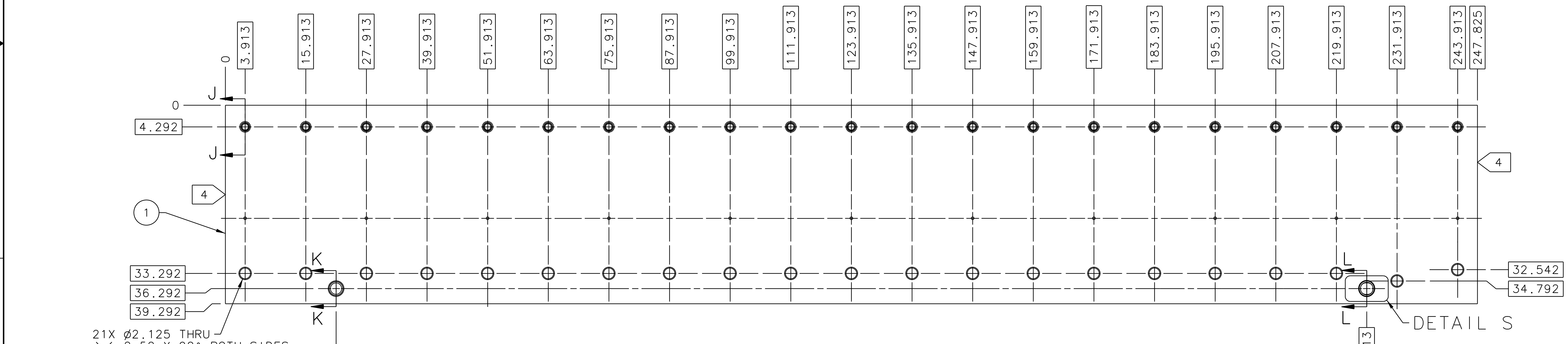
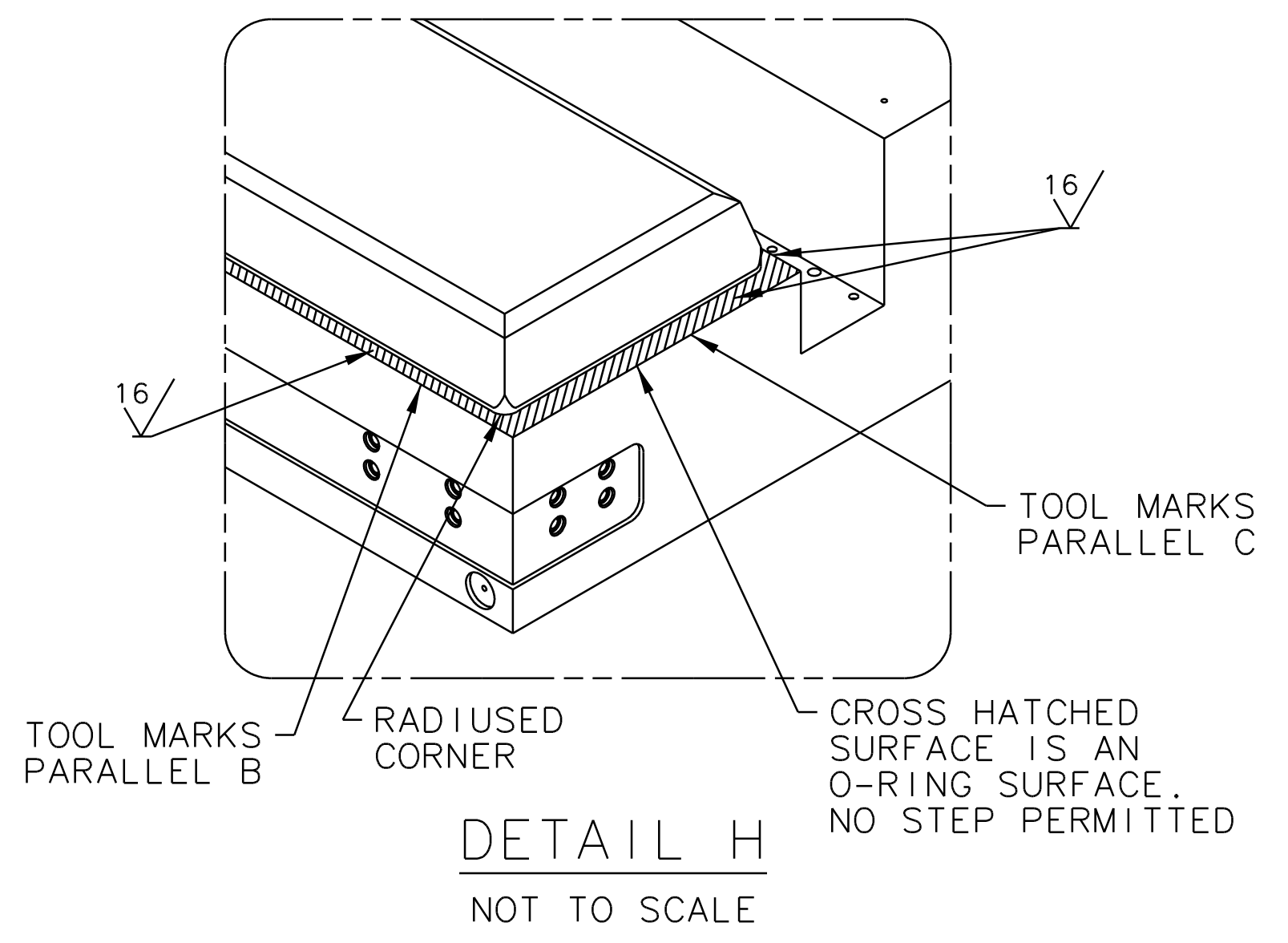
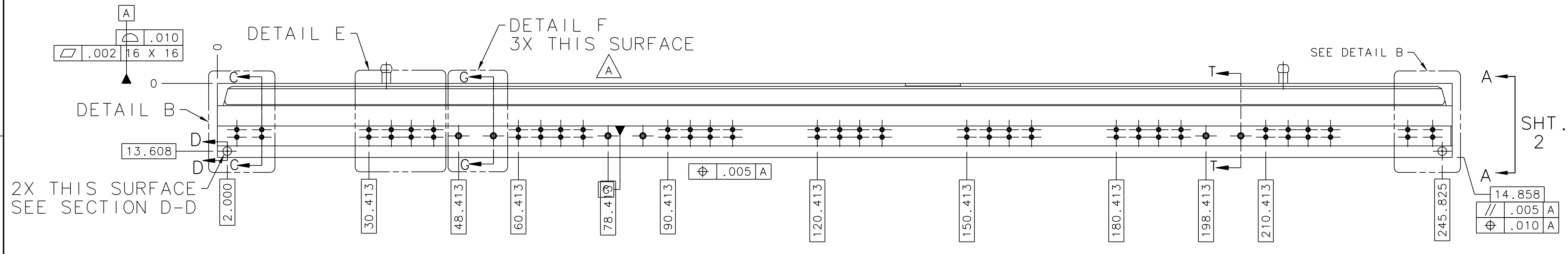
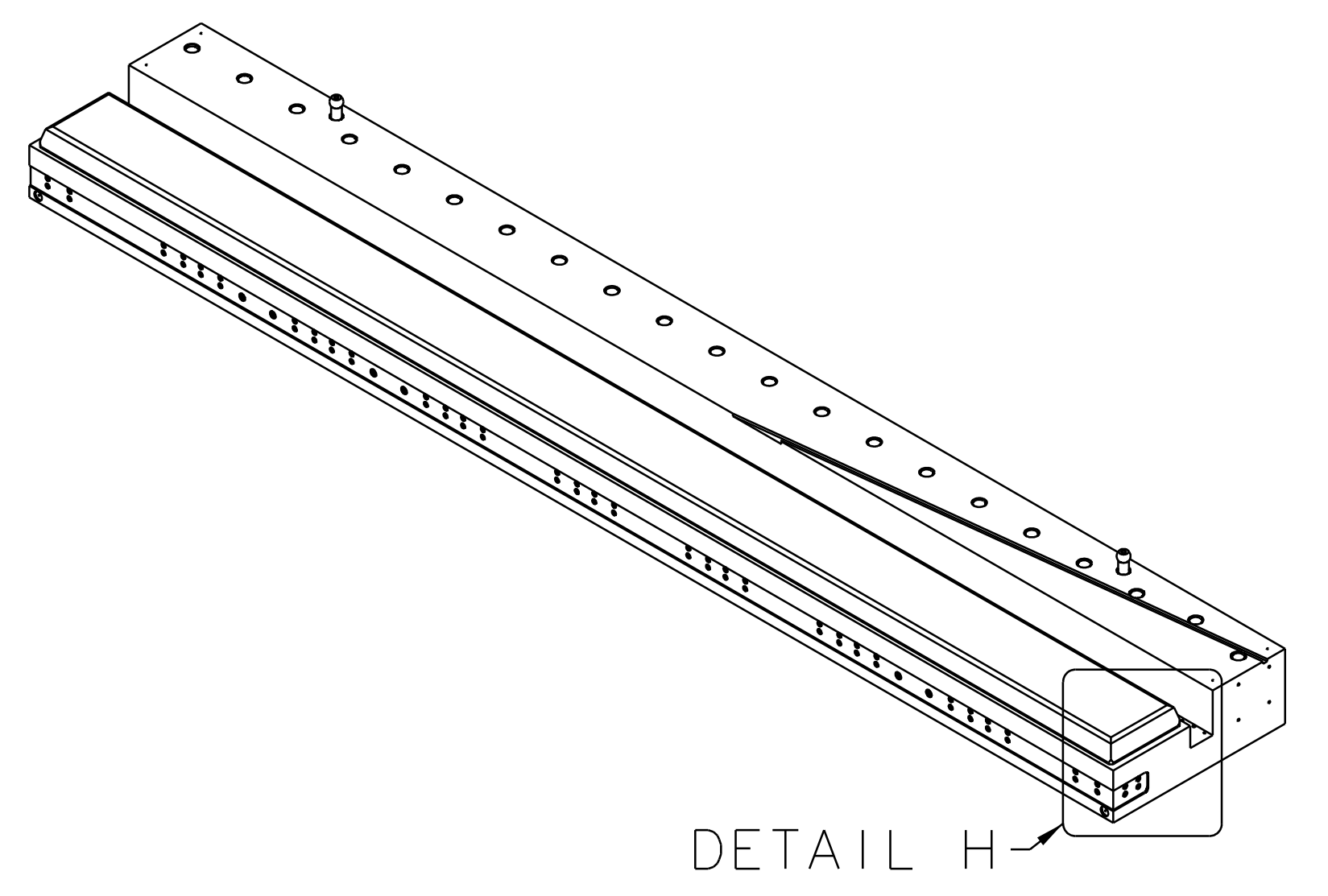
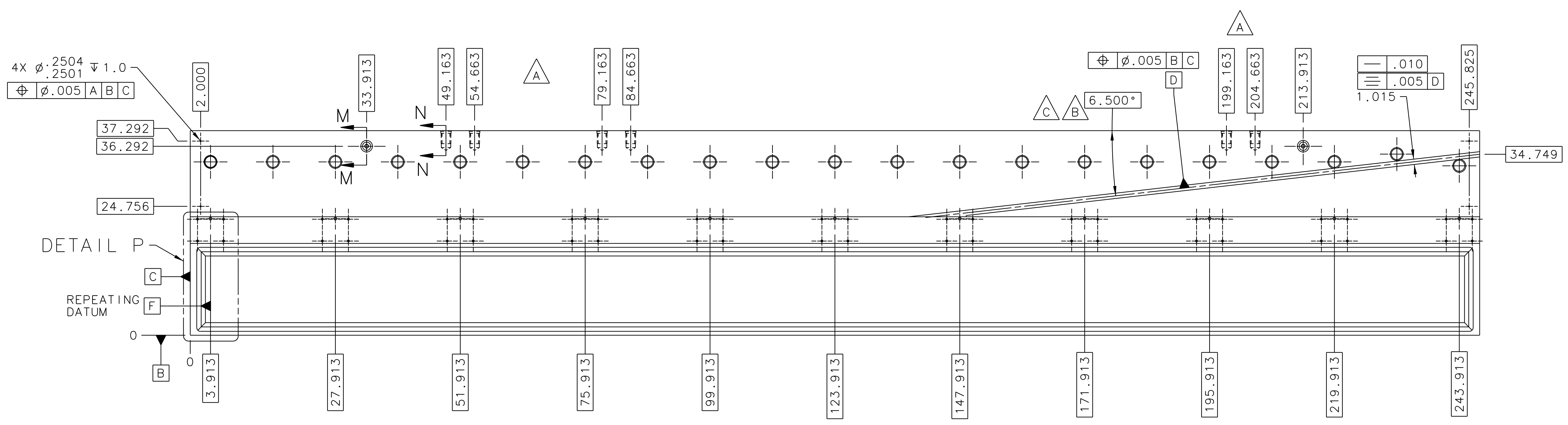


REVISION HISTORY				
ZONE	REV	DESCRIPTION	DATE	APPROVED
2-BF 1-3B & 1-5F	A	ADDED R.04 TWO PLACES. ADDED TWO ADDITIONAL 1/8-12 TAPPED HOLES. ADDED FOUR ADDITIONAL 1/8-12 TAPPED HOLES AND REVISED HOLE LOCATIONS. REVISED DIMENSION, WAS 7.858. REVISED QTY OF ITEM 5, WAS 4. REVISED QTY OF ITEM 5, WAS 2. D. RATH 06OCT11	12OCT11 12OCT11	W. CRAHEN T. WHITLATCH
1-4H 2-5C 1-2B 1-2B	B	CHANGED DIMENSION, WAS 6.5000*. CHANGED DEPTH, WAS 5.62.	7JAN13 7JAN13	W. CRAHEN T. WHITLATCH
1-4H 2-7B	C	CHANGED DIMENSION, WAS 6.506*.	6MAR13 6MAR13	W. CRAHEN T. WHITLATCH

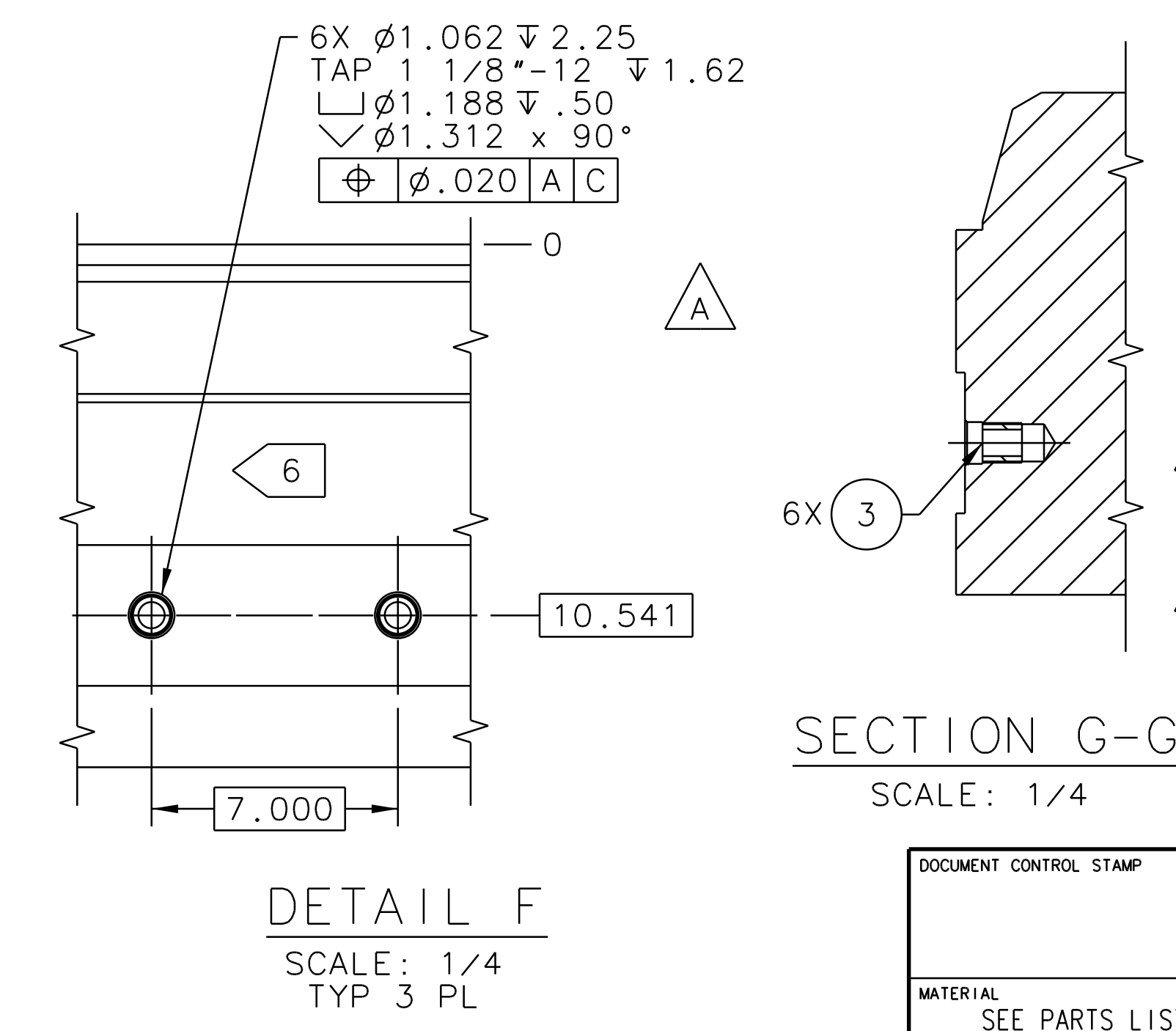
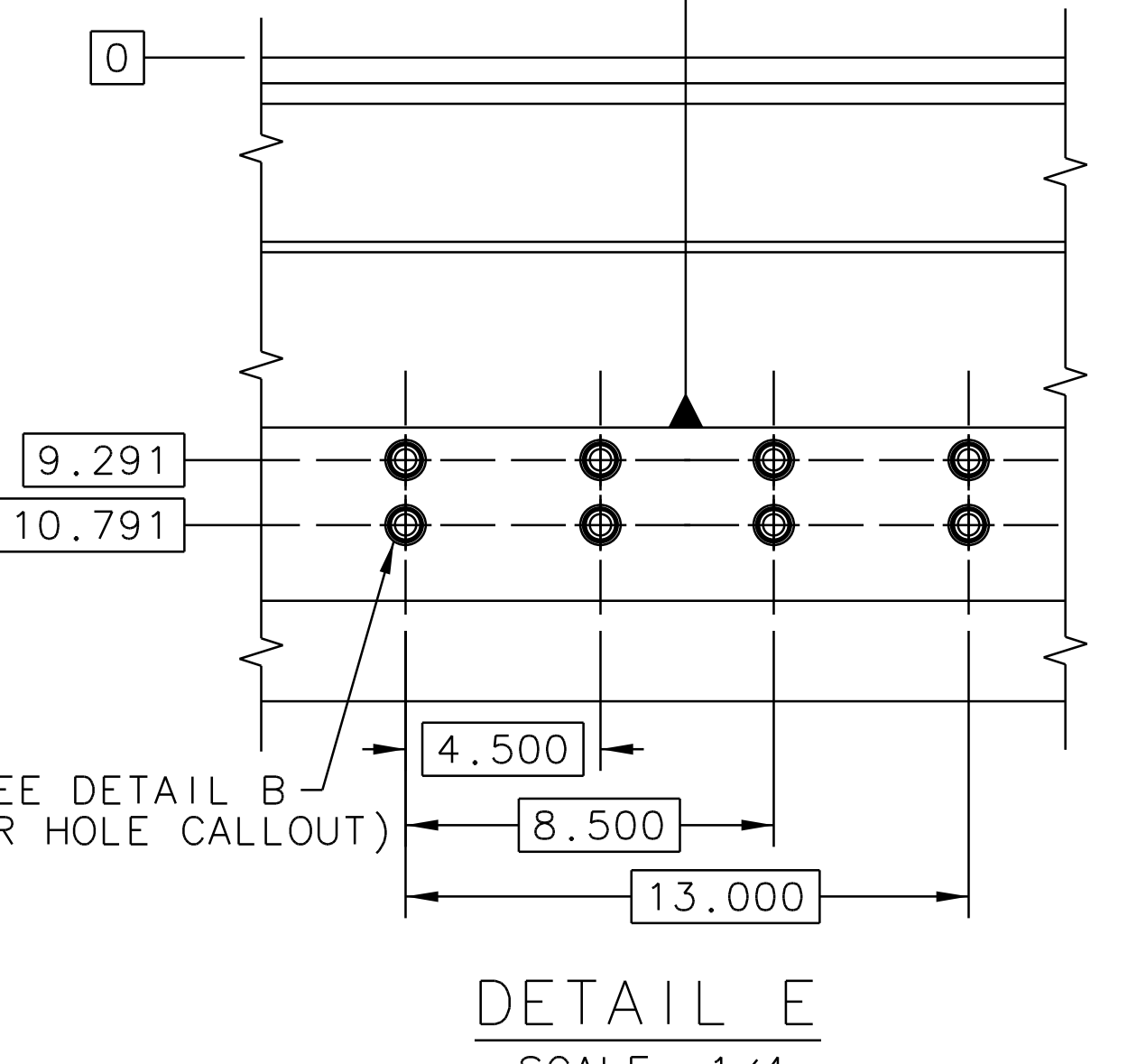
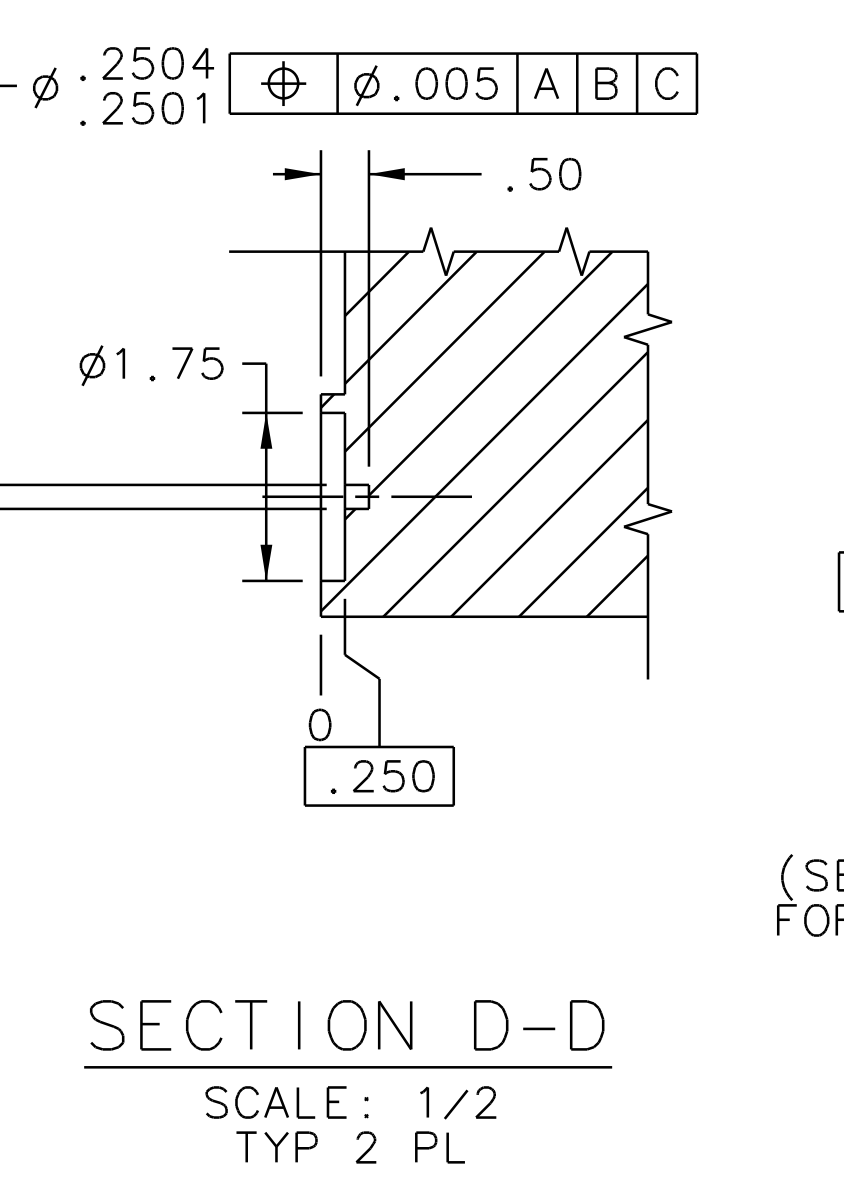
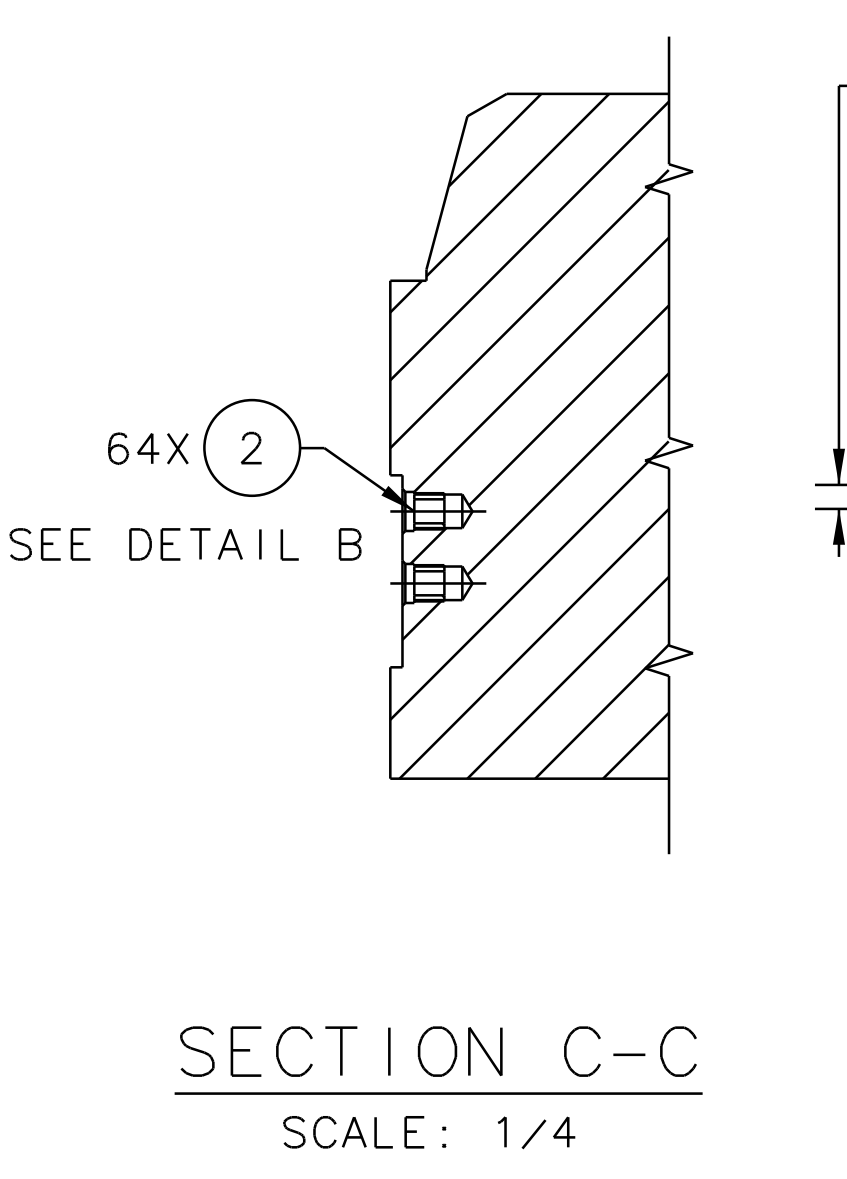
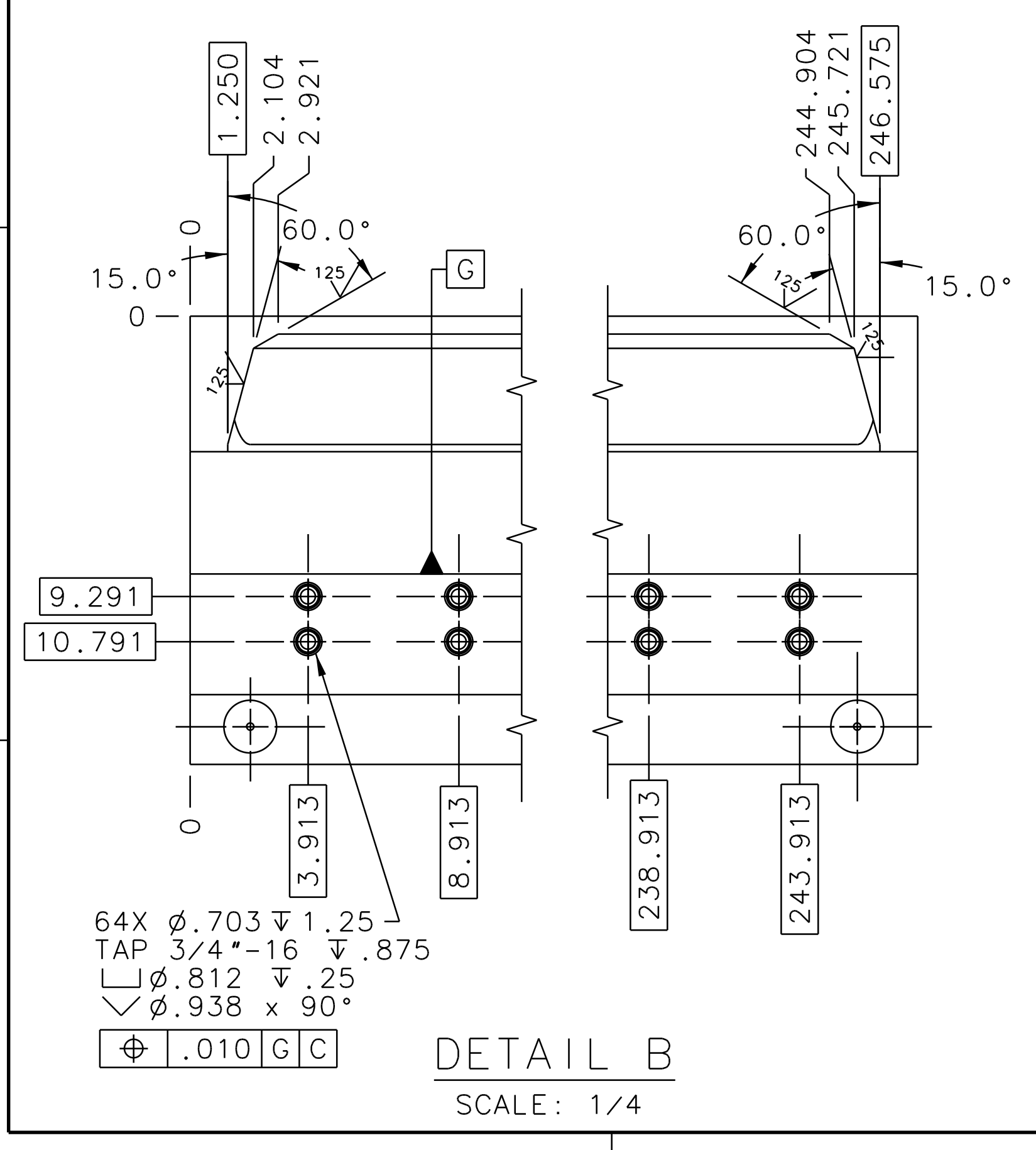


- NOTES:
- FABRICATION/MATERIAL SPEC IN ACCORDANCE WITH THIS DRAWING AND SPECIFICATION D00000-19-00-S003.
 - APPROXIMATE WEIGHT = 36040 LBS. WEIGHT & PART NUMBER OF MAGNET TO BE PAINTED IN 2 HIGH CHARACTERS IN APPROXIMATE LOCATION SHOWN, COLOR RED.
 - NEITHER HANDLING NOR MACHINING OPERATIONS SHALL USE MAGNETS FOR LIFTING OR HOLDING DOWN AFTER FINAL ANNEALING PROCESS.
 - MASK ALL MACHINED HOLES AND FINISH IDENTIFIED OUTER SURFACES WITH RUSTOLEUM PRIMER & RUSTOLEUM #866402 (MARLIN BLUE) PAINT PER MANUFACTURERS INSTRUCTIONS.
 - PROTECT UNPAINTED SURFACES PER SECTION 2.1.6 IN SPECIFICATION D00000-19-00-S003.
 - *DETAIL F* (2 PLACES) IS AN ATTACHMENT LOCATION FOR LIFTING PLATE ATTACHMENT. SEE SECTION *T-T*.
 - HOIST RING ATTACHMENT POINT.
 - INSTALL AND BOND AFTERWARDS WITH WICKING LOCTITE #290.
 - SUGGESTED SOURCES OR JLAB APPROVED ALTERNATE:

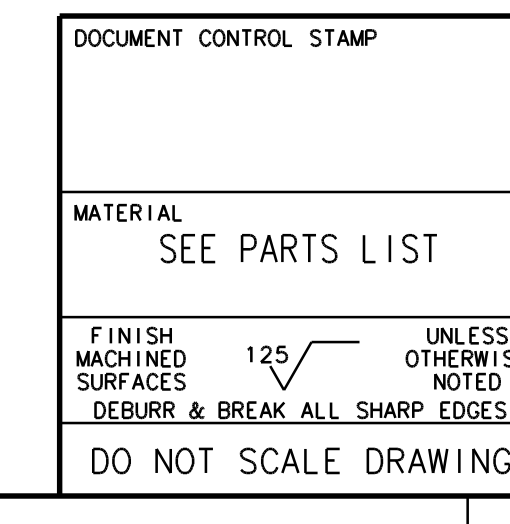
RECOIL/ALCOA
(317) 704.8864
WWW.ALCOA.COM

CARR-LANE MFG. CO.
(314) 647-6200
WWW.CARRLANE.COM

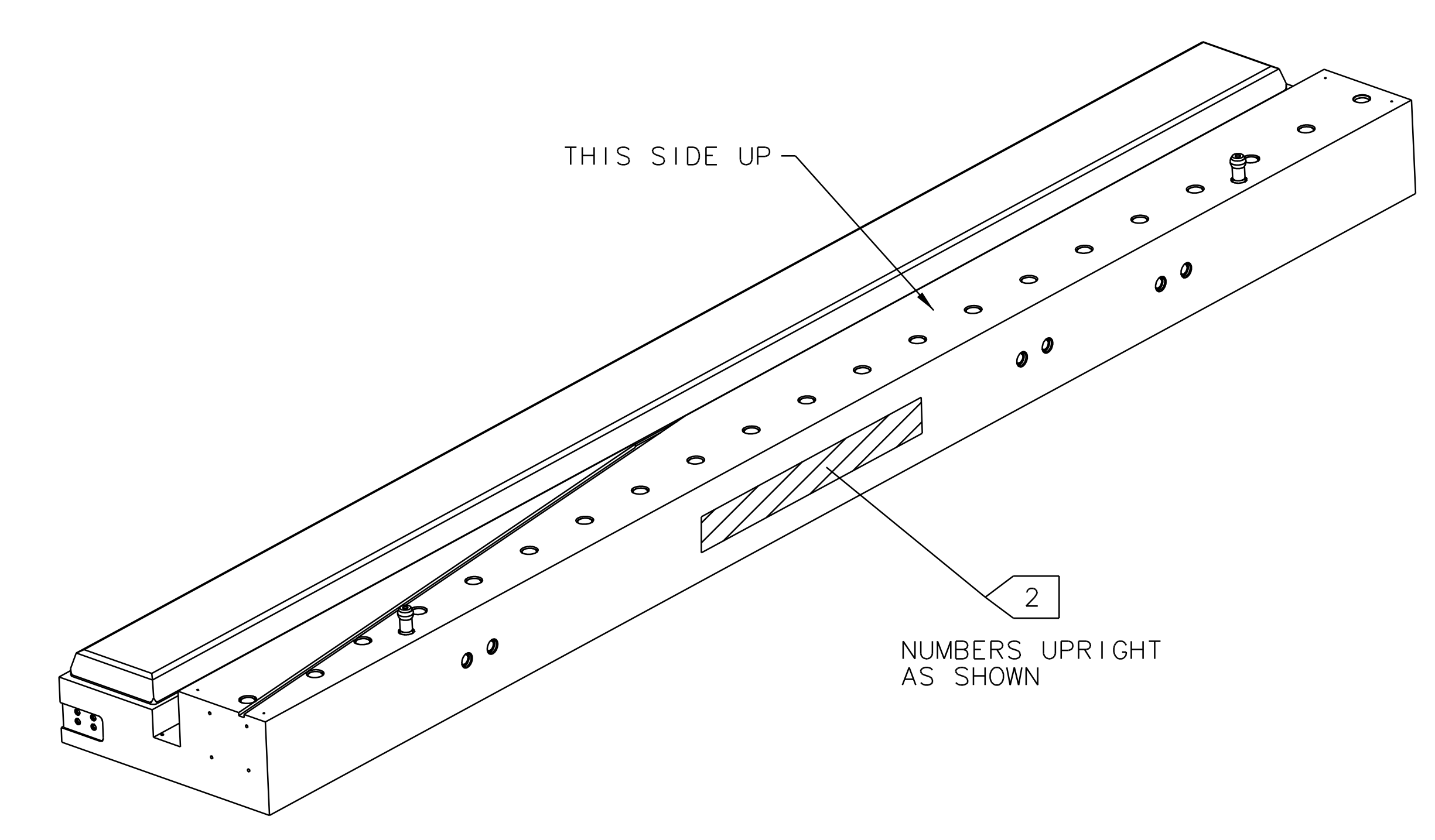
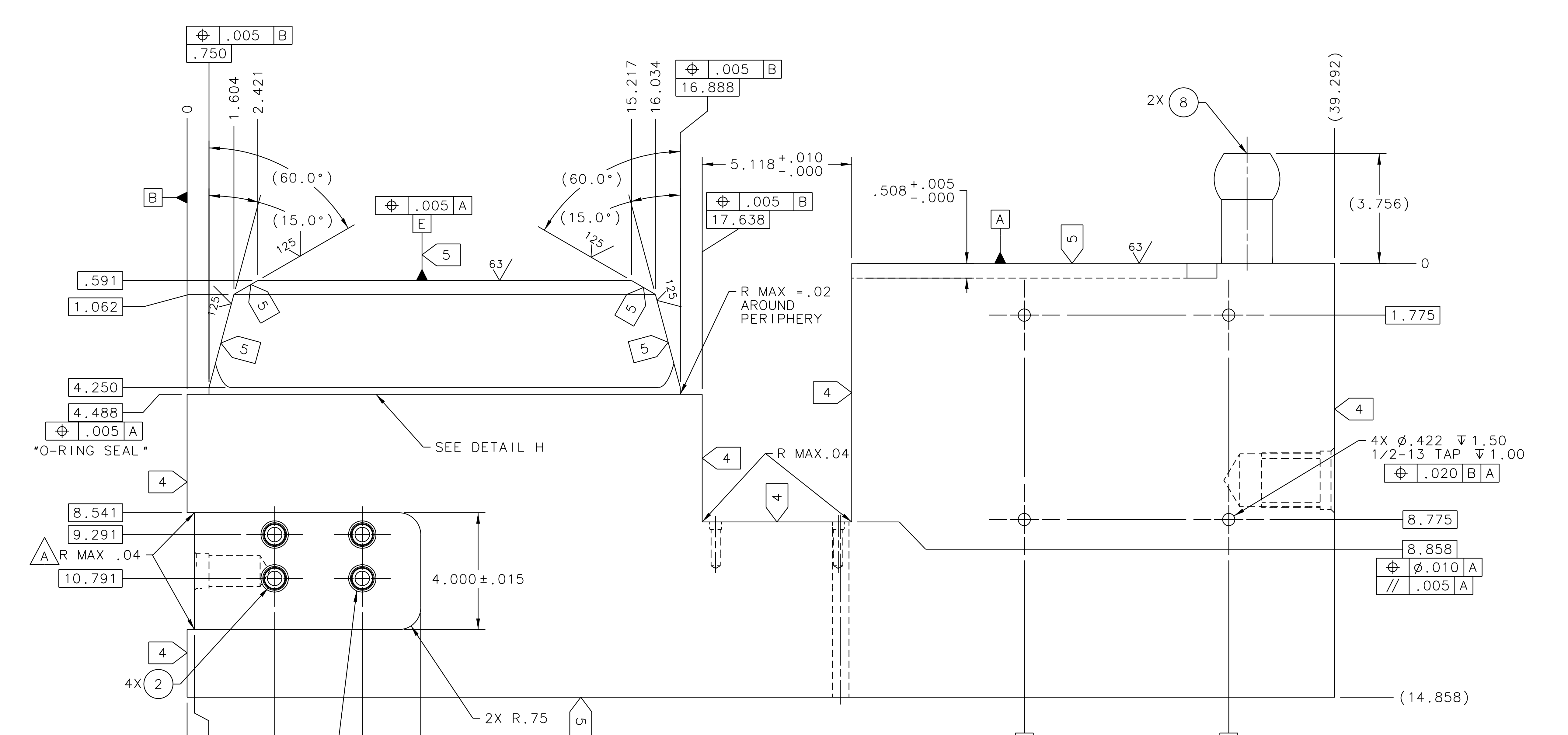
AR	QTY	DESCRIPTION	MATERIAL SPECIFICATION	NOTES
9		LOCTITE #290		8
8		D00000-19-00-2001	TAGGER TOOLING BALL	
7		D00000-19-00-2000	SEMI-HARD SLOT INSERT	
6		CARR LANE L-176-48	DRILL LINER BUSHING 2.25 ID X 2.75 OD X 3.0 LG	STEEL 9
5		RECOIL/ALCOA 73242	1.50-6 KEYSERT	STEEL 9
4		RECOIL/ALCOA 73202	1.25-7 KEYSERT	STEEL 9
3		RECOIL/ALCOA 73122	.75-10 KEYSERT	STEEL 9
2		RECOIL/ALCOA 73082	.50-13 KEYSERT	STEEL 9
1		-01	LOWER MAGNET POLE	SEE NOTE 1 1,2



SECTION G-G
SCALE: 1/4



DOCUMENT CONTROL STAMP	DWG & TOOL PER ASME Y14.5 UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE:	TRACKING NO.	United States Department of Energy	Jefferson Lab	Newport News Virginia
MATERIAL: SEE PARTS LIST	FRACTIONS: ±.010, ±.005, ±.002, ±.001, ±.0005, ±.0002, ±.0001, ±.00005, ±.00002, ±.00001, ±.000005, ±.000002, ±.000001, ±.0000005, ±.0000002, ±.0000001, ±.00000005, ±.00000002, ±.00000001	N/A	APPROVALS: J. LADNER, C. HUTTON, W. CRAHEN, T. WHITLATCH	DATE: 14SEP10, 27OCT10, 22OCT10, 27OCT10	HALL D-GLUEX PHOTON TAGGER MAGNET LOWER POLE SUB-ASSEMBLY
FINISH: MACHINED SURFACES UNLESS OTHERWISE NOTED DEBURR & BREAK ALL SHARP EDGES	DO NOT SCALE DRAWING	THIRD ANGLE PROJECTION	APPROVED: W. CRAHEN, T. WHITLATCH	DATE: 27OCT10	SCALE: 1:10 (80 OR ASSY NO. D00000-19-00-1000) SHEET 1 OF 2



VIEW A-A
SCALE: 1/2
(SOME HIDDEN LINES NOT SHOWN FOR CLARITY)

4X ϕ .703 ∇ 1.25
TAP 3/4"-16 ∇ .875
 ∇ ϕ .812 ∇ .25
 ∇ ϕ .938 x 90°
 ϕ .010 G B

