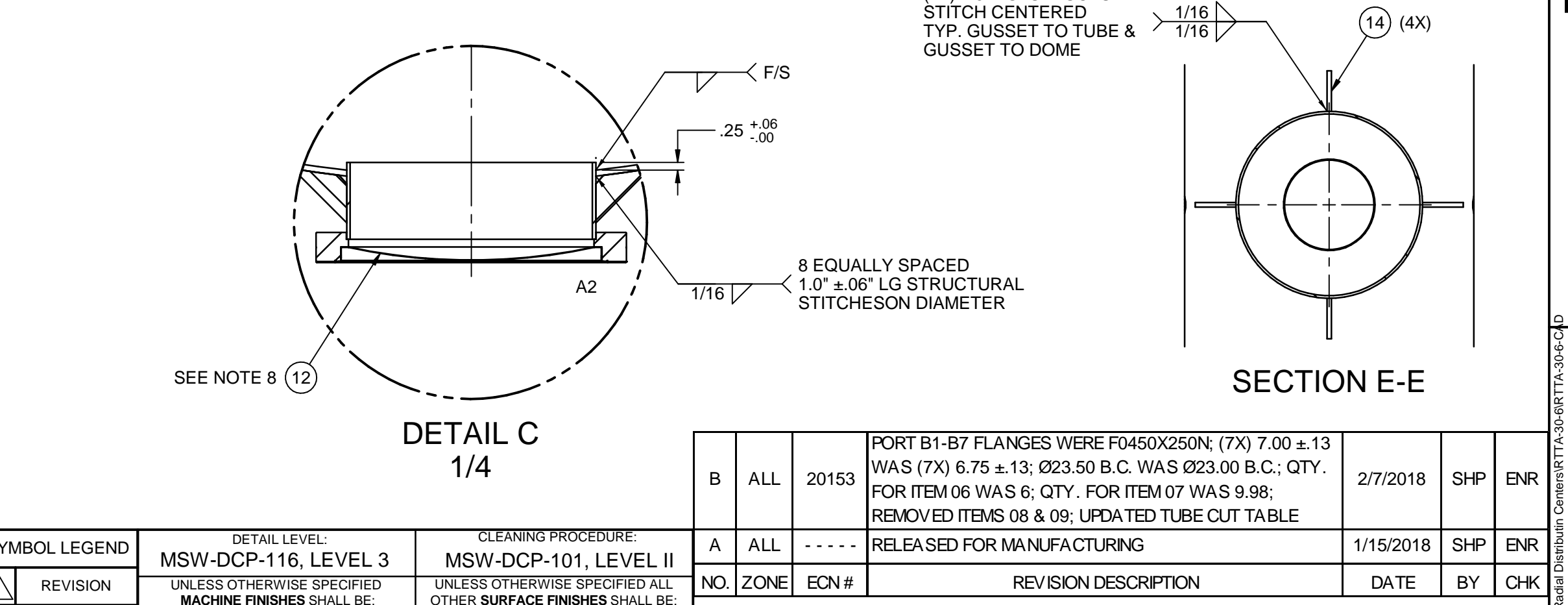
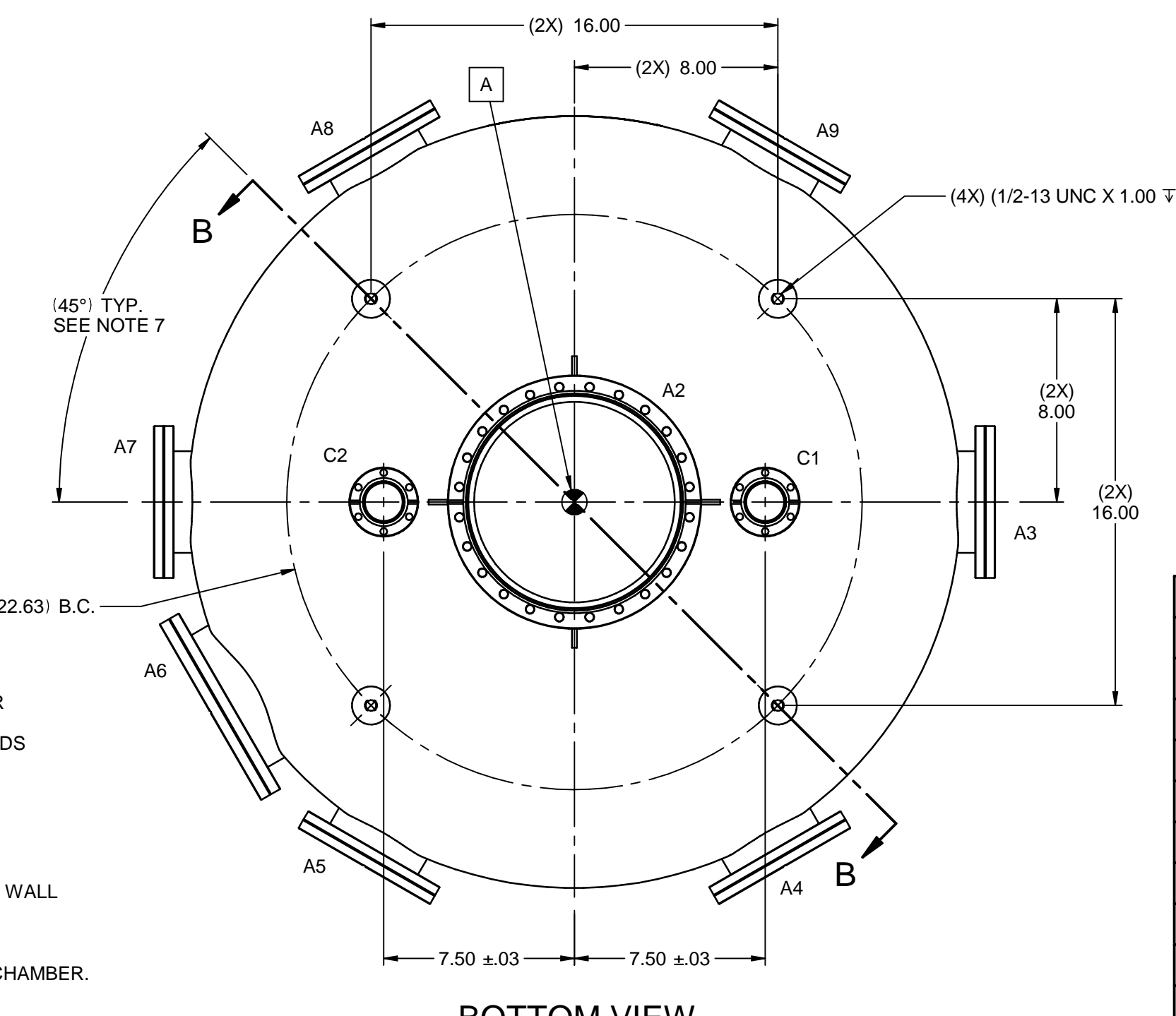
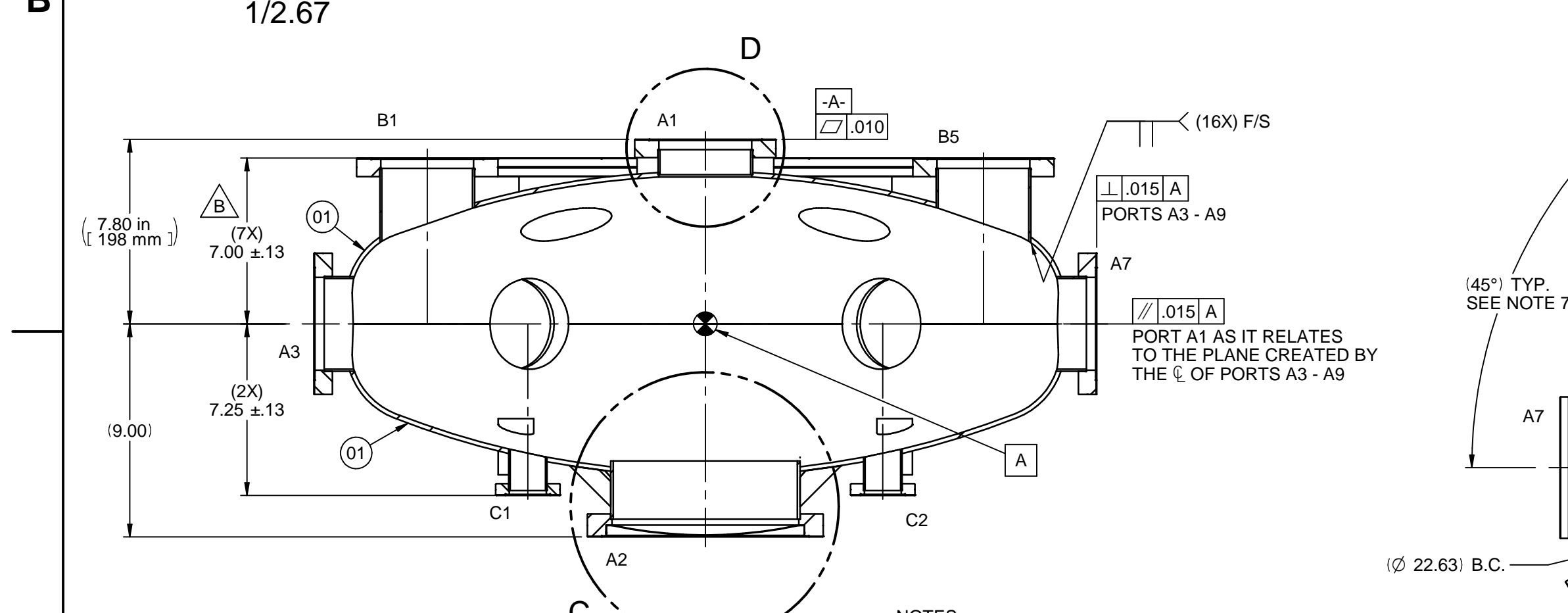
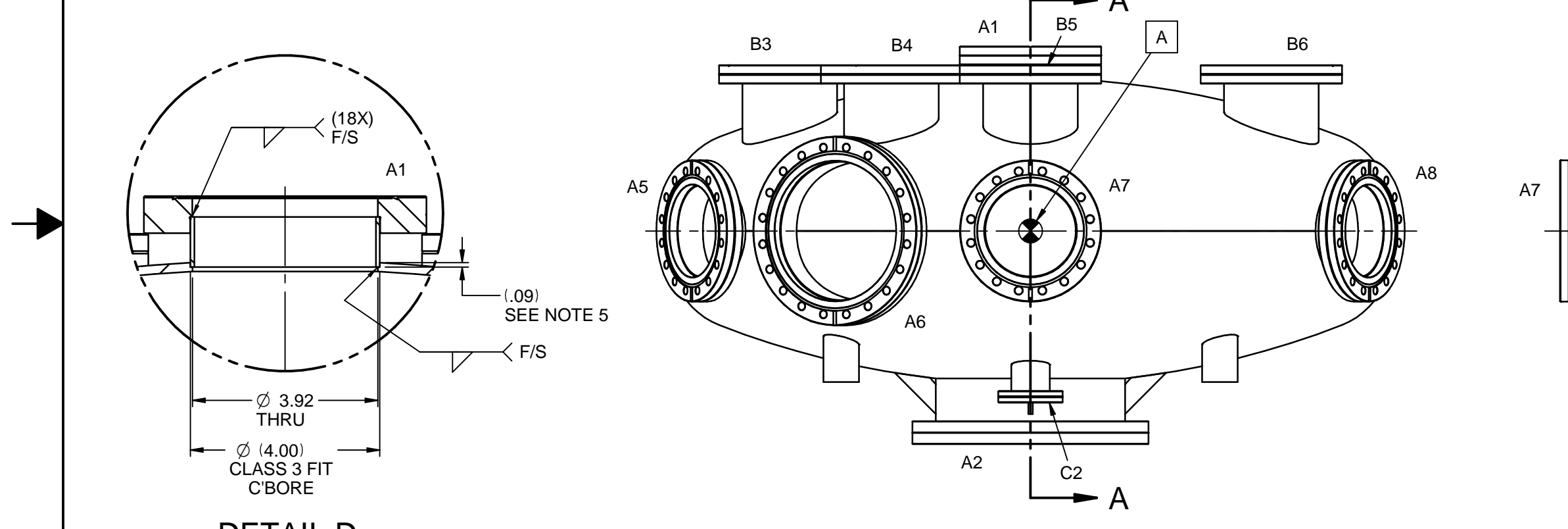
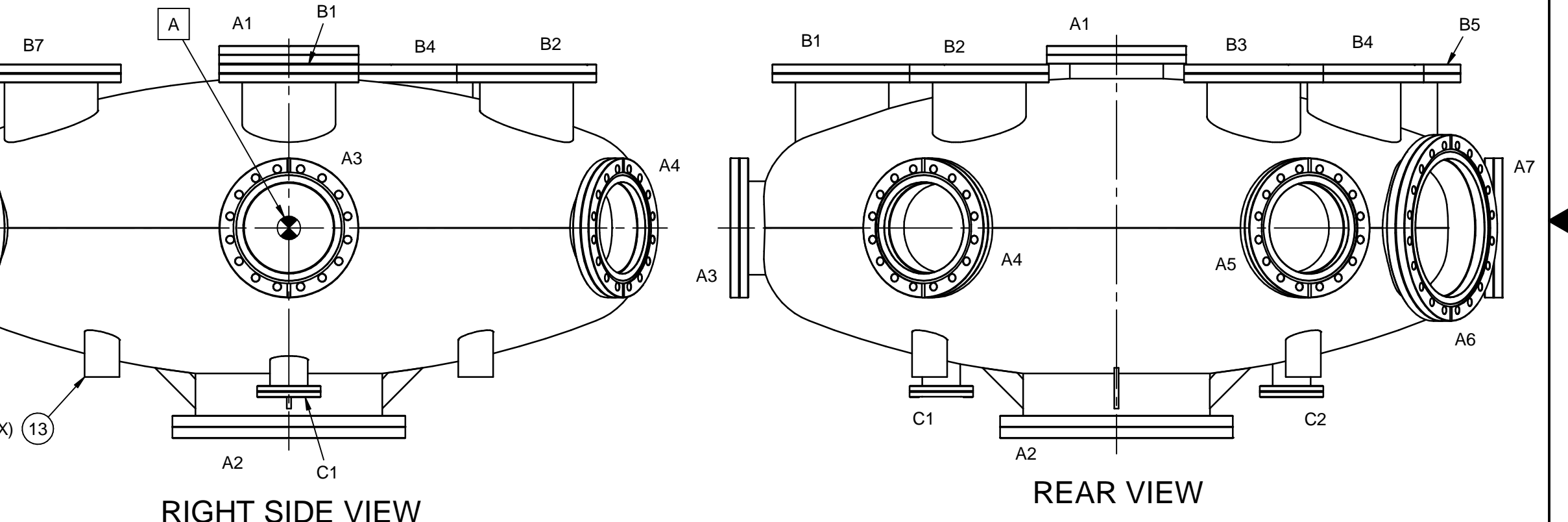
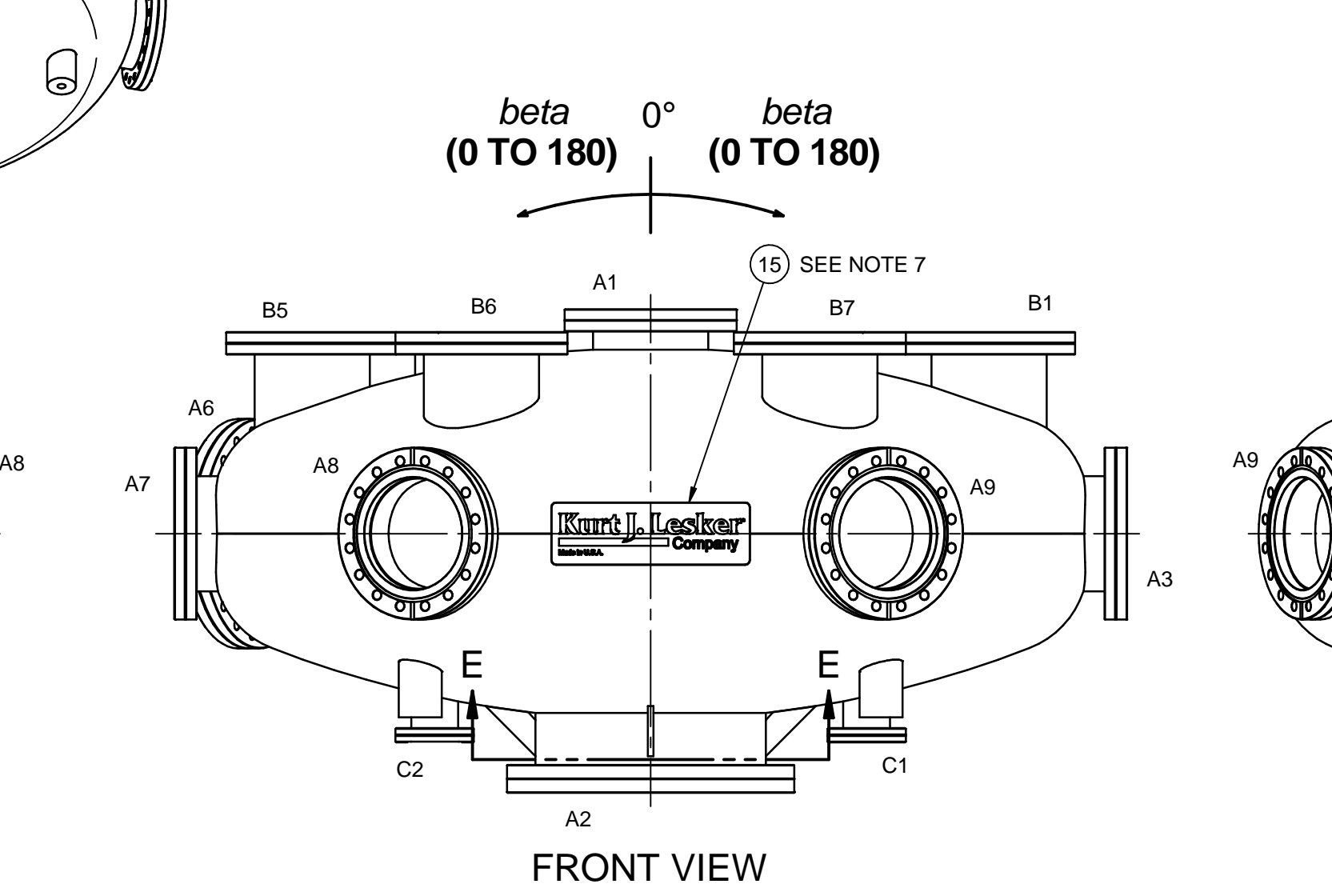
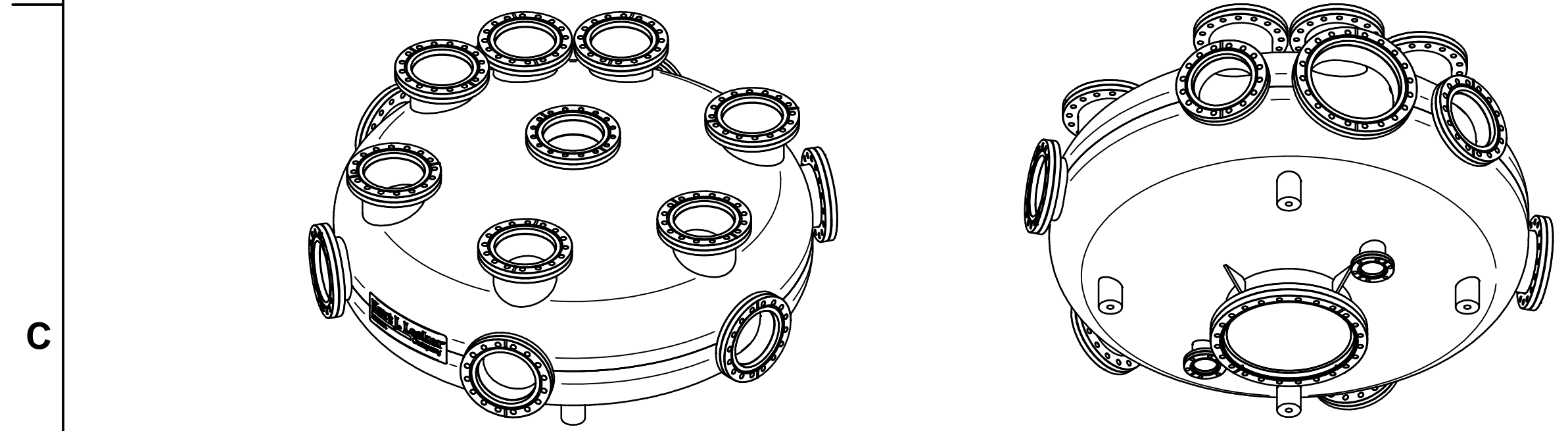
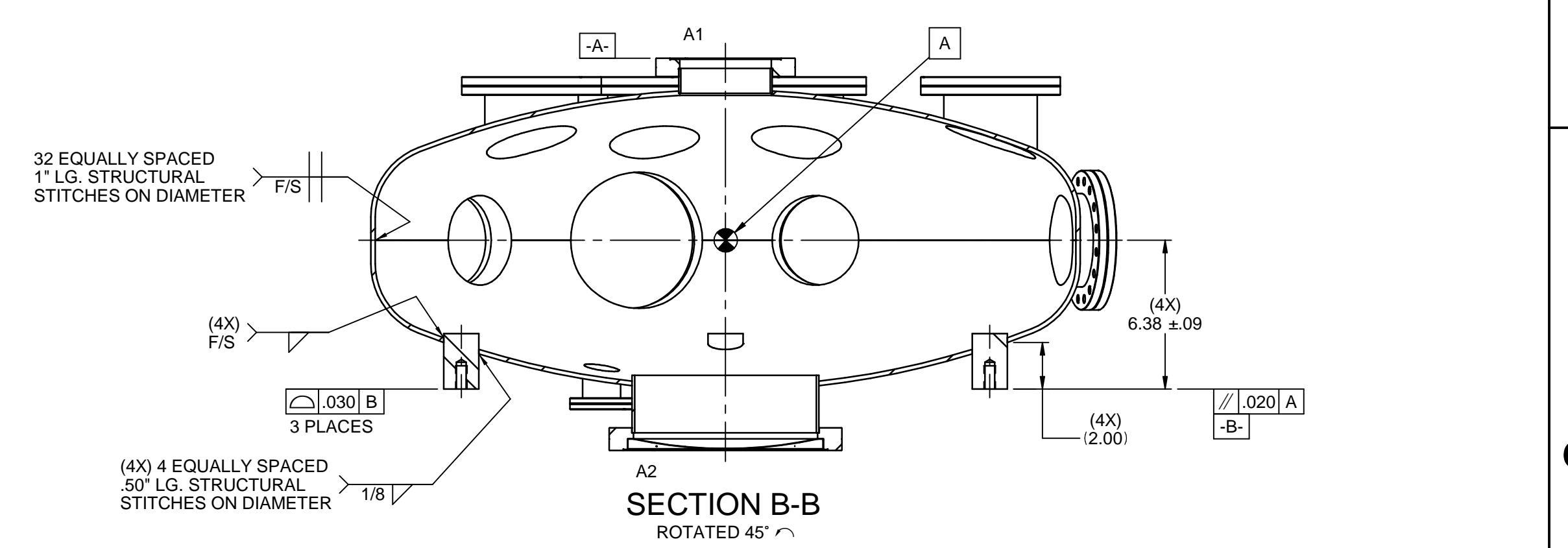
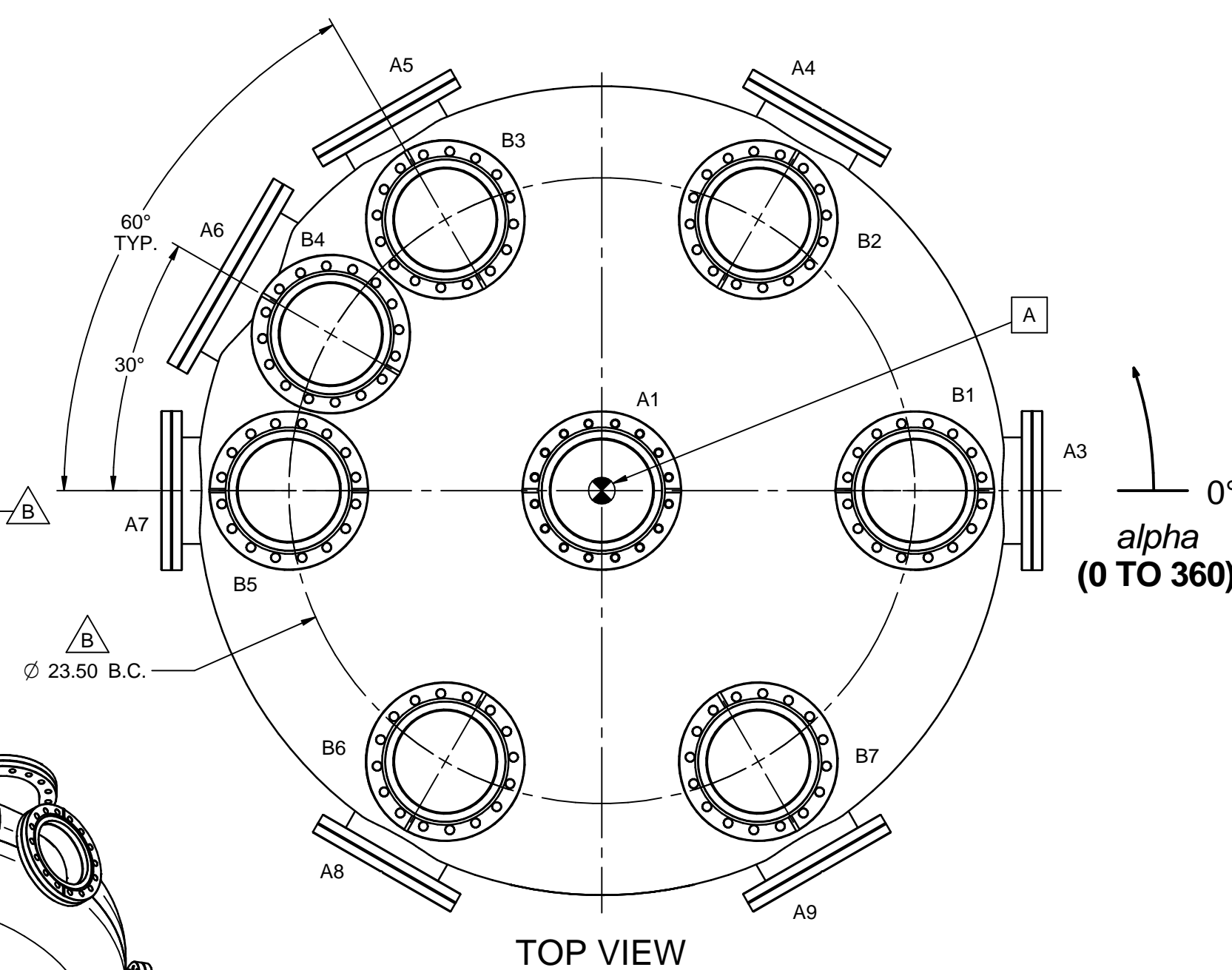


PORT IDENTIFICATION TABLE													
PORT	FLANGE/BOM	TUBE	TUBE CUT LENGTH	PORT LENGTH	PORT LG TOL +/-	FOCAL LENGTH	FOCAL LG TOL +/-	FOCAL PT DATUM	FOCAL PT TOL DIA	ALPHA α	BETA β	CUSTOMER REF	FUNCTION
A1	F0600X400NT	SST-0400I	1.06	-	-	7.80	0.06	A	1/8"	-	0	-	TRANSFER ARM MOUNTING
A2	ITEM 02	SST-0800PI	2.46	-	-	9.00	0.13	A	1/4"	-	180	-	PUMP
A3	F0600X400N	SST-0400I	1.27	-	-	16.54	0.13	A	1/8"	0	90	-	TRANSFER PORT
A4	F0600X400N	SST-0400I	1.27	-	-	16.54	0.13	A	1/8"	60	90	-	TRANSFER PORT
A5	F0600X400N	SST-0400I	1.27	-	-	16.54	0.13	A	1/8"	120	90	-	TRANSFER PORT
A6	F0800X600N	SST-0600PI	1.80	-	-	16.54	0.13	A	1/8"	150	90	-	TRANSFER / ACCESS PORT
A7	F0600X400N	SST-0400I	1.27	-	-	16.54	0.13	A	1/8"	180	90	-	TRANSFER PORT
A8	F0600X400N	SST-0400I	1.27	-	-	16.54	0.13	A	1/8"	240	90	-	TRANSFER PORT
A9	F0600X400N	SST-0400I	1.27	-	-	16.54	0.13	A	1/8"	300	90	-	TRANSFER PORT
B1	F0600X400N	SST-0400I	3.13	-	-	-	-	-	-	0	-	-	VIEWPORT
B2	F0600X400N	SST-0400I	3.13	-	-	-	-	-	-	0	-	-	VIEWPORT
B3	F0600X400N	SST-0400I	3.13	-	-	-	-	-	-	0	-	-	VIEWPORT
B4	F0600X400N	SST-0400I	3.13	-	-	-	-	-	-	0	-	-	VIEWPORT
B5	F0600X400N	SST-0400I	3.13	-	-	-	-	-	-	0	-	-	VIEWPORT
B6	F0600X400N	SST-0400I	3.13	-	-	-	-	-	-	0	-	-	VIEWPORT
B7	F0600X400N	SST-0400I	3.13	-	-	-	-	-	-	0	-	-	VIEWPORT
C1	F0275X162N	SST-0162I	1.75	-	-	-	-	-	-	180	-	-	SPARE / GAUGING
C2	F0275X162N	SST-0162I	1.75	-	-	-	-	-	-	180	-	-	SPARE / GAUGING

BILL OF MATERIALS					
NO.	PART NUMBER	DRAWING NUMBER	DESCRIPTION	QTY.	UM
01	RDS0407499		DOM, SS304L, 30.0" ID X .188" THK, 1" SF, 36" DR, 3" KR, 6"	2	EA
02	D-P0053711	P0053711	MODIFIED 10" CF, RTTA CHAMBER PUMPING PORT	1	EA
03	SST-0800PI		TUBING, 304L, 8" OD (+.005" - .010") X .109" WALL POLISHED ID	2.69	IN
04	F0800X600N	P0000271	FLANGE, UHV, SS, BORED, FXD, 8" OD, 8" C-BORE	1	EA
05	SST-0600PI		TUBING, SS304L, 6" OD X .083" WL, 32 RA POLISHED ID AND OD	2.03	IN
06	F0600X400N	P0000235	FLANGE, UHV, SS, BORED, FXD, 6" OD, 4" C-BORE	13	EA
07	SST-0400I		TUBING, SS304L, 4" OD, .083" WALL, ASTM A270 POLISHED OD	33.18	IN
10	F0275X162N	P0000133	FLANGE, UHV, SS, BORED, FXD, 2.75" OD, 1.62" C-BORE	2	EA
11	SST-0162I		TUBING, SS304L, ASTM A249/269, 1-5/8" OD X .065" WALL	3.75	IN
12	LH-20091639		INLET SCREEN, DN200 ISO-K	1	EA
13	D-P0053712	P0053712	30" RTTA CHAMBER MOUNTING FOOT	4	EA
14	D-P0053713	P0053713	30" RTTA CHAMBER PUMPING PORT GUSSET	4	EA
15	CH-LOGO-US-LG-LX		LOGO, LEXAN, MADE IN USA, 2" X 7", FULL COLOR	1	EA
16	F0600X400NT	P0000237	FLANGE, UHV, SS, BORED, FXD, TAPPED 6" OD, 4" C-BORE	1	EA
17	GA-0600I	P0001080	GASKET, COPPER, 6" FLANGE, 4.743" OD, 4.006" ID, 1/PKG	1	EA
18	HCUU3124-200S4		SCREW, SOCKET SET, SS, 5/16-24 X 2" LG	16	EA
19	NHFU3124S4		HEX NUT, 5/16-24, 1/8" SS	16	EA
20	WPNU031S4		WASHER, FLAT, SS, 5/16" SAE	16	EA



NOTES:

- ALL DIMENSIONS ARE IN INCHES, REFER TO TABLE 1 FOR STANDARD TOLERANCING INFORMATION.
- ALL WELDS TO BE INTERNAL FULL FUSION VACUUM WELDS UNLESS OTHERWISE NOTED.
- VACUUM WELDS TO BE LEAK CHECKED WITH A HELIUM MASS SPECTROMETER WITH A SENSITIVITY TO 2 X 10⁻¹⁰ STD CC/SEC FOR HELIUM.
- DIMENSIONS FOR ALL PARTS LISTED IN THE BILL OF MATERIALS ARE NOMINAL.
- DEPTH OF COUNTERBORE IS TO BE EQUAL TO HALF THE WALL THICKNESS OF ITEM 01 IN THAT AREA.
- ORIENT ALL FLANGES AS SHOWN.
- ATTACH LOGO IN APPROXIMATE LOCATION.
- ITEMS 17 - 20 (NOT SHOWN) USED TO ATTACH RTTA TO CHAMBER. BAG, TAG, AND SHIP ITEMS 12 & 17 - 20 SEPARATE.

TUBE CUT TABLE			
TUBE P/N	LENGTH	QTY	CUT ALLOWANCE REQUIRED
SST-0162I	1.75	2	
SST-0400I	1.06	1	
	1.27	6	
	3.13	7	
SST-0600PI	1.80	1	
SST-0800PI	2.46	1	

SYMBOL	LEGEND	DETAIL LEVEL:	CLEANING PROCEDURE:
△	REVISION	MSW-DCP-116, LEVEL 3	MSW-DCP-101, LEVEL II
○	ITEM BALLOON	UNLESS OTHERWISE SPECIFIED MACHINE FINISHES SHALL BE:	UNLESS OTHERWISE SPECIFIED ALL OTHER SURFACE FINISHES SHALL BE:
●	FOCAL POINT	63 Ra	AS SUPPLIED
⊕	FOCAL POINT DESIGNATOR	UNLESS OTHERWISE SPECIFIED REFER TO DOCUMENT STM-1201, KJLC STANDARD TOLERANCES AND MANUFACTURING PRACTICES	FABRICATION / WELDMENT TOLERANCES (UNLESS OTHERWISE NOTED)
□	INSPECTION BALLOON	DIMENSIONS ARE IN INCHES	
◇	WATER TRACE IDENTIFICATION	DIMENSIONS ARE IN MILLIMETERS	
⊕	CENTER OF GRAVITY IDENTIFICATION	ANGULAR	

NO.	ZONE	ECN #	REVISION DESCRIPTION	DATE	BY	CHK
B	ALL	20153	PORT B1-B7 FLANGES WERE F0450X250N; (7X) 7.00 ± .13 WAS (7X) 6.75 ± .13; Ø23.50 B.C. WAS Ø23.00 B.C.; QTY. FOR ITEM 06 WAS 6; QTY. FOR ITEM 07 WAS 9.98; REMOVED ITEMS 08 & 09; UPDATED TUBE CUT TABLE	2/7/2018	SHP	ENR
A	ALL	-	RELEASED FOR MANUFACTURING	1/15/2018	SHP	ENR

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SCALE: 3/16 APPROVED BY: ENR CHECKED BY: ENR DRAWN BY: SHP
FOR REFERENCE ONLY DATE: 1/15/2018 DATE: 1/15/2018 DATE: 11/7/2016

TITLE: DISTRIBUTION CHAMBER FOR RTTA. 30"OD, (6) 6"UHV DIST. PORTS

SIZE: MATERIAL SPECIFICATION: DRAWING NO.: A0053709 REV: B
D AS NOTED

KJLC PART NUMBER: RTTA-30-6 APPROX. WEIGHT: 165.1 lbs SHEET: 1 OF 1

CAD FILE LOCATION: ENG_FILES_RUSTANDARDS/CHAMBERS/RTTA-30-6-RTTA-30-6-CAD