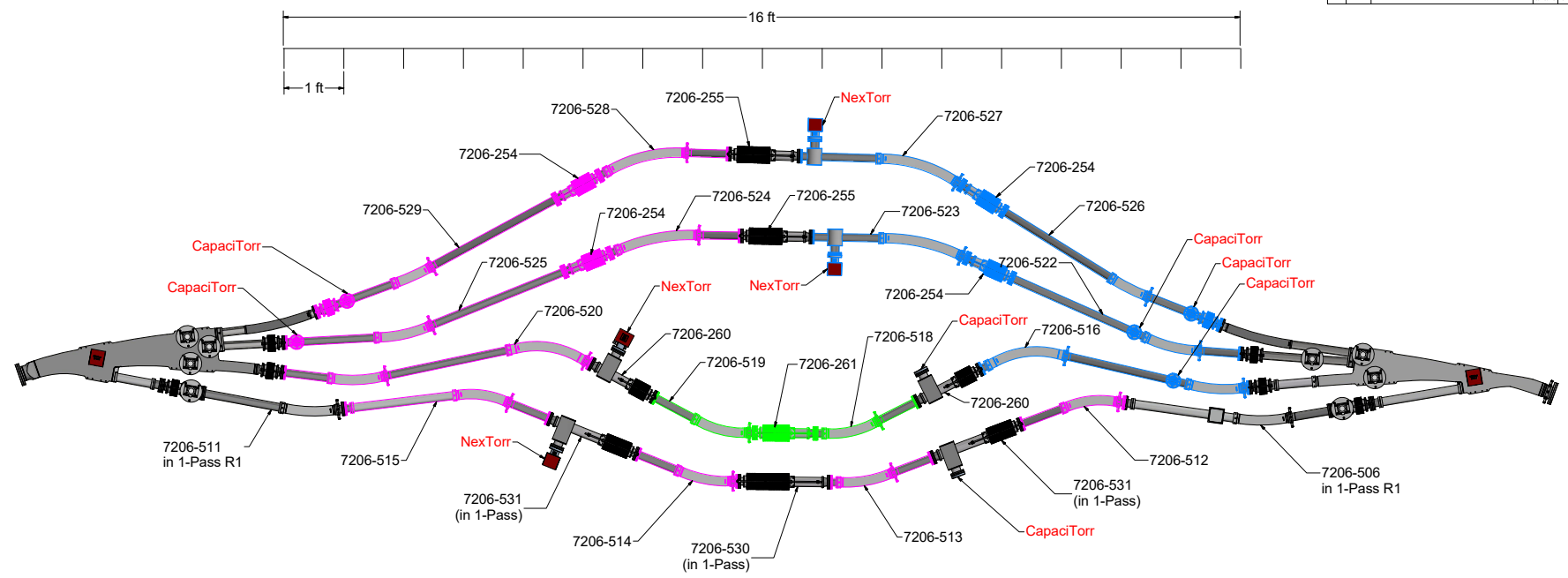


REVISIONS		DATE	APP
SYM	ZONE	DESCRIPTION	
		Initial Release	3/28/19 JLT



**R1 Assembly Instruction:**

- Clean four colored components (7206-515, -514, -513, -512), and dry over night, in Newman Clean Room.
- Assemble these components into one string, only visually align them in one-plane, in Newman Clean Room.
- Pump down the string in Newmna Clean Room and leak check.
- Transport the string under vacuum to Wilson R-128 for bakeout.
- Transport to L0E Clean Tent for flow-controlled venting, and separation into individual beampipe, readying for installation.

**R2 Assembly Instruction:**

- Clean seven colored components (7206-520, -519, -518, -516, -260X2, -261), and dry over night, in Newman Clean Room.
- Assemble these components into three strings, as color coded, in Newman Clean Room. Need to use jig plate to assure all components in one plane. (String 1: -520) (String 2: -519, -261, -518) (String 3: -516)
- Pump down the strings in Newmna Clean Room and leak check.
- Transport the strings under vacuum to Wilson R-128 for bakeout.
- Transport to L0E Clean Tent for flow-controlled venting, and readying for installation.

**R3 Assembly Instruction:**

- Clean seven colored components (7206-525, -524, -523, -522, -254X2, -255), and dry over night, in Newman Clean Room.
- Assemble these components into twostrings, as color coded, in Newman Clean Room. Need to use jig plate to assure all components in one plane. (String 1: -525, -254, -524) (String 2: -523, -254, -522)
- Pump down the strings in Newmna Clean Room and leak check.
- Transport the strings under vacuum to Wilson R-128 for bakeout.
- Transport to L0E Clean Tent for flow-controlled venting, and readying for installation.

**R4 Assembly Instruction:**

- Clean seven colored components (7206-529, -528, -527, -526, -254X2, -255), and dry over night, in Newman Clean Room.
- Assemble these components into twostrings, as color coded, in Newman Clean Room. Need to use jig plate to assure all components in one plane. (String 1: -529, -254, -528, -255) (String 2: -527, -254, -526)
- Pump down the strings in Newmna Clean Room and leak check.
- Transport the strings under vacuum to Wilson R-128 for bakeout.
- Transport to L0E Clean Tent for flow-controlled venting, and readying for installation.

**Additional Instruction:**

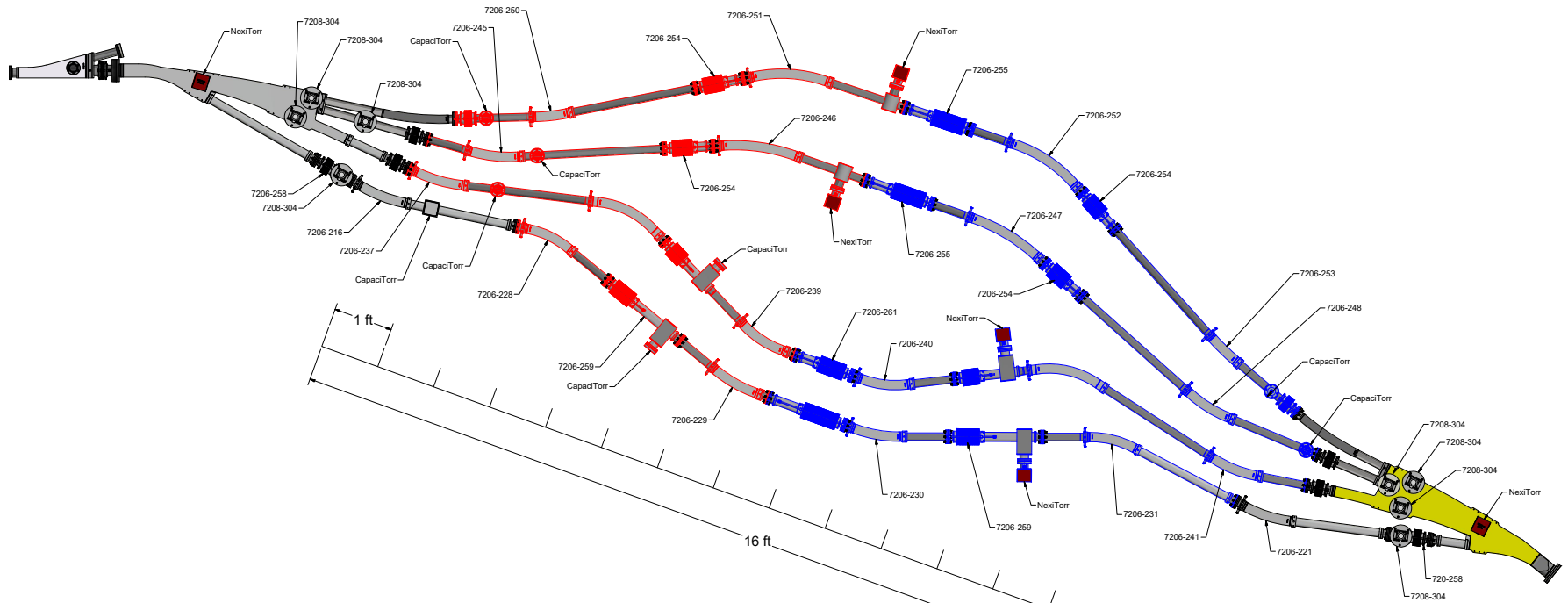
- All BLACK-colored components are to be cleaned and baked separately.
- R1: Four colored beampipes will be installed into the beamline separately.
- R2: Three colored strings will be installed into the beamline, then two units of 7206-260 (ready) will be inserted.
- R3: Two colored strings will be installed into the beampipe, then 7206-255 will be inserted.
- R4: Two colored strings will be installed into the beampipe, then 7206-255 will be inserted.

REV	DESCRIPTION	DATE	QUANTITY			REMARKS
			G1	G2	G3	

<p>7206-500 YL          CR-1          1/2019          REVISION</p>	<p>UNLESS OTHERWISE SPECIFIED          DIMENSIONS ARE IN MILLIMETERS          TOLERANCES ON          X ± 0.5          Y ± 0.5          H ± 0.1          H ± 0.1          ANGLES ± 0.5          ALL SURFACES ✓</p>	<p>PLANT DATE:          CAD FILE NAME: 7206-500 YL.i2d</p>	<p>THESE DRAWINGS, WHICH CONTAIN PROPRIETARY INFORMATION, ARE THE PROPERTY OF CORNELL UNIVERSITY. USE OF THESE DRAWINGS BEYOND THE INTENDED PURPOSE IN SUPPORT OF OUR RESEARCH AS DESCRIBED AND FUNDED BY OUR SPONSORING AGENCIES MUST BE NEGOTIATED AND APPROVED IN ADVANCE BY CORNELL UNIVERSITY.</p>	<p>Cornell Laboratory for Accelerator-based ScienceS and Education (CLASSE)</p> <p><b>Vacuum String 4-Pass          RX 4-Pass Assembly</b></p>
<p>DRAWN BY: J.Turco          DRAWN FOR: D.Burke          DATE: 6/19/2018          SCALE: D</p>	<p>7206-500 YL          sh.no. 1 of 2</p>	<p>REV.</p>		

		REVISIONS	
SYM	ZONE	DESCRIPTION	DATE APP
		Initial Release	5/16/18 JLT



### SX 4-Pass

REV.	REMARKS	G1	G2	G3	QUANTITY		
					QTY	UNIT	TOTAL
1							

 Cornell Laboratory for Accelerator-based Science and Education (CLASSE)	DRAWN BY J.Turco	DRAWN FOR D.Burke	DATE 6/19/2018	SCALE D	REV. 7206-225 sh. no. 1 of 1
---	---------------------	----------------------	-------------------	------------	------------------------------------

THESE DRAWINGS, WHICH CONTAIN PROPRIETARY INFORMATION, ARE THE PROPERTY OF CORNELL UNIVERSITY. USE OF THESE DRAWINGS BEYOND THE INTENDED PURPOSE IN SUPPORT OF OUR RESEARCH AS DESCRIBED AND FUNDED BY OUR SPONSORING AGENCIES MUST BE NEGOTIATED AND APPROVED IN ADVANCE BY CORNELL UNIVERSITY.

ITEM DWG. NO. DESCRIPTION  
 CR-1 7206-225-1 Vacuum String from MLC to End of 4-Pass SX 4-Pass Assembly  
 UNLESS OTHERWISE SPECIFIED  
 DIMENSIONS ARE IN MILLIMETERS  
 TO DIMENSIONS ON  
 X 3.0  
 XX 2.0  
 XXX 1.5  
 ANGLES 1:1  
 ALL SURFACES  $\sqrt{R}$

PRINT DIST. D  
 7206-225-1  
 CR-1