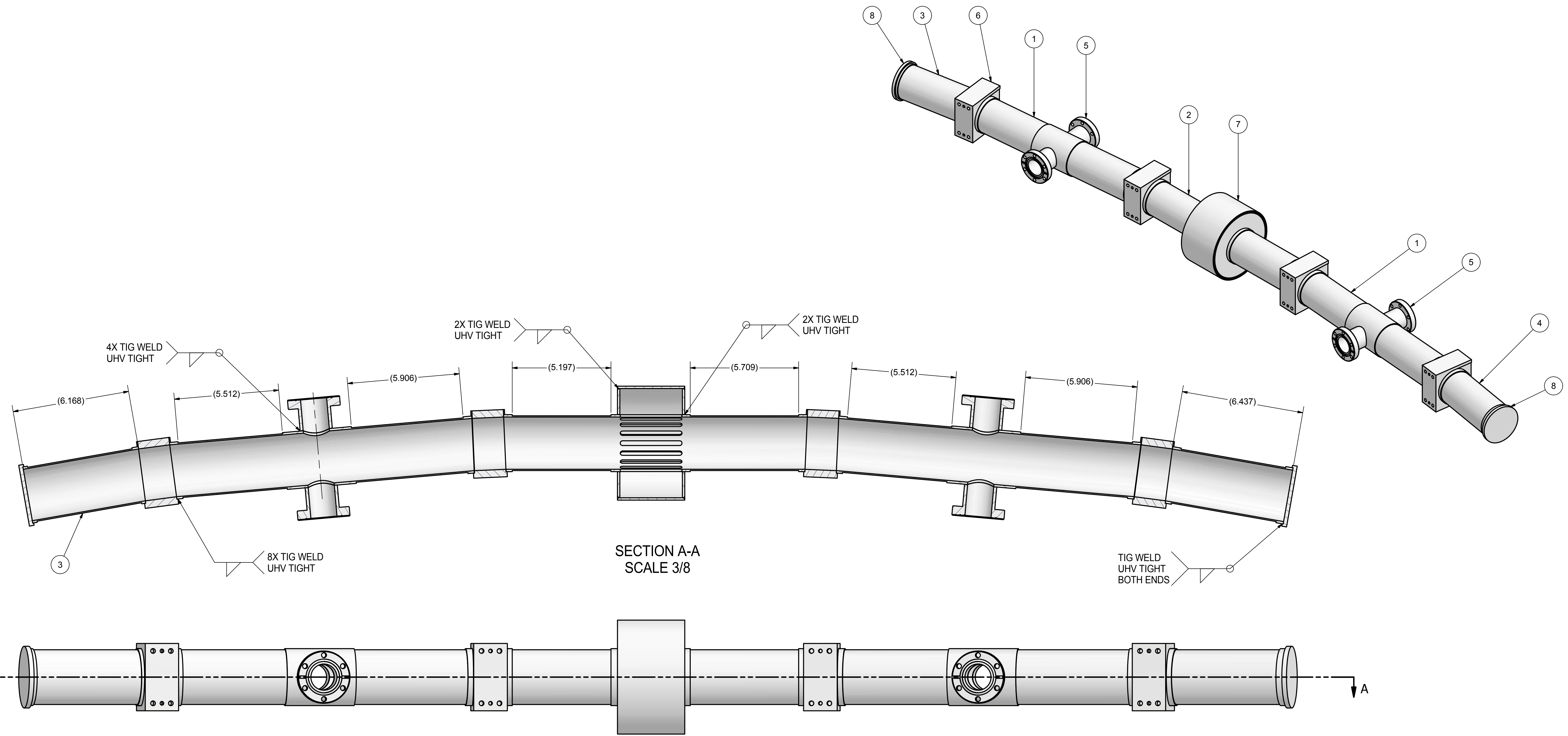


REVISIONS				
SYM	ZONE	DESCRIPTION	DATE	APP
		Initial Release		

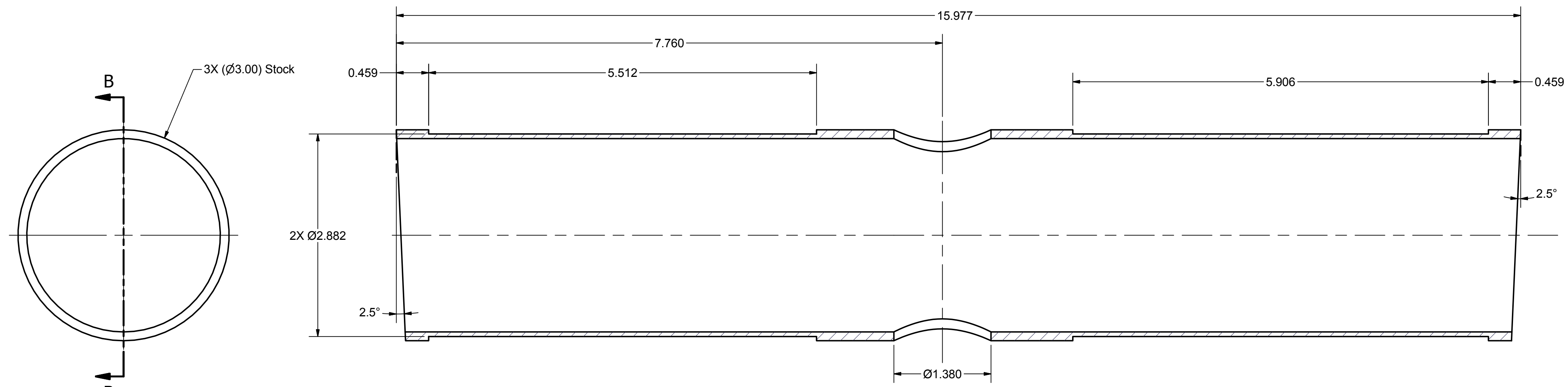


NOTE: 1) BEAMPIPES (PARTS 1-4) ARE NOT SYMMETRICAL. PLACE AND ORIENT THEM ACCORDINGLY.  
 2) REFER TO ASSEMBLY SETUP AND INSTRUCTIONS ON SHEET 4.

ITEM	DWG. NO.	DESCRIPTION	G1	G2	G3	REMARKS	REV.
8	Sheet 3	End Cap	2				
7	7206-612	FFAG Dummy Pump Port	1				
6	Sheet 3	Dummy Block	4				
5	7206-615	FFAG Viewer Port Flange	4				
4	Sheet 3	End Beam Pipe, Flange End	1				
3	Sheet 3	End Beam Pipe, SLD JT End	1				
2	Sheet 2	Long Beam Pipe, Pump Port	1				
1	Sheet 2	Long Beam Pipe, Beam View Port	2				

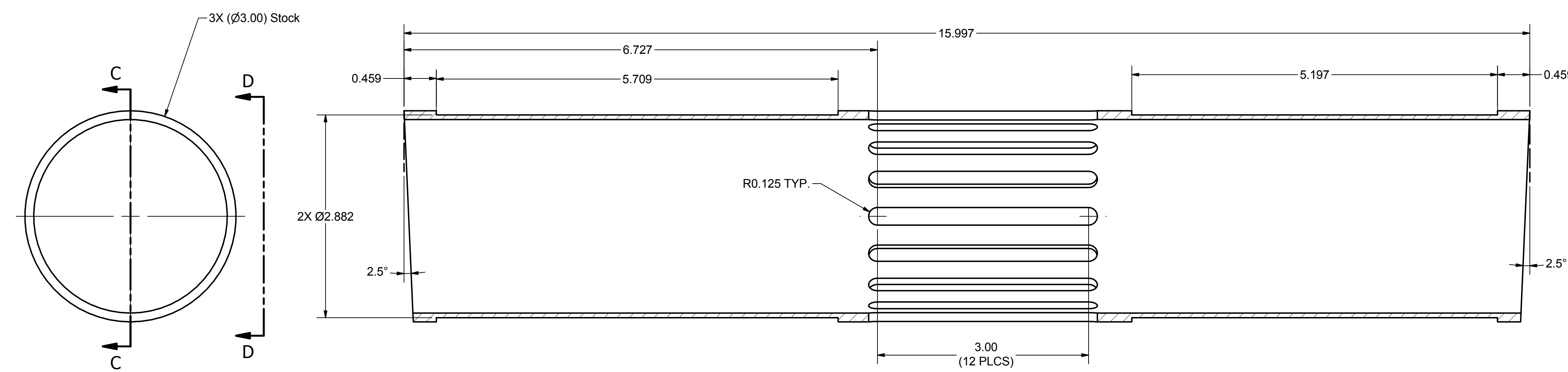
D	PRINT	PLOT DATE: CAD FILE NAME: 7206-301 Dummy.idw	<table border="1"> <tr> <th>QUANTITY</th> <th>REMARKS</th> <th>REV.</th> </tr> <tr> <td></td> <td></td> <td></td> </tr> </table>				QUANTITY	REMARKS	REV.			
	QUANTITY		REMARKS	REV.								
DISTR.	CR-1	UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES; TOLERANCES ON: 0 ± .02 .00 ± .010 .000 ± .005 FRACTIONS ± 1/32 ANGLES ± 0.5° ALL SURFACES	Cornell Laboratory for Accelerator-based ScienceS and Education (CLASSE)									
REV.	7206-301D SH. NO. 1 OF 5	CHECKED BY: S Hartman APPROVED BY: Y Li	DRAWN BY: Y Li	DRAWN FOR: 2	DATE: 2/17/2017	SCALE: D	7206-301D SH. NO. 1 OF 5	REV.				

REVISIONS				
SYM	ZONE	DESCRIPTION	DATE	APP
		Initial Release		



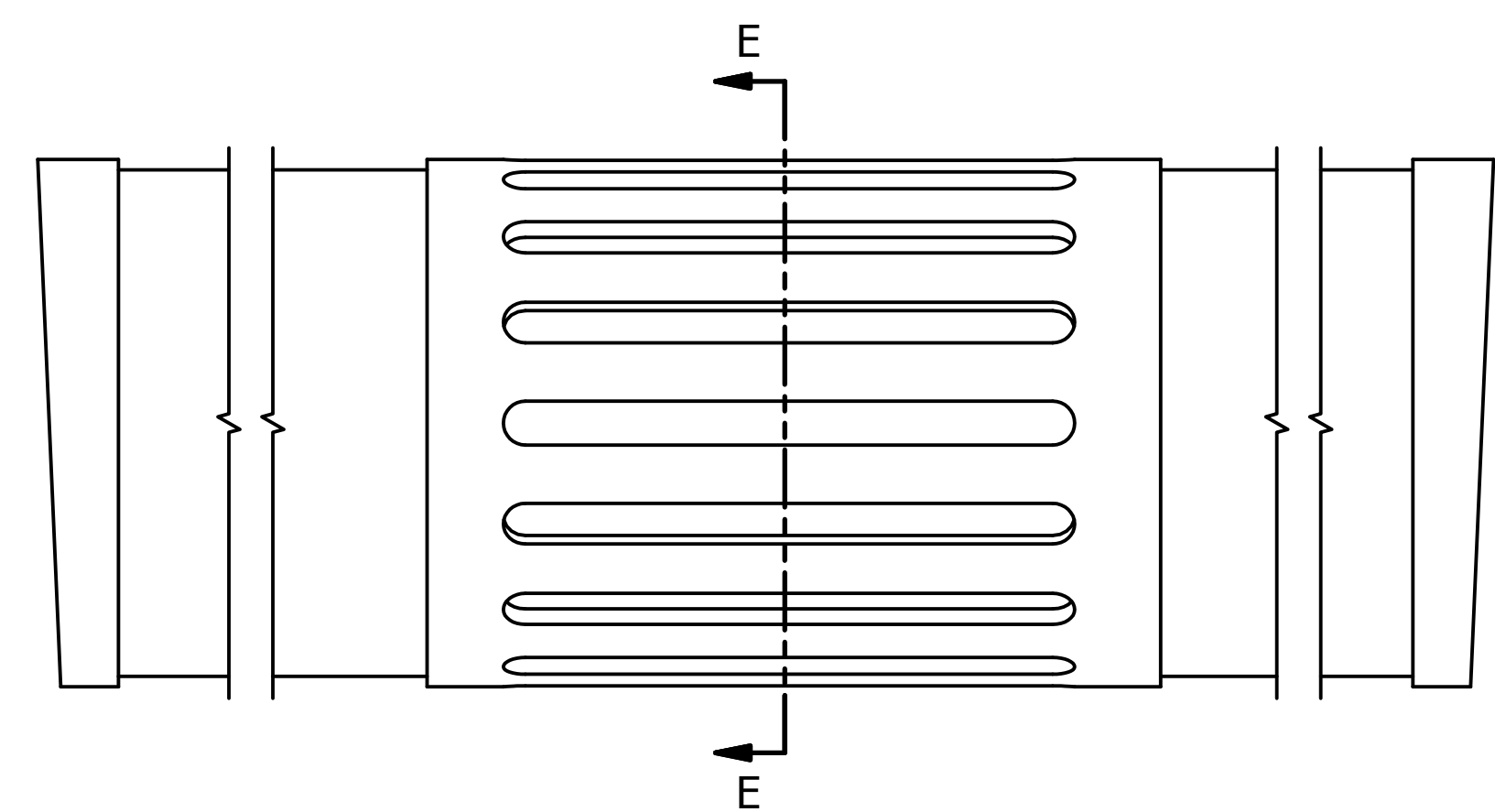
SECTION B-B  
SCALE 1:1

1 Long Beam Pipe, Beam View Port  
 FILE NAME: 7206-301D  
 SHEET NO.: 2  
 DFT. SCALE: 1:1  
 MATERIAL: 6061-T6 Alum, 3.00" OD, 0.125" wall  
 QTY: 2  
 NOTES:

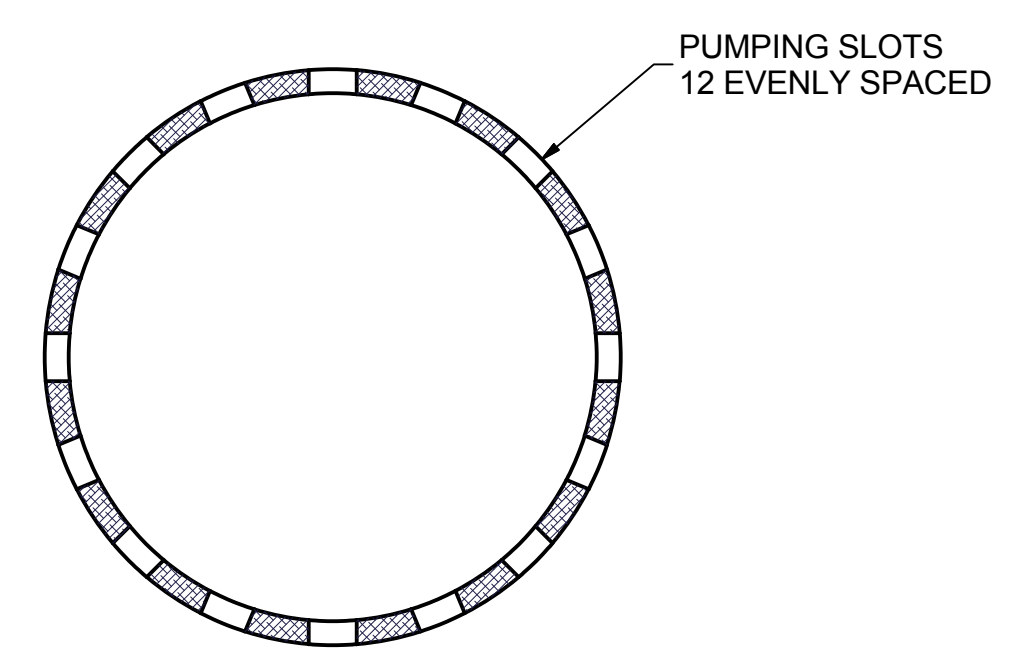


SECTION C-C  
SCALE 1:1

2 Long Beam Pipe, Pump Port  
 FILE NAME: 7206-301D  
 SHEET NO.: 2  
 DFT. SCALE: 1:1  
 MATERIAL: 6061-T6 Alum, 3.00" OD, 0.125" wall  
 QTY: 1  
 NOTES:



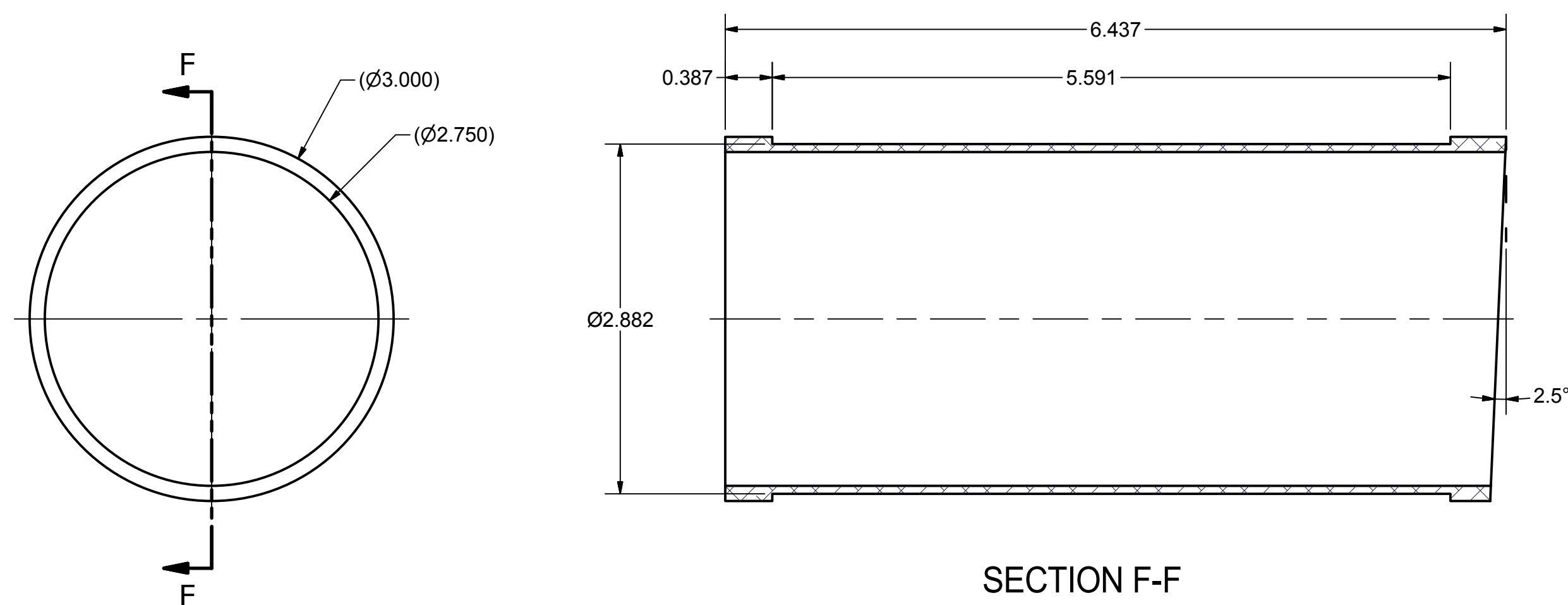
VIEW D-D  
SCALE 1:1



SECTION E-E  
SCALE 1:1

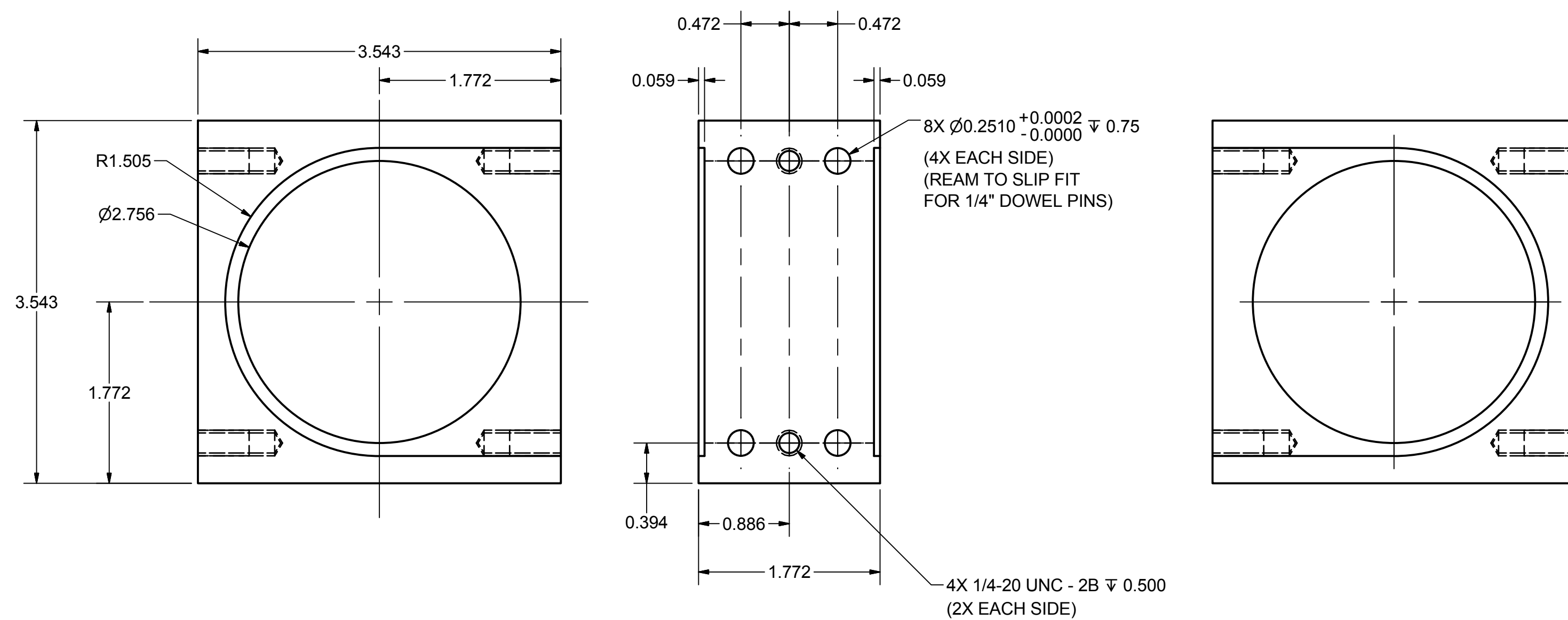
ITEM	DWG. NO.	DESCRIPTION	G1	G2	G3	REMARKS	REV.
			QUANTITY				
PRINT DISTR.		PLOT DATE: CAD FILE NAME: 7206-301 Dummy.idw					
7206-301D SH. NO. 2 OF 5	CR-1	UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES: TOLERANCES ON: 0 ± .02 .00 ± .010 0.00 ± .005 FRACTIONS ± 1/32 ANGLES ± 0.5° ALL SURFACES	 Cornell Laboratory for Accelerator-based ScienceS and Education (CLASSE)			Dummy FA 4-Cell Chamber for Welding Test	
REV.	CHECKED BY: S Hartman	DRAWN BY	DRAWN FOR	DATE	SCALE	D	7206-301D SH. NO. 2 OF 5
	APPROVED BY: Y Li			2/17/2017			

REVISIONS				
SYM	ZONE	DESCRIPTION	DATE	APP
		Initial Release		

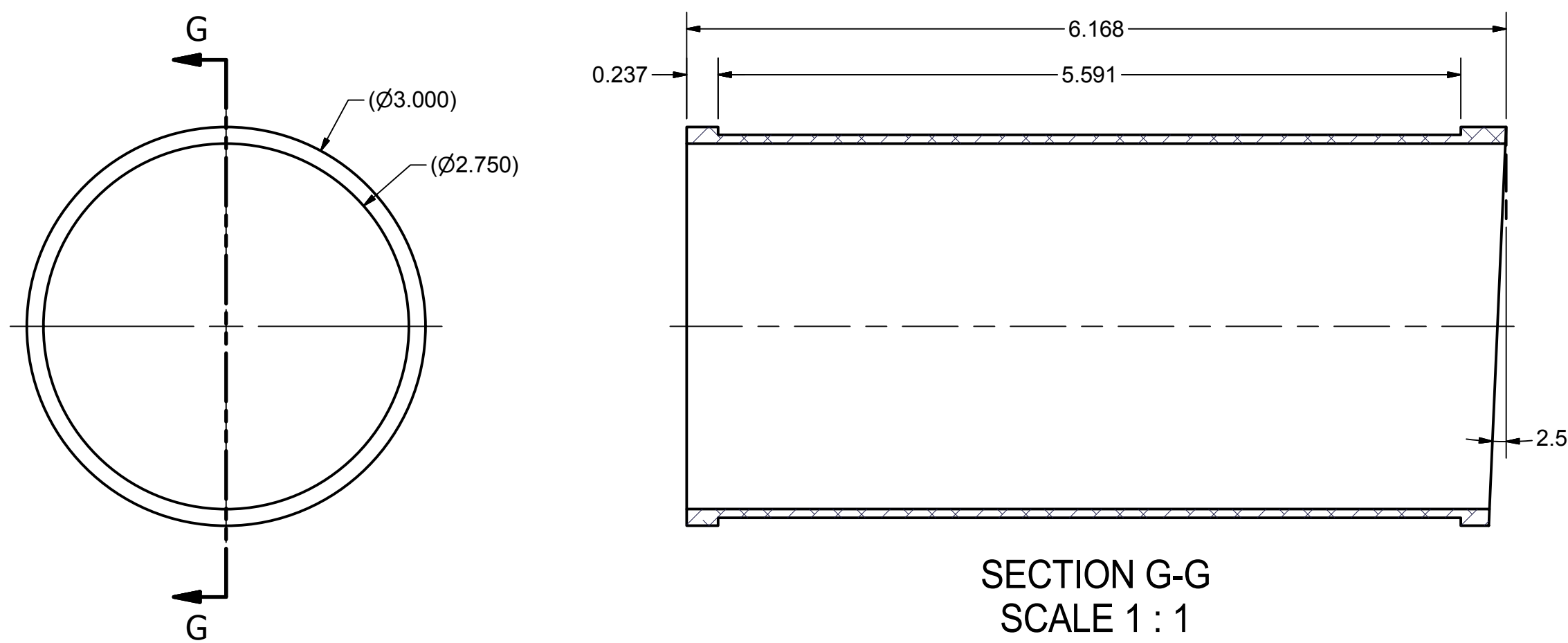
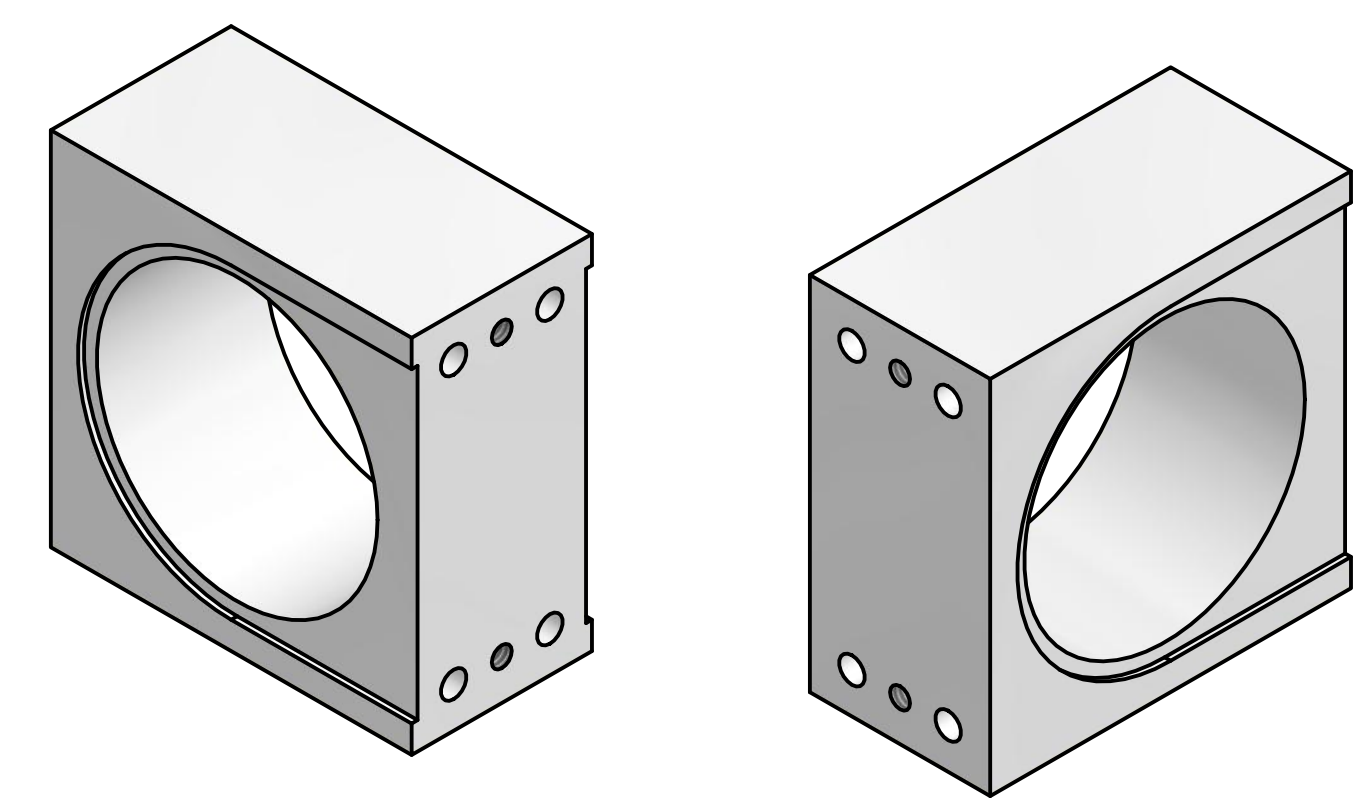


SECTION F-F  
SCALE 1 : 1

**4** End Beam Pipe, SLD JT End  
 FILE NAME: 7206-301D  
 SHEET NO.: 3  
 DFT. SCALE: 1 : 1  
 MATERIAL: 6061-T6 Alum, 3.00" OD, 0.125" Wall  
 QTY: 1  
 NOTES:

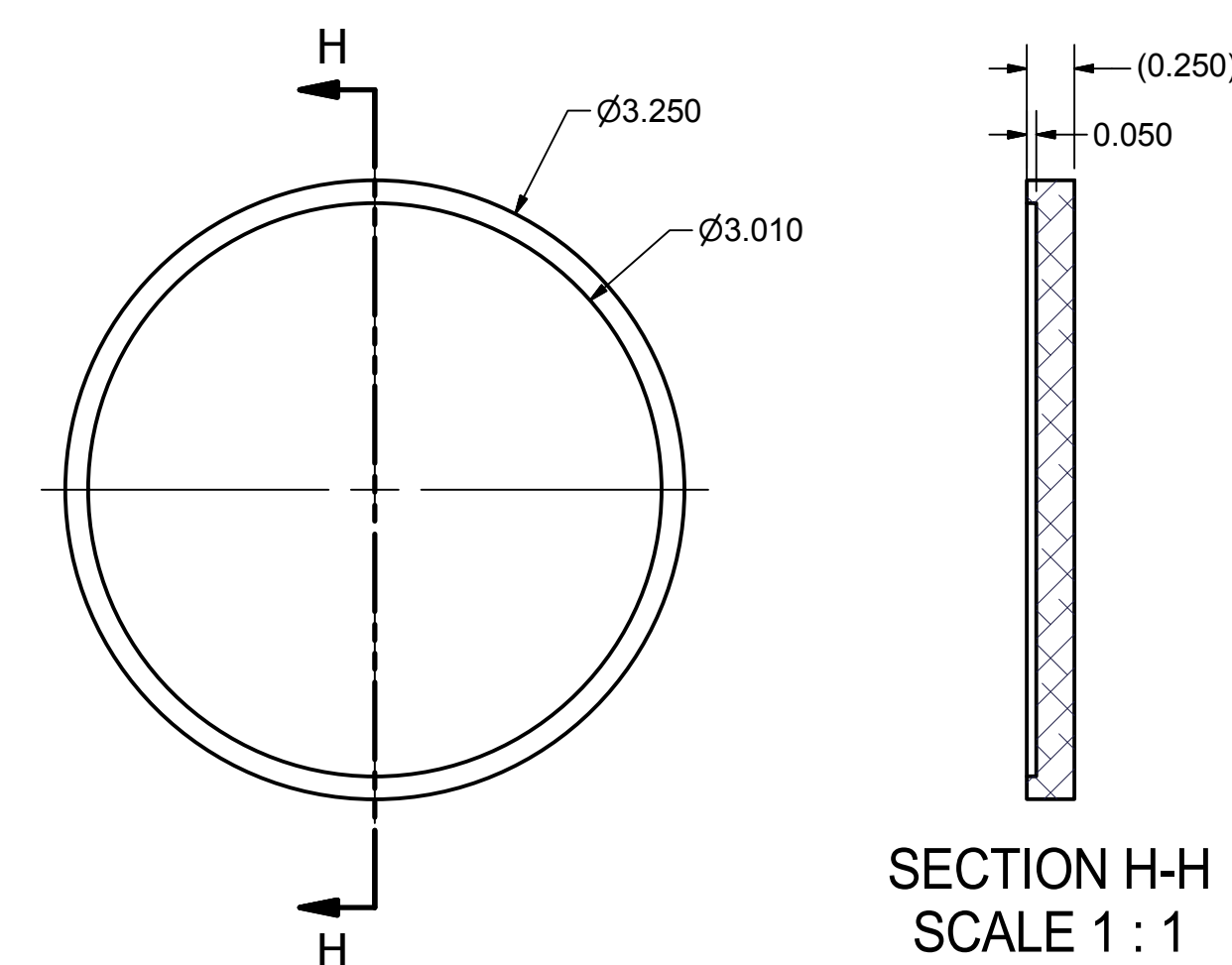


**6** Dummy BPM Block  
 FILE NAME: 7206-301D  
 SHEET NO.: 3  
 DFT. SCALE: 1 : 1  
 MATERIAL: 6061-T6 Alum  
 QTY: 4  
 NOTES:



SECTION G-G  
SCALE 1 : 1

**3** End Beam Pipe, Flange End  
 FILE NAME: 7206-301D  
 SHEET NO.: 3  
 DFT. SCALE: 1 : 1  
 MATERIAL: 6061-T6 Alum, 3.00" OD, 0.125" Wall  
 QTY: 1  
 NOTES:



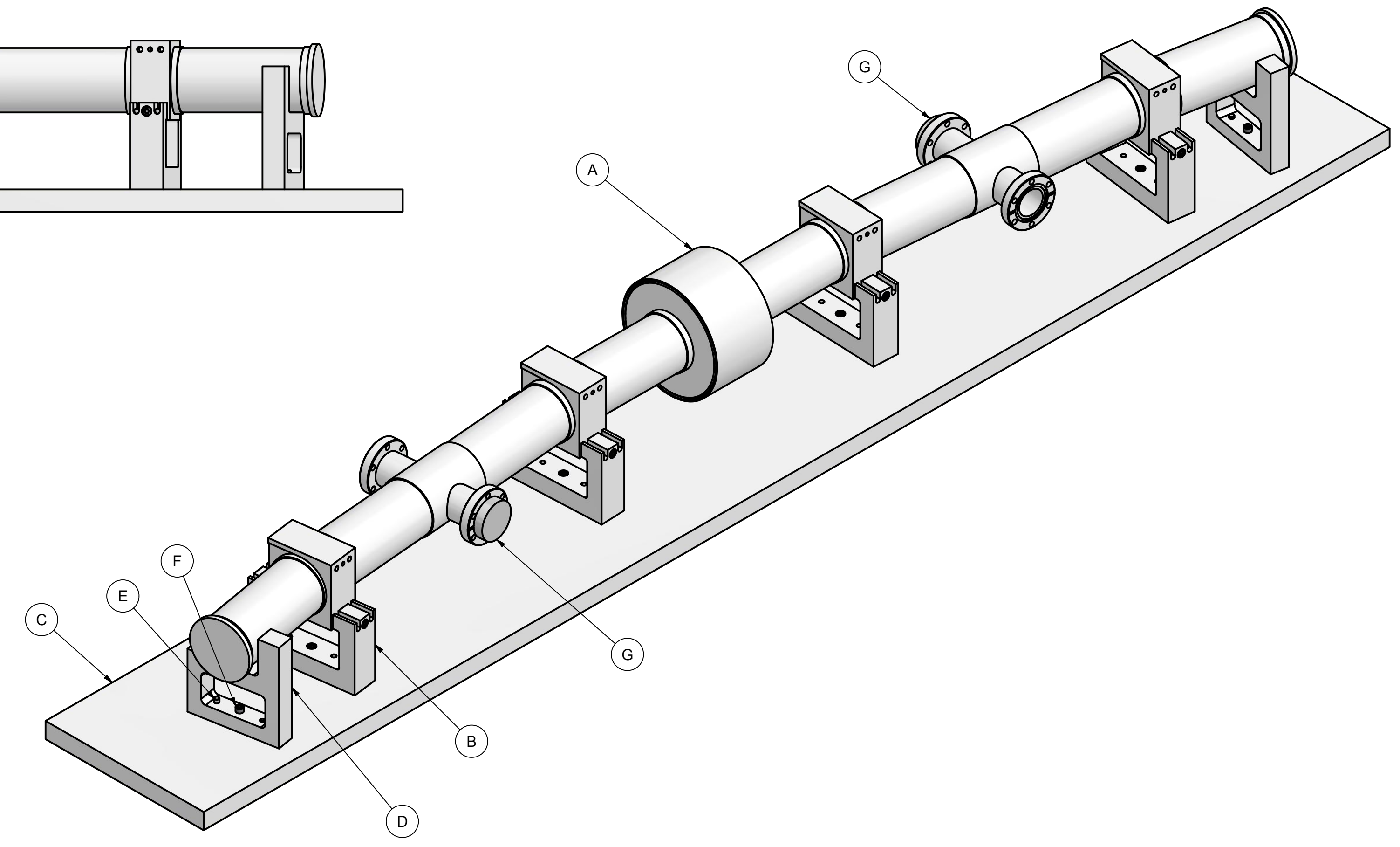
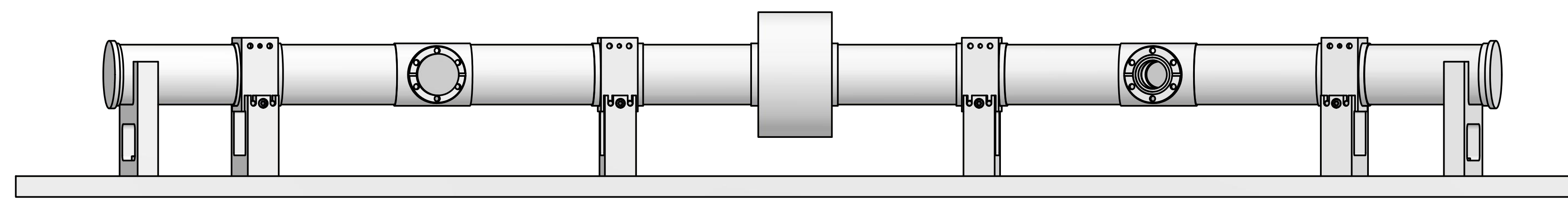
SECTION H-H  
SCALE 1 : 1

**8** End Cap  
 FILE NAME: 7206-301D  
 SHEET NO.: 3  
 DFT. SCALE: 1 : 1  
 MATERIAL: 6061-T6 Alum  
 QTY: 2  
 NOTES:

ITEM	DWG. NO.	DESCRIPTION	G1	G2	G3	REMARKS	REV.	
			QUANTITY					
<b>D</b>	PRINT DISTR.	PLOT DATE: CAD FILE NAME: 7206-301 Dummy.idw					Cornell Laboratory for Accelerator-based ScienceS and Education (CLASSE) <b>Dummy FA 4-Cell Chamber for Welding Test</b>	
	CR-1	UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES: TOLERANCES ON: 0 ± .02 .00 ± .010 .000 ± .005 FRACTIONS ± 1/32 ANGLES ± 0.5° ALL SURFACES						
	7206-301D SH. NO. 3 OF 5	7206-301D						
REV.	CHECKED BY: S Hartman	DRAWN BY	DRAWN FOR	DATE	SCALE	<b>D</b>	7206-301D SH. NO. 3 OF 5	
	APPROVED BY: Y Li			2/17/2017				



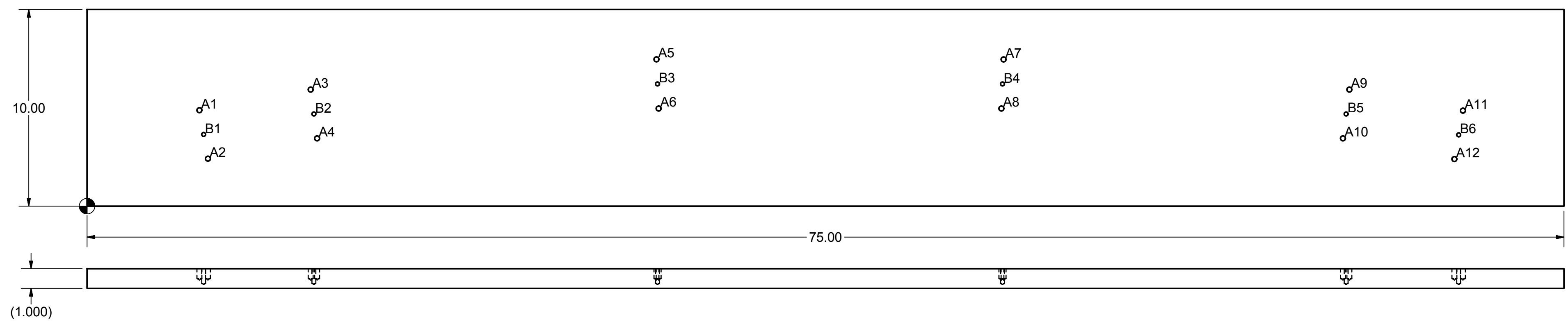
REVISIONS				
SYM	ZONE	DESCRIPTION	DATE	APP
		Initial Release		



HOLE	XDIM	YDIM	DESCRIPTION
A1	5.704	4.877	Ø0.2495±0.0005 ∇ 0.500
A2	6.138	2.415	Ø0.2495±0.0005 ∇ 0.500
A3	11.355	5.926	Ø0.2495±0.0005 ∇ 0.500
A4	11.681	3.448	Ø0.2495±0.0005 ∇ 0.500
A5	28.914	7.463	Ø0.2495±0.0005 ∇ 0.500
A6	29.024	4.965	Ø0.2495±0.0005 ∇ 0.500
A7	46.542	7.462	Ø0.2495±0.0005 ∇ 0.500
A8	46.432	4.964	Ø0.2495±0.0005 ∇ 0.500
A9	64.102	5.926	Ø0.2495±0.0005 ∇ 0.500
A10	63.776	3.448	Ø0.2495±0.0005 ∇ 0.500
A11	69.868	4.857	Ø0.2495±0.0005 ∇ 0.500
A12	69.434	2.394	Ø0.2495±0.0005 ∇ 0.500

Tapped Hole Table			
HOLE	XDIM	YDIM	DESCRIPTION
B1	5.921	3.646	1/4-20 UNC - 2B ∇ 0.500
B2	11.518	4.687	1/4-20 UNC - 2B ∇ 0.500
B3	28.969	6.214	1/4-20 UNC - 2B ∇ 0.500
B4	46.487	6.213	1/4-20 UNC - 2B ∇ 0.500
B5	63.939	4.687	1/4-20 UNC - 2B ∇ 0.500
B6	69.651	3.626	1/4-20 UNC - 2B ∇ 0.500

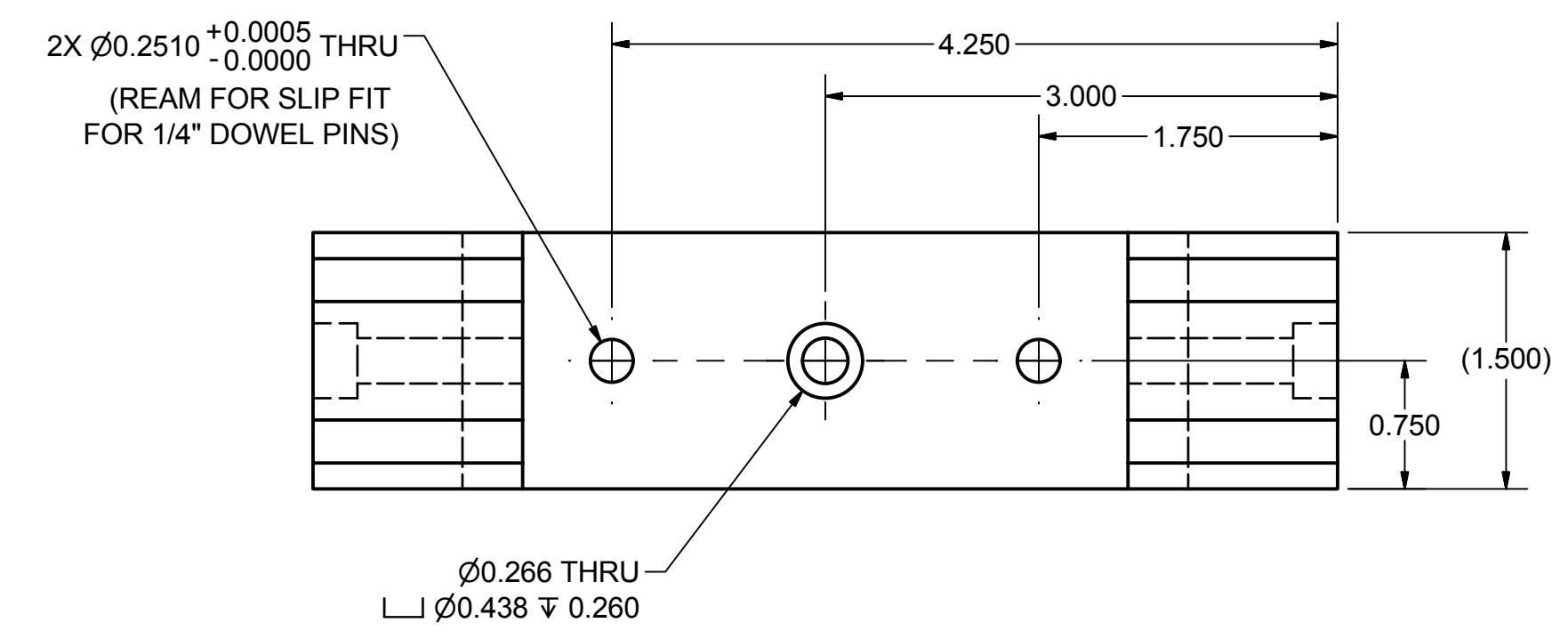
**C** Welding Base Jig Plate  
 FILE NAME: 7206-301D  
 SHEET NO.: 4  
 DFT. SCALE: 1 : 2  
 MATERIAL: 7075 ALuminum, 1.00" Thick  
 QTY: 1  
 NOTES:



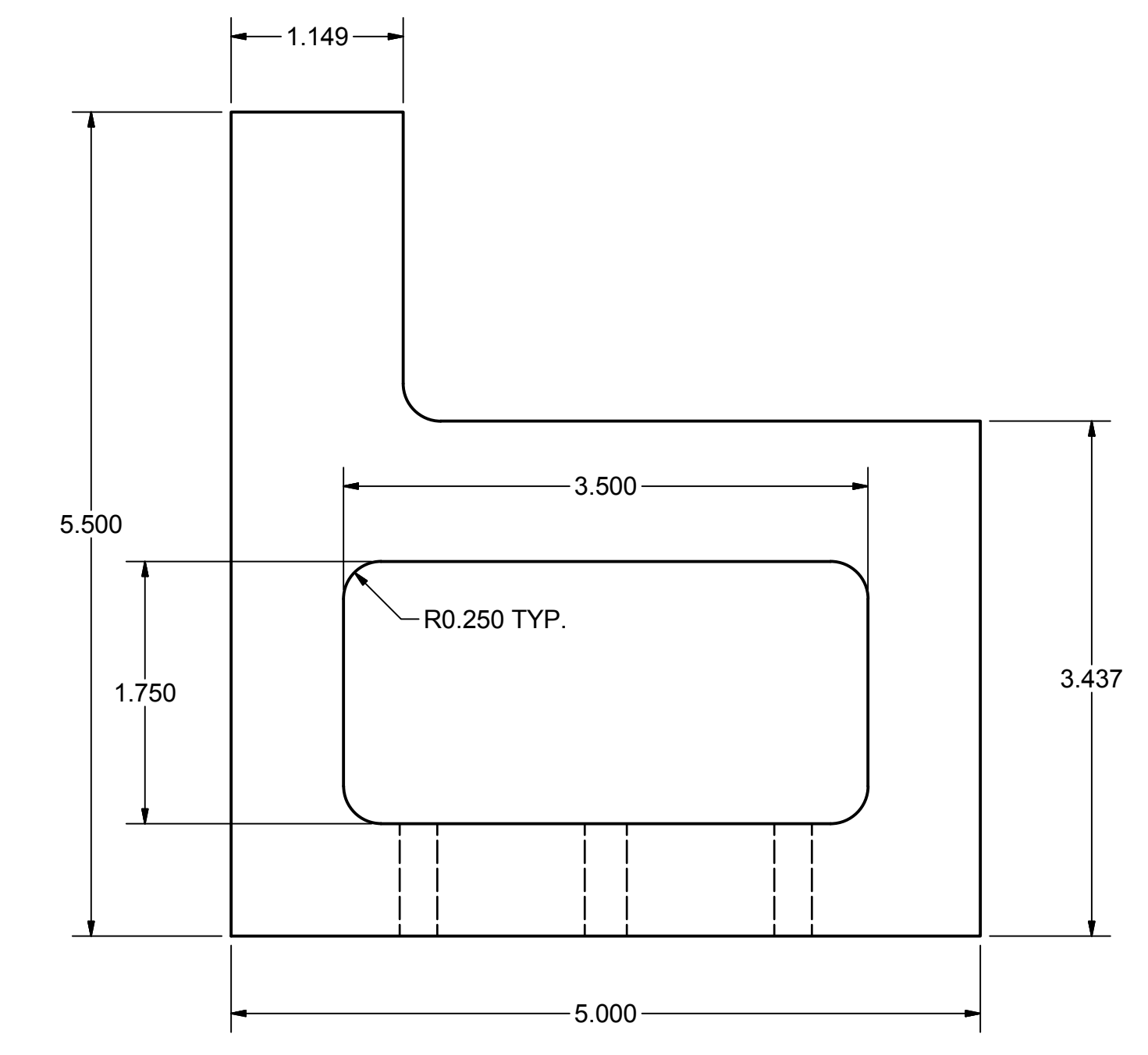
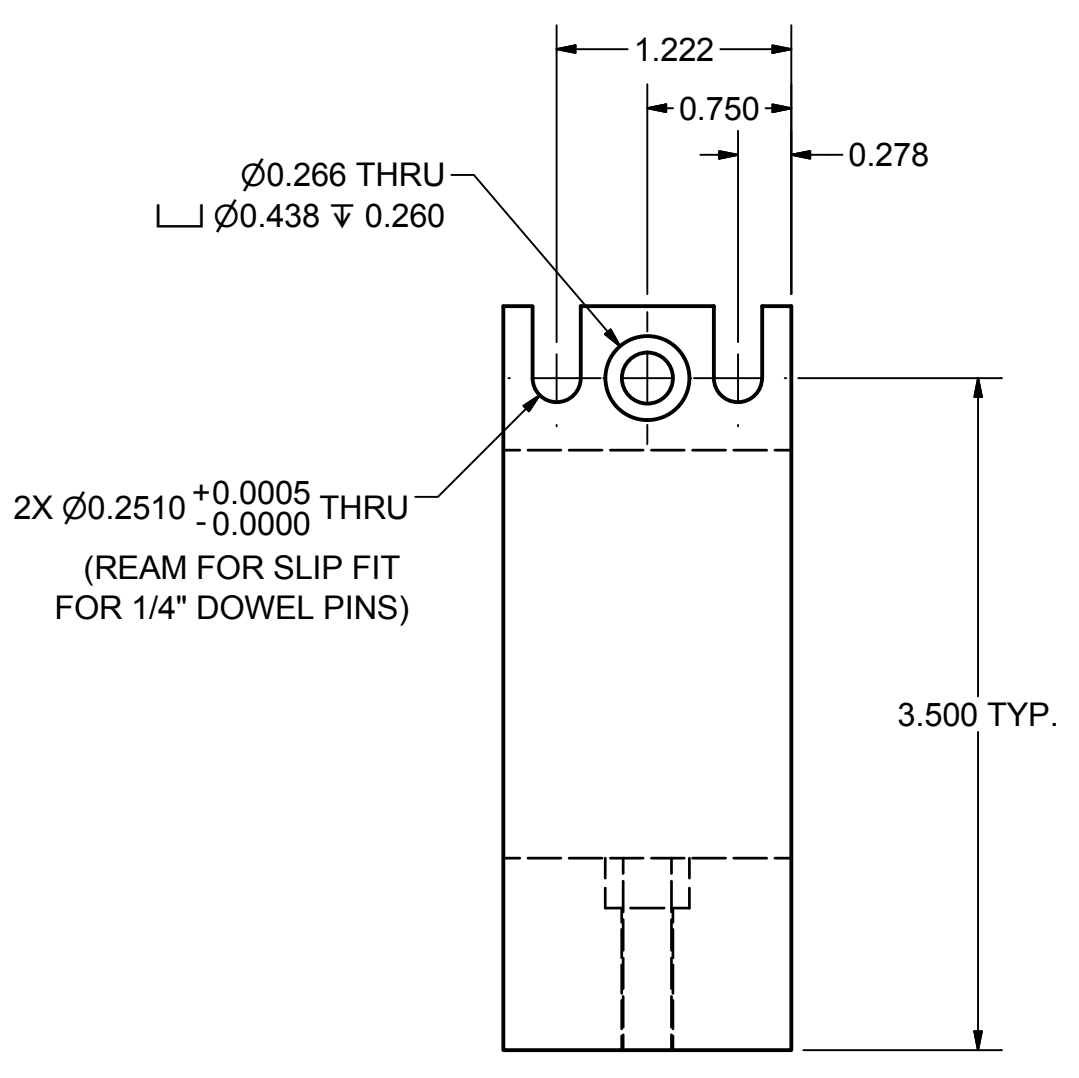
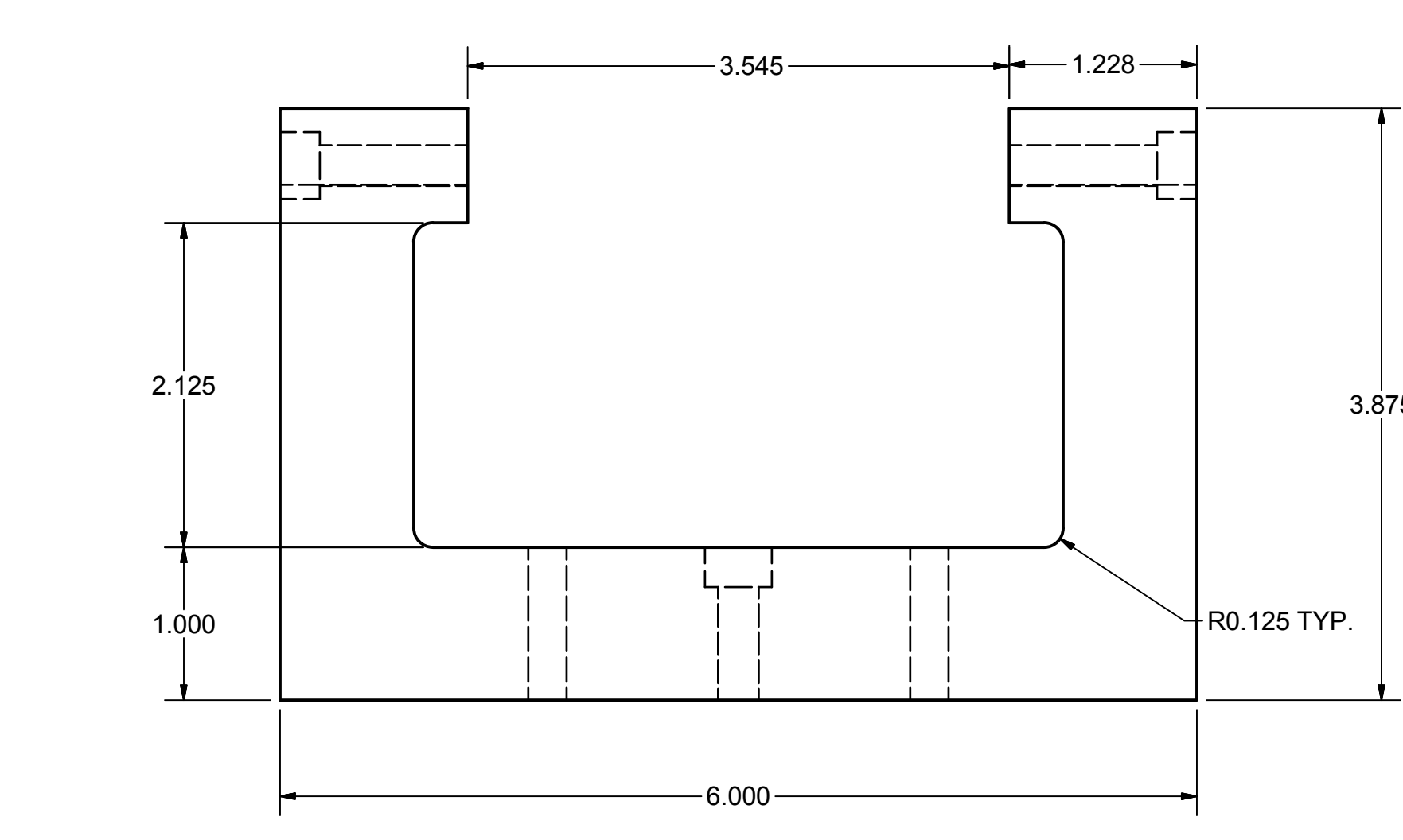
G	Sheet 5	Viewer Port Alignment Rod	2				
F	Stock	Hexagon Socket Head Cap Screw. 1/4 - 20 UNC - 1 1/4 HS HCS	14				
E	Purchased	Dowel Pin, 0.2500, 2" Long	20				
D	Sheet 5	End Pipe Jig Block	2				
C	Sheet 4	Base Jig Plate	1				
B	Sheet 5	BPM Jig Plate	4				
A	Sheet 1	Dummy FA GD1 Beampipe	1				

REV.	PRINT DISTR.	PLOT DATE: CAD FILE NAME: 7206-301 Dummy.idw	ITEM	DWG. NO.	DESCRIPTION	QUANTITY			REMARKS	REV.
						G1	G2	G3		
D	CR-1	UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES: TOLERANCES ON: Ø ± .02 .00 ± .010 .000 ± .005 FRACTIONS ± 1/32 ANGLES ± 0.5° ALL SURFACES ∇	Cornell Laboratory for Accelerator-based ScienceS and Education (CLASSE) <b>Dummy FA 4-Cell Chamber for Welding Test</b>							
		CHECKED BY: S Hartman	DRAWN BY	DRAWN FOR	DATE	SCALE	D	7206-301D	REV.	
		APPROVED BY: Y Li			2/17/2017			SH. NO. 4 OF 5		

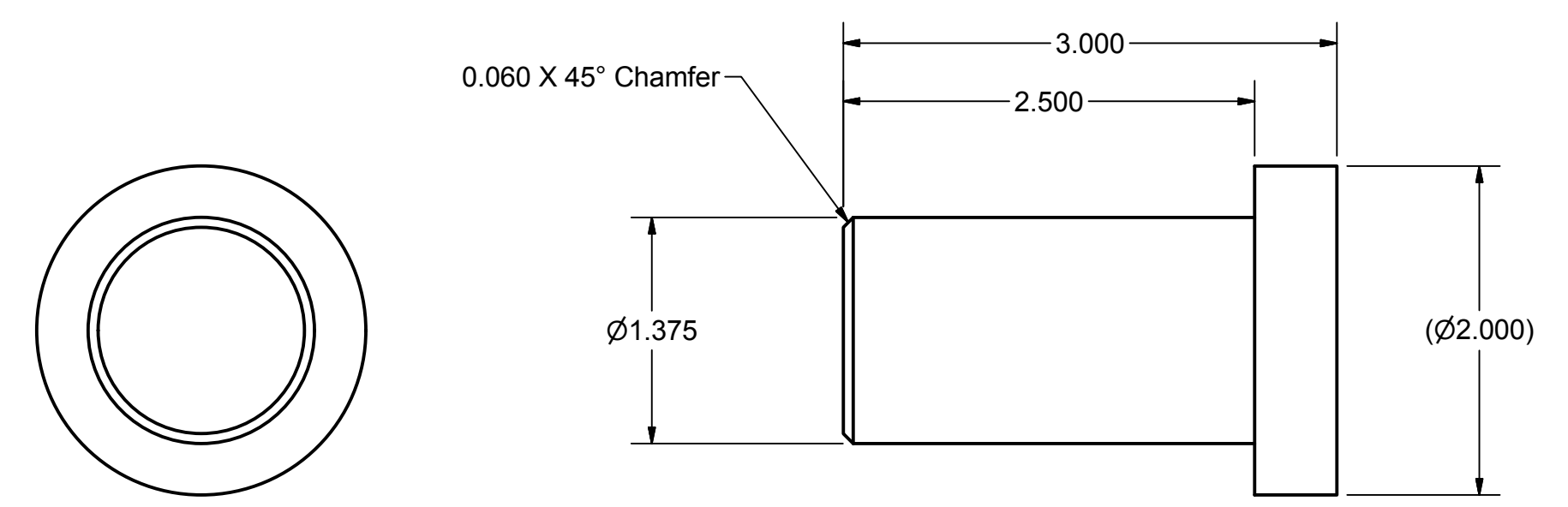
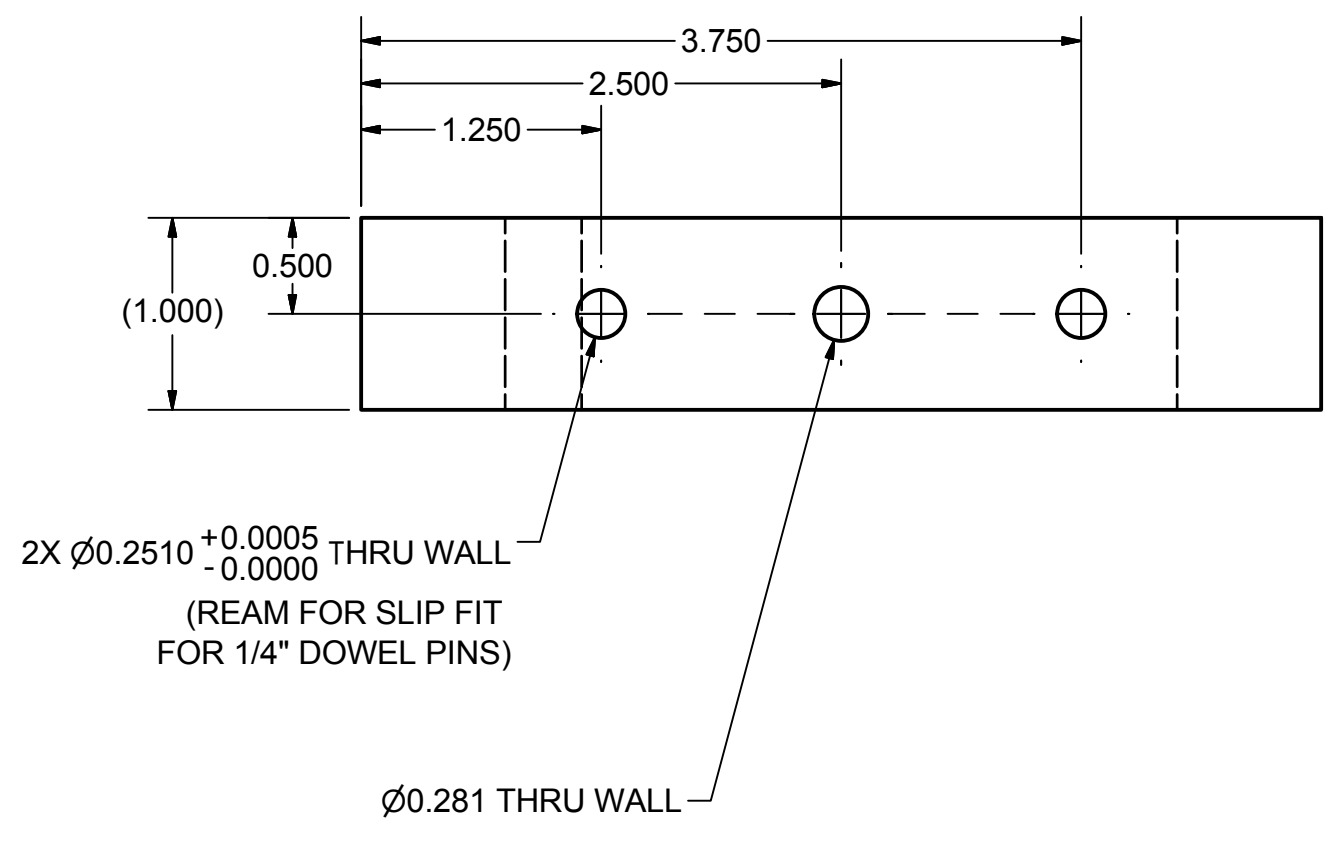
REVISIONS				
SYM	ZONE	DESCRIPTION	DATE	APP
		Initial Release		



**B** BPM Jig Block  
 FILE NAME: 7206-301D  
 SHEET NO.: 5  
 DFT. SCALE: 1 : 1  
 MATERIAL: 7075 Aluminum, 1.50" Thick  
 QTY: 4  
 NOTES:



**D** End Tube Jig Block  
 FILE NAME: 7206-301D  
 SHEET NO.: 5  
 DFT. SCALE: 1 : 1  
 MATERIAL: 7075 Aluminum, 1.50" Thick  
 QTY: 2  
 NOTES:



**G** Beam View Port Tube Alignment Rod  
 FILE NAME: 7206-301D  
 SHEET NO.: 5  
 DFT. SCALE: 1 : 1  
 MATERIAL: 304L Stn Stl. Rod, 2.00" OD  
 QTY: 2  
 NOTES:

ITEM	DWG. NO.	DESCRIPTION	G1	G2	G3	REMARKS	REV.	
			QUANTITY					
<b>D</b>	PRINT DISTR.	PLOT DATE: CAD FILE NAME: 7206-301 Dummy.idw					Cornell Laboratory for Accelerator-based ScienceS and Education (CLASSE)	Dummy FA 4-Cell Chamber for Welding Test
7206-301D	CR-1	UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES: TOLERANCES ON: .0 ± .02 .00 ± .010 .000 ± .005 FRACTIONS ± 1/32 ANGLES ± 0.5° ALL SURFACES ✓						
REV.	CHECKED BY: S Hartman	DRAWN BY	DRAWN FOR	DATE	SCALE	<b>D</b>	7206-301D	REV.
	APPROVED BY: Y Li			2/17/2017			SH. NO. 5 OF 5	