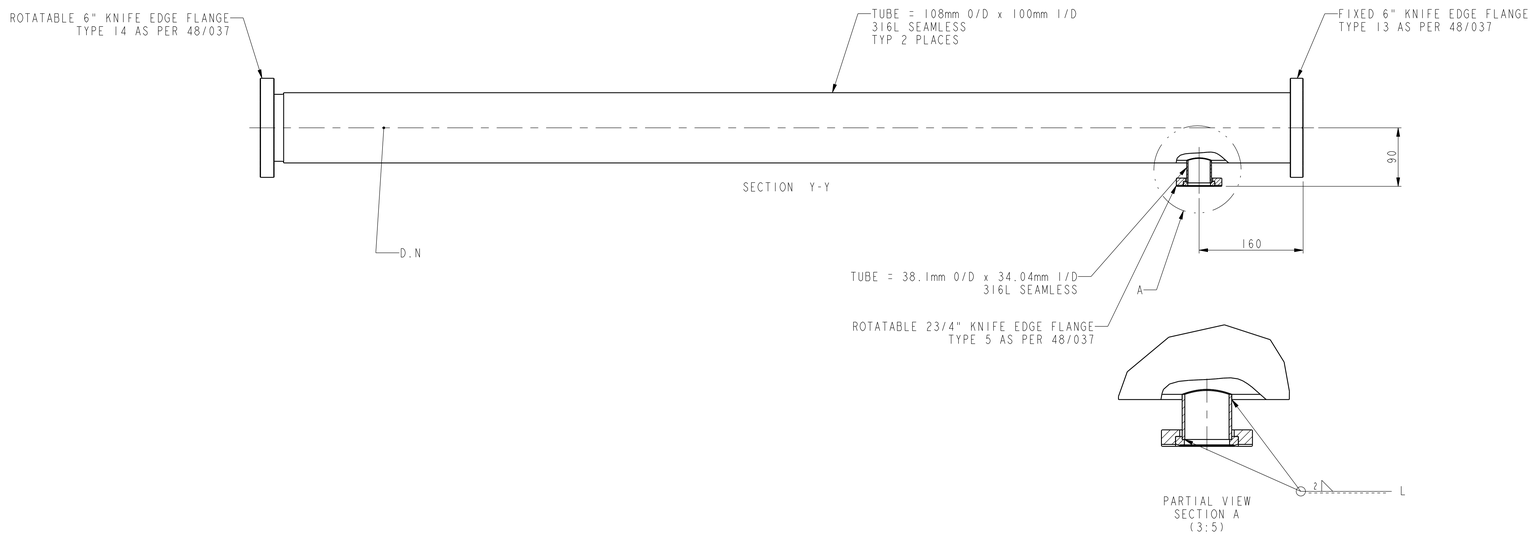
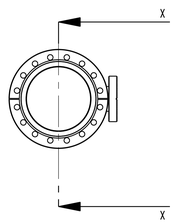
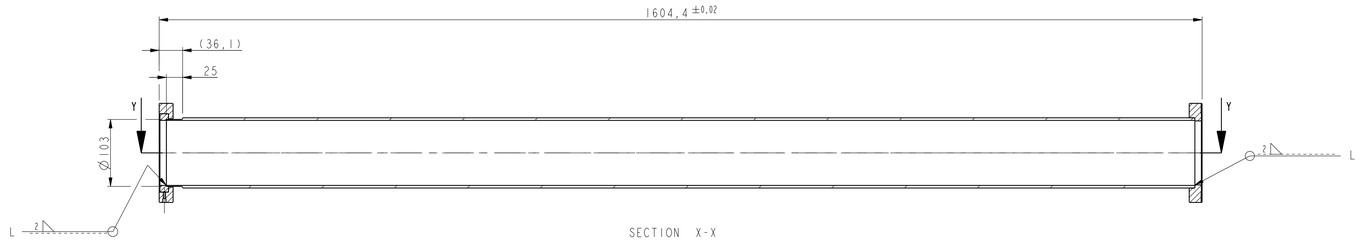
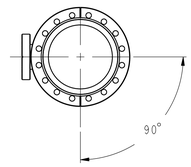
DRG. N° A0 | SHEET 1 OF 1 | 289-10726

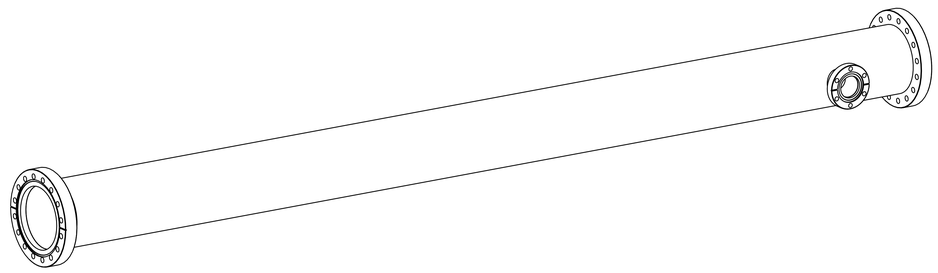
DRG. PRACTICE TO B.S. 308. THIRD ANGLE PROJECTION











NOTES

1. REMOVE ALL BURRS & SHARP EDGES.
2. GENERAL SURFACE FINISH 1.6 UNLESS OTHERWISE STATED.
3. ALL SCREW THREADS TO BS 3643 ISO METRIC COARSE SERIES, MEDIUM FIT UNLESS OTHERWISE STATED.
4. DRG No TO BE INCRIBED ON ITEM WHERE INDICATED THUS: DN.
5. ALL VACUUM SURFACES TO BE FREE FROM VISIBLE DEFECTS SUCH AS PITTING, CRACKS AND INDENTIONS.
6. ITEM TO BE MANUFACTURED TO SPEC ASTEC-VAC-QCD-spc-002.
7. ITEM TO BE CLEANED IN ACCORDANCE WITH SPEC ASTEC-VAC-QCD-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 PERMABILITY 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-QCD-spc-004

A	FIRST ISSUE		
B	DRN. PJS DATE. 07/11/16 CHKD. RJS APPD. PMA	07/11/16	MISSING WELDS ADDED FOR ONLY ROTABLE FLANGE ADDITIONAL LABEL ADDITIONAL ITEM FOR DN40 TO SPAR CONNECTED NO.

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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 (0 – 200)
ALL DIMENSIONS IN mm's UNLESS OTHERWISE STATED

DRN.	PMA	SCIENCE AND TECHNOLOGY FACILITIES COUNCIL
DATE.	07/11/16	DARESBURY LABORATORY, CHESHIRE
CKD.	PMA	TITLE: ESS BEAM TRANSPORT BEAM PIPE 1 PORT FAB
DATE.	07/11/16	
APPD.	PMA	
DATE.	07/11/16	

DRAWING N° A0 | 289-10726 | SHEET 1 OF 1 | ISSUE B

PROTE CAD PART N° 289-10726

USED ON

CONTRACTORS COMPANY --------

CONTRACTORS DRG N° .

ORIGINAL FRAME SIZE 1139mm X 791mm