



REVISIONS				
ZONE	REV	DESCRIPTION	BY	APPROVED DATE

NOTE:

- 1 THE USE OF SULPHUR BEARING OILS OR ABRASIVES IS PROHIBITED.
- 2 PROCESSES SUCH AS GRINDING, AND OR POLISHING THAT MAY RESULT IN EMBEDDED CONTAMINATION OF THE PART ARE PROHIBITED.
- 3 USE ONLY CIMCOOL, KOOLMIST #77, MOBIL CUT-MAX, MISSILE LUBE #5, OR AN ANL APPROVED EQUAL LUBRICANT FOR MACHINING.
- 4 PRIOR TO SHIPPING ALL SURFACES OF THE PART ARE TO BE THOROUGHLY CLEANED, AND FREE OF ALL OIL AND OR SOLUTIONS.
- 5 ALL MOUNTING HOLES ARE TO STRADDLE THE BEAM DIR. CENTERLINES IN THE HORIZONTAL PLANE, OR AS NOTED.

1	G12836	QUARDANT BRAZE ASSEMBLY	SEE PARTS LIST	3
ITEM	DRAWING/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL/SPEC	QTY
PARTS LIST/BILL OF MATERIALS				
UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN INCHES		THIS DRAWING IS THE PROPERTY OF		
TOLERANCES		ARGONNE NATIONAL LABORATORY		
DECIMALS ± .01		RARE ISOTOPE ACCELERATOR		
ANGULAR ± .5°		TITLE:		
.XX ± .01		RARE ISOTOPE ACCELERATOR		
.XXX ± .005		CONCEPTUAL DESIGN		
.XXXX ± .001		57 MHZ RFQ STRUCTURE		
SURFACE ROUGHNESS		QUADRANT MACHINING		
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		DRAWN BY: B. RUSTHOVEN CHECKED BY: S. SHARMA DESIGNED BY: B. RUSTHOVEN RESPONSIBLE ENGINEER: S. SHARMA GROUP LEADER: S. SHARMA APPROVED BY: D. SCHRAGE	DATE: 16-Jun-03 DATE: 16-Jun-03 DATE: 16-Jun-03 DATE: 16-Jun-03 DATE: 16-Jun-03 DATE: 16-Jun-03	SIZE: 1/8" x 1/2" x 1/4" DRAWING NUMBER: G12834 REV: 00
MODEL NAME: A98-01153-1-QUAD_FIN.MC		RELEASE LEVEL: -	VERSION: -	SCALE: 0.500
ELECTRONIC FILE NAME: G12834		MATERIAL: SEE PARTS LIST		DO NOT SCALE DRAWING SHEET 1 OF 1