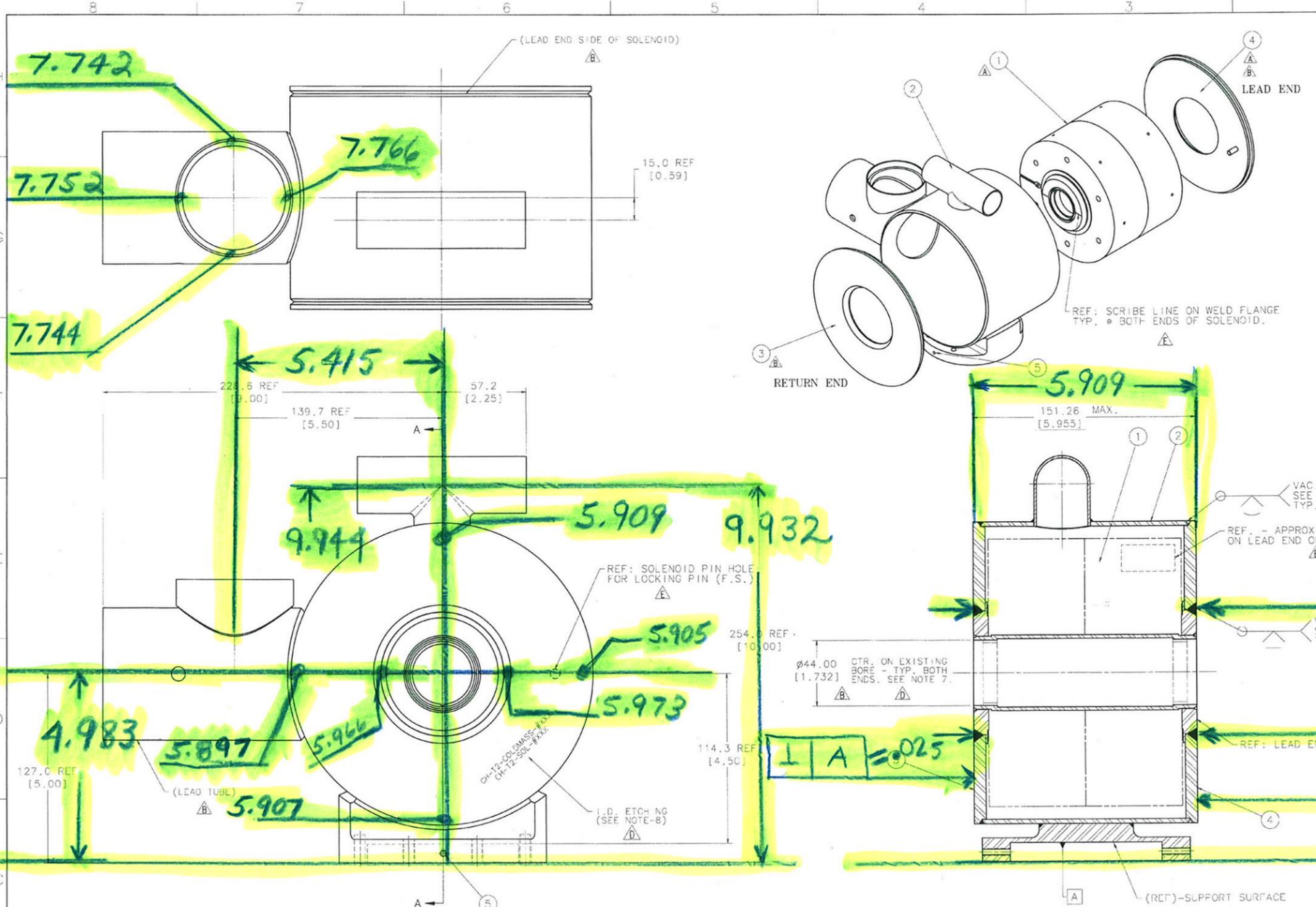


JN#1206

REV	DESCRIPTION	BY	DATE
	F.R. #8523		
A	ECC-8826 ROTATED ITEMS-1 & 4 30°	G. DAVIS	04-OCT-2007
B	ECC-8872 RELOCATED LEAD ENDS. REVERSED ITEMS 3&4. ADDED FINISHED BORE. ADDED WIRING SCHEME. REVISED ALL NOTES.	G. DAVIS	07-NOV-07
C	REV ITEMS NO. 7. ECO NO. 923C	I. TERECHKINE	08-NOV-07
D	ECC-9105 NEW NOTE-4. OLD NOTES 4-6 - NOW NOTES 5-7. NEW NOTE-8. OLD NOTE-7 IS NOW NOTE-9.	S.L. VEREDITH	11-APR-2008
E	ECC-9214 REV. NOTE-1. ADDED REFERENCE NOTES.	G. DAVIS	15-APR-2008
F	ECC-9231 REV. NOTE 1C. REMOVED (3) P.S. CHANGED M.C. OUTER (RED) TO INNER.	I. TERECHKINE	26-JUN-08
		G. DAVIS	07-OCT-2008
		I. TERECHKINE	09-OCT-2008
		G. DAVIS	21-JAN-2009



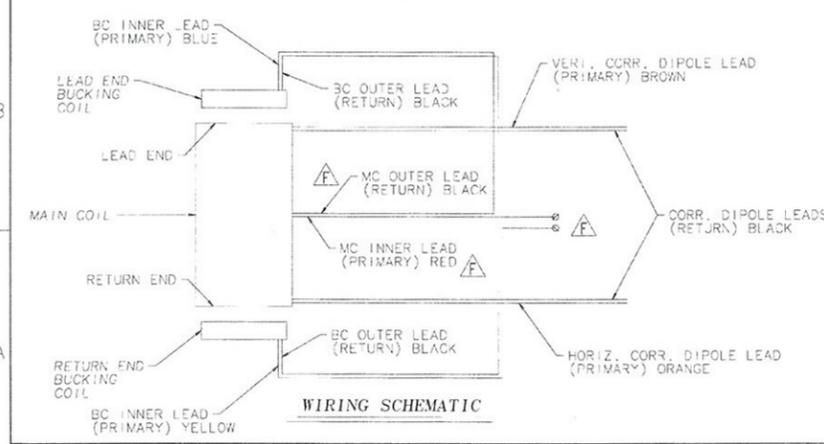
$L/A = .025$

$L/A = .010$

A

- NOTES:
1. A) INSTALL SOLENOID ASSEMBLY INTO THE VESSEL WITH PROPER LEAD SIDE LOCATION AS SHOWN.
 - B) ADD BOTH END PLATES (ITEMS 3&4) WITH THE PIN OF THE LOCKING PLATE ENGAGING THE PIN HOLE ON THE LEAD END OF THE SOLENOID ASSEMBLY.
 - C) ROTATE THE SOLENOID ASSEMBLY SO THAT SCRIBE LINE ON THE LEAD END WELD FLANGE IS PARALLEL TO THE SUPPORT POST MOUNTING BLOCK SURFACE (DATUM-A) WITHIN 1/2° (THIS WILL ESTABLISH THE VERTICAL PLANE OF THE DIPOLE CORRECTOR.) TACK WELD BOTH END PLATE FLANGES IN PLACE.
 - 2) ALL WELDS SHALL BE IN ACCORDANCE WITH THE ASME BOILER & PRESSURE VESSEL CODE (EXCEPT AS SHOWN), SECTION VIII, DIVISION 1. THE VESSEL NEED NOT BE CODE STAMPED, BUT SHALL BE CONSTRUCTED PER THE CODE, MAWP: 42 PSI 20°C.
 - 3) HI-POI ALL COILS TO 1000V. AND RING TEST.
 - 4) THE LEAK CHECK WELDED ASSEMBLY PER FERMI SPEC. #ES-107240.
 - 5) IN PREPARATION FOR COLD MASS TESTING - CONNECT THE WINDING OF THE SOLENOID ASSEMBLY AS SHOWN IN THE WIRING SCHEME AT LEFT.
 - 6) PERFORM CRYSTAL TEST OF THE COLD-MASS IN ACCORDANCE WITH THE TEST REQUIREMENTS.
 - 7) AFTER TESTING THE COLD-MASS - FINAL MACHINE THE INNER BORE OF THE LHe TUBE AS SHOWN IN THE CROSS-SECTION VIEW.
 - 8) ETCH I.D. NO'S AT APPROX. LOCATION SHOWN IN 4mm MIN. HIGH CHARACTERS, AND RECORD NO'S ON REQUIRED PAPERWORK.
 - 9) CLEAN & PACKAGE PER FERMI SPEC. #ES-107222

PRIMARY DIMENSIONS ARE IN MM. - MM(IN)



ITEM	PART NO.	DESCRIPTION OR SIZE	QTY.
5	MA-392436	SET SCR. #10-28X1/8" STN. STL.	2
4	VD-457117	HE VESSEL LOCK PLATE	1
3	VE-441949	HE VESSEL END PLATE	1
2	VE-457076	HE VESSEL SUB-ASSY (T-2)	1
1	VE-442657	SOLENOID ASSEMBLY (W/CORR. COILS)	1

PARTS LIST

UNLESS OTHERWISE SPECIFIED	ORIGINATOR	I. TERECHKINE	01-UN-2007
XX ANGLES	DRAM	G. DAVIS	27-UN-2007
± .03 ± .13 ±	CHECKED	J. BRANDT	28-UN-2007
	APPROVED	J. BRANDT	28-UN-2007

USED ON: VD-457135

WATERIAL: SEE PARTS LIST

FERMI NATIONAL ACCELERATOR LABORATORY
UNITED STATES DEPARTMENT OF ENERGY

HINS - FRONT END
CH-SECTION FOCUSING SOLENOID
TYPE-2 COLD-MASS ASSEMBLY

SCALE: 1:1
DRAWING NUMBER: 5520.000-ME-442964
SHEET: 1 OF 1
REV: F

CREATED WITH: ideas1205.rte
GROUP: TO/COOIS-PS/IN-COMPLING