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ITEM	RQ'D	Part Number	Material/Parts Call-Out
1	1	24A4634	HEADER BRAZE ASSEMBLY, RIGHT
1	2	24A4624	HEADER BRAZE ASSEMBLY, LEFT
2	3	24A4893-3	HEADER PORT FITTING
2	4	24A4893-2	DRAIN PORT FITTING
1	5	24A4643	TUBE #01 MACHINING
1	6	24A4653	TUBE #02 MACHINING
1	7	24A4663	TUBE #03 MACHINING
1	8	24A4673	TUBE #04 MACHINING
1	9	24A4683	TUBE #05 MACHINING
1	10	24A4693	TUBE #06 MACHINING
1	11	24A4703	TUBE #07 MACHINING
1	12	24A4713	TUBE #08 MACHINING
1	13	24A4723	TUBE #09 MACHINING
1	14	24A4733	TUBE #10 MACHINING
1	15	24A4743	TUBE #11 MACHINING
1	16	24A4753	TUBE #12 MACHINING
1	17	24A4763	TUBE #13 MACHINING
1	18	24A4773	TUBE #14 MACHINING
1	19	24A4783	TUBE #15 MACHINING
-	20	-	-
-	21	-	-
REF	22	24A4806	BONDING FIXTURE

REF:
O-RING REQUIRED: #2-014, (1/16 x 1/2)
FOR MATING NUT SEE 24A4913-1
FOR MATING CAP-OFF SEE 24A4923-1
FOR MATING NIPPLE SEE 24A4933-1

2.965 / 75.31 REF
2.200 / 55.88 REF
1.800 / 45.72
24.222 / 615.25 REF

20.552 / 522.02 REF

7.661 / 194.58 REF

2.000 / 50.80 REF
2.815 / 71.50 REF

REF:
O-RING REQUIRED: #2-010, (1/16 x 1/4)
FOR MATING NUT SEE 24A4913-2
FOR MATING CAP-OFF SEE 24A4923-2
FOR MATING NIPPLE SEE 24A4933-2

SECTION A-A
SCALE 1:2

NOTES:

1. PRIOR TO BONDING ALL PARTS ARE TO BE PREPPED AND PRIMED PER THE NOTES ON EACH PART DRAWING.
2. USE BONDING FIXTURE, DWG # 24A4806, TO ASSEMBLE AND BOND ALL PARTS
3. BOND PARTS TOGETHER WITH DEXTER-HYSOL # EA 9309.3 NA
4. PART JOINTS ARE DESIGNED FOR .005" BONDING MATERIAL. (.007±.002 BETWEEN PARTS) ADHESIVE SPECIFIED CONTAINS .005 GLASS BEADS FOR BOND LINE CONTROL
5. PRESSURE TEST WITH AIR UNDER WATER AT 40 PSI(276 kPa or 276 000 N/m^2) FOR 15 MINUTES. IF AFTER THAT PERIOD OF TIME NO AIR BUBBLES APPEAR THE MANIFOLD SHALL HAVE PASSED THE TEST.

24A3696A

REV.	DWN.	CHK.	ZONE	DATE	CHANGES
A	JB			95/04/19	NEW LOGO, METRIC DIMS, STAR #

UNLESS OTHERWISE SPECIFIED
ALL DIMENSIONS ARE INCHES / CENTIMETERS
TOLERANCES: X/X = ±.06/.15; XX/X = ±.02/0.05; 0.XXX/XX=±.005/.01; ANGLES ±5°; FINISH 125/32
SAWED, FLAMECUT, SHEARED OR STOCK FINISH
ALL SCREW THREADS ARE ISO METRIC CLASS 6
BREAK EDGES .020/.05 MAX ON MACHINE WORK.
REFERENCE - ANSI Y14.5 & B46.1

SHOP ORDERS
ACCT. NO.
WBS NO.
DATE REQ'D
NO. REQ'D
DELIVER TO
SURFACE TREATMENT: DEGREASE
IDENTIFICATION METHOD: TAG
DRAWN BY: J BOEHM
DATE: 94/05/17
CHECK BY:
DATE

STAR | WBS # 0.00.0 | Production Approval: | Cognizant Engineer: J BERCOVITZ

STAR DRAWING NUMBER: TPC354-E-1 | REV.: A | RHIC DRAWING NUMBER: XXXXXXXXXX | REV.: -

LAWRENCE BERKELEY LABORATORY
UNIVERSITY OF CALIFORNIA - BERKELEY
RHIC-STAR-TPC
INNER SECTOR
COOLING MANIFOLD ASSEMBLY
SCALE: FULL
DO NOT SCALE PRINTS

PATENT CLEAR	DRAWING TYPE	DRAWN ON	LBL DRAWING NUMBER	REV.
LPC	DETAIL	00X0000	24A3696	A
MICROFILMED	DESIGN ACCOUNT	CATEGORY CODE		
	8052-24	SR-02-04		