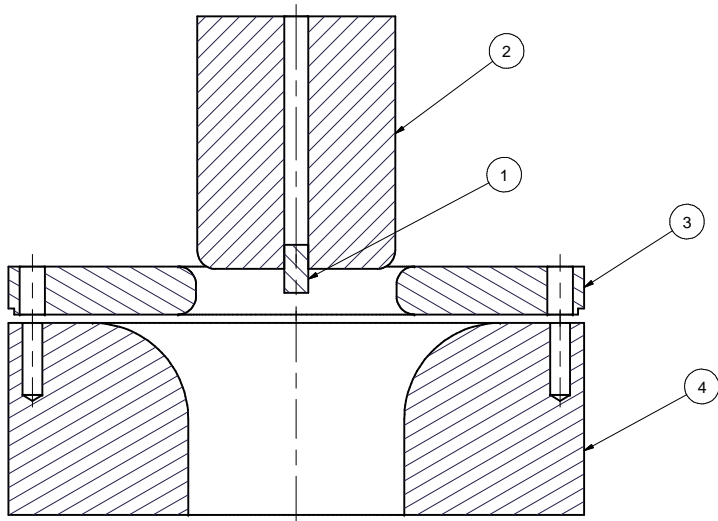


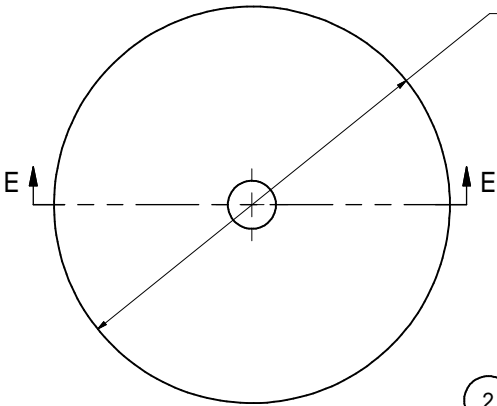
REVISIONS				
SYM.	ZONE	DESCRIPTION	DATE	APP.
A	A1	Title Change to Reflect Specific Part Being Made	7/26/05	TIO
B	E1, B8	Diameter 4.125 was 4.165, Part #2; Diameter 4.505 was 4.550, Part #4.	7/27/05	TIO



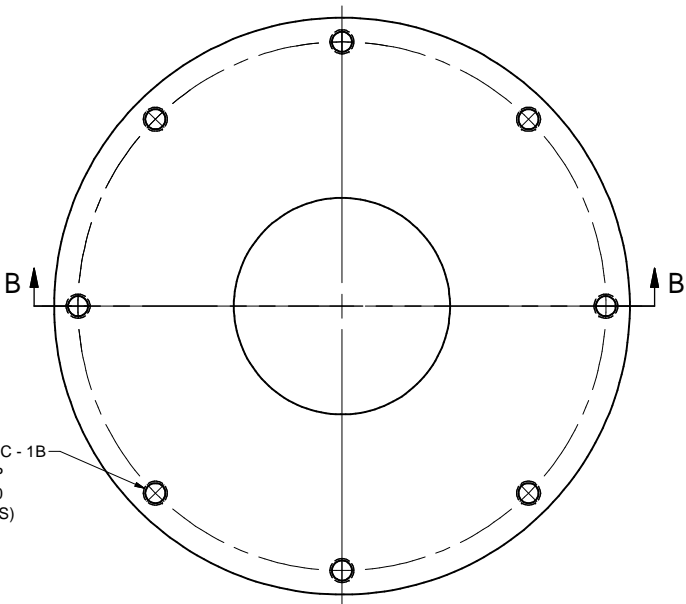
DIE SET FOR 3/16" COPPER

ANNEAL BLANK, 8-1/2" DIA  
FINGER TIGHTEN SCREW  
PRESS THROUGH TONAGE 35 TO 40 SINGLE  
PRESS

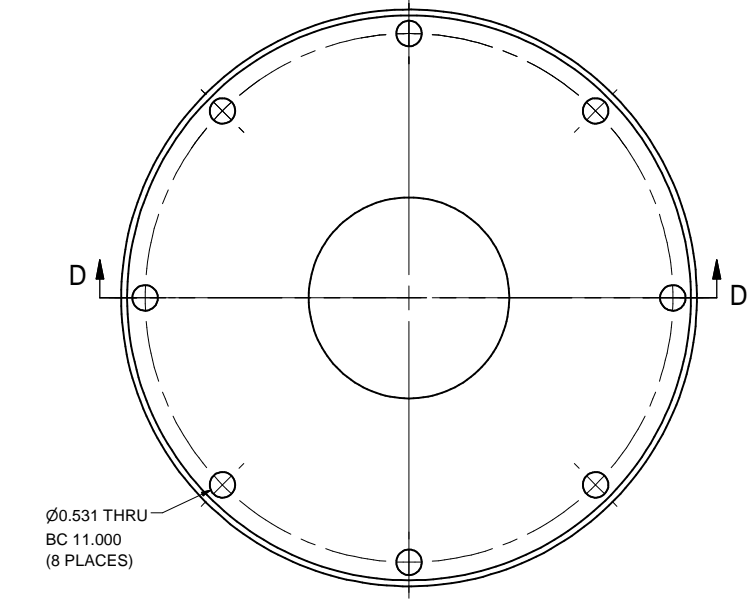
FINISHED TUBE OD 4.500", ID 4.173"  
2.300" LONG



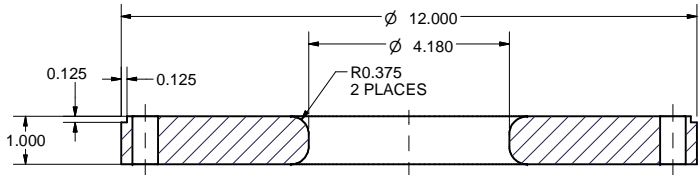
**2 PRESS**  
FILE NAME: 7102-022  
SHEET NO.: 1  
DFT. SCALE: 1:1  
MATERIAL: 7075 ALUM.  
QTY: 1  
NOTES:



1/2-13 UNC - 1B  
1.5" DEEP  
BC 11.000  
(8 PLACES)

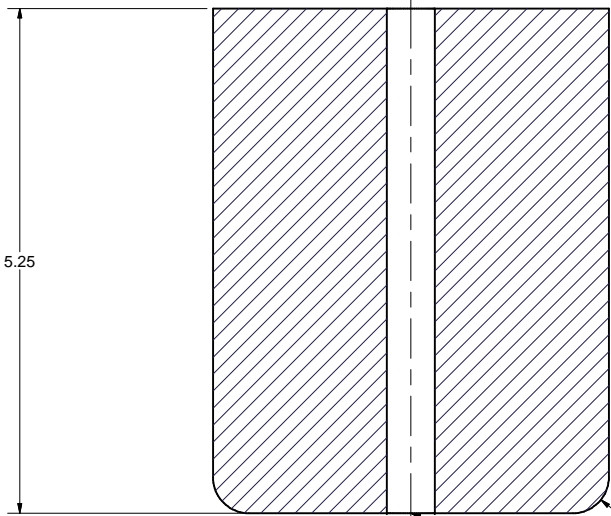


Ø0.531 THRU  
BC 11.000  
(8 PLACES)



SECTION D-D  
SCALE 1 / 2

**3 RING**  
FILE NAME: 7102-022  
SHEET NO.: 1  
DFT. SCALE: .5  
MATERIAL: 6061 ALUM.  
QTY: 1  
NOTES:



SECTION E-E  
SCALE 1 : 1

R0.375  
Ø.500 THRU -  
1/2" DOWEL PIN PRESS FIT  
x 1.00 DEEP, THIS END


**4 DIE**  
FILE NAME: 7102-022  
SHEET NO.: 1  
DFT. SCALE: 1:2  
MATERIAL: 7075 ALUM.  
QTY: 1  
NOTES:

SECTION B-B  
SCALE 1 / 2

FOR MACHINING LUBRICANT USE ONLY  
ALKALINE DETERGENT LUBRICANT CIMSTAR 40  
OR EQUIVALENT APPROVED BY CORNELL LEPP

TECHNICAL RESOURCE APPROVALS REQUIRED BEFORE FABRICATION			
OK	DATE	N/A	
DRAFTING (O'Connell):	TIO	6/28/05	
MACHINE SHOP (Kaminski):			
CHEMISTRY (Conklin):			
ELECTRONICS SHOP (Barley):			
FURNACE BRAZING (Sherwood):			
BEAM WELDING (Sears):			
WELDING OTHER (Gallagher):			
UTILITIES INTEGRATION (Gallagher):			
STOCKROOMS (Lockwood):			

ITEM	DWG. NO.	DESCRIPTION	Q1	Q2	Q3	REMARKS	REV.
4	die		1				
3	ring		1				
2	press		1				
1	dowel pin	1/2" DIA LEPP STOCK	1				

4	die		1					
3	ring		1					
2	press		1					
1	dowel pin	1/2" DIA LEPP STOCK	1					
ITEM	DWG. NO.	DESCRIPTION	G1	G2	G3	REMARKS	REV.	
			QUANTITY					
PLOT DATE: 7/27/2005								
CAD FILE NAME: 7102-022.idw								
UNLESS OTHERWISE SPECIFIED:  DIMENSIONS ARE IN INCHES; TOLERANCES ON: .00 ± .010 .000 ± .005 FRACTIONS ± 1/64 ANGLES ± 0.5° ALL SURFACES ✓		<div><div><div>CORNELL UNIVERSITY</div><div>LEPP</div><div>Laboratory for Elementary-Particle Physics</div></div><div><div>CORNELL UNIVERSITY</div><div>Floyd R. Newman Laboratory</div><div>Ithaca, NY 14853</div></div></div>						
		ERL INJ. CRYO MODULE LARGE PIPE INSERT - DEEP DRAWN DIES						
CHECKED BY: J.K.	DRAWN BY EHB		DRAWN FOR J. KAMINSKI		DATE 6/27/2005	SCALE D	7102-022 SH. NO. 1 OF 1	REV. B
APPROVED BY: J.K.								



CORNELL UNIVERSITY  
Floyd R. Newman Laboratory  
Ithaca, NY 14853

ERL INJ. CRYO MODULE LARGE PIPE INSERT -  
DEEP DRAWN DIES