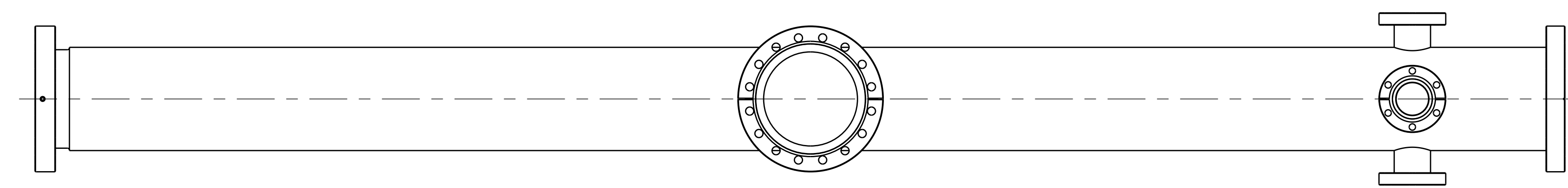
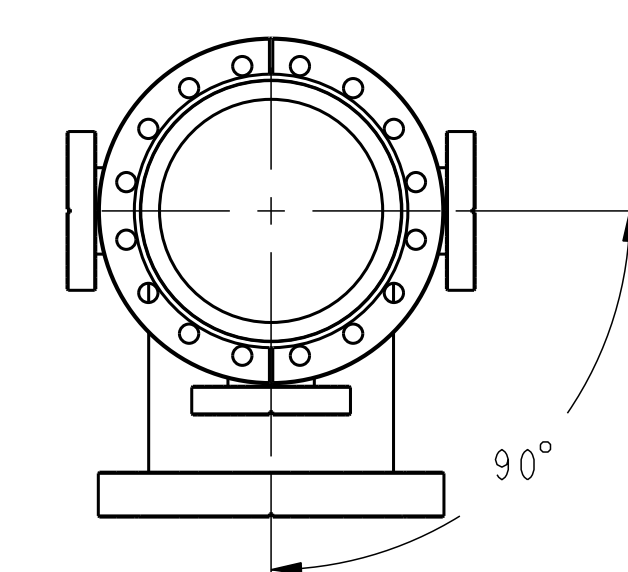
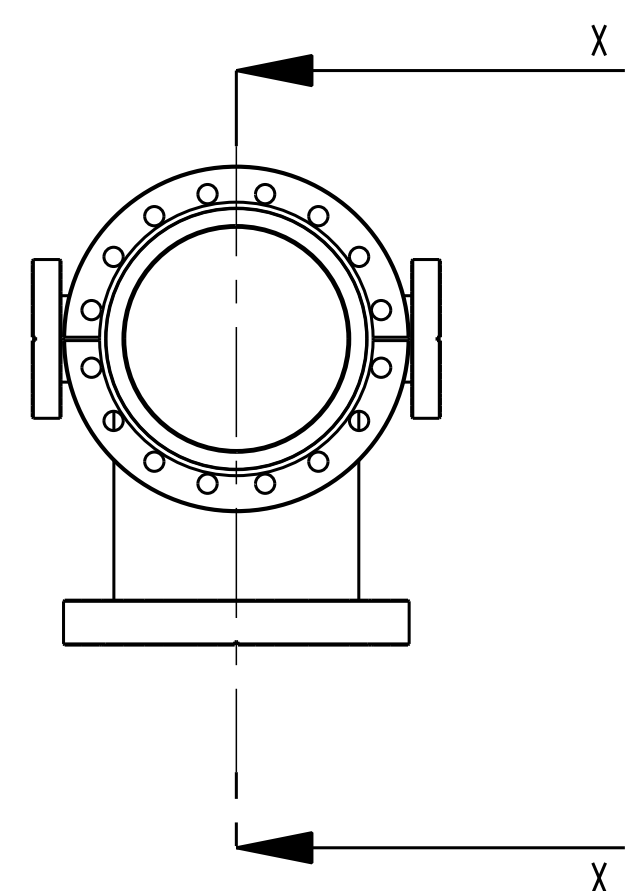
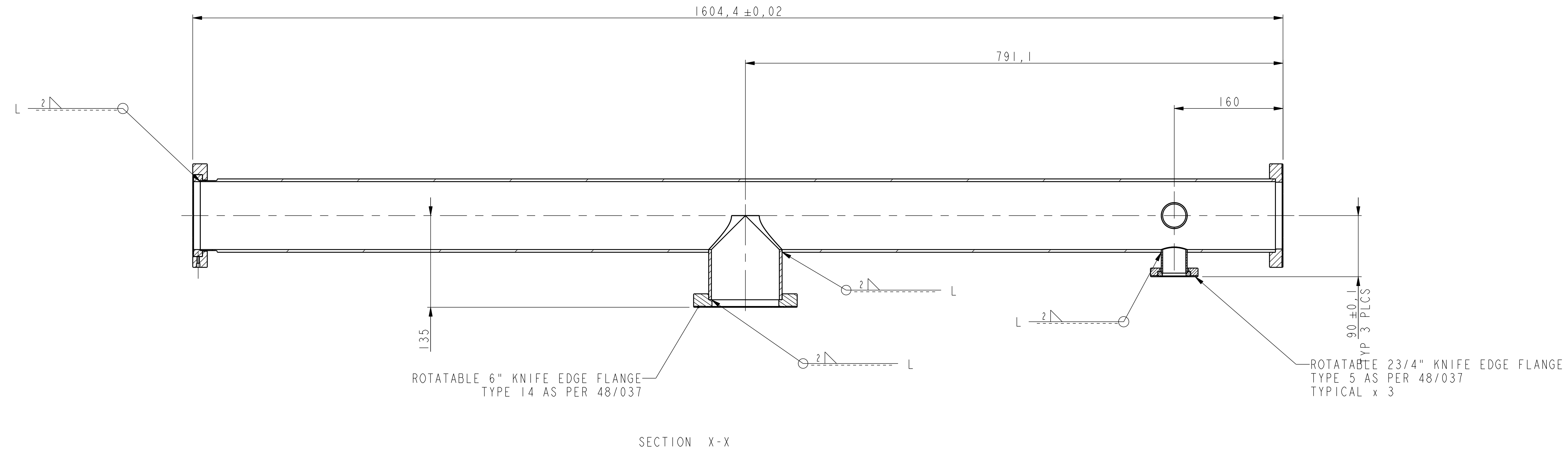
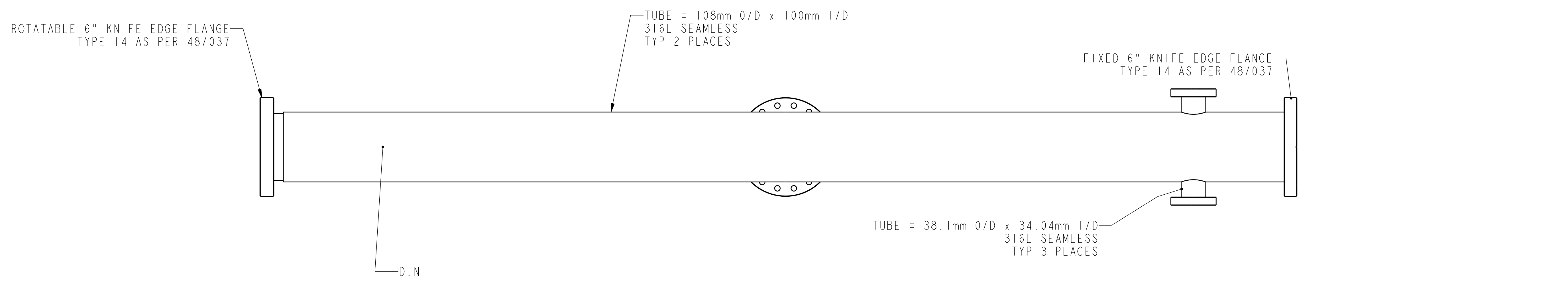


- NOTES
1. REMOVE ALL BURRS & SHARP EDGES.
 2. GENERAL SURFACE FINISH UNLESS OTHERWISE STATED.
 3. ALL SCREW THREADS TO BS 3643 ISO METRIC COARSE SERIES, MEDIUM FIT UNLESS OTHERWISE STATED.
 4. DRG N° TO BE INCRIBED ON ITEM WHERE INDICATED THUS: DN.
 5. ALL VACUUM SURFACES TO BE FREE FROM VISIBLE DEFECTS SUCH AS PITTING, CRACKS AND INDENTATIONS.
 6. ITEM TO BE MANUFACTURED TO SPEC ASTEC-VAC-OCD-spc-002.
 7. ITEM TO BE CLEANED IN ACCORDANCE WITH SPEC ASTEC-VAC-OCD-spc-003.
 8. WELDING SYMBOLS TO BS. 499 PT 2.
 9. ALL WELDING SYMBOLS WITH 'L' INDICATE THAT A VACUUM SEALING WELD IS REQUIRED.
 10. WELDING SPEC BS EN 1011-1-2
 11. MATERIAL - STAINLESS STEEL WITH MAGNETIC PERMEABILITY OF LESS THAN 1,005
PLATE - 316L
BAR - 316L
FLANGES - 316LN
 12. VACUUM VESSEL TO BE TESTED TO A LEAK RATE BETTER THAN $10e-9$ TORR LITRES/SEC IN ACCORDANCE WITH SPEC ASTEC-VAC-OCD-spc-004



RELEASE STATUS		Approved	
WELDING SPEC		-----	
MATERIAL SPEC		-----	
MATERIAL		-----	
TOLERANCES UNLESS OTHERWISE STATED			
LINEAR DIMENSIONS UP TO 200 ± 0.25; OVER ± ±			
ANGULAR DIMENSIONS ± -			
SCALE 3: 10			
ALL DIMENSIONS IN mm's UNLESS OTHERWISE STATED			
DRN.	PMA	SCIENCE AND TECHNOLOGY FACILITIES COUNCIL	
DATE.	07/11/16	DARESBUURY LABORATORY	
CKD.	PMA	CHESHIRE	
DATE.	07/11/16	TITLE	
APPD.	PMA	ESS BEAM TRANSPORT	
DATE.	07/11/16	BEAM PIPE 2 PORT FAB	
DRAWING N°		SHEET 1 OF 2 ISSUE	
A0		289-10725	
PROJ. CAD PART N°		289-10725	
USED ON			
CONTRACTORS COMPANY			
CONTRACTORS DRG N°			

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A FIRST ISSUE