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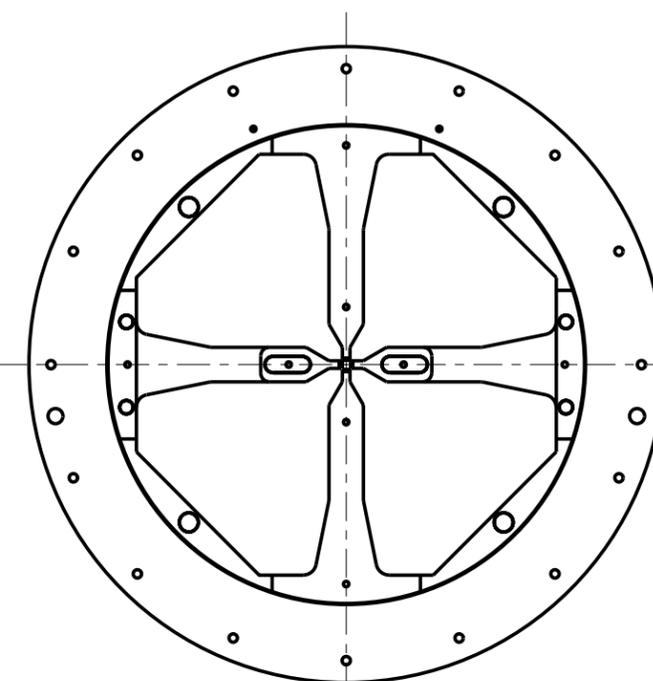
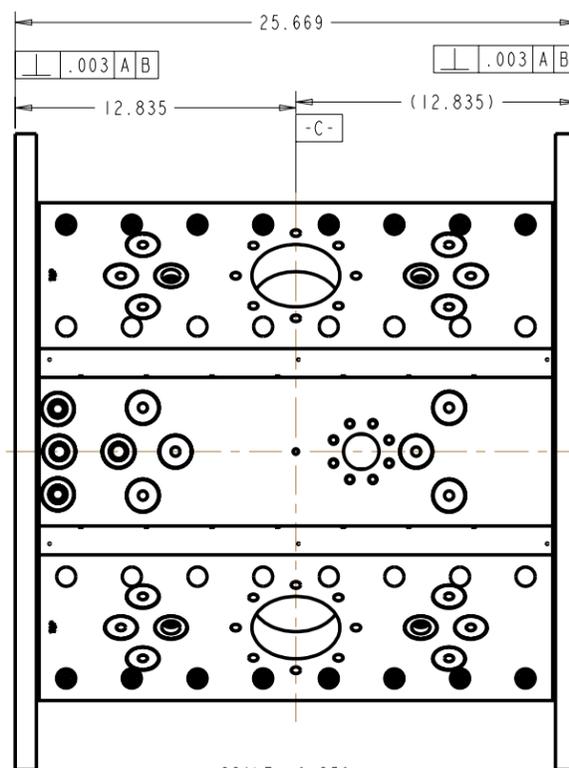
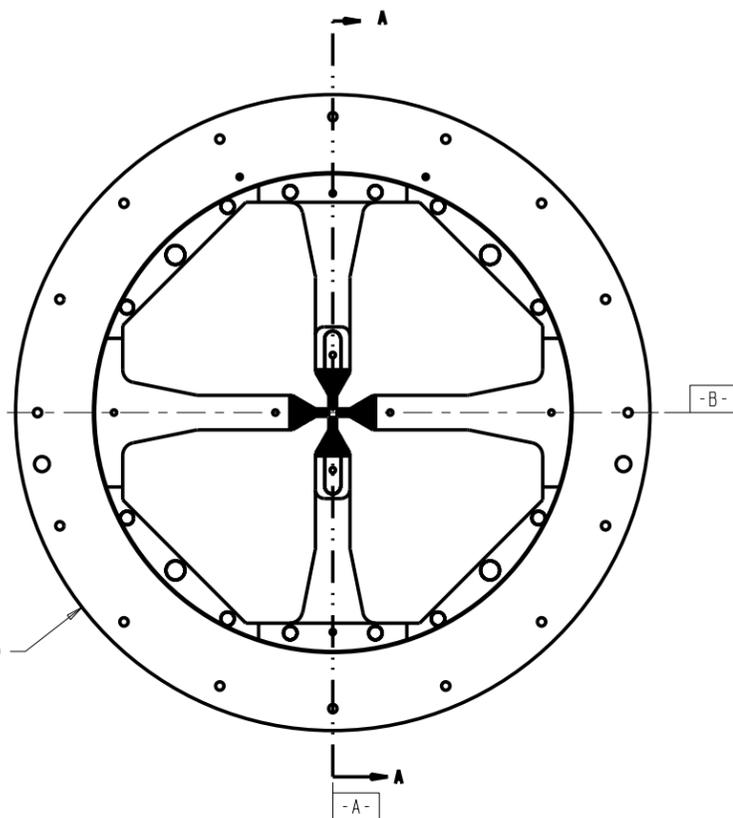
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REVISIONS				
ZONE	REV	DESCRIPTION	BY	APPROVED DATE



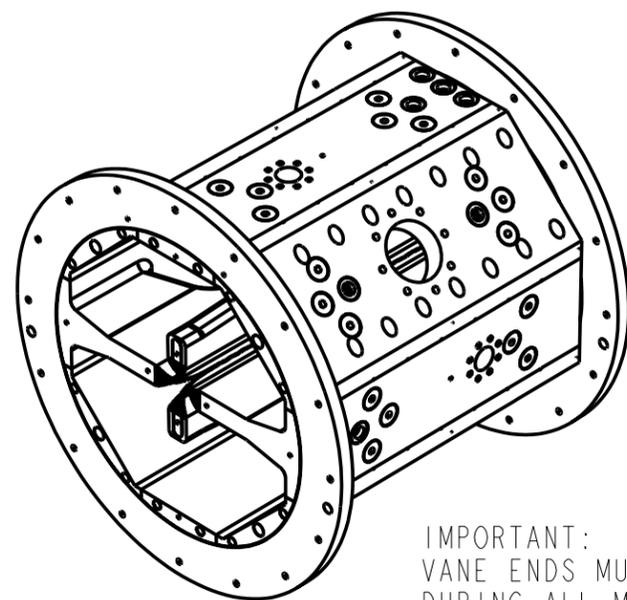
NOTES:

1. FINISH MACHINE BOTH ENDS TO DIMENSION AND FLATNESS SHOWN. MACHINE FLANGE FACES AND VANE ENDS. PROVIDE ADEQUATE TOOLING TO SUPPORT CANTILEVERED VANE ENDS DURING MACHINING OPERATIONS.
2. LEAK TEST WITH HELIUM MASS SPECTROMETER LEAK DETECTOR. TOTAL LEAK RATE NOT TO EXCEED 1×10^{-9} STD. (cc/Sec HE).

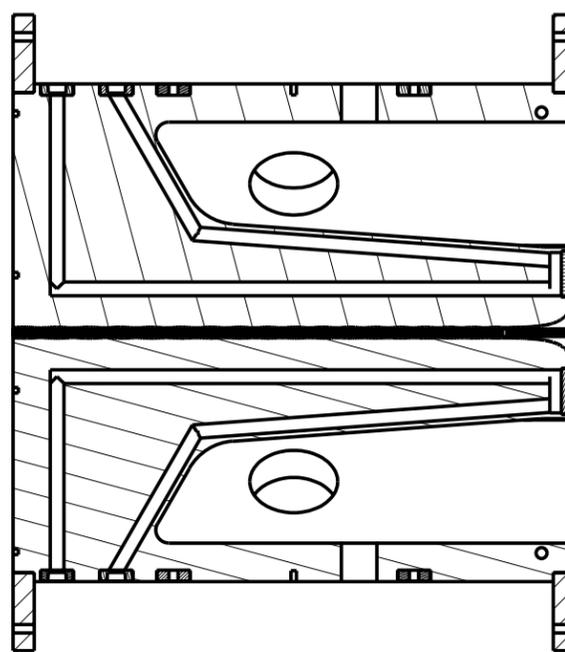
RF FREQUENCY TEST

1. A FREQUENCY TEST TO VERIFY ASSEMBLY BRAZING TO BE PERFORMED AT THIS POINT.
2. CLOSE THE CAVITY WITH TWO END-PLATES, PROVIDING A REASONABLE MECHANICAL CONTACT BETWEEN THE END-PLATES AND THE CAVITY BODY. USE BALSEAL SPRINGS WHEREVER POSSIBLE.
3. INSTALL THE DRIVING LOOP IN ONE OF FOUR TUNER PORTS; CLOSE THE OTHER TUNER PORTS WITH TEMPORARY CONDUCTIVE PLATES.
4. INSTALL THE PROVIDED PICK-UP LOOP IN ONE OF FOUR PICK-UP LOOP PORTS.
5. MEASURE THE FREQUENCY SPECTRUM UP TO THIRD MODE USING HP NETWORK ANALYZER.
6. MEASURE THE QUALITY FACTOR OF THE RESONATOR ON OPERATING FREQUENCY ~57.5 MHZ.

WEIGHT: 1296 lbs.



IMPORTANT:
VANE ENDS MUST BE SUPPORTED
DURING ALL MACHINING OPERATIONS



SECTION A-A
SCALE 0.250

ITEM	DRAWING/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL/SPEC	QTY
1	G12827	SEGMENT PRE-BRAZE ASSEMBLY	SEE PARTS LIST	1
PARTS LIST/BILL OF MATERIALS				
UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN INCHES TOLERANCES		THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY RARE ISOTOPE ACCELERATOR		
DECIMALS X ± .1 XX ± .01 XXX ± .005	ANGULAR ± .5°	DRAWN BY: B. RUSTHOVEN DATE: 13-Jun-03	TITLE: RARE ISOTOPE ACCELERATOR CONCEPTUAL DESIGN 57 MHZ RFQ STRUCTURE SEGMENT FINAL MACHINING ASSEMBLY	
SURFACE ROUGHNESS		CHECKED BY:	DATE:	
REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX. SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1 DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5		DESIGNED BY: B. RUSTHOVEN DATE: 13-Jun-03	DATE:	
		RESPONSIBLE ENGINEER: S. SHARMA DATE:	DATE:	
		GROUP LEADER: S. SHARMA DATE:	DATE:	
		APPROVED BY:	DATE:	
MODEL NAME: A98-01150-1_SEG_FIN.MC		RELEASE LEVEL:	VERSION:	SIZE TSW No. D OHRHS
ELECTRONIC FILE NAME: G12826		MATERIAL: SEE PARTS LIST	DRAWING NUMBER: G12826	REV. 00
		SCALE: 0.250	DO NOT SCALE DRAWING	SHEET 1 OF 1

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