



SECTION A-A

SCALE 1:2

REC'D ITEM	PART NO.	DESCRIPTION
1	24A4154	HEADER BRAZE ASSEMBLY, RIGHT
1	24A4054	HEADER BRAZE ASSEMBLY, LEFT
1	24A4303	TUBE #01 MACHINING
1		TUBE #02 MACHINING
1		TUBE #03 MACHINING
1		TUBE #04 MACHINING
1		TUBE #05 MACHINING
1		TUBE #06 MACHINING
1		TUBE #07 MACHINING
1		TUBE #08 MACHINING
1		TUBE #09 MACHINING
1		TUBE #10 MACHINING
1		TUBE #11 MACHINING
1		TUBE #12 MACHINING
1		TUBE #13 MACHINING
1		TUBE #14 MACHINING
1		TUBE #15 MACHINING
1		TUBE #16 MACHINING
1		TUBE #17 MACHINING
1		TUBE #18 MACHINING
1		TUBE #19 MACHINING
	REF20-24A4266A	BONDING FIXTURE

24A4296

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 # 24A4266A, 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

UNLESS OTHERWISE SPECIFIED	SHOP ORDERS	LAWRENCE BERKELEY LABORATORY
X ± .1	FRM. #1764	UNIVERSITY OF CALIFORNIA-BERKELEY
XX ± .02	ACCT. SERIAL	RHTC-STAR-IPC
XXX ± .005	DATE	OUTER SECTOR COOLING MANIFOLD
FINISH 12.57	REV. NO.	MANIFOLD ASSEMBLY
THREADS ARE CLASS 2	DEGREASE	MANIFOLD ASSEMBLY
ON MACHINING CUT IN PREVIOUS	TAG	DETAIL
UNLESS OTHERWISE SPECIFIED	DATE	SCALE
REMOVE BURRS WELD SPATTER & LOOSE SCALE	BY J. BOEHM	REV. NO.
REFERENCES: ANS1 Y14.5 & Y14.1	DATE	24A4296
	REV. DATE	
	CHANGES	