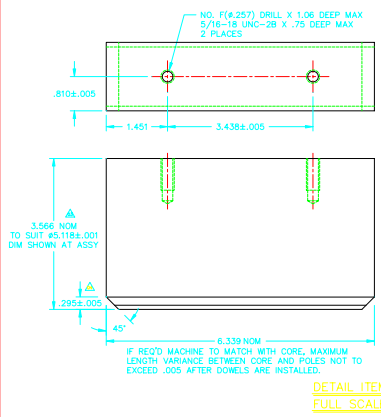
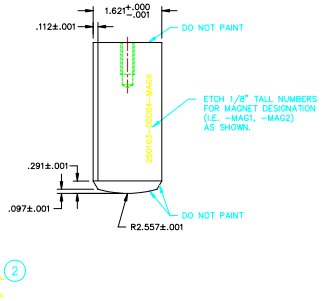
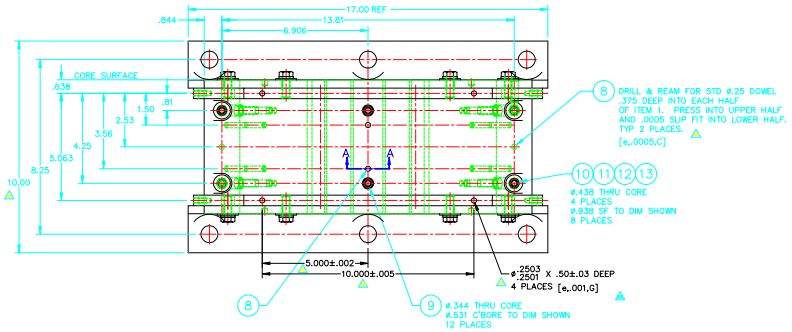
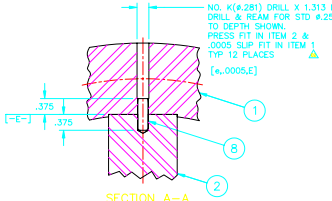
(E)	PLOT SCALE: 1=2	DWG. SCALE: 2	A11054



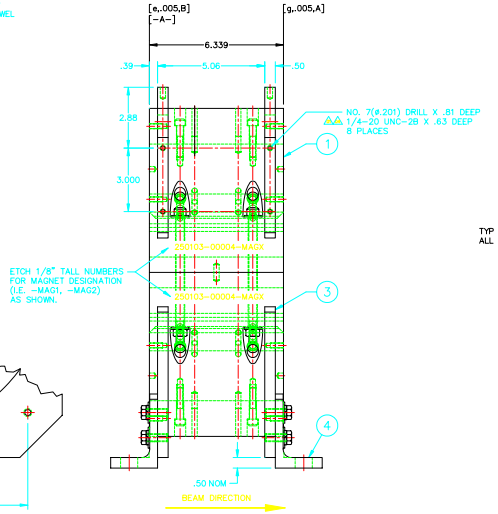


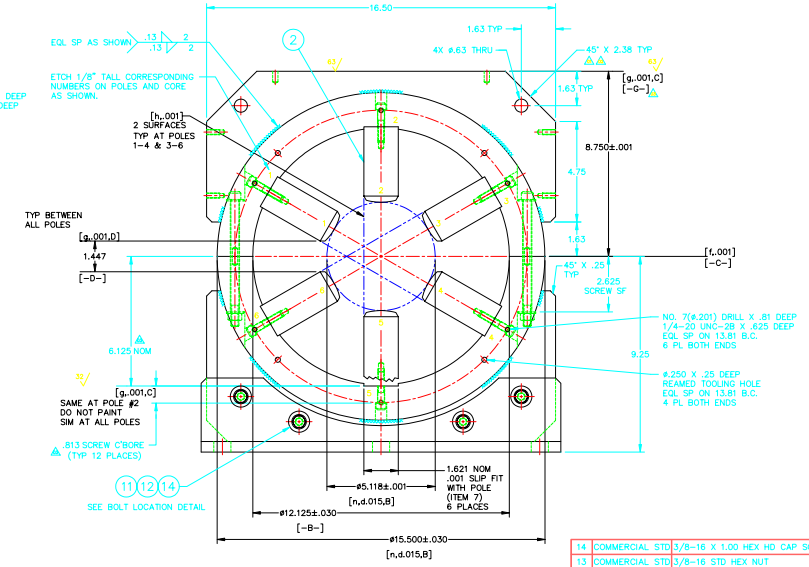
DETAIL ITEM 2
FULL SCALE

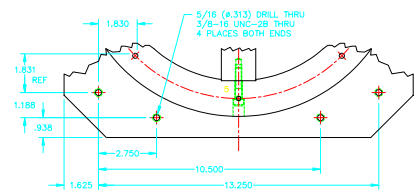




SECTION A-A
FULL SCALE







BOLT LOCATION DETAIL
SCALE = 1:2

NOTES:

ANNEALING

FOLLOWING ROUGH CUTTING TO SHAPE AND WELDING, THE STEEL SHALL BE HEAT TREATED PRIOR TO FINAL MACHINING, ACCORDING TO THE FOLLOWING PROCEDURE:

(a) HEAT TO 850-900° C AND HOLD FOR 2.0 HOURS (MINIMUM).

(b) SLOW COOL TO 400° C AT A MAXIMUM RATE OF 27° C PER HOUR.

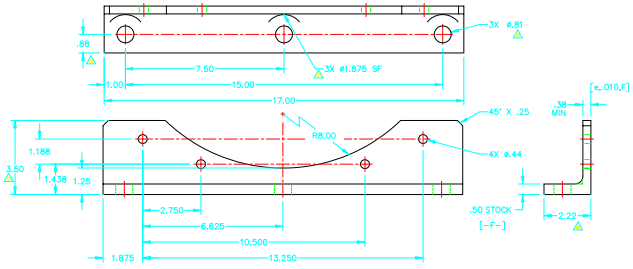
(c) COOL TO ROOM TEMPERATURE IN AIR.

FINAL MACHINING

MACHINING AND DRILLING SCHEDULES SHALL BE SUCH THAT WORK HARDENING SHALL BE LIMITED TO .02" BENEATH THE FINISHED POLE FACE SURFACES AND .05" BENEATH ALL OTHER CORE SURFACES. FOR PURPOSE OF ESTABLISHING THIS SCHEDULE, THE SUB-CONTRACTOR MAY ASSUME THAT WORK HARDENING FOR A SHARP TOOL WILL EXTEND TO A DEPTH EQUAL TO THE THICKNESS OF THE CHIP REMOVED. THIS SCHEDULE IS NECESSARY TO AVOID DEGRADATION OF MAGNETIC PROPERTIES.

PAINTING

PAINT ALL SURFACES EXCEPT WHERE NOTED WITH 2 COATS OF SUITABLE PRIMER AND 1 COAT OF YELLOW INSL-X GU 2523 OR EQUIVALENT. DO NOT PAINT POLE MOUNTING SLOTS IN CORE, POLE SURFACE, OR DATUM [-C-].



DETAIL ITEM 4

A11054
250103-00004-04
INJECTOR
POSITRON ACCUMULATOR RING
SEXTUPOLE
CORE ASSEMBLY
8-19-92 DRAWN
5-25-93 REVISED

APPROXIMATE WEIGHT: 300 LBS

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
14	COMMERCIAL STD	3/8-16 X 1.00 HEX HD CAP SCR	18-8 SST	8
13	COMMERCIAL STD	3/8-16 STD HEX NUT	18-8 SST	4
12	COMMERCIAL STD	HELICAL SPRING LOCK WASHER, 3/8 REG	18-8 SST	12
11	COMMERCIAL STD	.406 ID X .812 OD X .065 THK FLAT WASH	18-8 SST	12
10	COMMERCIAL STD	3/8-16 X 6.00 SOC HD CAP SCR	18-8 SST	4
9	COMMERCIAL STD	5/16-18 X 1.50 SOC HD CAP SCR	ALLOY STEEL	12
8	COMMERCIAL STD	PINS, HRD GRD MACH DOWEL, .25 X .75	ALLOY STEEL	12
7				—
6				—
5				—
4		3 1/2 X 3 1/2 X 1/2 ANGLE	304 SST	2
3		MOUNTING PLATE	1018 HR STEEL	4
2	SEE DETAIL	POLE - MAKE FROM ITEM 1	C1006 HR STEEL	6
1		CORE- 7.0 THK X ø16.5	C1006 HR STEEL	1

PARTS LIST

REV	CHANGE DESCRIPTION	BY	CHK	DATE
04	SEE DCN 930525-04	KWC		
03	SEE DCN 930205-05	KWC	JJ	2/93
02	SEE DCN 921118-03	KWC	JJ	12/92
01	SEE DCN 921106-01	KWC	JJ	11/92

REVISIONS

UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN INCHES
TOLERANCES
DECIMALS ±.005
FRACTIONS ±.1/64
ANGLES ±.5°
SURFACE ROUGHNESS 125

DRAWN BY K. COSTELLO 8-19-92
DESIGN BY J. JAGGER 9/92
DESIGN BY K. COSTELLO 8-19-92
MECHANICAL ENGINEER J. JAGGER 9/92
ELECTRICAL ENGINEER
MANAGER K. THOMPSON 9/16/92

LOC NUMBER A11054
CHECKED BY J. JAGGER 9/92
PROJECT ENG M. BORLAND 9/17/92
APPROVED/RELEASED

THIS DRAWING IS THE PROPERTY OF
ARGONNE NATIONAL LABORATORY

TITLE ADVANCED PHOTON SOURCE
INJECTOR
POSITRON ACCUMULATOR RING
SEXTUPOLE
CORE ASSEMBLY

SCALE 1:2
WT: 1:1
SIZE E
DRAWING NUMBER 250103-00004-04

SEE PARTS LIST