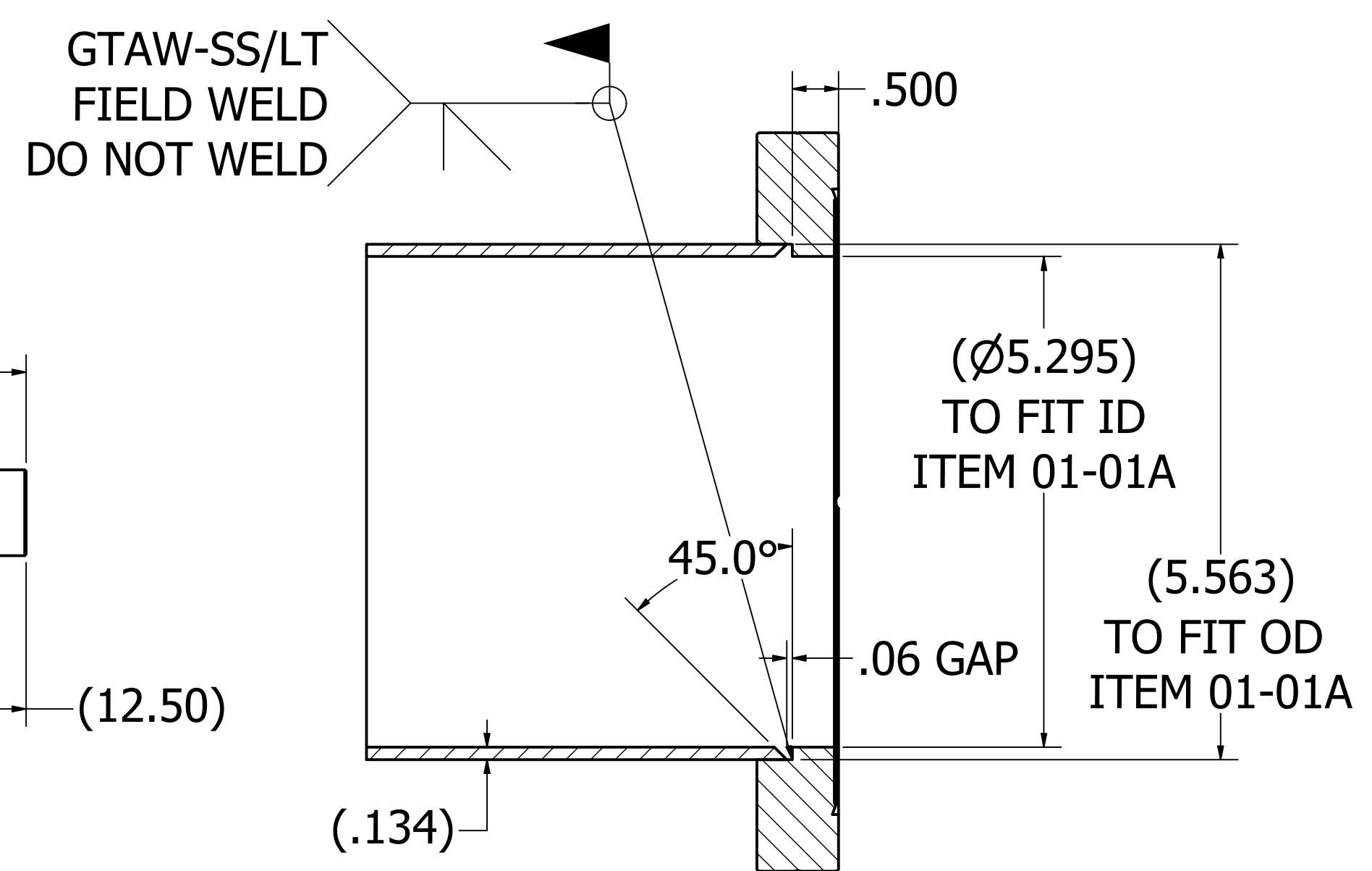
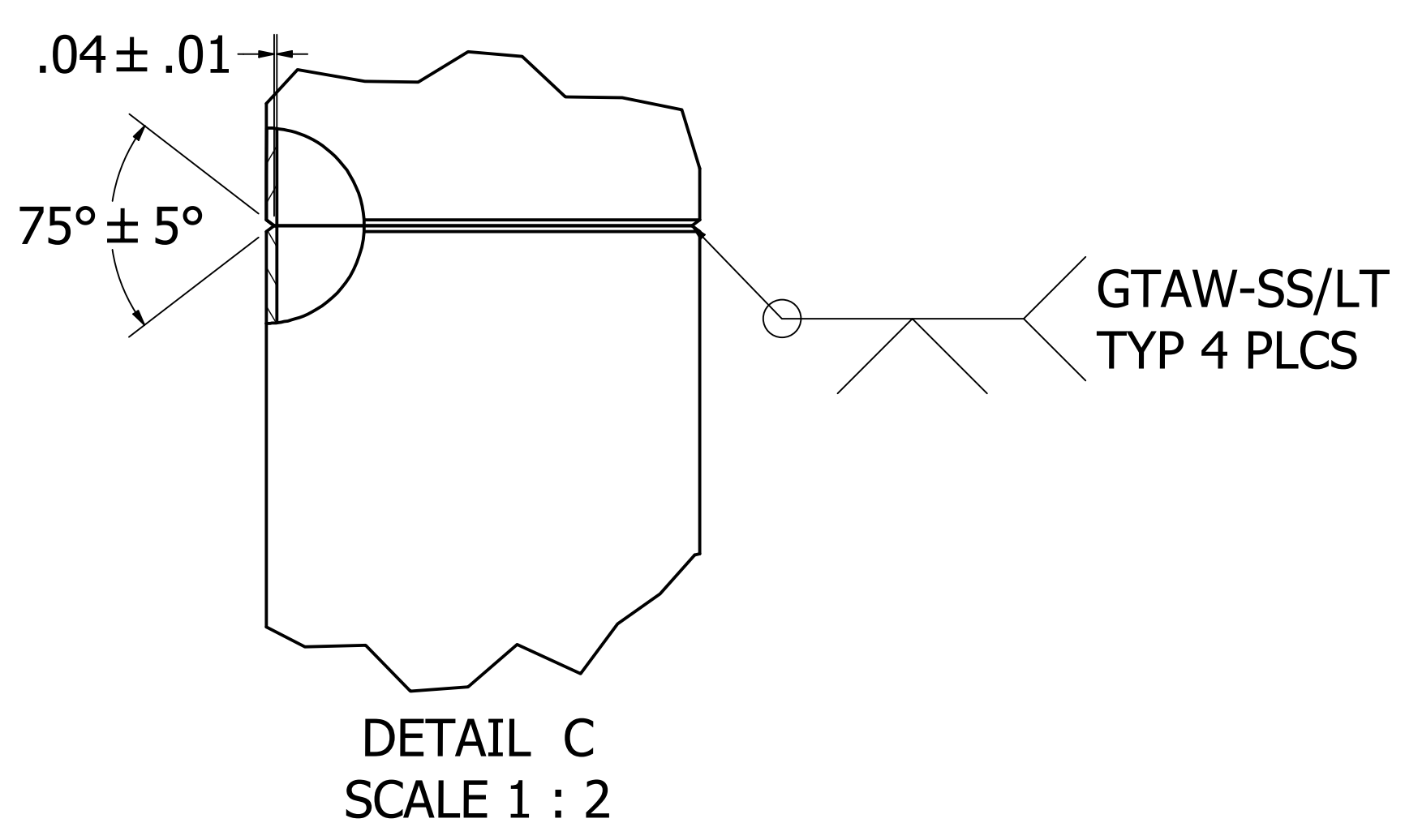


- A. 5" SCH10S Pipe = 0.134" w
- B. Assume .03" weld shrinkage per weld joint
- C. Add .06" length to Items 01-01A, 01-01B, 01-01C
- D. Add 3" for Item 01-01D trim at FNAL

Item	Machined Length
01-01A	58.56" +/- .03"
01-01B	57.06" +/- .03"
01-01C	9.56" +/- .03"
01-01D	12.5" +/- .03"



SECTION A-A  
SCALE 1 : 1.5

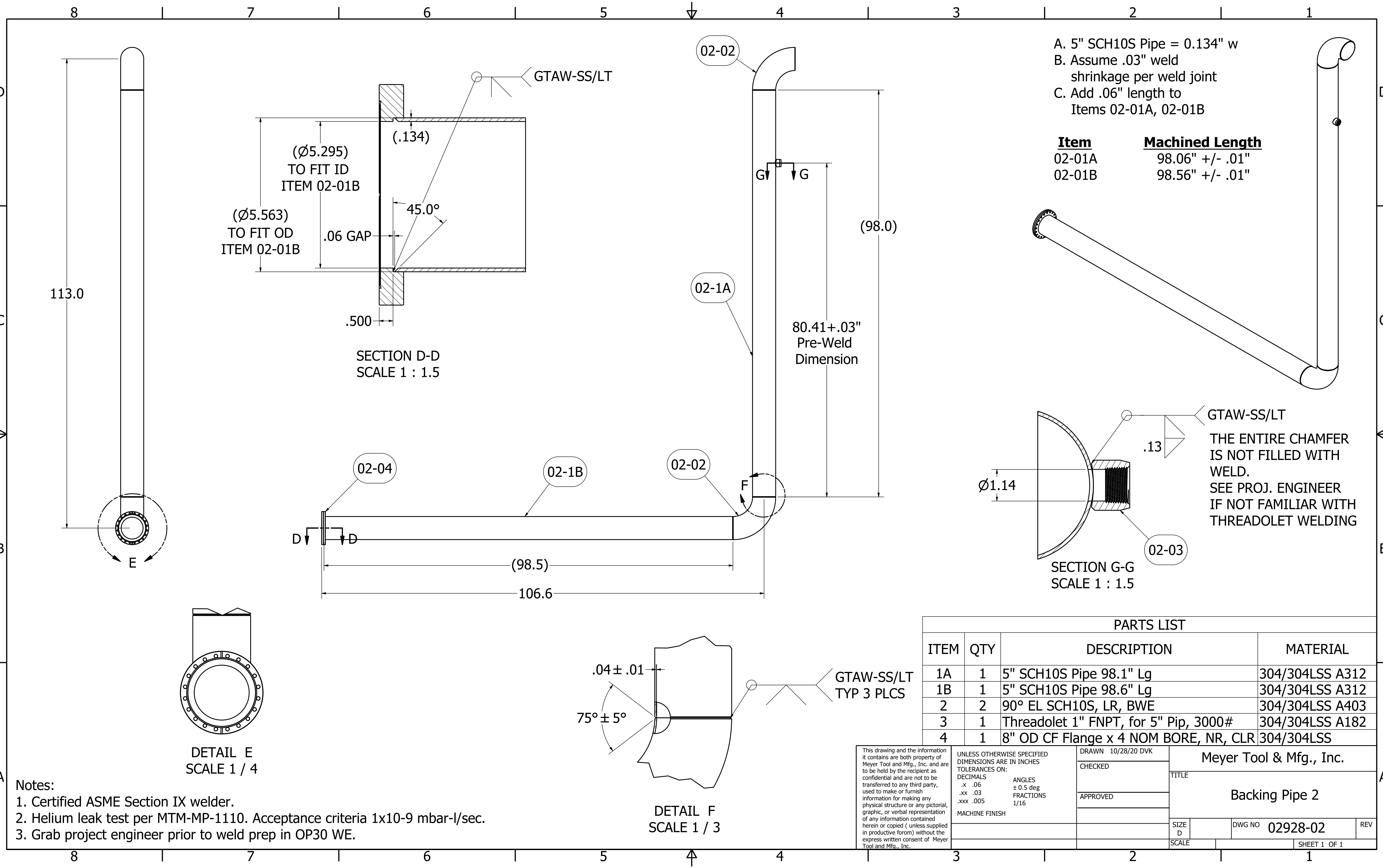


DETAIL C  
SCALE 1 : 2

PARTS LIST			
ITEM	QTY	DESCRIPTION	MATERIAL
1A	1	5" Pipe SCH10S 68.56" +/- .03"	304/304LSS A312
1B	1	5" Pipe SCH10S 57.06" +/- .03"	304/304LSS A312
1C	1	5" Pipe SCH10S 9.56" +/- .03"	304/304LSS A312
1D	1	5" Pipe SCH10S 12.5" +/- .03"	304/304LSS A312
2	2	90° EL 5" SCH10S, LR, BWE	304/304LSS A403
4	1	8" OD CF Flange x 4 NOM BORE, NR , CLR	304/304LSS
5	1	Flex Hose 5" ID, Single Braid 5" SCH10S, 12" Live Length	304/304LSS

- Notes:
1. Certified ASME Section IX welder.
  2. Helium leak test per MTM-MP-1110. Acceptance criteria 1x10-9 mbar-l/sec.
  3. To be trimmed by FNAL at field fit up.
  4. Grab project engineer prior to weld prep in OP30 WE.

<small>This drawing and the information it contains are both property of Meyer Tool and Mfg., Inc. and are to be held by the recipient as confidential and are not to be transferred to any third party, used to make or furnish information for making any physical structure or any pictorial, graphic, or verbal representation of any information contained herein or copied ( unless supplied in productive forum) without the express written consent of Meyer Tool and Mfg., Inc.</small>	<small>UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON:</small> DECIMALS                      ANGLES .x    .06                              ± 0.5 deg .xx   .03                             FRACTIONS .xxx .005                            1/16 MACHINE FINISH		DRAWN 10/28/20 DVK CHECKED APPROVED	Meyer Tool & Mfg., Inc. TITLE <h3>Backing Pipe 1</h3>	
	DWG NO 02928-01 SCALE	REV	SHEET 1 OF 1		



- A. 5" SCH10S Pipe = 0.134" w
- B. Assume .03" weld shrinkage per weld joint
- C. Add .06" length to Items 02-01A, 02-01B

Item	Machined Length
02-01A	98.06" +/- .01"
02-01B	98.56" +/- .01"

PARTS LIST			
ITEM	QTY	DESCRIPTION	MATERIAL
1A	1	5" SCH10S Pipe 98.1" Lg	304/304LSS A312
1B	1	5" SCH10S Pipe 98.6" Lg	304/304LSS A312
2	2	90° EL SCH10S, LR, BWE	304/304LSS A403
3	1	Threadolet 1" FNPT, for 5" Pip, 3000#	304/304LSS A182
4	1	8" OD CF Flange x 4 NOM BORE, NR, CLR	304/304LSS

- Notes:
1. Certified ASME Section IX welder.
  2. Helium leak test per MTM-MP-1110. Acceptance criteria  $1 \times 10^{-9}$  mbar-l/sec.
  3. Grab project engineer prior to weld prep in OP30 WE.

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UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES  
 TOLERANCES ON:  
 DECIMALS .x .06  
 .xx .03  
 .xxx .005  
 ANGLES  $\pm 0.5$  deg  
 FRACTIONS 1/16  
 MACHINE FINISH

DRAWN 10/28/20 DVK  
 CHECKED  
 APPROVED

Meyer Tool & Mfg., Inc.  
 TITLE Backing Pipe 2  
 DWG NO 02928-02  
 SHEET 1 OF 1