTM A36 STEEL		
GROUP:	Technical Division - Design and Drafting	CAGE CODE:	OU5R6

		<b>FERMI NATIONAL ACCELERATOR LABORATORY</b> UNITED STATES DEPARTMENT OF ENERGY			
		NAME <b>STAND, OUTER LEAD BEND, UPPER COIL, ORNL PULSED DIPOLE WINDING</b>			
SCALE	SIZE	DRAWING NUMBER	SHEET	REV	
1:1	A3	F10205551	1 OF 1	-	

TEMPLATE VERSION: 2021.06.06

REV	REVISION CONTROL DOCUMENT	DATES	SIGNATURES
-	F10205552--RCD		DRAWN APPROVED



NOTES (UNLESS OTHERWISE SPECIFIED):

- PART MUST BE FREE OF DIRT, GREASE, OIL, AND CHIPS.
- PART MUST BE FREE OF SHARP EDGES, CORNERS, AND BURRS.
- TRAILING ZEROS DENOTE TOLERANCE.
- APPROXIMATE WEIGHT: 1.35KG (3LBS)

UNLESS OTHERWISE SPECIFIED					DRAWN	J.VANDER MEULEN	DATE	17-Nov-2023
±X	±X.X	±X.XX	±X/X	±X'	CHECKED		DATE	
2	0.3	0.12	N/A	1'	APPROVED		DATE	

BREAK ALL SHARP EDGES, MAX: 0.5  
 DO NOT SCALE DRAWING  
 DIMENSIONS BASED ON: ASME Y14.5M-2009  
 MAX MACHINE ALL SURFACES, Ra: 3.2  
 DRAWING UNITS: MM

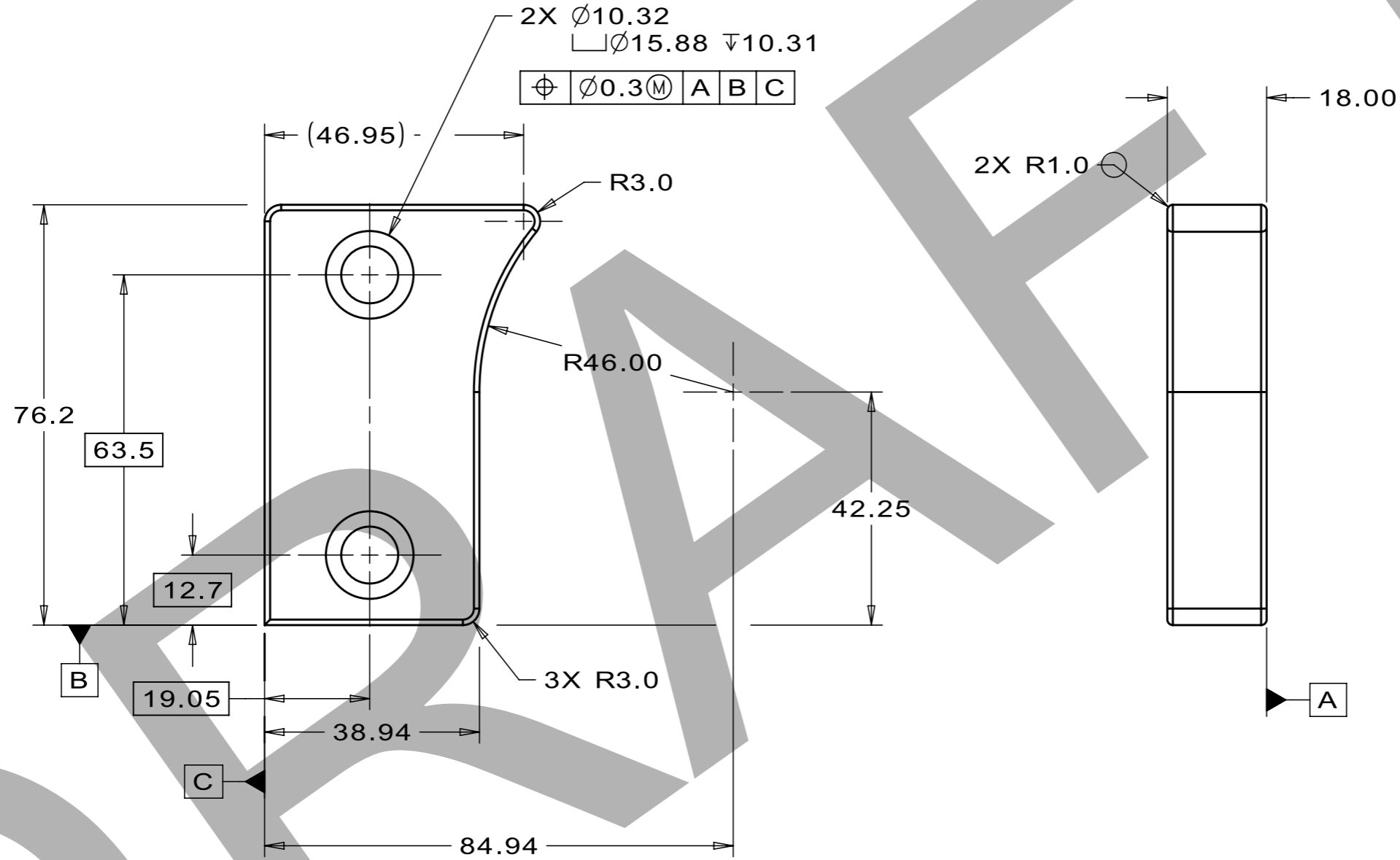
THIRD ANGLE PROJECTION

				<b>FERMI NATIONAL ACCELERATOR LABORATORY</b> UNITED STATES DEPARTMENT OF ENERGY			
NAME WEDGE, OUTER LAYER TRANSITION, ORNL PULSED DIPOLE WINDING							
SCALE	SIZE	DRAWING NUMBER	SHEET	REV			
1:1	A2	F10205552	1 of 1	-			
GROUP: Technical Division - Design and Drafting				CAGE CODE: OJ5R6			

SNS S02040000-M8U-8820-A10070

DESCRIPTION: CLAMP, OUTER LEAD EXIT, ORNL PULSED DIPOLE WINDING  
 PROJECT: ORNL-STS\_Magnets  
 CATEGORY: CLAMP

REV	REVISION CONTROL DOCUMENT	DATES	SIGNATURES	
-	F10205743---RCD		DRAWN	
			APPROVED	



NOTES:(UNLESS OTHERWISE SPECIFIED)

- PART MUST BE FREE OF DIRT, GREASE, OIL AND CHIPS.
- PART TO BE FREE OF ALL SHARP EDGES, CORNERS, AND BURRS.
- TRAILING ZEROS DENOTE TOLERANCE.

UNLESS OTHERWISE SPECIFIED				
+X	+X.X	+X.XX	+X/X	+X"
2	0.3	0.12	N/A	1"

BREAK ALL SHARP EDGES, MAX: 0.5  
 DO NOT SCALE DRAWING  
 DIMENSIONS BASED ON: ASME Y14.5M-2009  
 MAX MACHINE ALL SURFACES, Ra: 3.2  
 DRAWING UNITS: MM

THIRD ANGLE PROJECTION

DRAWN	J.VANDER MEULEN	DATE	28-Nov-2023
CHECKED		DATE	
APPROVED		DATE	
USED ON	F10205208		
MATERIAL	ASTM A36 STEEL		
GROUP:	Technical Division - Design and Drafting		CAGE CODE: OU5R6

		<b>FERMI NATIONAL ACCELERATOR LABORATORY</b> UNITED STATES DEPARTMENT OF ENERGY			
		CLAMP, OUTER LEAD EXIT, ORNL PULSED DIPOLE WINDING			
SCALE	SIZE	DRAWING NUMBER	SHEET	REV	
1:1	A3	F10205743	1 OF 1	-	

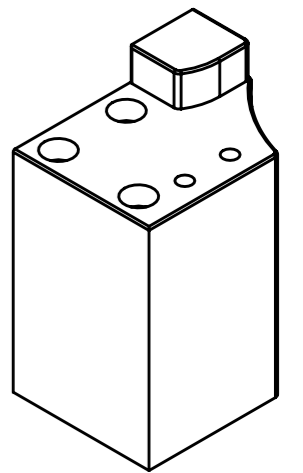
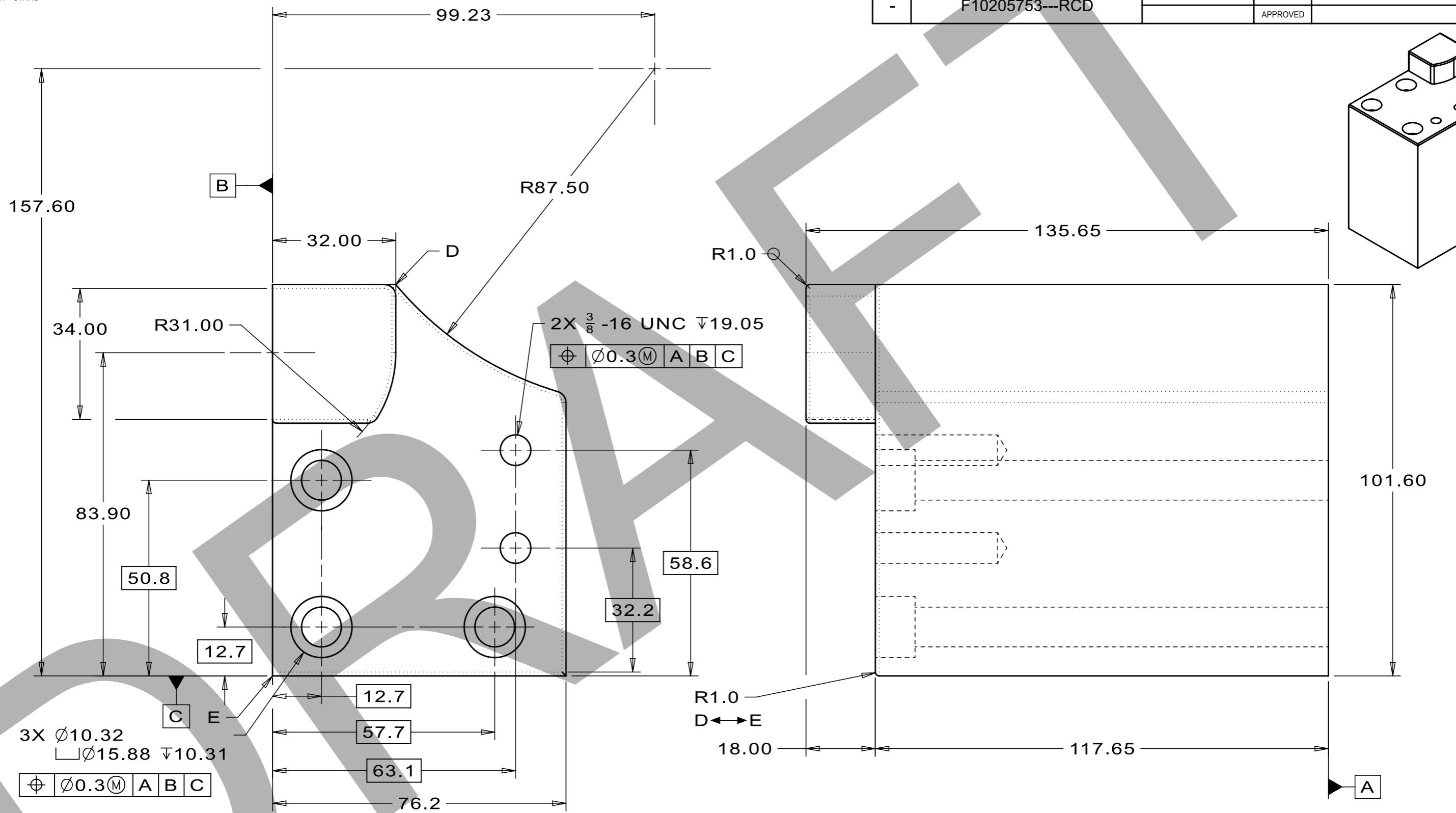
SNS S02040000-M8U-8820-A10071

TEMPLATE VERSION: 2021.08.06



DESCRIPTION: STAND, INNER LEAD BEND, ORNL PULSED DIPOLE WINDING  
 PROJECT: ORNL-ST5\_Magnets  
 CATEGORY: STAND

REV	REVISION CONTROL DOCUMENT	DATES	SIGNATURES	
-	F10205753---RCD		DRAWN	
			APPROVED	



NOTES:(UNLESS OTHERWISE SPECIFIED)

- PART MUST BE FREE OF DIRT, GREASE, OIL AND CHIPS.
- PART TO BE FREE OF ALL SHARP EDGES, CORNERS, AND BURRS.
- TRAILING ZEROS DENOTE TOLERANCE.

SNS S02040000-M8U-8820-A10072

UNLESS OTHERWISE SPECIFIED				
+X	+X.X	+X.XX	+X/X	+X*
2	0.3	0.12	N/A	1*

BREAK ALL SHARP EDGES, MAX: 0.5  
 DO NOT SCALE DRAWING  
 DIMENSIONS BASED ON: ASME Y14.5M-2009  
 MAX MACHINE ALL SURFACES, Ra: 3.2  
 DRAWING UNITS: MM

THIRD ANGLE PROJECTION

DRAWN	J.VANDER MEULEN	DATE	22-Nov-2023
CHECKED		DATE	
APPROVED		DATE	
USED ON	F10205208		
MATERIAL	ASTM A36 STEEL		
GROUP:	Technical Division - Design and Drafting		CAGE CODE: OU5R6

<b>FERMI NATIONAL ACCELERATOR LABORATORY</b> UNITED STATES DEPARTMENT OF ENERGY			
NAME <b>STAND, INNER LEAD BEND, ORNL PULSED DIPOLE WINDING</b>			
SCALE	SIZE	DRAWING NUMBER	SHEET
1:1	A3	F10205753	1 OF 1
			REV
			-

TEMPLATE VERSION: 2021.08.06

4

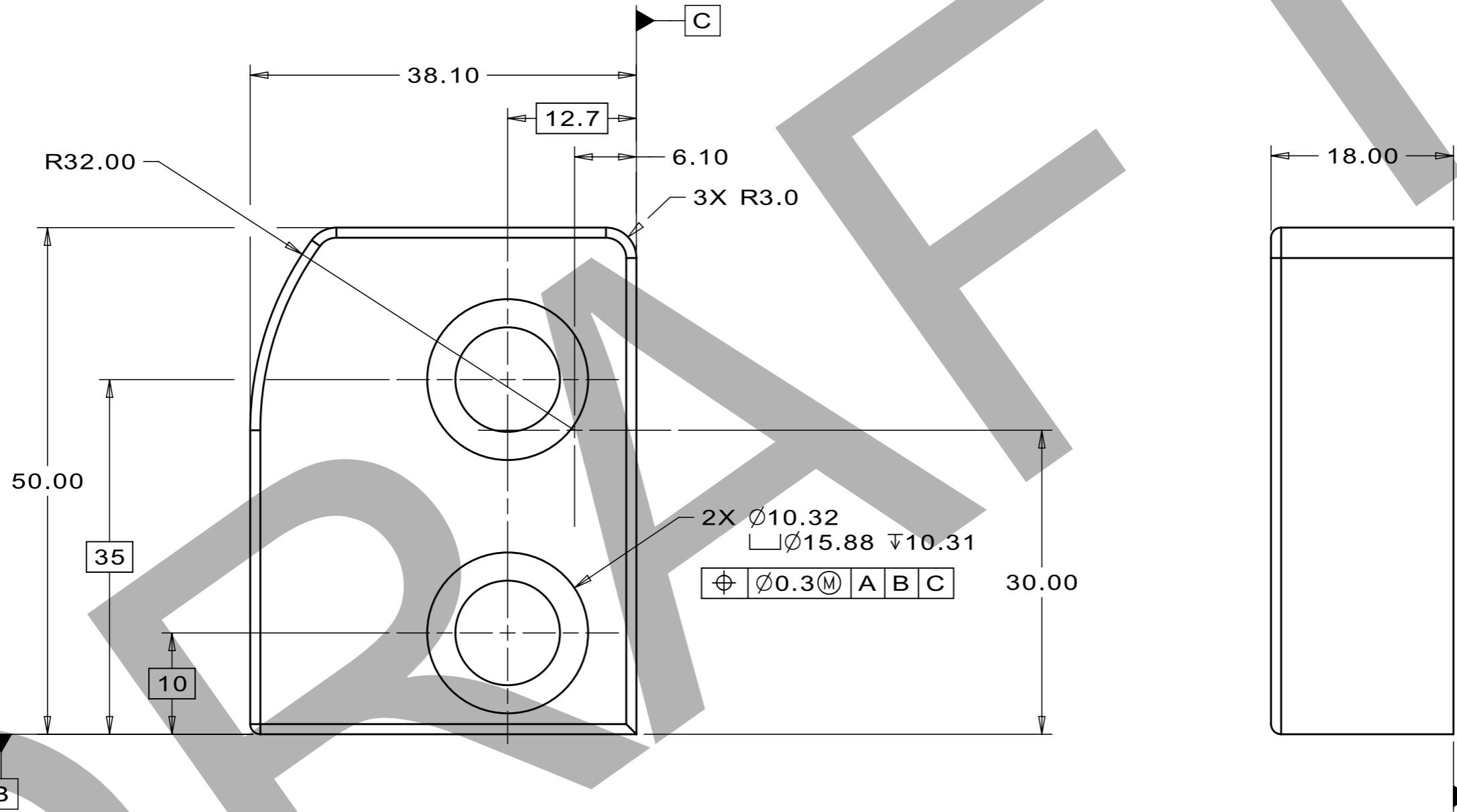
3

2

1

DESCRIPTION: CLAMP, INNER LEAD BEND, UPPER COIL, ORNL PULSED DIPOLE WINDING  
PROJECT: ORNL-STS\_Magnets  
CATEGORY: CLAMP

REV	REVISION CONTROL DOCUMENT	DATES	SIGNATURES	
-	F10205754---RCD		DRAWN	
			APPROVED	



NOTES:(UNLESS OTHERWISE SPECIFIED)

- PART MUST BE FREE OF DIRT, GREASE, OIL AND CHIPS.
- PART TO BE FREE OF ALL SHARP EDGES, CORNERS, AND BURRS.
- TRAILING ZEROS DENOTE TOLERANCE.

SNS S02040000-M8U-8820-A10073

UNLESS OTHERWISE SPECIFIED				
+X	+X.X	+X.XX	+X/X	+X"
2	0.3	0.12	N/A	1"

BREAK ALL SHARP EDGES, MAX: 0.5  
DO NOT SCALE DRAWING  
DIMENSIONS BASED ON: ASME Y14.5M-2009  
MAX MACHINE ALL SURFACES, Ra: 3.2  
DRAWING UNITS: MM

THIRD ANGLE PROJECTION

DRAWN	J.HELSLEY	DATE	22-Nov-2023
CHECKED		DATE	
APPROVED		DATE	
USED ON	F10205208		
MATERIAL	ASTM A36 STEEL		
GROUP:	Technical Division - Design and Drafting		CAGE CODE: OU5R6

		<b>FERMI NATIONAL ACCELERATOR LABORATORY</b> UNITED STATES DEPARTMENT OF ENERGY			
		CLAMP, INNER LEAD BEND, UPPER COIL, ORNL PULSED DIPOLE WINDING			
SCALE	SIZE	DRAWING NUMBER	SHEET	REV	
2:1	A3	F10205754	1 OF 1	-	

4

3

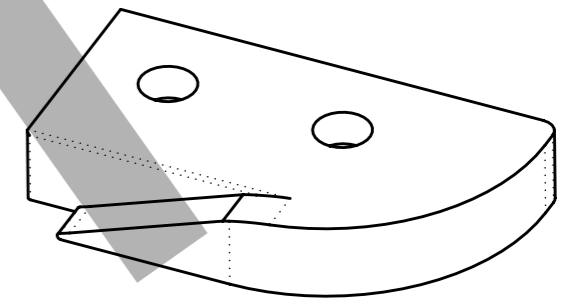
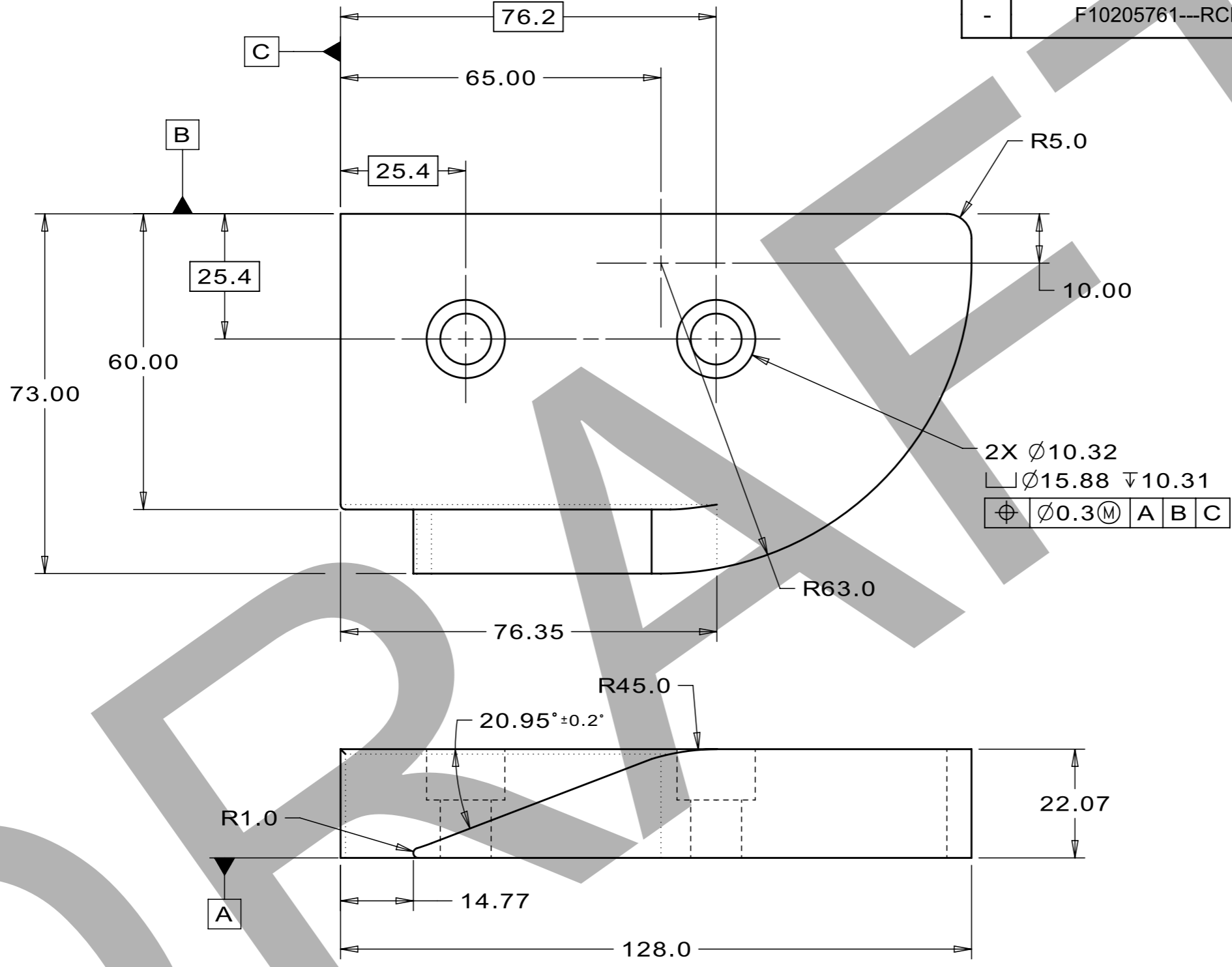
2

1

TEMPLATE VERSION: 2021.08.06

DESCRIPTION: EXTENTION, CENTER BLOCK RH, ORNL PULSED DIPOLE WINDING  
 PROJECT: ORNL-STS\_Magnets  
 CATEGORY: BLOCK

REV	REVISION CONTROL DOCUMENT	DATES	SIGNATURES	
-	F10205761---RCD		DRAWN	
			APPROVED	



NOTES (UNLESS OTHERWISE SPECIFIED):

- PART MUST BE FREE OF DIRT, GREASE, OIL, AND CHIPS.
- PART MUST BE FREE OF SHARP EDGES, CORNERS, AND BURRS.
- TRAILING ZEROS DENOTE TOLERANCE.
- APPROXIMATE WEIGHT: 1.33KG (3LBS)

UNLESS OTHERWISE SPECIFIED				
+X	+X.X	+X.XX	+X/X	+X"
2	0.3	0.12	N/A	1"

BREAK ALL SHARP EDGES, MAX: 0.5  
 DO NOT SCALE DRAWING  
 DIMENSIONS BASED ON: ASME Y14.5M-2009  
 MAX MACHINE ALL SURFACES, Ra: 3.2  
 DRAWING UNITS: MM

THIRD ANGLE PROJECTION

DRAWN	J.VANDER MEULEN	DATE	21-Nov-2023
CHECKED		DATE	
APPROVED		DATE	
USED ON	F10205208		
MATERIAL	ASTM A36 STEEL		
GROUP:	Technical Division - Design and Drafting		CAGE CODE: OU5R6

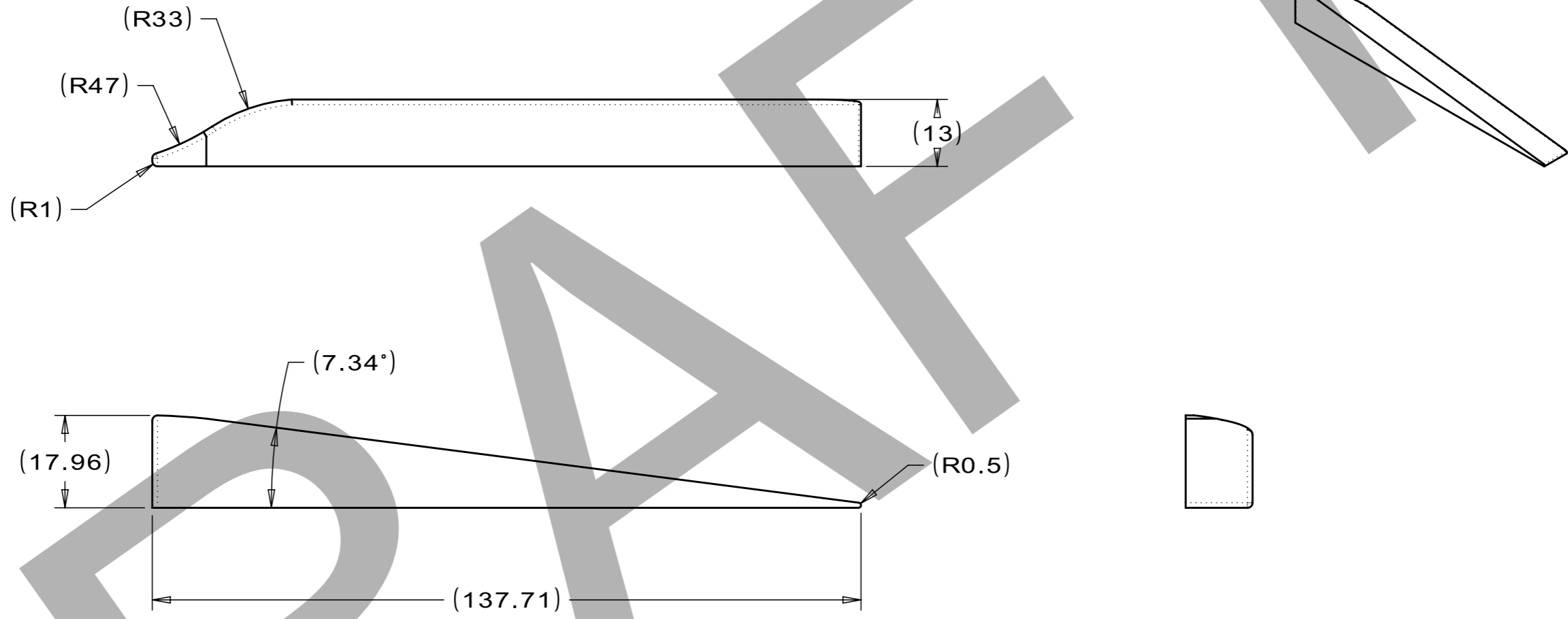
<b>FERMI NATIONAL ACCELERATOR LABORATORY</b> UNITED STATES DEPARTMENT OF ENERGY			
NAME EXTENTION, CENTER BLOCK RH, ORNL PULSED DIPOLE WINDING			
SCALE 1:1	SIZE A3	DRAWING NUMBER F10205761	SHEET 1 OF 1
		REV -	

SNS S02040000-M8U-8820-A10074

TEMPLATE VERSION: 2021.08.06

DESCRIPTION: F10205821  
 PROJECT: ORNL-STS\_Magnets  
 CATEGORY: INSERT

REV	REVISION CONTROL DOCUMENT	DATES	SIGNATURES	
-	F10205821---RCD		DRAWN	
			APPROVED	



NOTES (UNLESS OTHERWISE SPECIFIED):

- PART MUST BE FREE OF DIRT, GREASE, OIL, AND CHIPS.
- PART MUST BE FREE OF SHARP EDGES, CORNERS, AND BURRS.
- THE CAD MODEL IS MASTER, DIMENSIONS SHOWN ARE REFERENCE ONLY.

UNLESS OTHERWISE SPECIFIED				
+X	+X.X	+X.XX	+X/X	+X"
2	0.3	0.12	N/A	1"

BREAK ALL SHARP EDGES, MAX: 0.5  
 DO NOT SCALE DRAWING  
 DIMENSIONS BASED ON: ASME Y14.5M-2009  
 MAX MACHINE ALL SURFACES, Ra: 3.2  
 DRAWING UNITS: MM

THIRD ANGLE PROJECTION

DRAWN	J.VANDER MEULEN	DATE	21-Nov-2023
CHECKED		DATE	
APPROVED		DATE	
USED ON	F10205208		
MATERIAL	ASTM A36 STEEL		
GROUP:	Technical Division - Design and Drafting		CAGE CODE: OU5R6

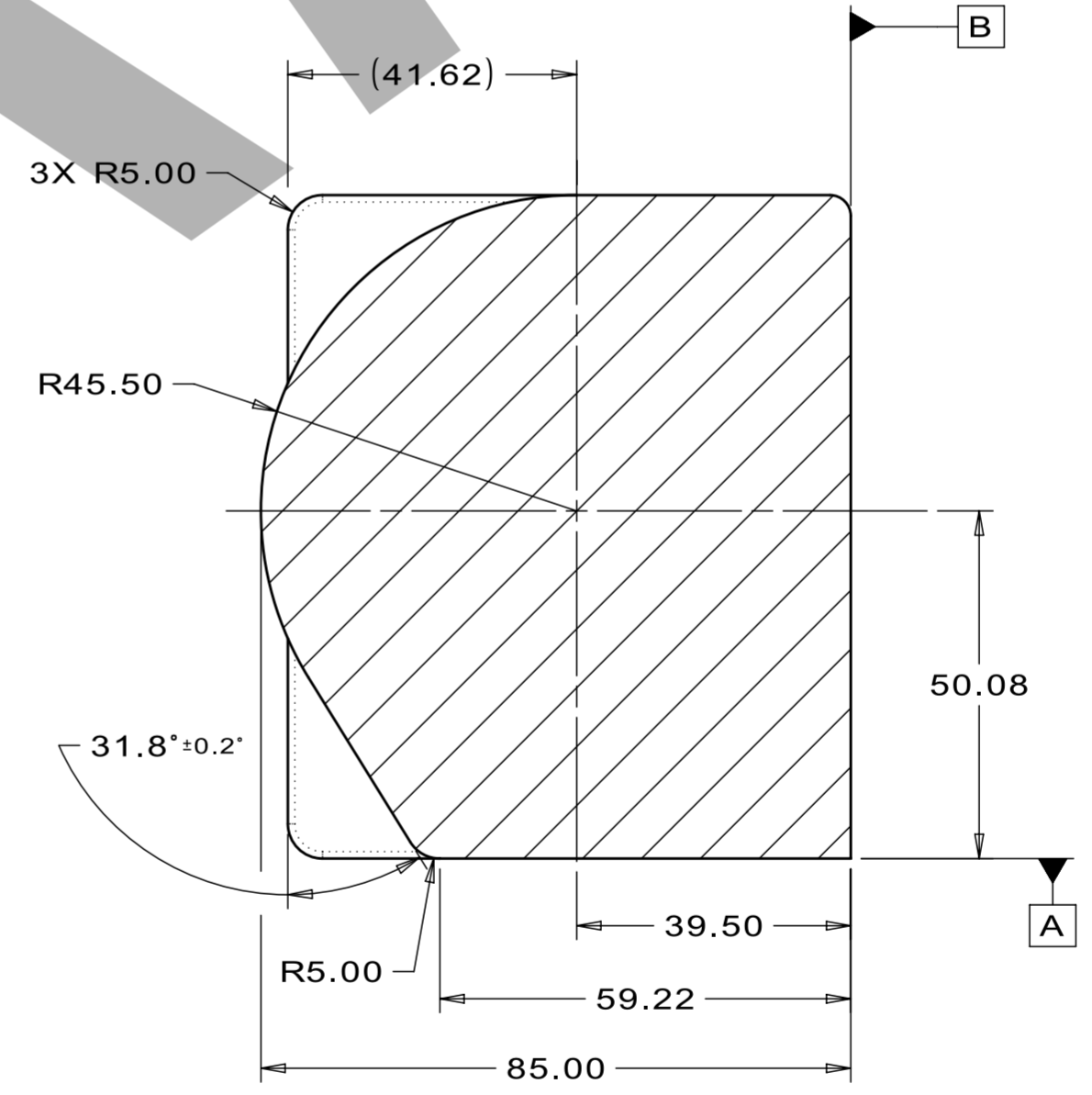
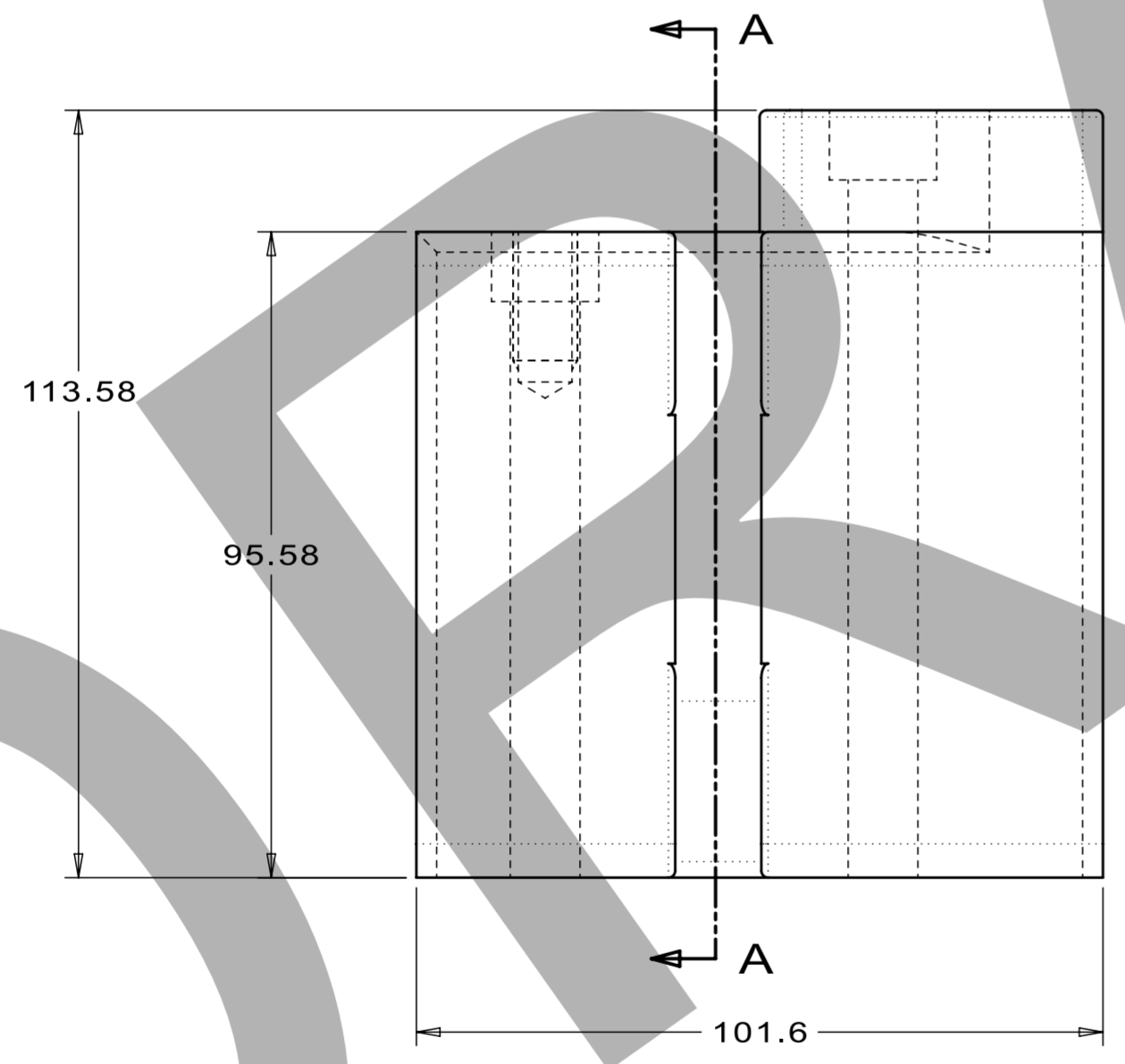
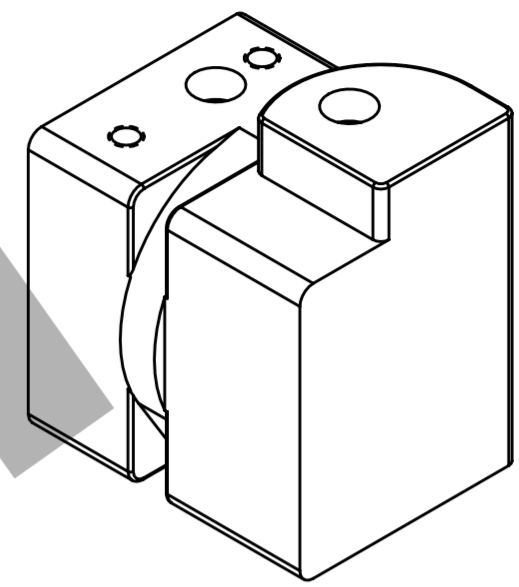
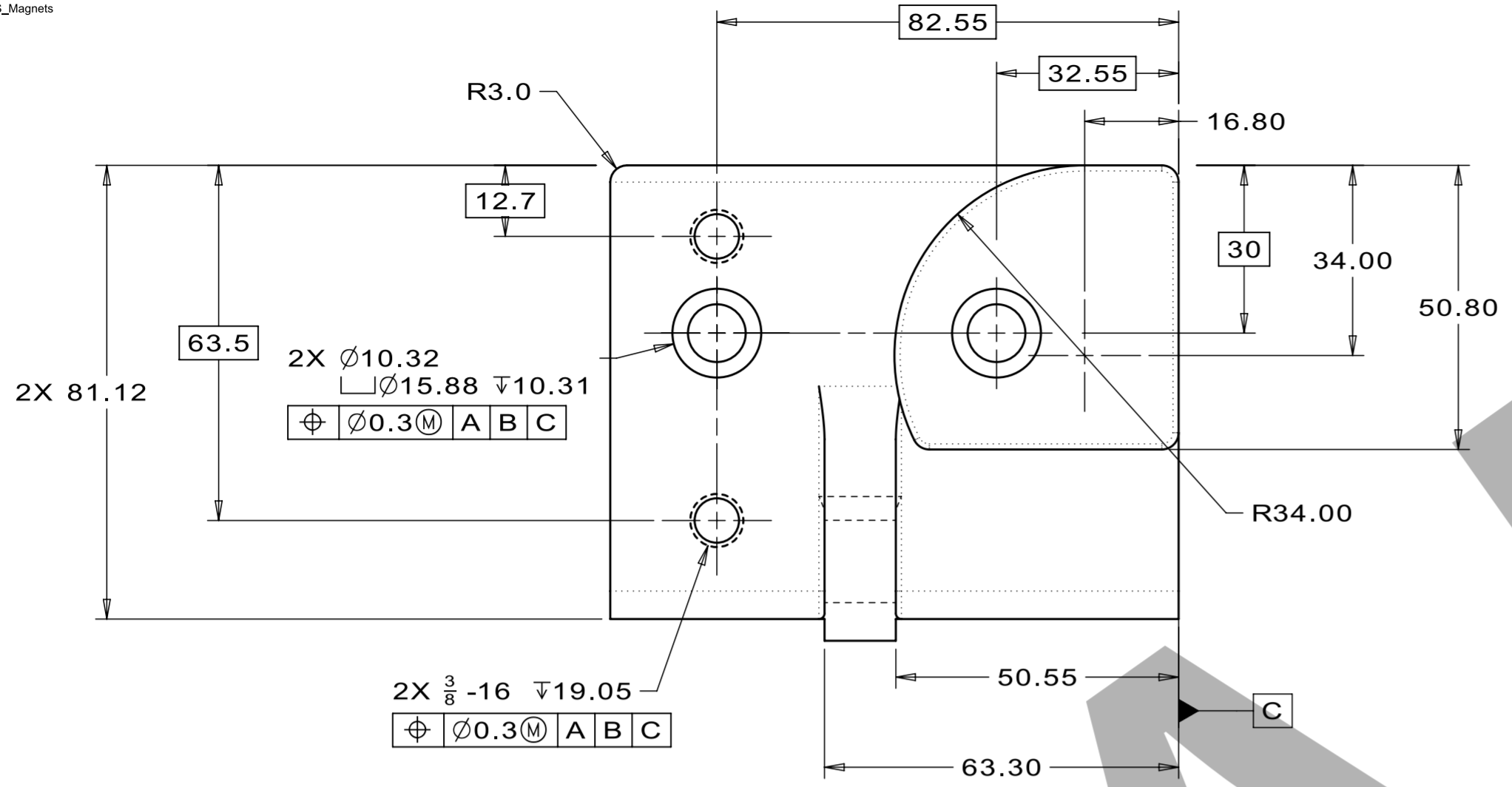
		<b>FERMI NATIONAL ACCELERATOR LABORATORY</b> UNITED STATES DEPARTMENT OF ENERGY			
		NAME SPACE SAVER, OUTER TRANSITION, ORNL PULSED DIPOLE WINDING			
SCALE	SIZE	DRAWING NUMBER	SHEET	REV	
1:1	A3	F10205821	1 OF 1	-	

SNS S02040000-M8U-8820-A10075

TEMPLATE VERSION: 2021.06.06

DESCRIPTION: STAND, OUTER LEAD BEND, LOWER COIL, ORNL PULSED DIPOLE WINDING  
 PROJECT: ORNL-STS\_Magnets  
 CATEGORY: BLOCK

REV	REVISION CONTROL DOCUMENT	DATES	SIGNATURES
-	F10205827--RCD		DRAWN APPROVED



- NOTES (UNLESS OTHERWISE SPECIFIED):
- PART MUST BE FREE OF DIRT, GREASE, OIL, AND CHIPS.
  - PART MUST BE FREE OF SHARP EDGES, CORNERS, AND BURRS.
  - TRAILING ZEROS DENOTE TOLERANCE.
  - APPROXIMATE WEIGHT: 6.27KG (13.83LBS)
  - CAD MODEL IS MASTER. REFER TO STEP FILE.

SNS S02040000-M8U-8820-A10076

UNLESS OTHERWISE SPECIFIED				
±X	±X.X	±X.XX	±X/X	±X'
2	0.3	0.12	N/A	1'

BREAK ALL SHARP EDGES, MAX: 0.5  
 DO NOT SCALE DRAWING  
 DIMENSIONS BASED ON: ASME Y14.5M-2009  
 MAX MACHINE ALL SURFACES, Ra: 3.2  
 DRAWING UNITS: MM

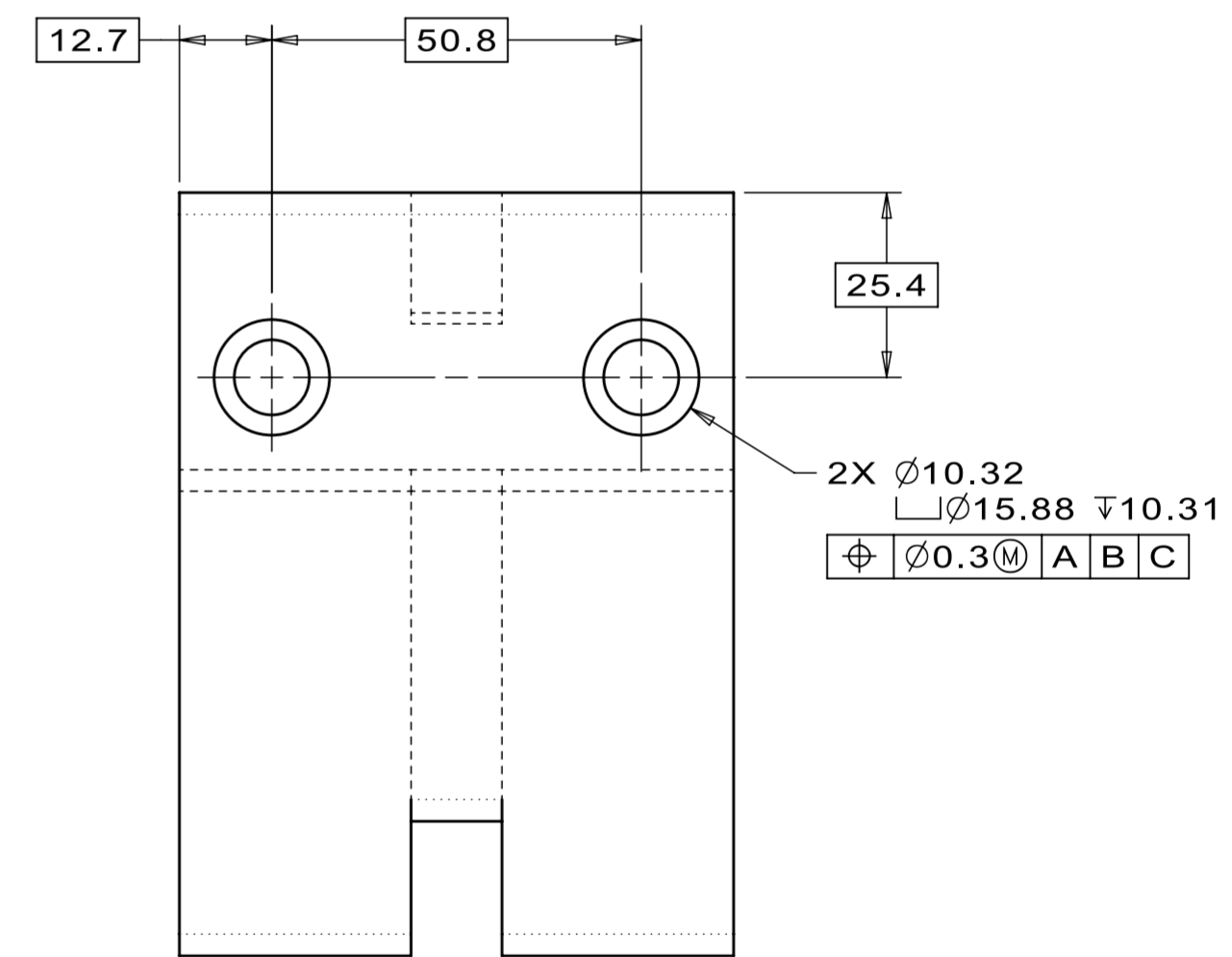
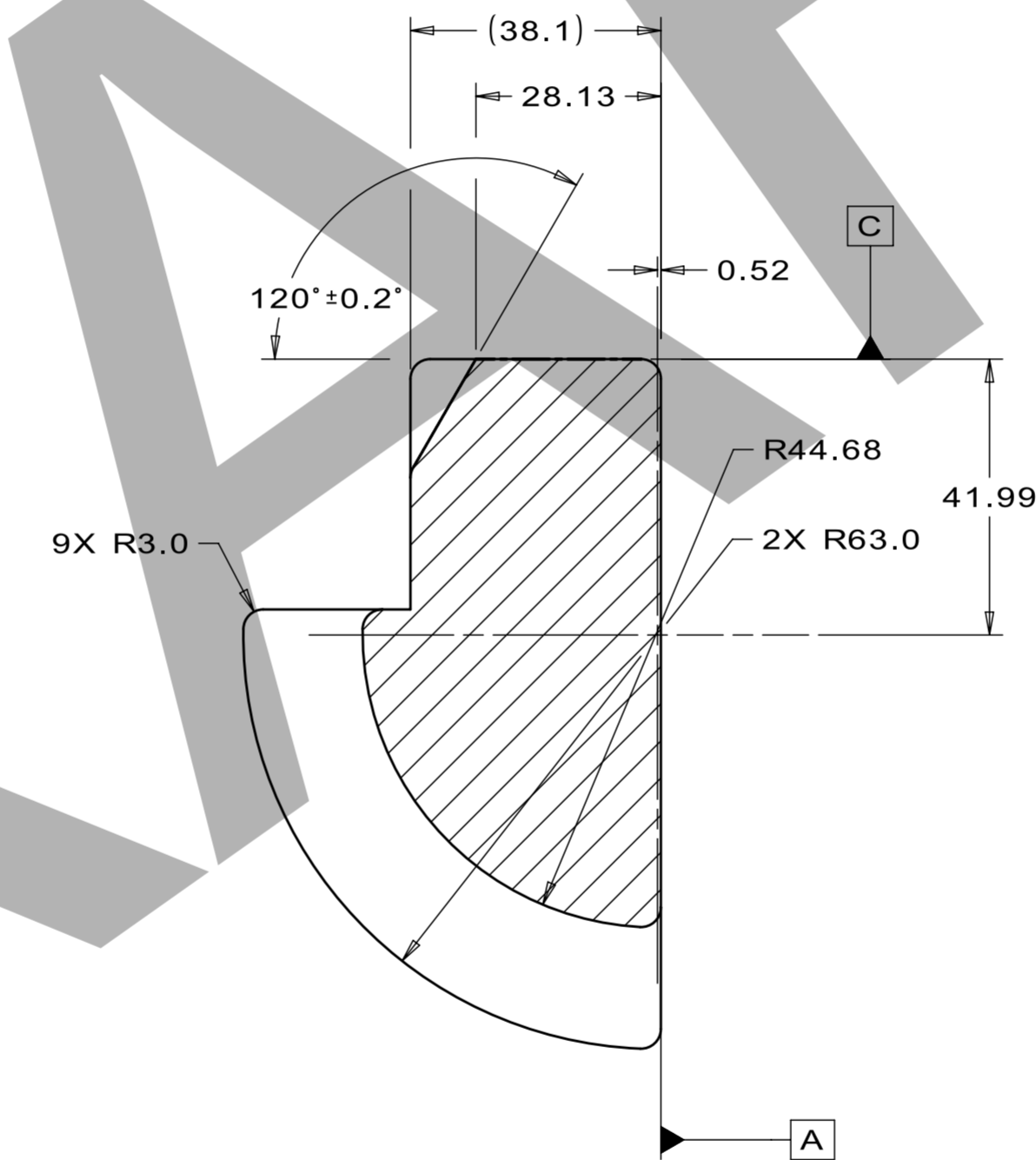
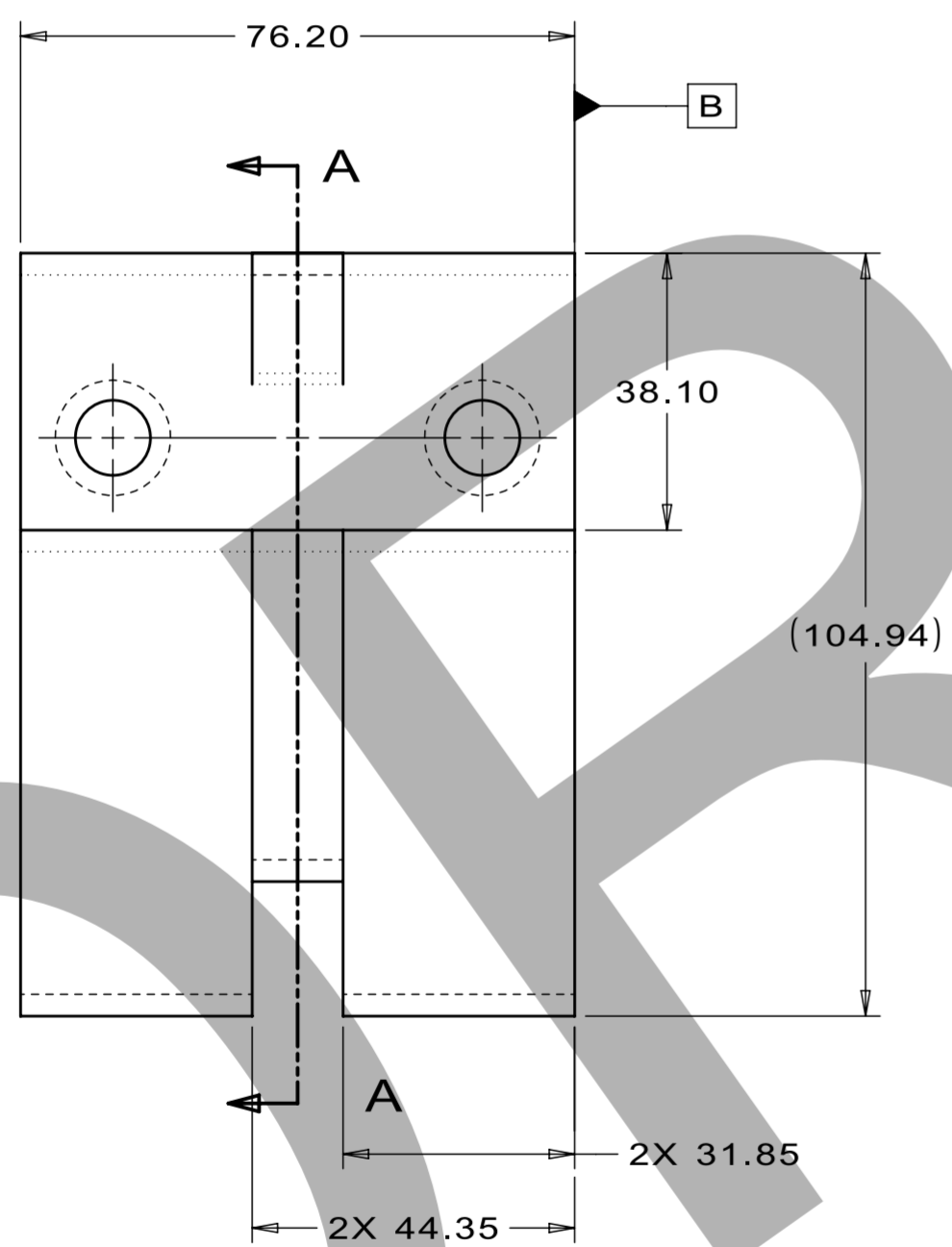
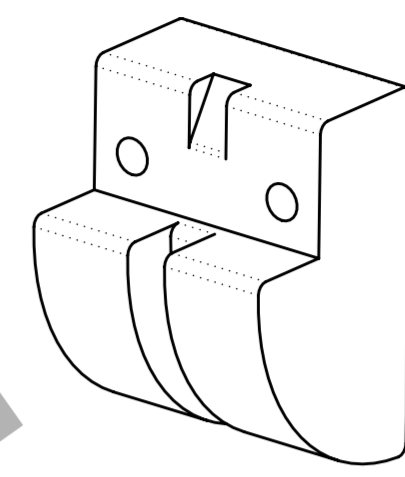
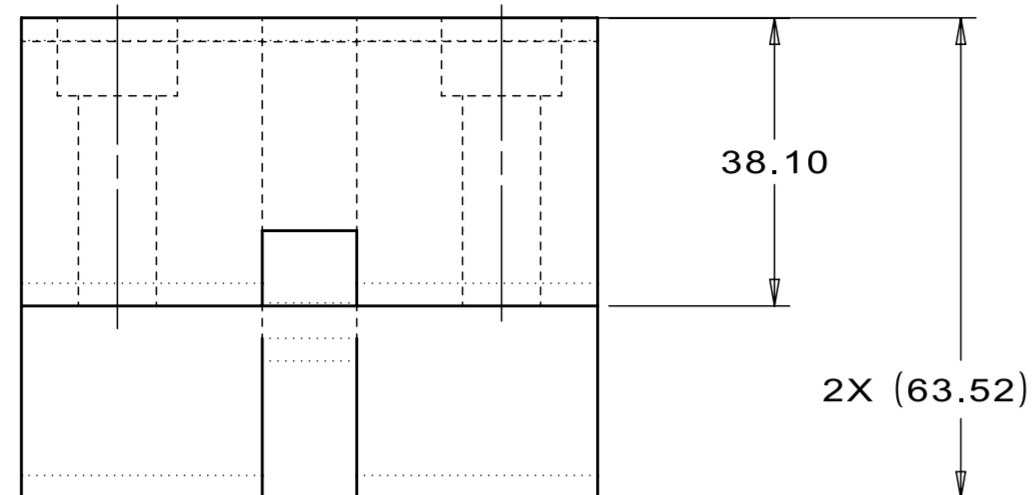
THIRD ANGLE PROJECTION

DRAWN	J.VANDER MEULEN	DATE	21-Nov-2023
CHECKED		DATE	
APPROVED		DATE	
USED ON	F10205208		
MATERIAL	ASTM A36 STEEL		
GROUP:	Technical Division - Design and Drafting		
CAGE CODE:	OU5R6		

<b>FERMI NATIONAL ACCELERATOR LABORATORY</b> UNITED STATES DEPARTMENT OF ENERGY			
NAME			
STAND, OUTER LEAD BEND, LOWER COIL, ORNL PULSED DIPOLE WINDING			
SCALE	SIZE	DRAWING NUMBER	SHEET
1:1	A2	F10205827	1 of 1
REV	-		

TEMPLATE VERSION: 2021.08.06

REV	REVISION CONTROL DOCUMENT	DATES	SIGNATURES
-	F10205948--RCD		DRAWN APPROVED



SECTION A-A

NOTES (UNLESS OTHERWISE SPECIFIED):

- PART MUST BE FREE OF DIRT, GREASE, OIL, AND CHIPS.
- PART MUST BE FREE OF SHARP EDGES, CORNERS, AND BURRS.
- APPROXIMATE WEIGHT: 2.66KG (5.86LBS)
- CAD MODEL IS MASTER, REFER TO THE STEP FILE.

SNS S02040000-M8U-8820-A10077

UNLESS OTHERWISE SPECIFIED					DRAWN	J.VANDER MEULEN	DATE	22-Nov-2023
±X	±X.X	±X.XX	±X/X	±X°	CHECKED		DATE	
2	0.3	0.12	N/A	1°	APPROVED		DATE	
BREAK ALL SHARP EDGES, MAX: 0.5					USED ON			
DO NOT SCALE DRAWING					F10205208			
DIMENSIONS BASED ON: ASME Y14.5M-2009					MATERIAL			
MAX MACHINE ALL SURFACES, Ra: 3.2					ASTM A36 STEEL			
DRAWING UNITS: MM					GROUP: Technical Division - Design and Drafting			
THIRD ANGLE PROJECTION					CAGE CODE: OJ5R6			

FERMI NATIONAL ACCELERATOR LABORATORY UNITED STATES DEPARTMENT OF ENERGY			
NAME OUTER LEAD END BEND, LOWER COIL, ORNL PULSED DIPOLE WINDING			
SCALE 1:1	SIZE A2	DRAWING NUMBER F10205948	SHEET 1 of 1
		REV -	

TEMPLATE VERSION: 2021.08.06

4

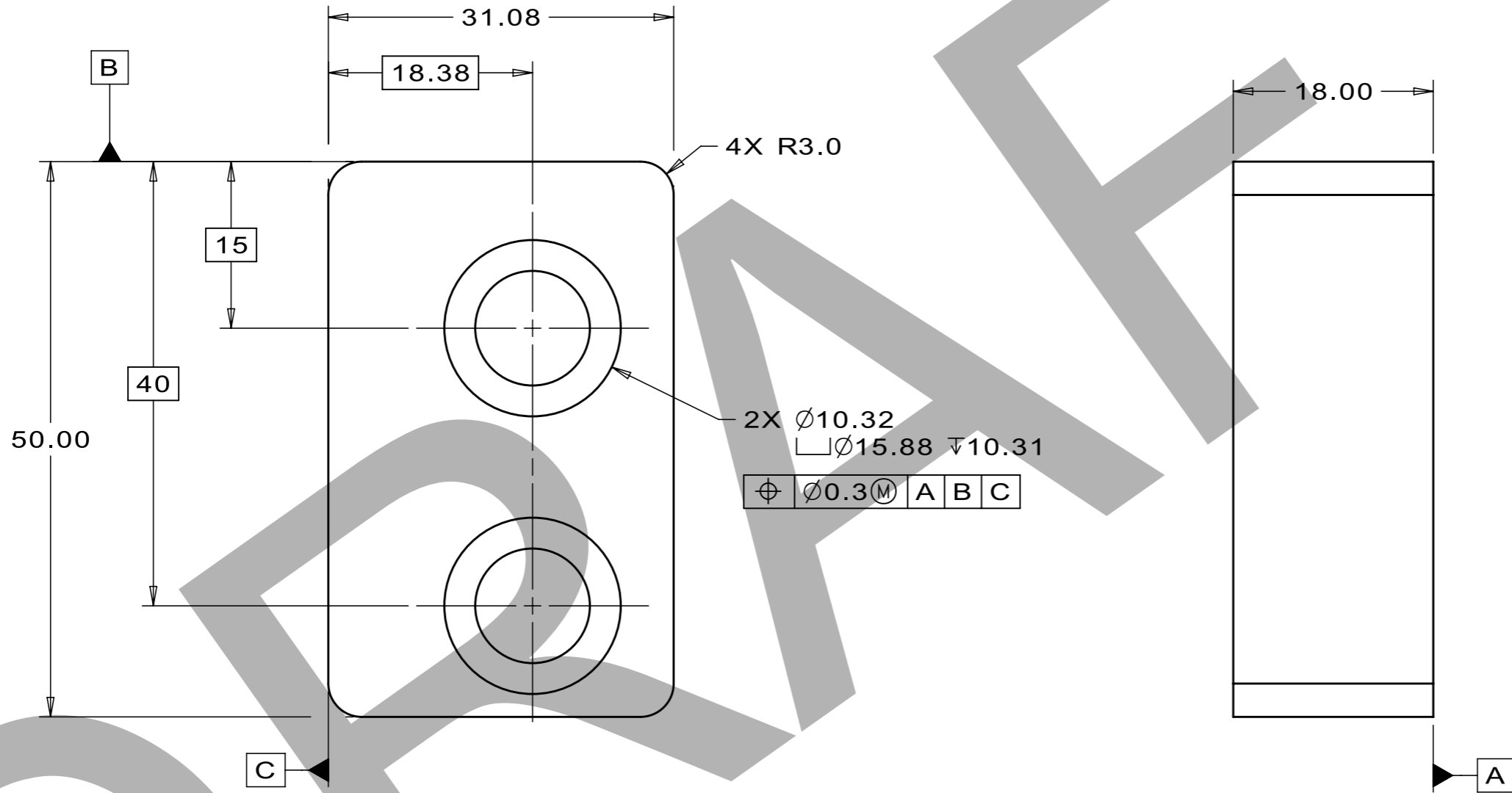
3

2

1

DESCRIPTION: CLAMP, INNER LEAD BEND, LOWER COIL, ORNL PULSED DIPOLE WINDING  
PROJECT: ORNL-STS\_Magnets  
CATEGORY: CLAMP

REV	REVISION CONTROL DOCUMENT	DATES	SIGNATURES	
-	F10205966---RCD		DRAWN	
			APPROVED	



NOTES:(UNLESS OTHERWISE SPECIFIED)

- PART MUST BE FREE OF DIRT, GREASE, OIL AND CHIPS.
- PART TO BE FREE OF ALL SHARP EDGES, CORNERS, AND BURRS.
- TRAILING ZEROS DENOTE TOLERANCE.

SNS S02040000-M8U-8820-A10078

UNLESS OTHERWISE SPECIFIED				
+X	+X.X	+X.XX	+X/X	+X'
2	0.3	0.12	N/A	1'

BREAK ALL SHARP EDGES, MAX: 0.5  
DO NOT SCALE DRAWING  
DIMENSIONS BASED ON: ASME Y14.5M-2009  
MAX MACHINE ALL SURFACES, Ra: 3.2  
DRAWING UNITS: MM

THIRD ANGLE PROJECTION

DRAWN	J.HELSELEY	DATE	22-Nov-2023
CHECKED		DATE	
APPROVED		DATE	
USED ON	F10205208		
MATERIAL	ASTM A36 STEEL		
GROUP:	Technical Division - Design and Drafting		CAGE CODE: OU5R6

	<b>FERMI NATIONAL ACCELERATOR LABORATORY</b> UNITED STATES DEPARTMENT OF ENERGY			
	NAME <b>CLAMP, INNER LEAD BEND, LOWER COIL, ORNL PULSED DIPOLE WINDING</b>			
SCALE 2:1	SIZE A3	DRAWING NUMBER F10205966	SHEET 1 OF 1	REV -

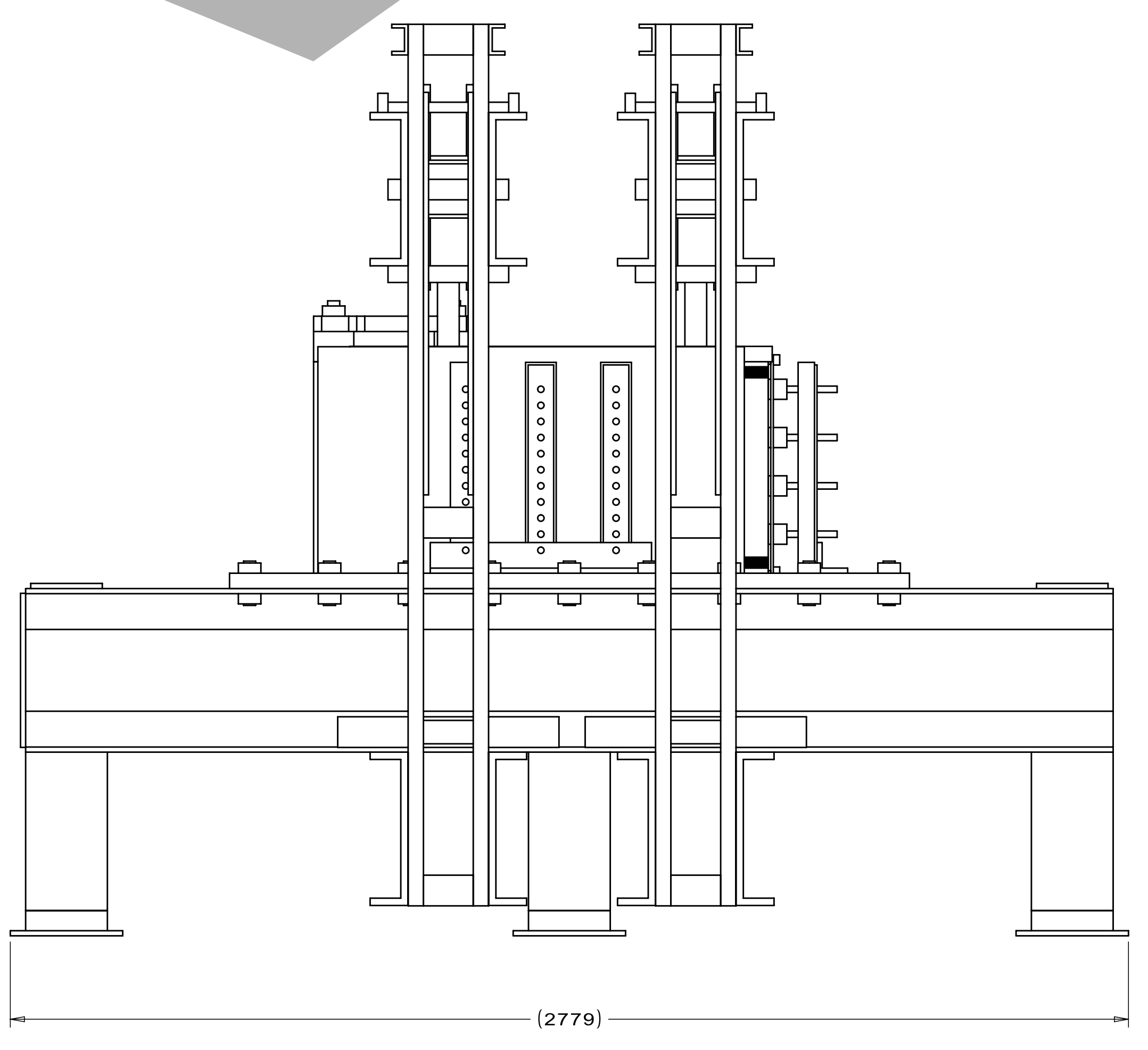
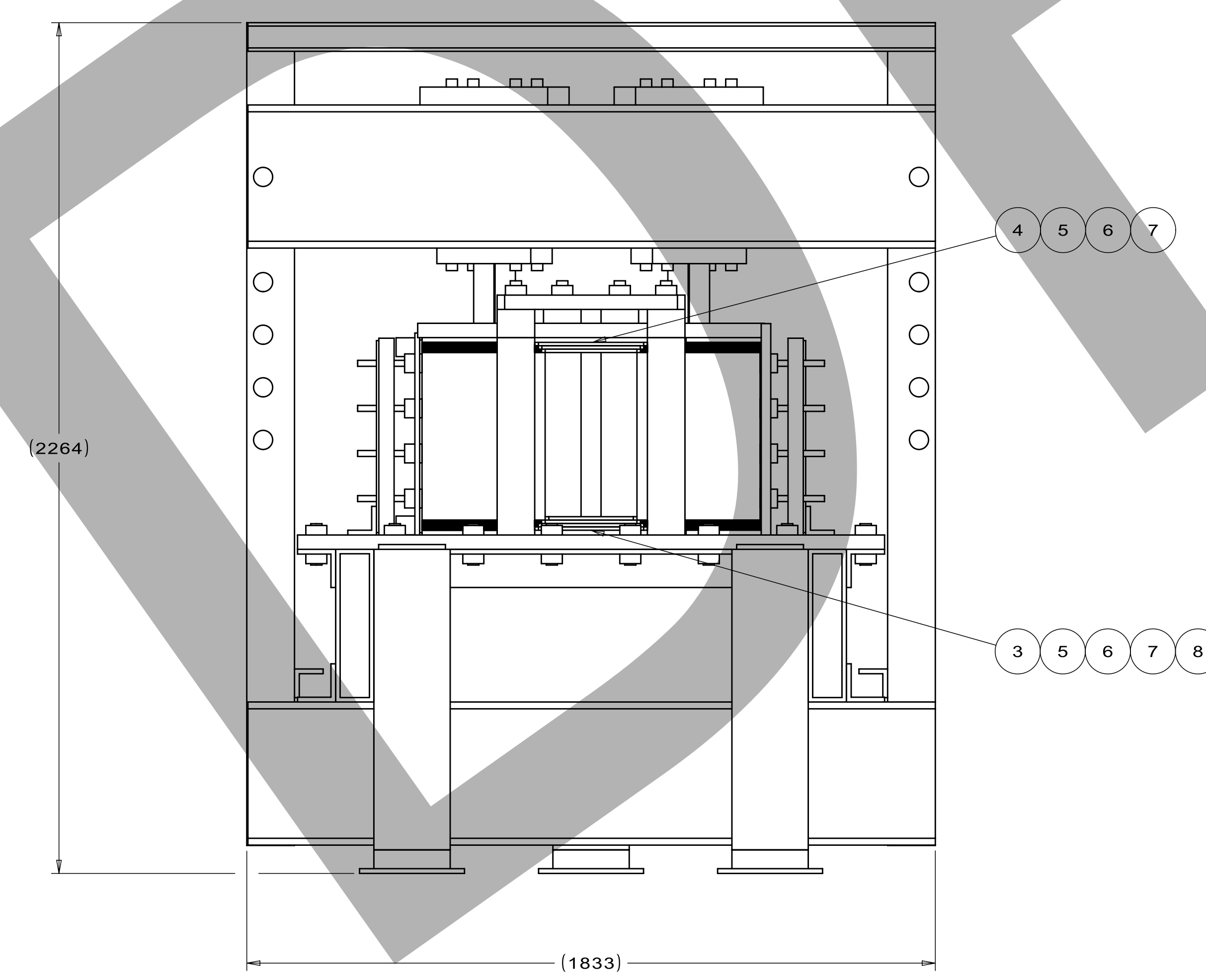
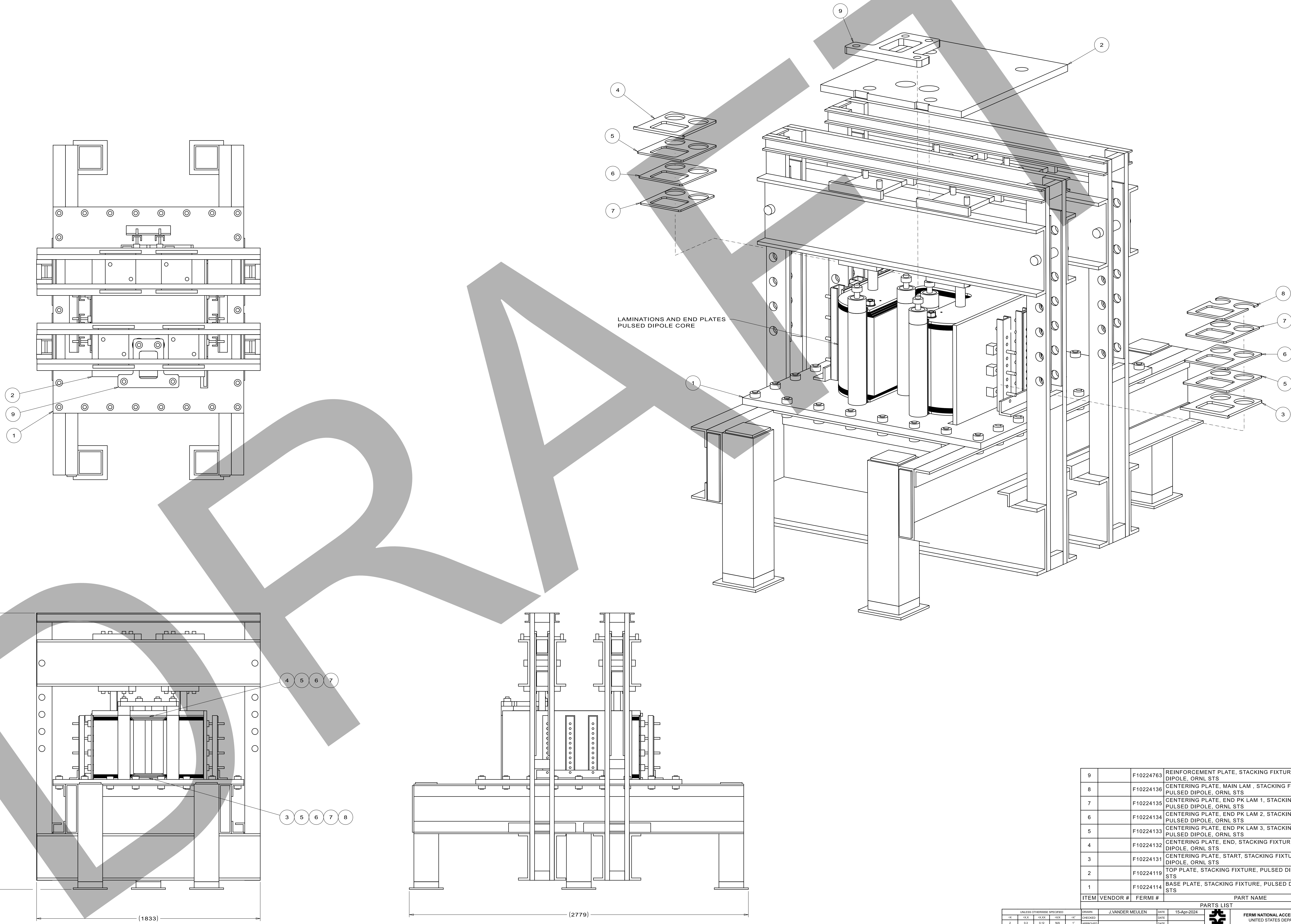
4

3

2

1

TEMPLATE VERSION: 2021.06.06



ITEM	VENDOR #	FERMI #	PART NAME	QTY
9		F10224763	REINFORCEMENT PLATE, STACKING FIXTURE, PULSED DIPOLE, ORNL STS	1
8		F10224136	CENTERING PLATE, MAIN LAM, STACKING FIXTURE, PULSED DIPOLE, ORNL STS	1
7		F10224135	CENTERING PLATE, END PK LAM 1, STACKING FIXTURE, PULSED DIPOLE, ORNL STS	2
6		F10224134	CENTERING PLATE, END PK LAM 2, STACKING FIXTURE, PULSED DIPOLE, ORNL STS	2
5		F10224133	CENTERING PLATE, END PK LAM 3, STACKING FIXTURE, PULSED DIPOLE, ORNL STS	2
4		F10224132	CENTERING PLATE, END, STACKING FIXTURE, PULSED DIPOLE, ORNL STS	1
3		F10224131	CENTERING PLATE, START, STACKING FIXTURE, PULSED DIPOLE, ORNL STS	1
2		F10224119	TOP PLATE, STACKING FIXTURE, PULSED DIPOLE, ORNL STS	1
1		F10224114	BASE PLATE, STACKING FIXTURE, PULSED DIPOLE, ORNL STS	1

UNLESS OTHERWISE SPECIFIED		DRAWN	J VANDER MEULEN	DATE	15-Apr-2024
IN	IN	CHECKED		DATE	
2	0.3	APPROVED		DATE	
BREAK ALL DIMENSIONS MAX. 1/8"		FERMILAB			
DO NOT SCALE DRAWING		FERMI NATIONAL ACCELERATOR LABORATORY			
DIMENSIONS BASED ON ASME Y14.5A-2009		UNITED STATES DEPARTMENT OF ENERGY			
MAX MACHINE ALL SURFACES, Pn 3.2		STACKING FIXTURE, PULSED DIPOLE, ORNL STS			
DRAWING UNIT: MM		SCALE: 1:10.8			
		SIZE: A0			
		DRAWING NUMBER: F10224107			
		SHEET: 1 of 1			
		REV: -			