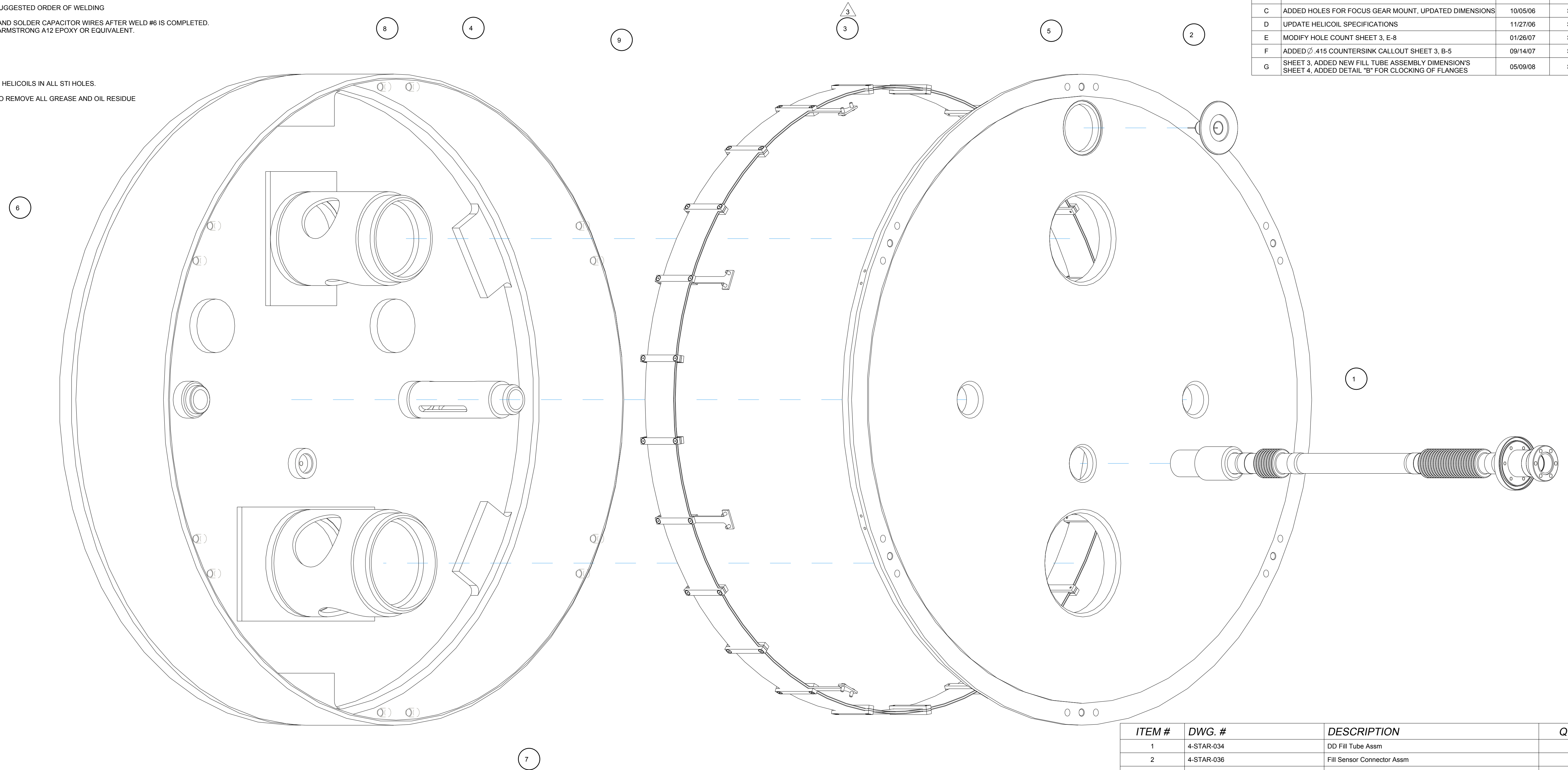


NOTES:

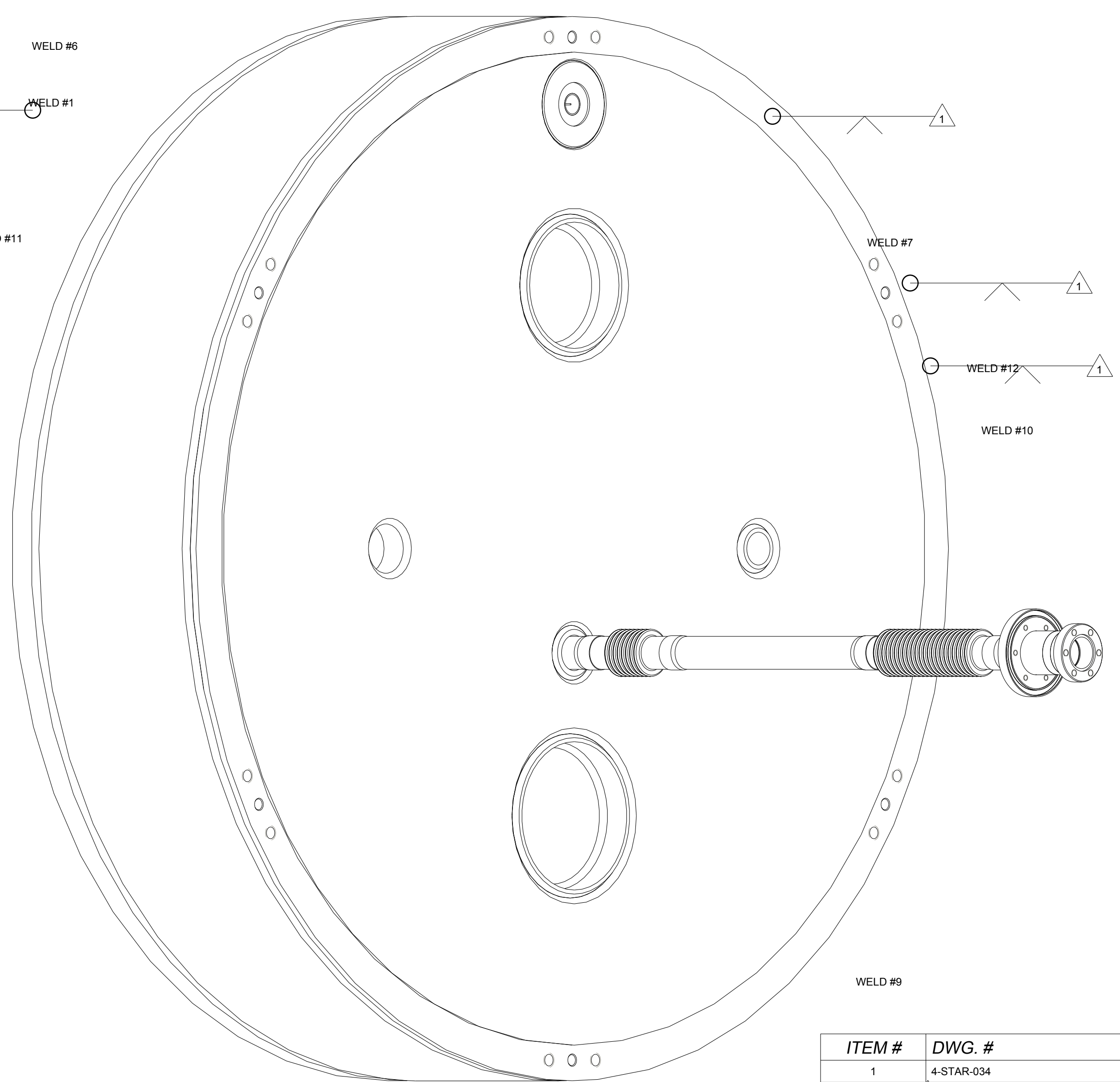
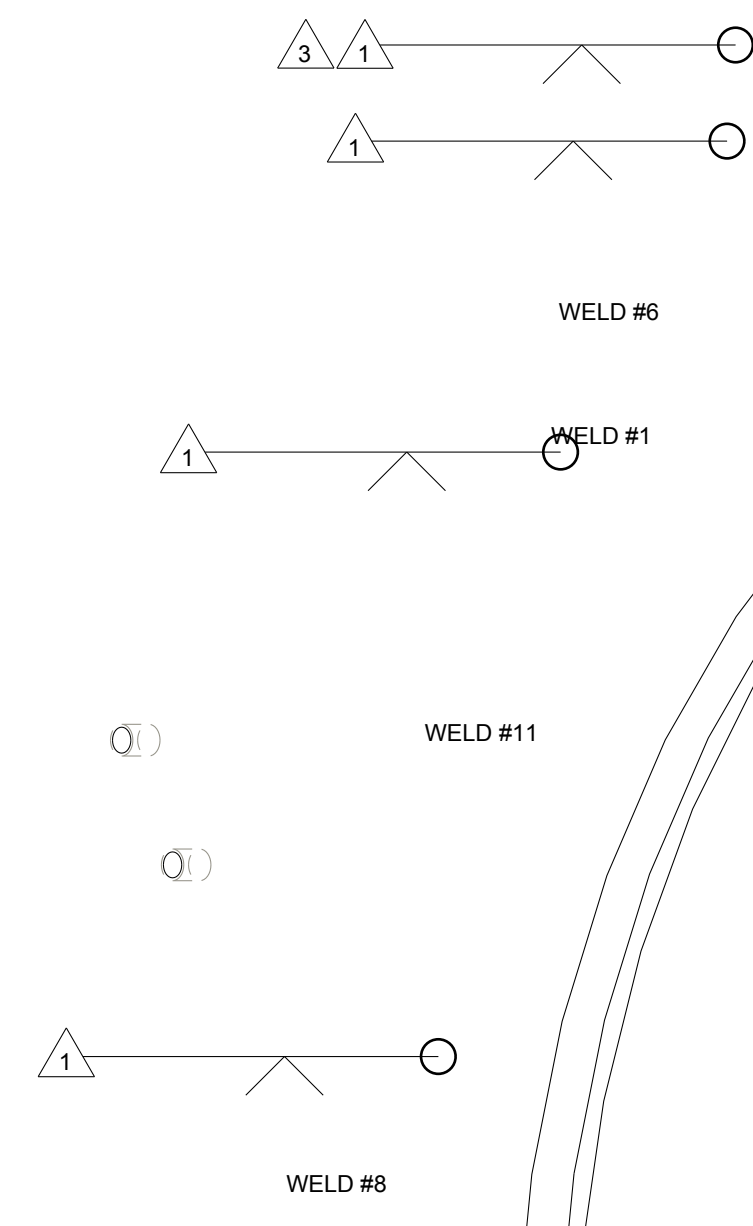
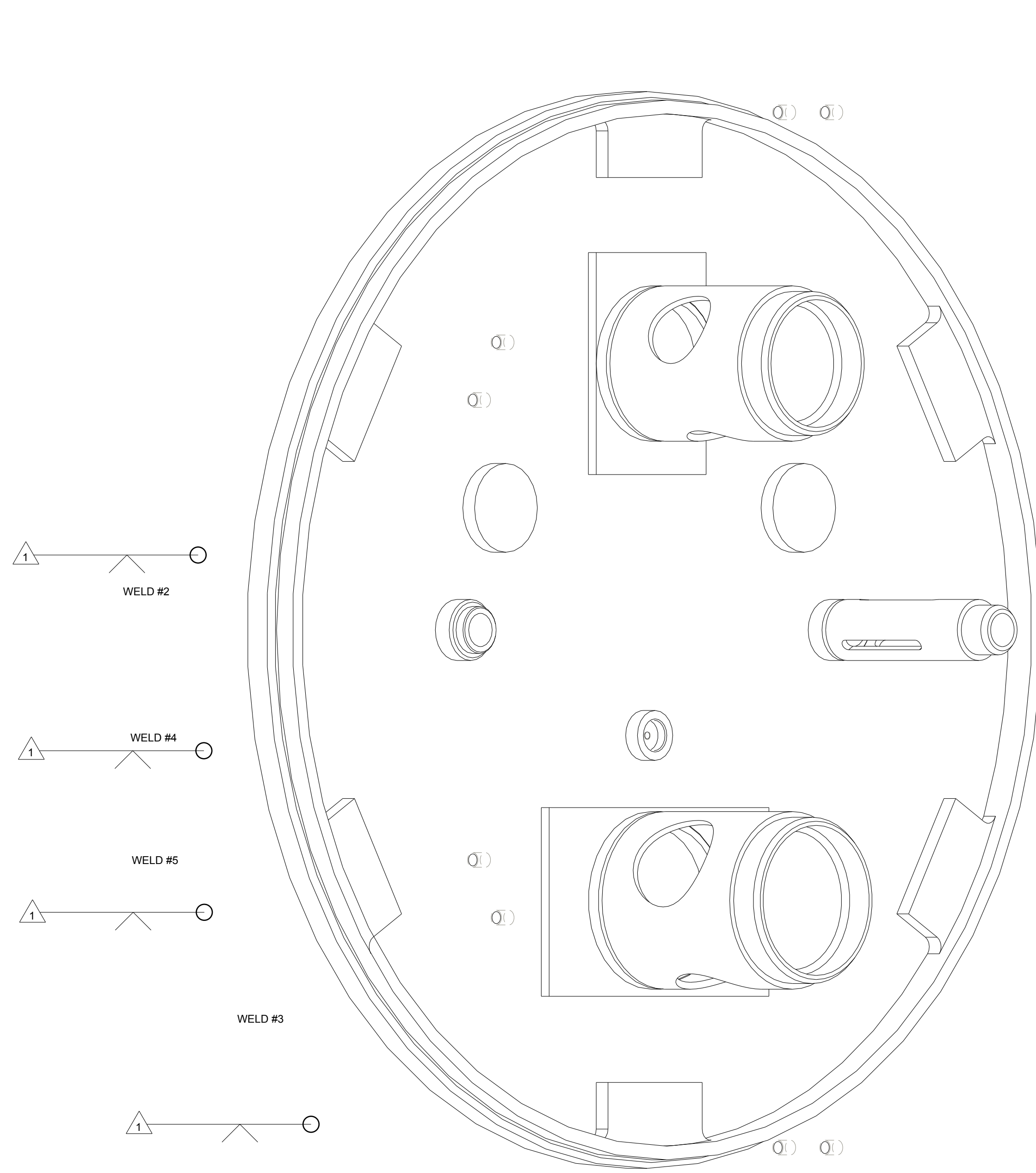
1. WELDS SHALL BE VACUUM CAPABLE TO NOT EXCEED A LEAK RATE OF 10E-9 STANDARD ATMOSPHERIC CCs PER SECOND OF HELIUM GAS
2. WELD NUMBERS REFER TO THE SUGGESTED ORDER OF WELDING
3. INSERT CAPACITOR (4-STAR-038) AND SOLDER CAPACITOR WIRES AFTER WELD #6 IS COMPLETED. STAKE MOUNTING SCREWS WITH ARMSTRONG A12 EPOXY OR EQUIVALENT.
4. DEBUR ALL SHARP EDGES
5. ALL HOLES ARE BLIND
6. UNLESS OTHERWISE SPECIFIED:  
-INSTALL 1.5D PHOSPHOR BRONZE HELICOILS IN ALL STI HOLES.
7. CLEAN PART AFTER MACHINING TO REMOVE ALL GREASE AND OIL RESIDUE

REV.	DESCRIPTION	DATE	APPROVAL
A	COMBINED WLDMNT AND MACHINE DRAWING	05/08/06	SMEE
B	MULTIPLE PART/DRAWING UPDATES	09/11/06	SMEE
C	ADDED HOLES FOR FOCUS GEAR MOUNT, UPDATED DIMENSIONS	10/05/06	SMEE
D	UPDATE HELICOIL SPECIFICATIONS	11/27/06	SMEE
E	MODIFY HOLE COUNT SHEET 3, E-8	01/26/07	SMEE
F	ADDED Ø.415 COUNTERSINK CALLOUT SHEET 3, B-5	09/14/07	SMEE
G	SHEET 3, ADDED NEW FILL TUBE ASSEMBLY DIMENSIONS SHEET 4, ADDED DETAIL "B" FOR CLOCKING OF FLANGES	05/09/08	SMEE



ITEM #	DWG. #	DESCRIPTION	QTY.
1	4-STAR-034	DD Fill Tube Assm	1
2	4-STAR-036	Fill Sensor Connector Assm	1
3	4-STAR-038	DD LN2 Level Sensor Assm	1
4	4-STAR-F-0024	Detector Dewar Shell	1
5	4-STAR-F-0026	Detector Dewar Back Plate	1
6	4-STAR-F-0027	Detector Dewar Cold Plate	1
7	4-STAR-F-0085	Detector Dewar Cold Plate	1
8	4-STAR-F-0086	Field Flattener Wheel Gusset	1
9	4-STAR-F-0087	DD Cold Plate Gusset	2

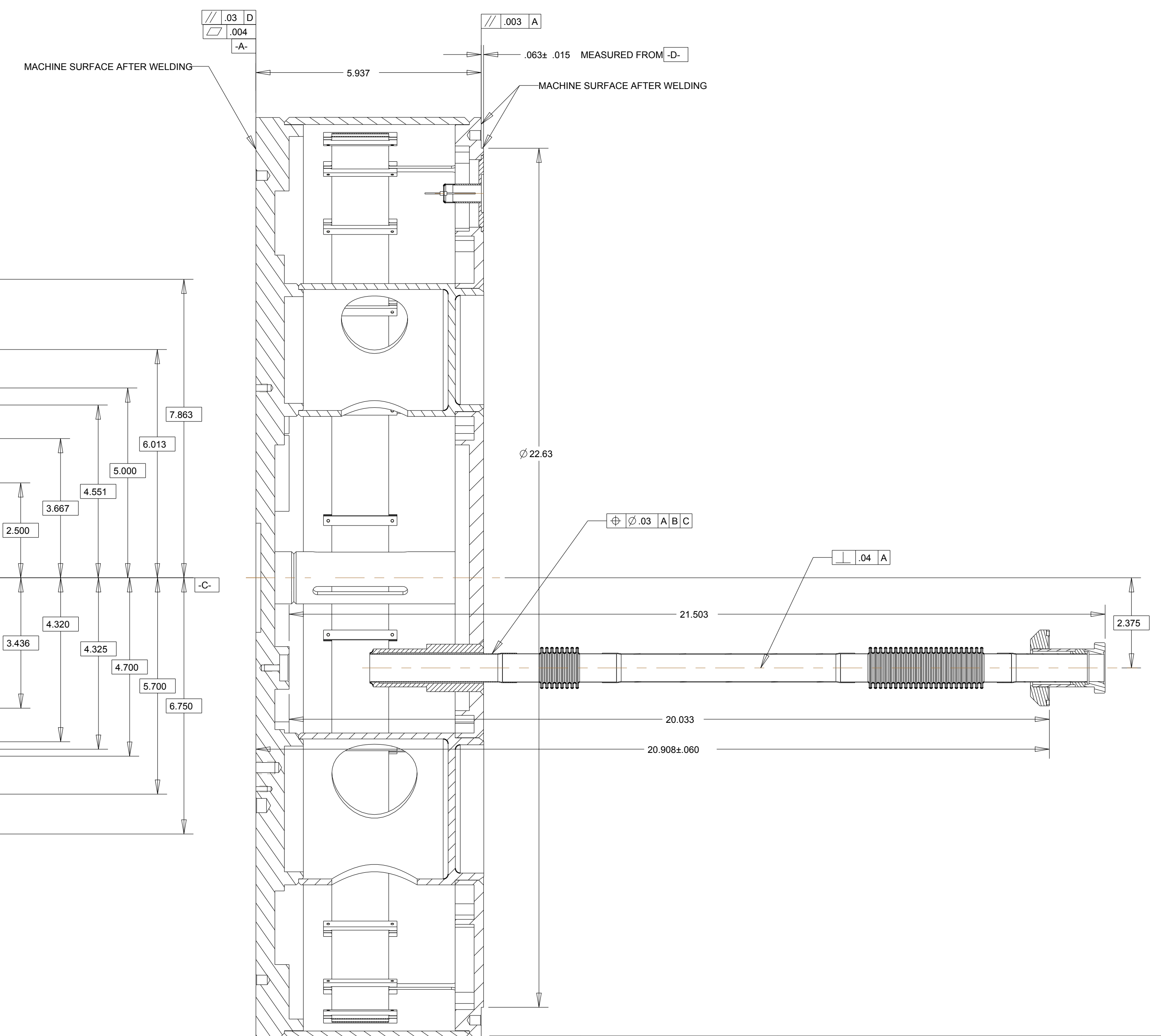
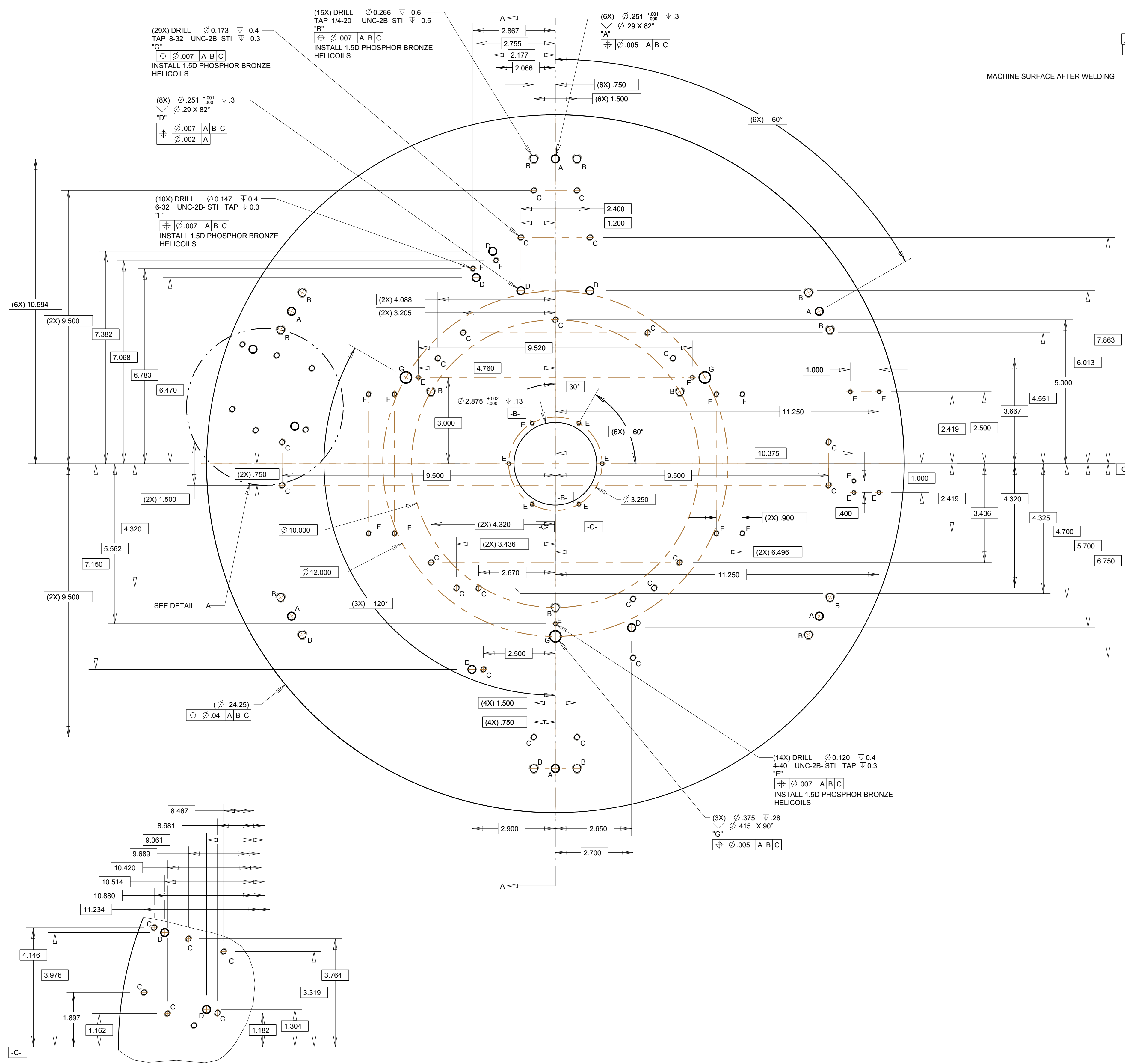
		***			
		***	11/27/06	***	
		D	4-STAR-009		***
		1/2		1 OF 4	



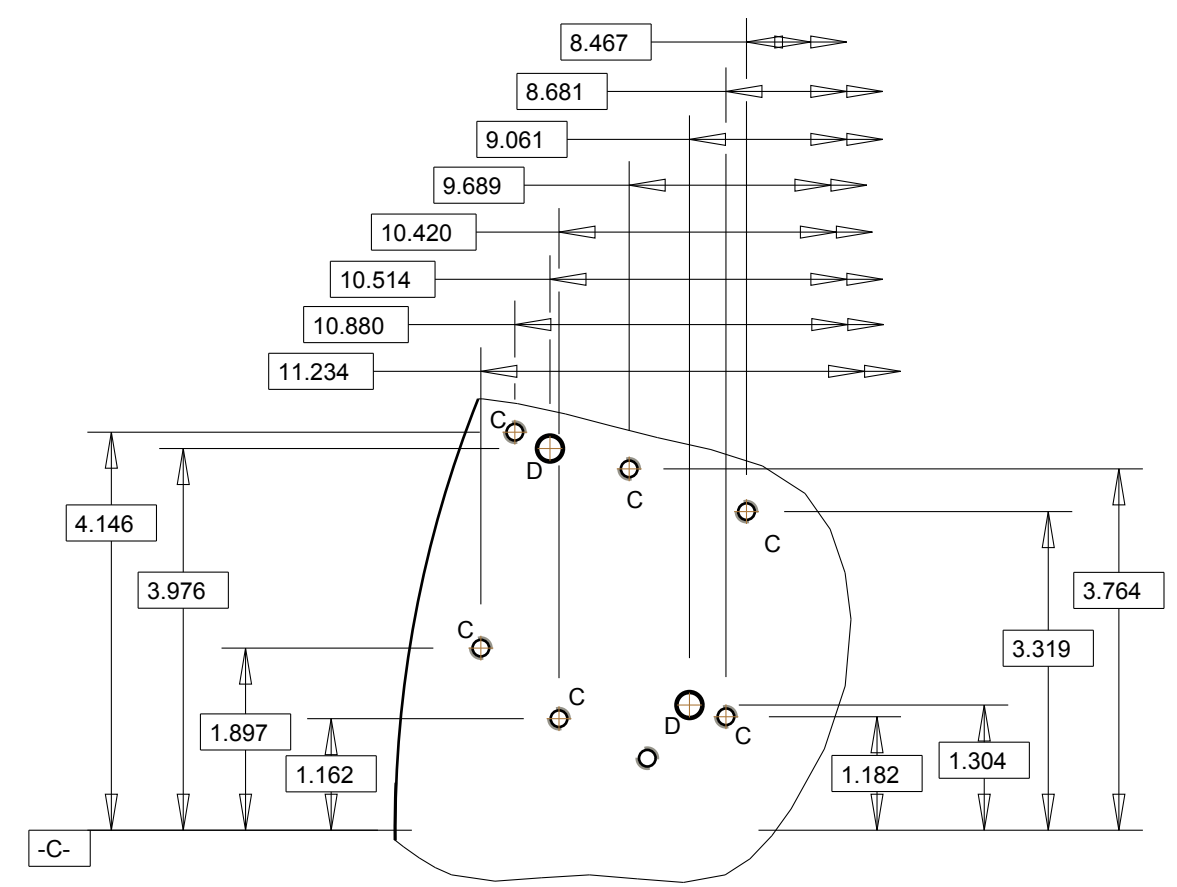
ITEM #	DWG. #	DESCRIPTION	QTY.
1	4-STAR-034	DD Fill Tube Assm	1
2	4-STAR-036	Fill Sensor Connector Assm	1
3	4-STAR-038	DD LN2 Level Sensor Assm	1
4	4-STAR-F-0024	Detector Dewar Shell	1
5	4-STAR-F-0026	Detector Dewar Back Plate	1
6	4-STAR-F-0027	Detector Dewar Cold Plate	1
7	4-STAR-F-0085	Detector Dewar Cold Plate	1
8	4-STAR-F-0086	Field Flattener Wheel Gusset	1
9	4-STAR-F-0087	DD Cold Plate Gusset	2

		<b>4-STAR</b>		<b>Detector Dewar</b>	
		A. HARDING	11/27/06		
4-STAR-019	S. SMEE	D	4-STAR-009	G	
		1/2		2 OF 4	





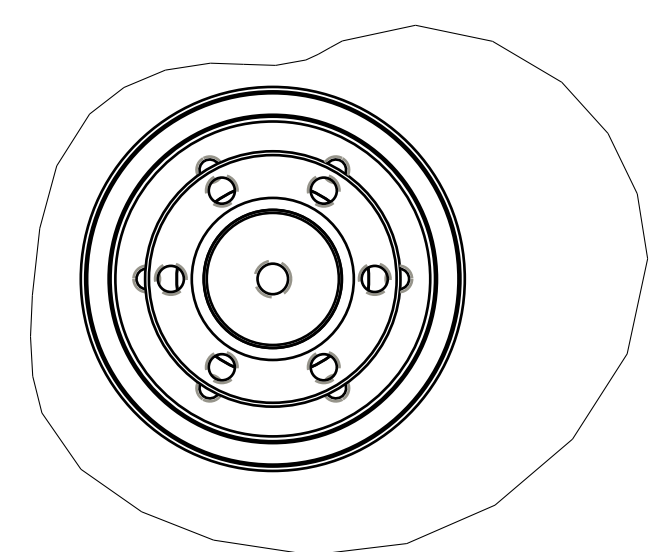
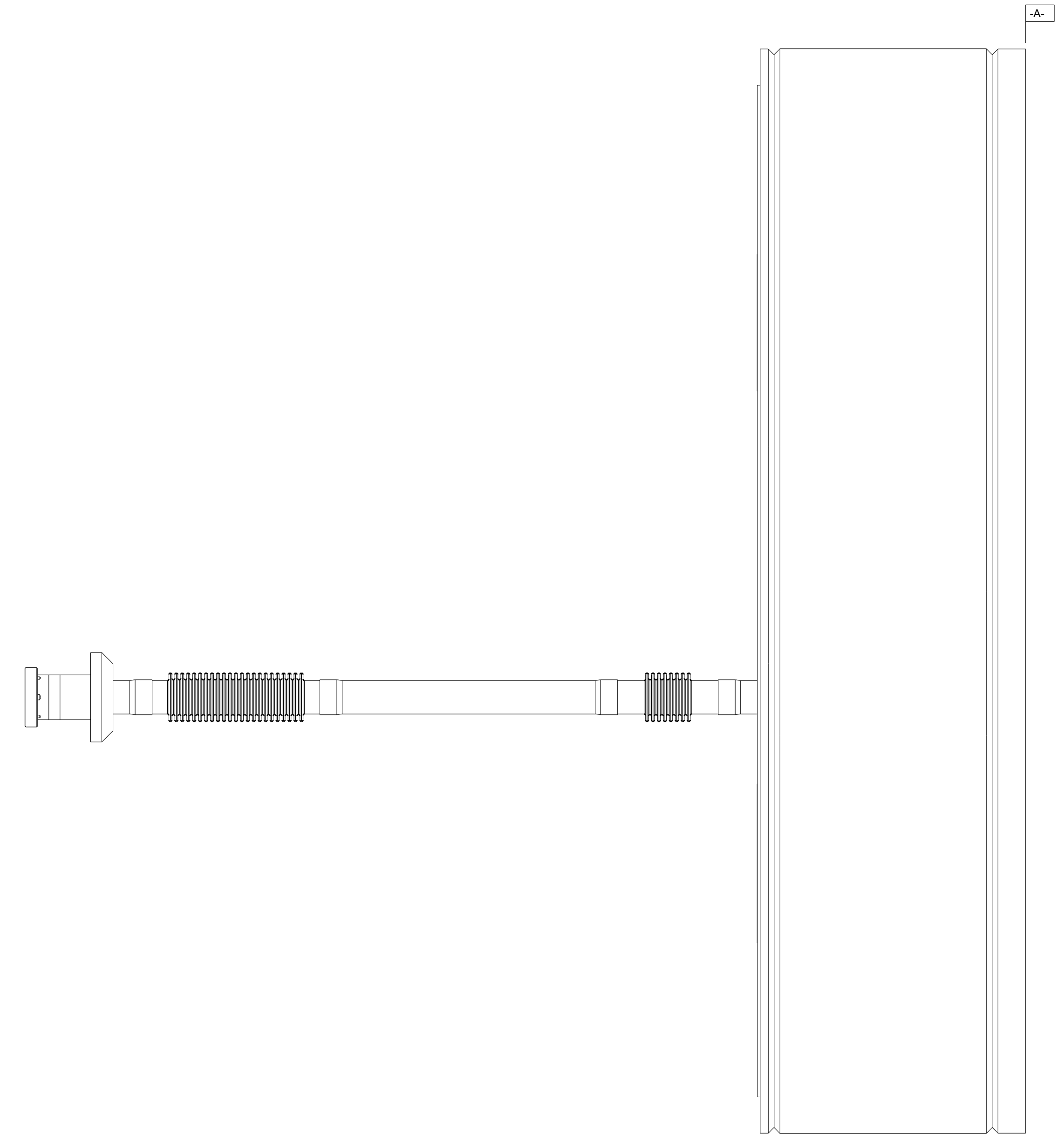
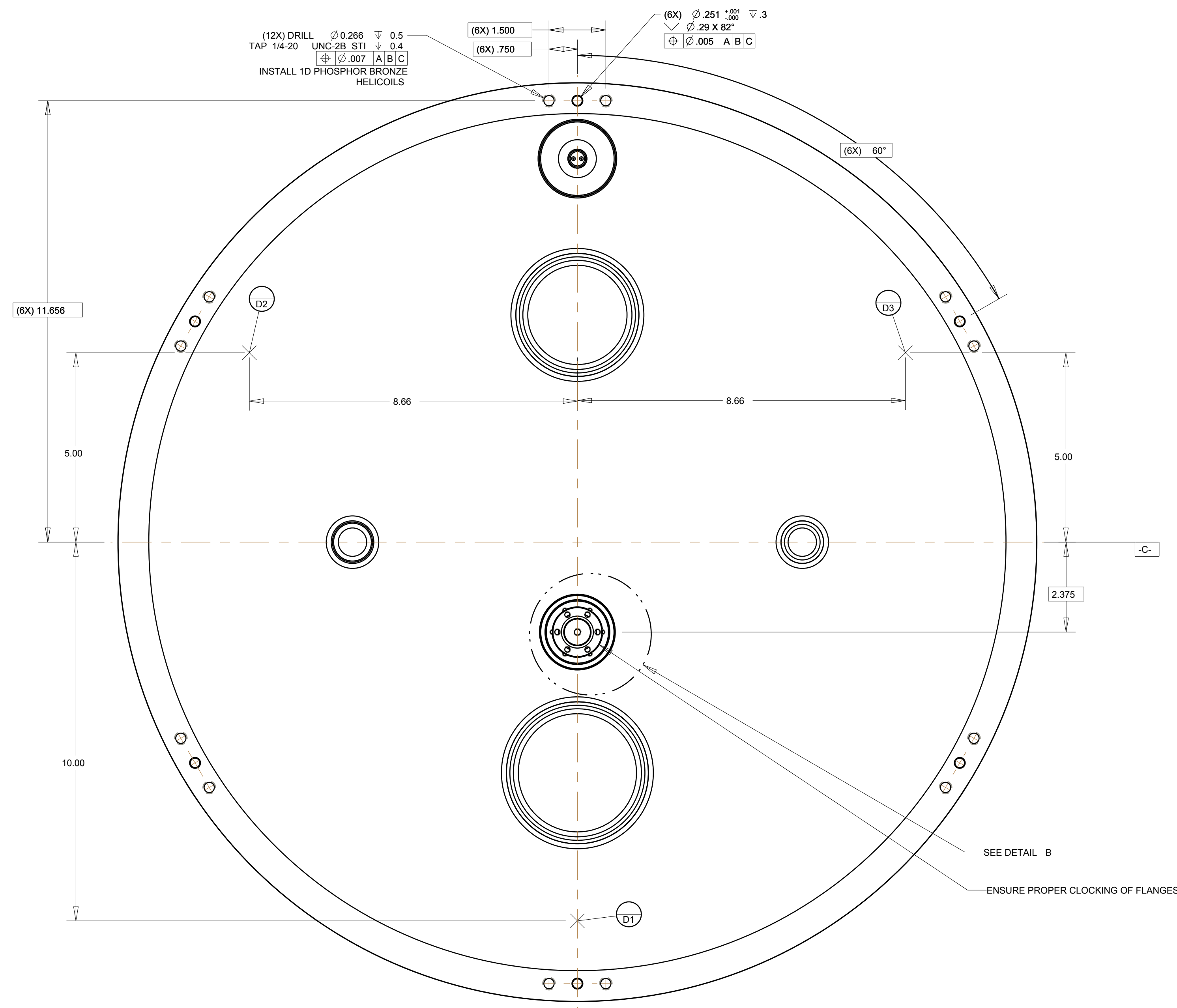
SECTION A-A



DETAIL A  
ALL HORIZONTAL DIMENSIONS REFERENCED TO CENTERLINE  
SCALE 1/2

ITEM #	DWG. #	DESCRIPTION	QTY.
1	4-STAR-034	DD Fill Tube Assm	1
2	4-STAR-036	Fill Sensor Connector Assm	1
3	4-STAR-038	DD LN2 Level Sensor Assm	1
4	4-STAR-F-0024	Detector Dewar Shell	1
5	4-STAR-F-0026	Detector Dewar Back Plate	1
6	4-STAR-F-0027	Detector Dewar Cold Plate	1
7	4-STAR-F-0085	Detector Dewar Cold Plate	1
8	4-STAR-F-0086	Field Flattener Wheel Gusset	1
9	4-STAR-F-0087	DD Cold Plate Gusset	2

<b>4-STAR</b>			
		A. HARDING	11/27/06
		<b>Detector Dewar</b>	
4-STAR-019	S. SMEE	D	<b>4-STAR-009</b>
		1/2	3 OF 4



DETAIL B  
SCALE 1/1

ITEM #	DWG. #	DESCRIPTION	QTY.
1	4-STAR-034	DD Fill Tube Assm	1
2	4-STAR-036	Fill Sensor Connector Assm	1
3	4-STAR-038	DD LN2 Level Sensor Assm	1
4	4-STAR-F-0024	Detector Dewar Shell	1
5	4-STAR-F-0026	Detector Dewar Back Plate	1
6	4-STAR-F-0027	Detector Dewar Cold Plate	1
7	4-STAR-F-0085	Detector Dewar Cold Plate	1
8	4-STAR-F-0086	Field Flattener Wheel Gusset	1
9	4-STAR-F-0087	DD Cold Plate Gusset	2

		<b>4-STAR</b>		<b>Detector Dewar</b>	
		A. HARDING	11/27/06		
4-STAR-019	S. SMEE	<b>D</b>	<b>4-STAR-009</b>	<b>G</b>	
		1/2	4 OF 4		