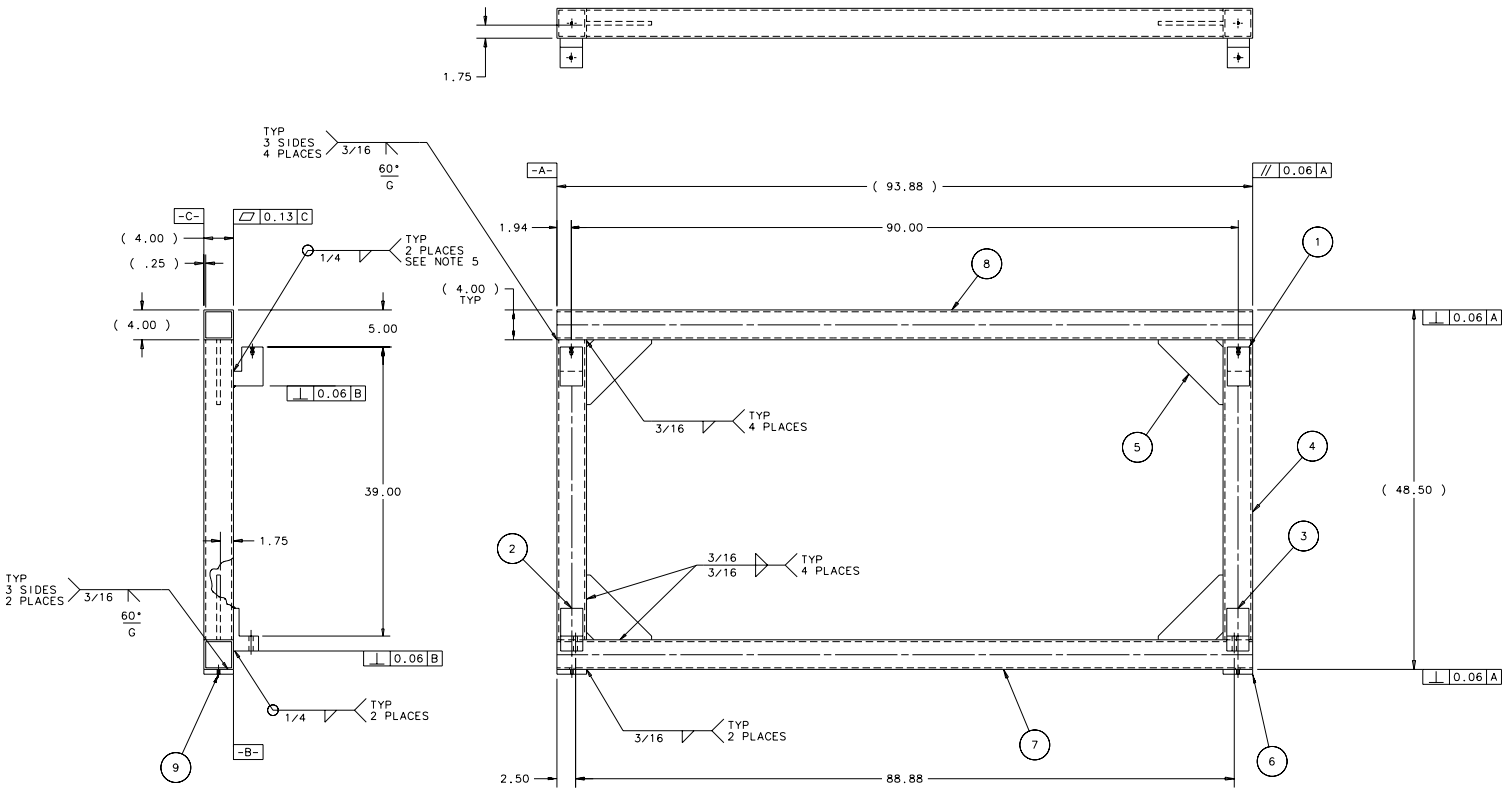
REV	DESCRIPTION	DRAWN	DATE
		APPROVED	DATE



NOTES:

1. WELDING SHALL BE DONE USING THE ELECTRIC ARC PROCESS BY WELDERS HOLDING CURRENT WELDING CERTIFICATES FOR EASH REQUIRED PROCEDURE.
2. ALL WELDING SHALL BE DONE WITH ER5356 ELECTRODES USLESS SPECIFIED OTHERWISE.
3. IT SHALL BE THE RESPONSIBILITY OF THE SUBCONTRACTOR TO VERIFY ALL PART DIMENSIONS TO INSURE THE EXACT OVERALL DIMENSIONS AND TOLERANCE OF THE FINAL ASSEMBLY AS SHOWN ON THE DRAWING 3907.500-MD-397786.
4. WELD SIZE MUST BE KEPT TO 1/4" MAX. TO OBTAIN THE ASSEMBLY CLEARANCE.

APPROX. WT. = 110 LBS.

ITEM	PART NO.	DESCRIPTION OR SIZE	QTY.
9	FERMI # 1204-1508	3/8-16 SELF LOCKING THREADED NSERT 303 SST. KEENSERT #KNH616	2
8	MC-397794	UPPER HORIZONTAL TUBE	1
7	MC-397785	LOWER HORIZONTAL TUBE	1
6	MC-397784	ADJUSTABLE CONNECTING PLATE	2
5	MC-397783	GUSSET	4
4	MC-397782	VERTICAL TUBE	2
3	MC-397781	LOWER CONNECTING BRACKET R.H.	1
2	MC-397780	LOWER CONNECTING BRACKET L.H.	1
1	MC-397779	UPPER CONNECTING BRACKET	2

PARTS LIST

UNLESS OTHERWISE SPECIFIED			ORIGINATOR	I.FANG	17-APR-2002
.XX	.XXX	ANGLES	DRAWN	G.SMITH	17-APR-2002
± .06	± ---	± ---	CHECKED	J.KILMER	06-JUN-2002
1. BREAK ALL SHARP EDGES .015 MAX. 2. DO NOT SCALE DRAWING. 3. DIMENSIONS BASED UPON ANSI Y14.5M-1982 4. ALL DIMENSIONS ARE INCHES 5. MAX. ALL MACH. SURFACES			APPROVED	J.KILMER	06-JUN-2002
			USED ON	3907.500-MD-397786	
			MATERIAL	SEE PARTS LIST ABOVE	

FERMI NATIONAL ACCELERATOR LABORATORY
UNITED STATES DEPARTMENT OF ENERGY

PPD/MECHANICAL DEPARTMENT
E907 CHAMBER #2 SUPPORT STAND
INNER FRAME WELDMENT

SCALE	DRAWING NUMBER	SHEET	REV
1:8	3907.550-MD-397778	1 OF 1	

CREATED WITH : Ideas8m4 GROUP: PPD/MECHANICAL DEPARTMENT