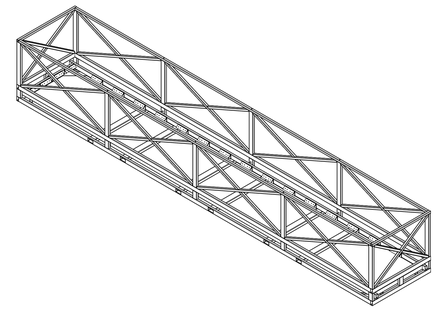
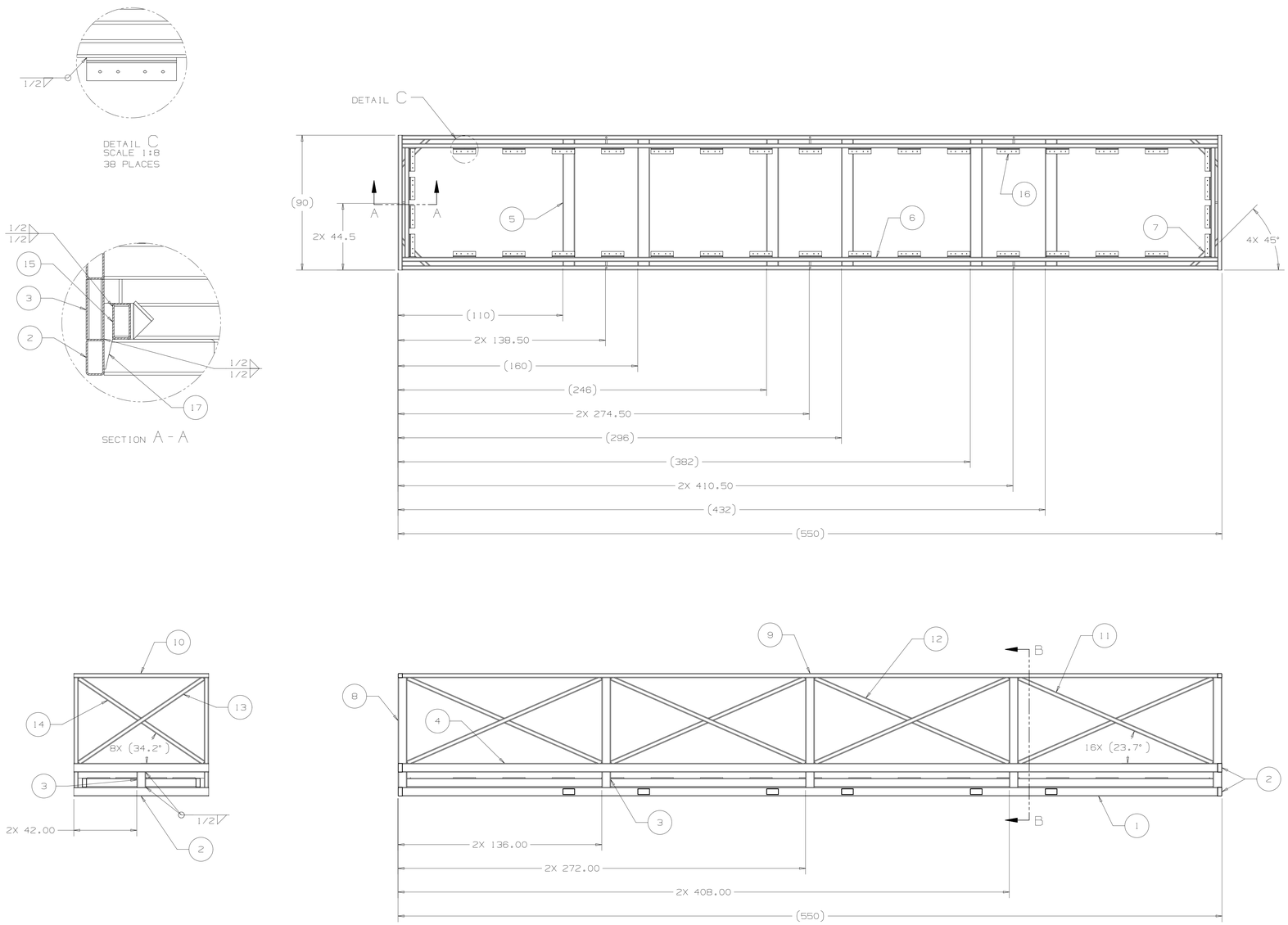
DESCRIPTION: WELDMENT, BASE FRAME - LCLS-II TRANSPORT SYSTEM
CATEGORY: WELDMENT PROJECT: LCLSIICryomodule

REV	REVISION CONTROL DOCUMENT	DATES	SIGNATURES
-	F10038882---RCD		DRAWN
			APPROVED

PRELIMINARY
NOT FOR PRODUCTION
OR PURCHASING PURPOSES
UNCONTROLLED COPY
LAST SAVED 17JUN15





ITEM	PART NUMBER	DESCRIPTION	QTY.
18	F10040359	GUSSET, LCLS-II TRANSPORT SYSTEM	6
17	F10040355	GUSSET, LCLS-II TRANSPORT SYSTEM	2
16	F10040013	WELDMENT, COMPRESSION SPRING - LCLS-II TRANSPORT SYSTEM	38
15	F10039627	TUBE, 6" X 3" - LCLS-II TRANSPORT SYSTEM	2
14	F10039089	TUBE, 3" X 3" - LCLS-II TRANSPORT SYSTEM	4
13	F10039088	TUBE, 3" X 3" - LCLS-II TRANSPORT SYSTEM	2
12	F10038977	TUBE, 3" X 3" - LCLS-II TRANSPORT SYSTEM	16
11	F10038975	TUBE, 3" X 3" - LCLS-II TRANSPORT SYSTEM	8
10	F10038971	TUBE, 3" X 3" - LCLS-II TRANSPORT SYSTEM	2
9	F10038970	TUBE, 3" X 3" - LCLS-II TRANSPORT SYSTEM	2
8	F10038968	TUBE, 6" X 3" - LCLS-II TRANSPORT SYSTEM	6
7	F10038950	TUBE, 6" X 3" - LCLS-II TRANSPORT SYSTEM	4
6	F10033835	TUBE, 6" X 3" - LCLS-II TRANSPORT SYSTEM	2
5	F10038928	TUBE, 8" X 4" - LCLS-II TRANSPORT SYSTEM	6
4	F10038927	TUBE, 6" X 3" - LCLS-II TRANSPORT SYSTEM	2
3	F10038926	TUBE, 6" X 3" - LCLS-II TRANSPORT SYSTEM	12
2	F10038925	TUBE, 6" X 3" - LCLS-II TRANSPORT SYSTEM	4
1	F10038924	TUBE, 6" X 3" - LCLS-II TRANSPORT SYSTEM	2

PARTS LIST

NOTES (UNLESS OTHERWISE SPECIFIED):

1. WELDMENT MUST BE FREE OF DIRT, GREASE, OIL, CHIPS, AND BURRS.
2. DIMENSIONS WITH TRAILING ZEROES DENOTE TOLERANCE.
3. ESTIMATED WEIGHT (FACTORING WELDING): 10,500 LBS.

UNLESS OTHERWISE SPECIFIED

±.X	±.XX	±.XXX	±X/X	±X°
.1	.02	.005	1/16	1°

BREAK ALL SHARP EDGES .015 MAX.
DO NOT SCALE DRAWING
DIMENSIONS BASED ON ASME Y14.5-2009
MAX. ALL MACH SURFACES 125
DRAWING UNITS: INCHES

DRAWN	M.SAWTELL	DATE	18-Mar-2015
CHECKED		DATE	
APPROVED		DATE	

USED ON
F10039188

MATERIAL
SEE PARTS LIST

GROUP: Accelerator Mechanical Support CAGE CODE: 0U5R6

FERMI NATIONAL ACCELERATOR LABORATORY
UNITED STATES DEPARTMENT OF ENERGY

NAME
WELDMENT, BASE FRAME - LCLS-II TRANSPORT SYSTEM

SCALE	SIZE	DRAWING NUMBER	SHEET	REV
1:32 AS SHOWN	E	F10038882	1 OF 1	-