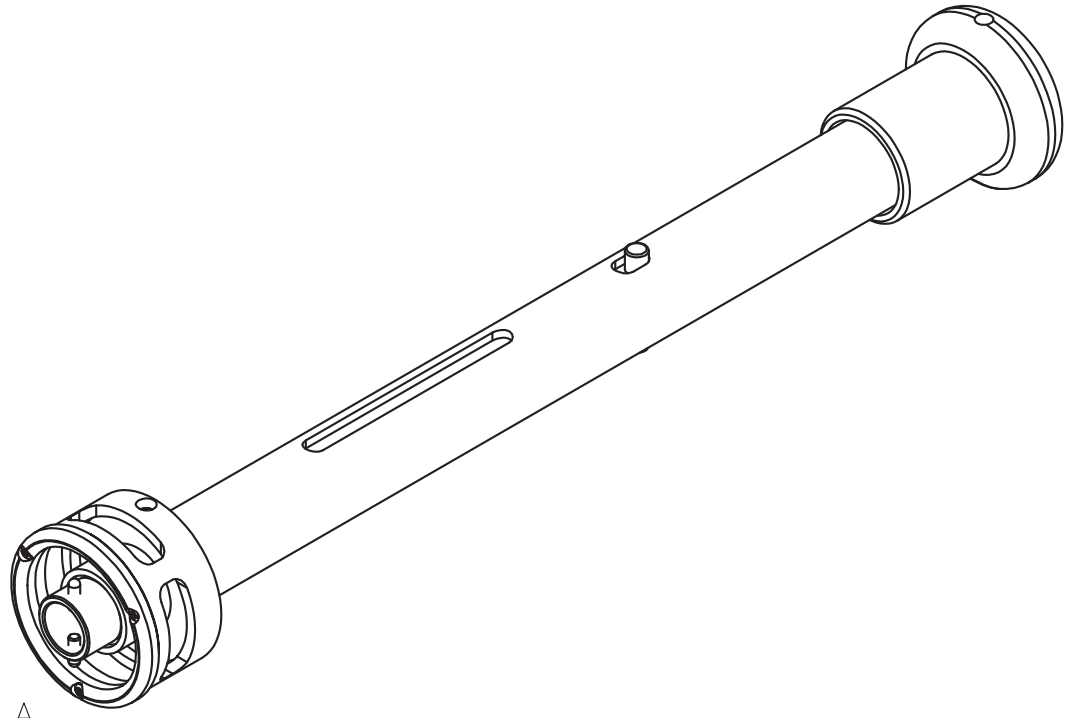
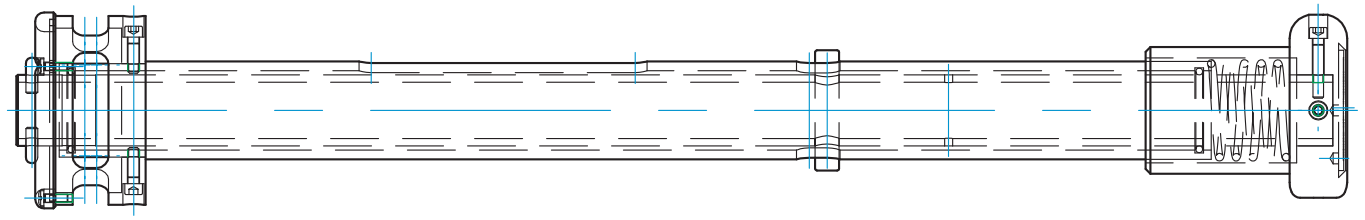
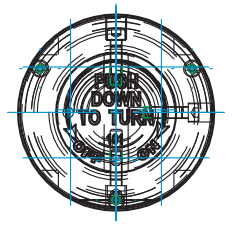
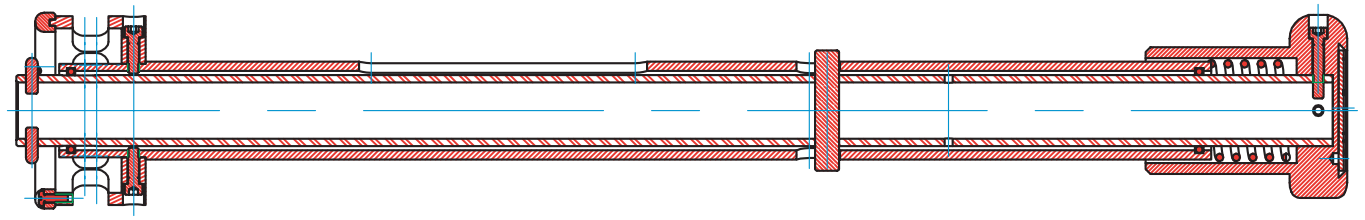








SECTION A–A

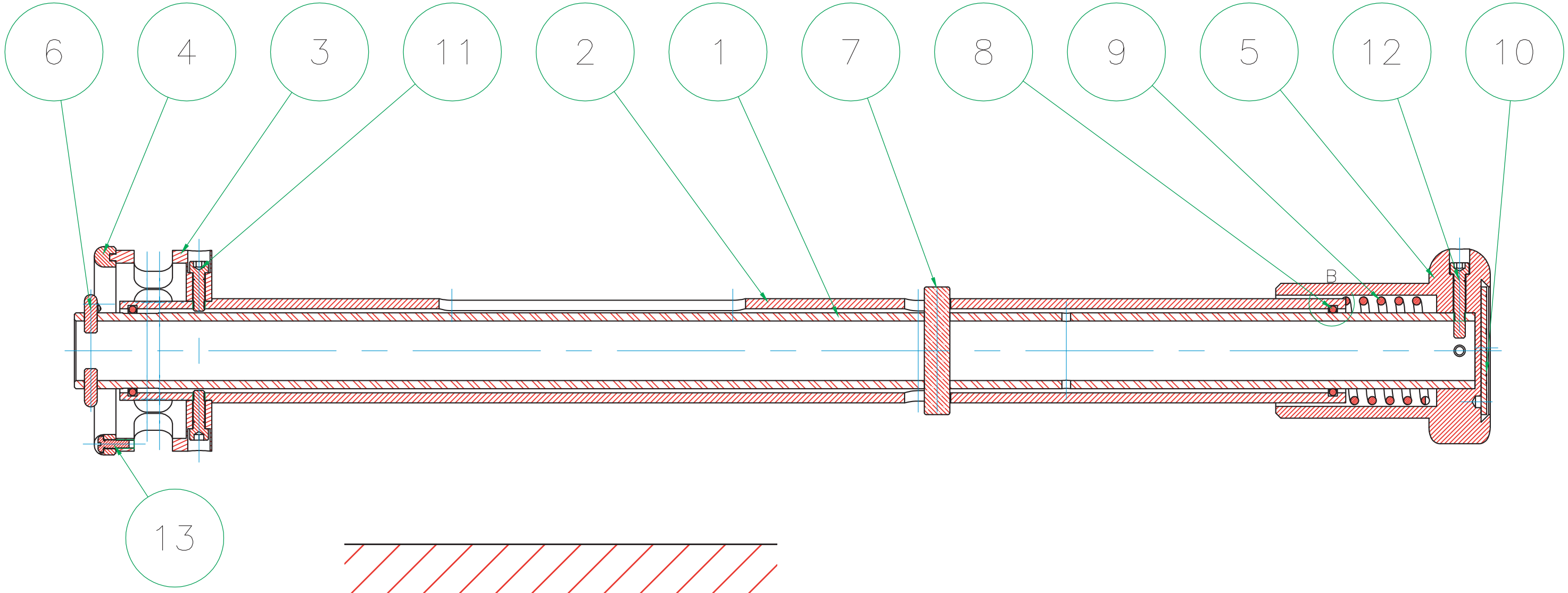
FILE NAME	Transfer-Handel-RevB.dwg
CONTRACT NO	–
DRAWN	07.30.2003 Mitch Miller
CHECK	
APPR.	
ISSUED	

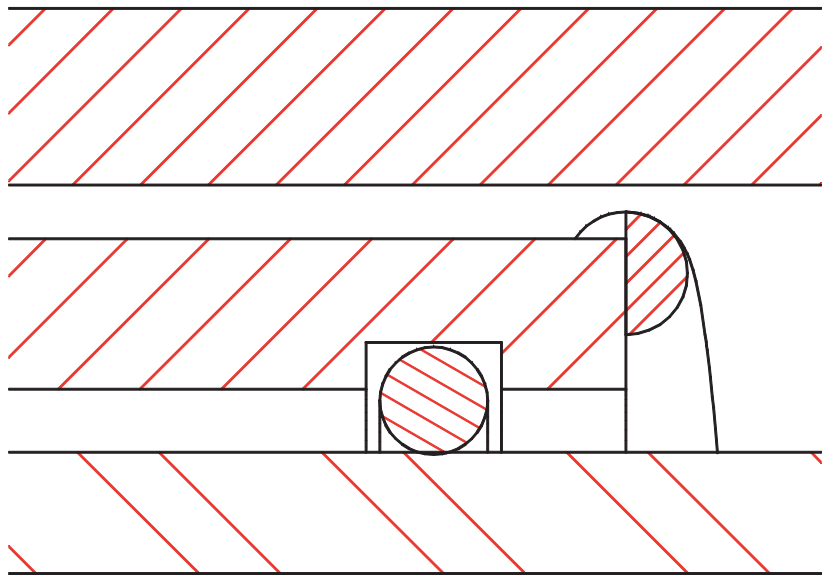
JCSG / SMB / SSRL / SLAC

CASSETTE TRANSFER HANDLE

ASSEMBLY OVERVIEW

SIZE	FSCM NO	DWG NO	REV
AM_B	–	–	B
SCALE 1:2	WEIGHT	SHEET 1 OF 14	





DETAIL B
SCALE 8:1

FILE NAME Transfer-Handel-RevB.dwg	JCSG / SMB / SSRL / SLAC		
CONTRACT NO –	CASSETTE TRANSFER HANDLE		
DRAWN 07.30.2003 Mitch Miller	CROSS SECTION OF ASSELBLY		
CHECK			
APPR.			
ISSUED	SIZE B / FSCM NO – / DWG NO — / REV B		
	SCALE 1:1	WEIGHT	SHEET 2 OF 14

Parts List						
Item	Qty	Description 2	Description	Material	Vendor	Note
1	1	INNER SS TUBE	3/4 OD STAINLESS STEEL TUBE – 0.083 WALL	STAINLESS STEEL		
2	1	OUTER AL PIPE	AL 6061 SCH 40 PIPE	Al 6061 PIPE		ANODIZE BLUE
3	1	BOTTOM CUP		ALUMINUM 6061		ANODIZE BLUE
4	1	TEFLON RING	MACHINED MECHANICAL GRADE PTFE	TEFLON		
5	1	TEFLON HANDLE	MACHINED MECHANICAL GRADE PTFE	TEFLON		
6	2	MODIFED DOWEL	MODIFIED 1/8 x 3/8 DOWEL PIN	STAINLESS STEEL	MSC 67600122 or EQUIV.	PRESSED & WELDED TO SS TUBE
7	1	DOWEL PIN	PIN – GROUND DOWEL, 1/4 x 1 1/4	STAINLESS STEEL	MSC 67601047 or EQUIV.	BRIGHT FINISH, CHAMFER OK
8	2	O–RING	AS 568 – 018	TEFLON	MSC 31955313 or EQUIV.	TIGHTER TOLERANCES THAN AS568A
9	1	SPRING	COMPRESSION .975 x .072 x 1.5	STAINLESS STEEL	MSC 03309218 or EQUIV.	
10	1	ENGRAVED LABEL	0.056" THK. ROWMARK RED/WHITE	ACRYLIC		LASERMARK ENGRAVING STOCK
11	2	SCREW #4–40 x 3/8	HEXAGON SOCKET HEAD CAP SCREW	STAINLESS STEEL	MSC 05664040 or EQUIV.	
12	2	SCREW #4–40 x 5/8	HEXAGON SOCKET HEAD CAP SCREW	STAINLESS STEEL	MSC 05664065 or EQUIV.	
13	3	SCREW #2–56 x 1/4	SLOTTED PAN HEAD MACHINE SCREW	STAINLESS STEEL	MSC 67568725 or EQUIV.	

FILE NAME Transfer-Handel-RevB.dwg

CONTRACT NO –

DRAWN 07.30.2003 Mitch Miller

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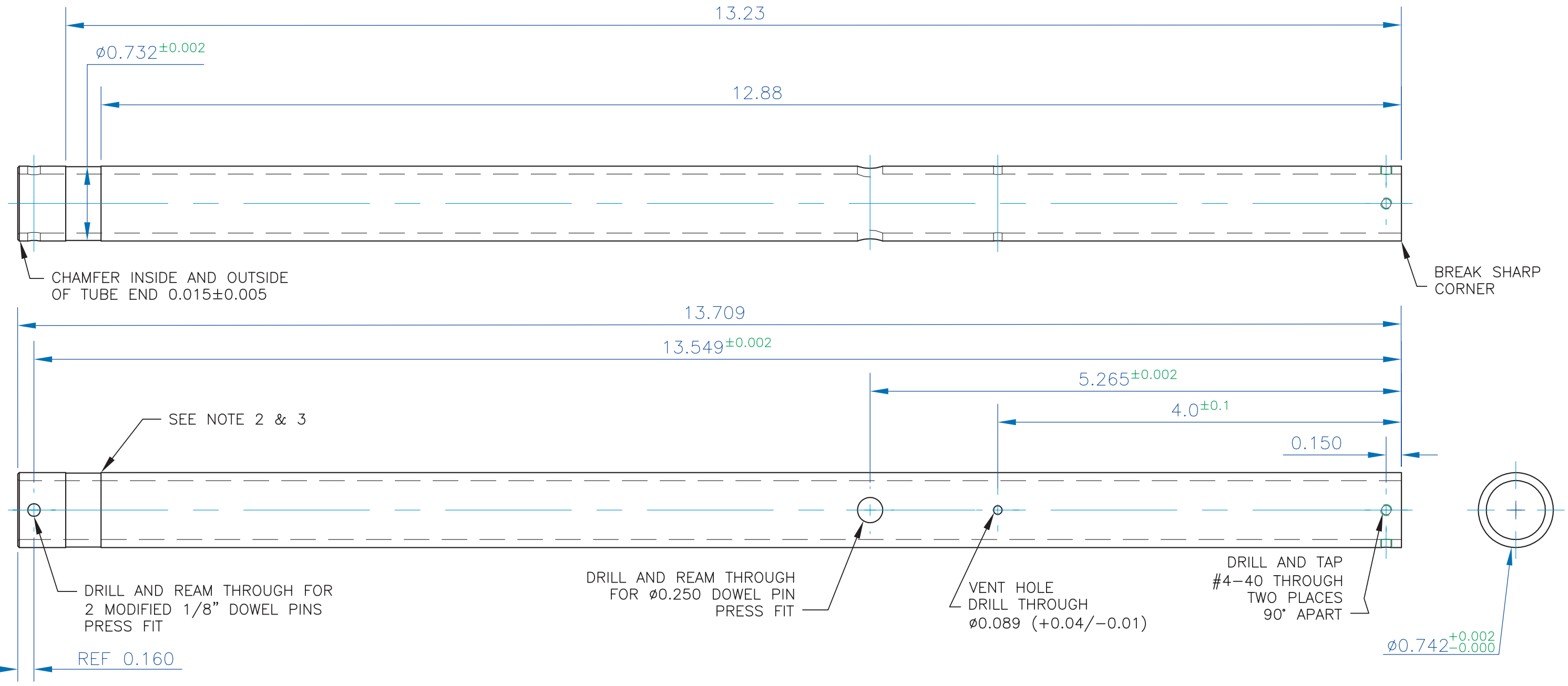
CASSETTE TRANSFER HANDLE

PARTS LIST

SIZE	FSCM NO	DWG NO	REV
B	–	—	B

SCALE 1:1 | WEIGHT | SHEET 3 OF 14

#	DESCRIPTION	DATE	APPROVED
B	ADJUSTED LENGTH AND D/P PLACEMENT TO ADJUST SPRING TENSTION & ADDED NOTES.	05/29/2003	mmiller



Notes:
1. RAW MATERIAL – 3/4" OD x 0.083 WALL STAINLESS STEEL TUBE (304 or 316, WELDED or SEAMLESS)
2. BLEND TRANSITIONS BETWEEN ø0.732 AND ø0.743 45°±10°
3. THE OD OF THE TUBE IS TO BE ø0.743±0.001 AT BOTH ENDS. THE 0.65" LONG ø0.732 OD SECTION IS TO ALLOW O−RING TO SLIDE UNDER LINQUID NITROGEN (−196° C).
4. ALL HOLES ARE ALIGNED ON THE SAME AXIS (AS SHOWN) ±2°
5. SURFACE FINISH, GENERAL 63 MICROINCHES RMS OR BETTER. FROM EACH END IN 1.5", 32 MICROINCHES RMS (EXCLUDING THE BLEND BETWEEN DIAMETERS).
6. PART TO BE FREE OF BURRS
7. ASSEMBLY: SEE SHEETS 11 AND 14

THIRD ANGLE
- DO NOT SCALE -
IF IN DOUBT, ASK.
UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE IN INCHES
.XXX ±0.005
.XX ±0.010

FILE NAME Transfer-Handel-RevB.dwg
CONTRACT NO –
DRAWN 07.30.2003 Mitch Miller
CHECK
APPR.
ISSUED

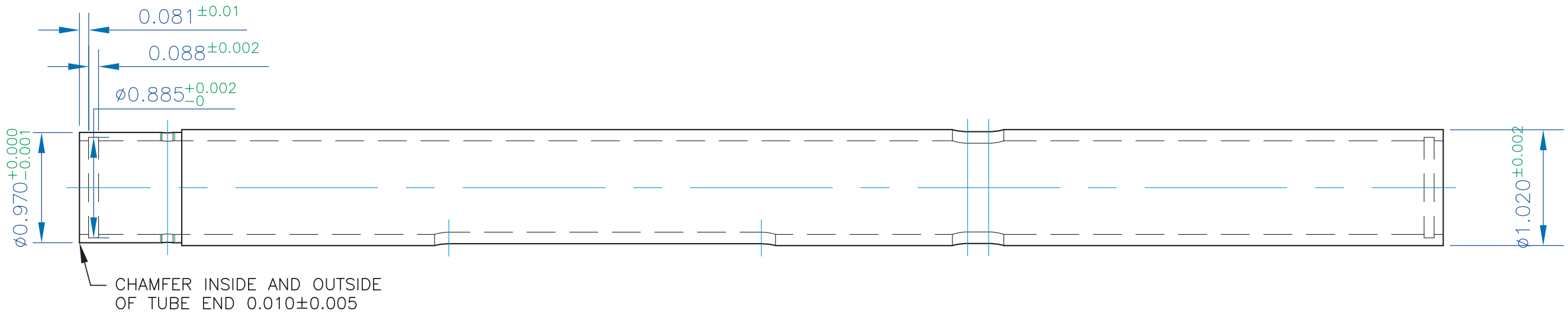
JCSG / SMB / SSRL / SLAC

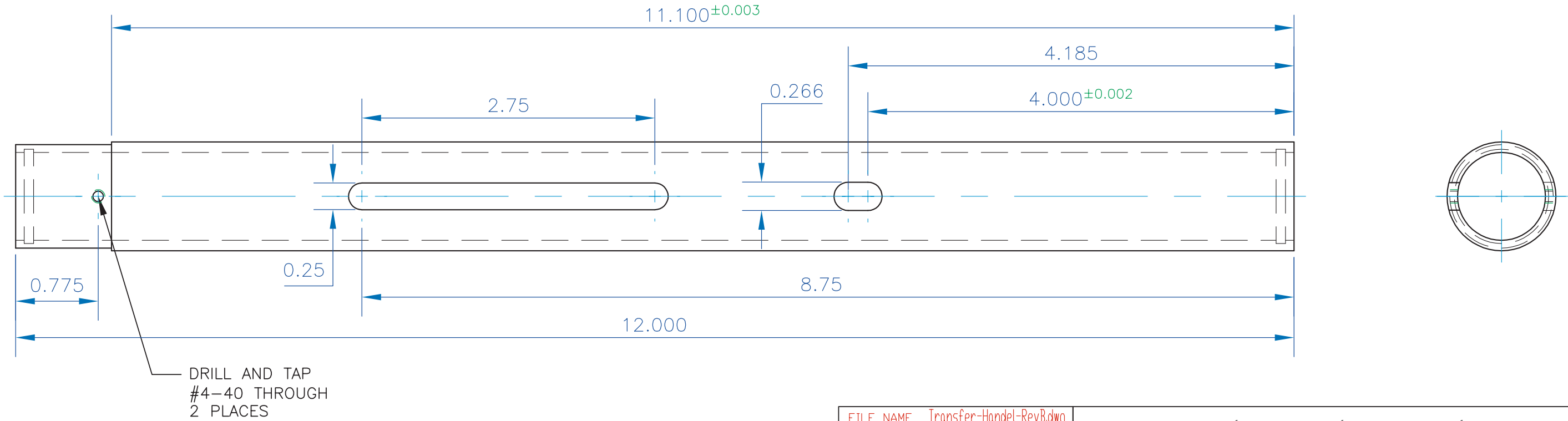
CASSETTE TRANSER HANDLE

INNER SS TUBE

SIZE	FSCM NO	DWG NO	REV
B	–	—	B
SCALE 1:1	WEIGHT	SHEET 4 OF 14	

#	DESCRIPTION	DATE	APPROVED
B	CORRECTED O-RING DEPTH ERROR	05/29/2003	mmiller





Notes:
1. RAW MATERIAL – 3/4" SCHEDULE 40 ALUMINUM 6061 PIPE (O.D. 1.05±0.01, NOMINAL WALL 0.113)
2. EXTERIOR IS A BRUSHED COSMETIC FINISH, 63 MICROINCHES RMS OR BETTER
3. O-RING GROVE IS THE SAME AT BOTH ENDS. O-RING SIDE WALLS MAY BE ANGLED 0° – 8°.
4. THIS PART AND THE BOTTOM CUP ARE TO BE ANODIZED BLUE.
5. ASSEMBLY: SEE SHEETS 13 AND 14.

THIRD ANGLE

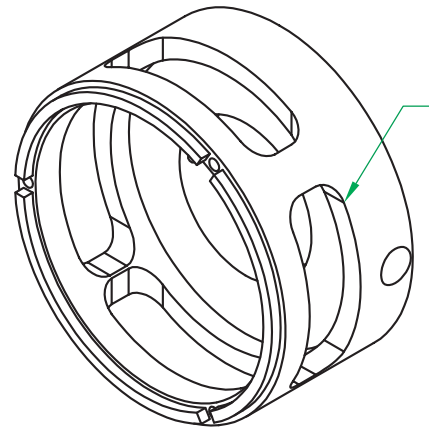
– DO NOT SCALE –
IF IN DOUBT, ASK.
UNLESS OTHERWISE SPECIFIED,
ALL DIMENSIONS ARE IN INCHES
.XXX ±0.005
.XX ±0.010

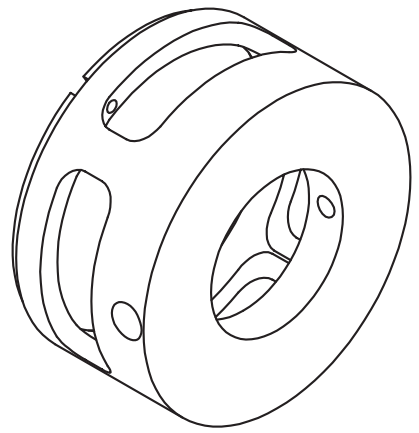
FILE NAME Transfer-Handel-RevB.dwg
CONTRACT NO –
DRAWN 07.30.2003 Mitch Miller
CHECK
APPR.
ISSUED

JCSG / SMB / SSRL / SLAC

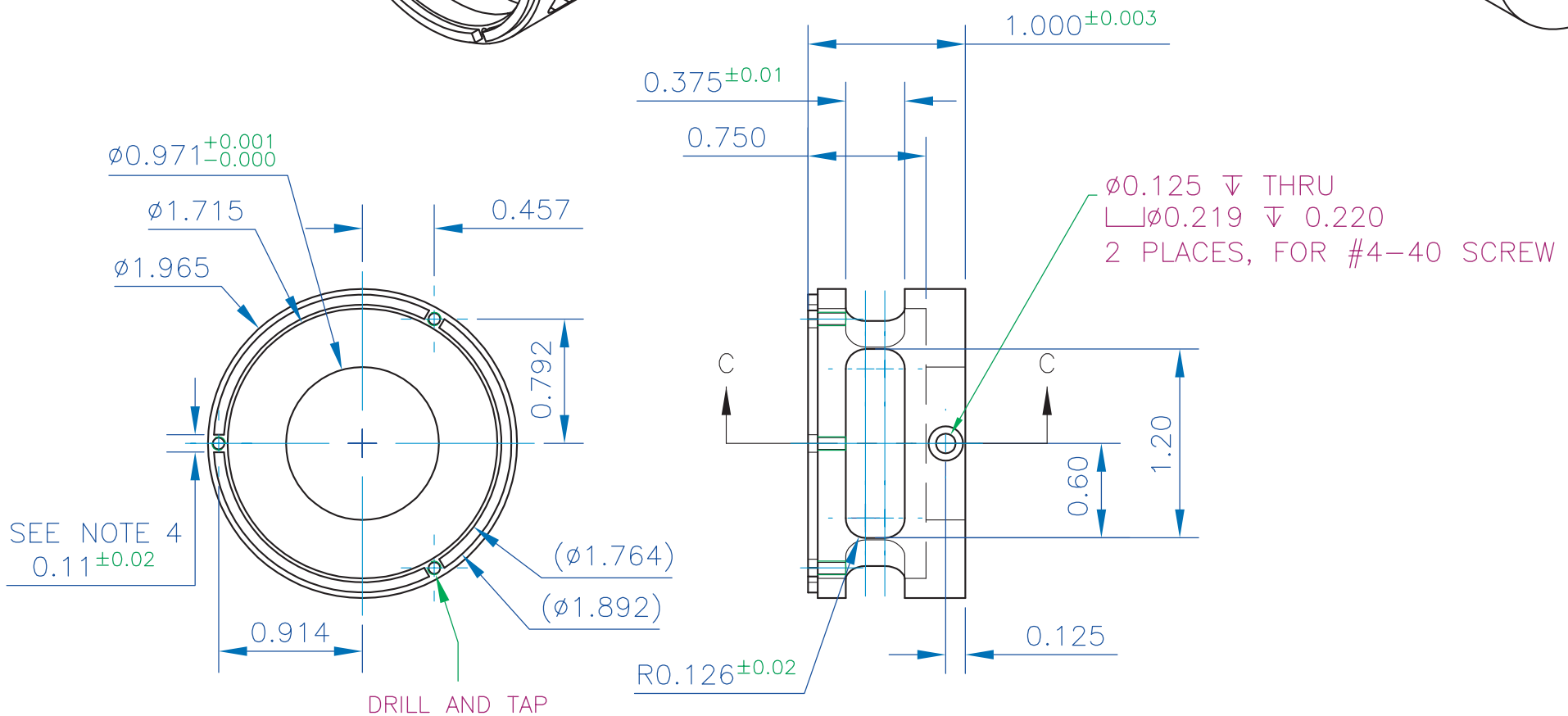
CASSETTE TRANSFER HANDLE
OUTER AL PIPE

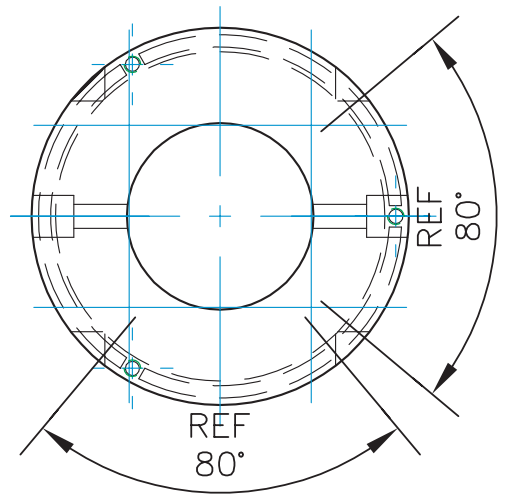
SIZE	FSCM NO	DWG NO	REV
B	–	—	B
SCALE 1:1	WEIGHT	SHEET 5 OF 14	

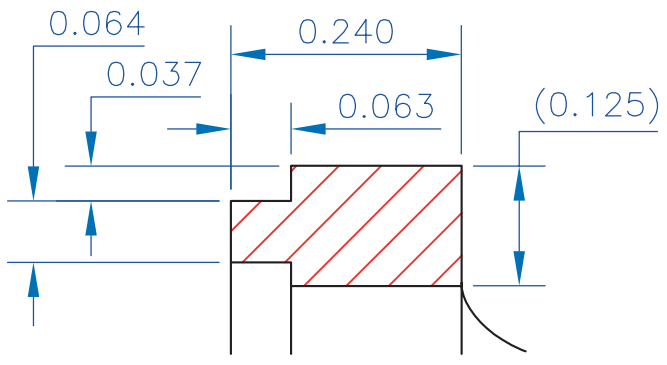




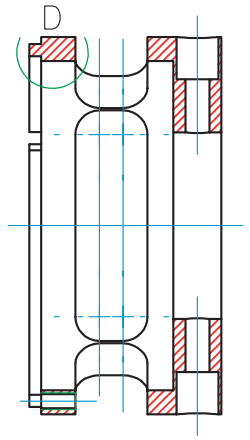
Notes:
1. RAW MATERIAL – ALUMINUM 6061
2. THIS PART AND THE OUTER ALUMINUM PIPE ARE TO BE ANODIZED BLUE.
3. VENT HOLES ARE SHOWN MILLED PERPENDICULAR TO THE CYLINDER TANGENT 1.2" WIDE X 0.375" HIGH. THEY MAY ALSO BE CUT RADIALLY. IF THEY ARE CUT RADIALLY, THEN THE 4 HOLES SHOULD BE 0.375" HIGH x 80°±1.5° (WITH 10° BETWEEN HOLES).
4. THE RAISED GROVE FOR THE TEFLON RING ATTACHMENT MAY BE MILLED (0.13" WIDE MAX) OR SPOTTED FLUSH AT THE 3 #2–56 HOLE LOCATIONS TO PREVENT BREAKOUT DURING TAPPING AT THE MACHINIST'S DISCRETION
5. EXTERNAL COSMETIC SURFACE FINISH, 32 MICROINCHES RMS
6. PART IS TO BE FREE OF BURRS
7. BREAK SHARP EDGES 0.005 MIN. 0.015 MAX.
8. ASSEMBLY: SEE SHEET 13.







VIEW D (5:1)



SECTION C–C

THIRD ANGLE
– DO NOT SCALE –
IF IN DOUBT, ASK.
UNLESS OTHERWISE SPECIFIED,
ALL DIMENSIONS ARE IN INCHES
.XXX ±0.005
.XX ±0.010

#	DESCRIPTION	DATE	APPROVED
B	ADJUSTED TO MATCH CHANGES IN TEFLON RING	05/29/2003	mmiller
	ADDED NOTE ABOUT RADIAL VENT HOLES		

FILE NAME Transfer-Handel-RevB.dwg
CONTRACT NO –
DRAWN 07.30.2003 Mitch Miller
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APPR.
ISSUED

JCSG / SMB / SSRL / SLAC

CASSETTE TRANSFER HANDLE

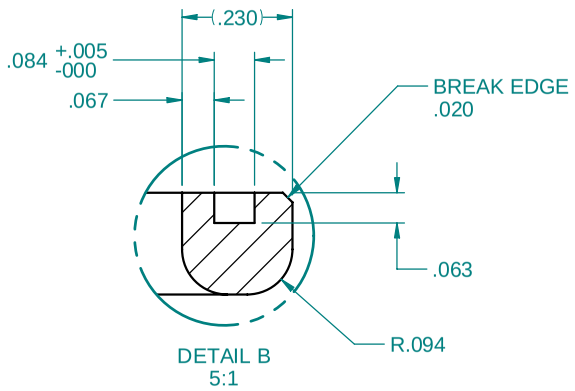
ALUMINUM CUP

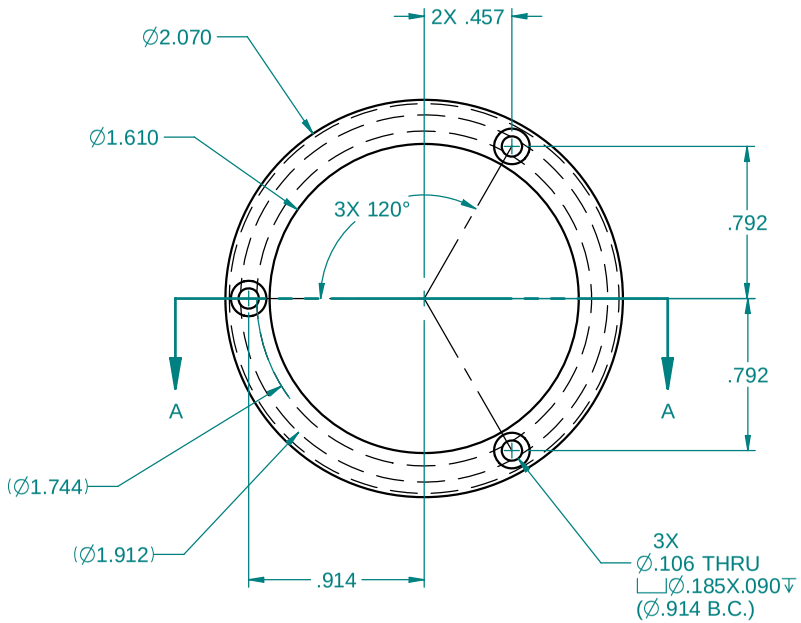
SIZE	FSCM NO	DWG NO	REV
B	–	—	B

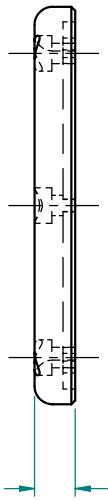
SCALE 1:1 | WEIGHT | SHEET 6 OF 14

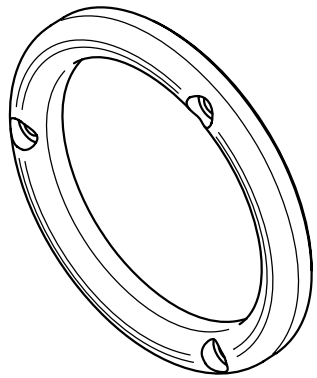
REV	DESCRIPTION	DWN	CHKR	APVD	DATE

NOTE:
1. MATERIAL: MECHANICAL GRADE PTFE-TEFLON.
2. PART IS TO BE FREE OF BURRS.









.212 ±.003

---	DIMENSIONING AND TOLERANCING IS IN ACCORDANCE WITH ASME Y14.5M-1994.	SCALE: 2:1	DO NOT SCALE DRAWING	CAD FILE NAME:

NEXT ASSEMBLIES:				

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES.
TOLERANCES:
BREAK EDGES .005-.015
INTERNAL CORNERS R.015 MAX
FRACTIONS ± ---
DEC .XX± .01
.XXX± .005
.XXXX± ---
ANGLE ± .25°
63 ALL SURF

STANFORD SYNCHROTRON RADIATION LABORATORY
U.S. DEPARTMENT OF ENERGY
SLAC, STANFORD UNIVERSITY STANFORD, CALIFORNIA

	DATE	APPROVALS
ENGR A. COHEN		---
DWN J. CHANG	5/31/07	---
CHKR ---		---

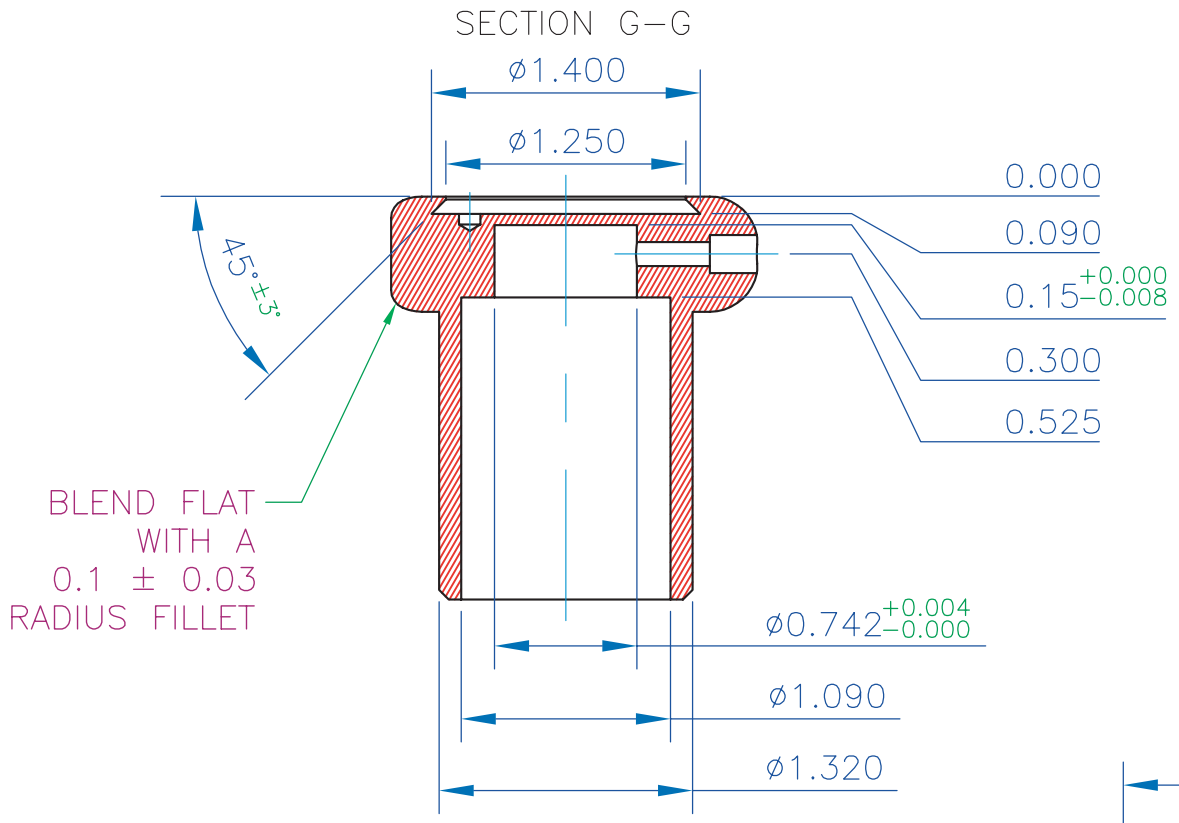
CASSETTE TRANSFER HANDLE TEFLON RING

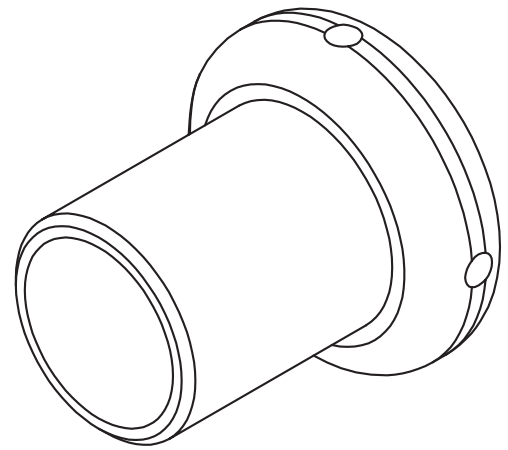
DRAWING NUMBER	REVISION NUMBER	
---	--	C

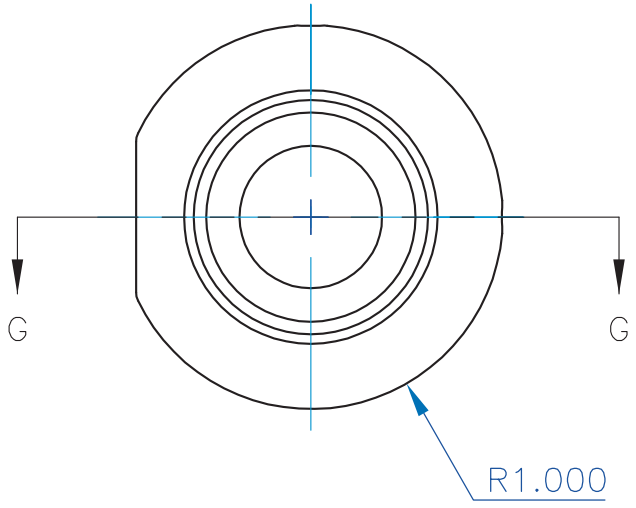
SH 1 OF 1

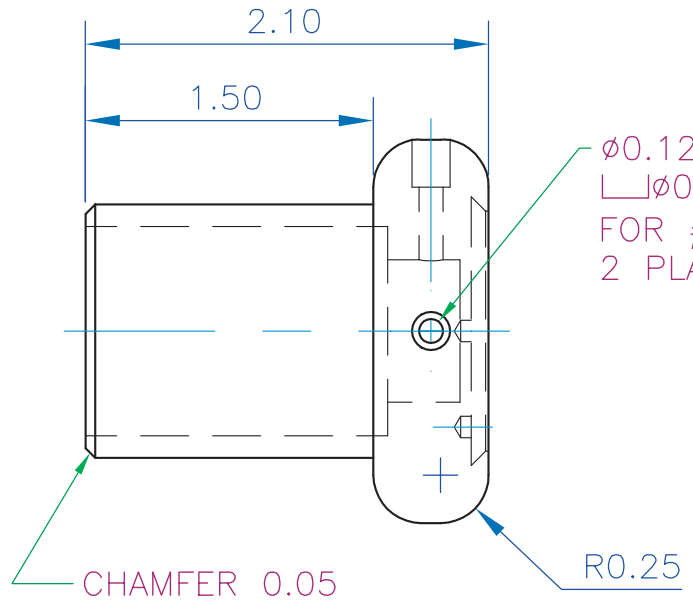
SLAC FORMAT V2.0

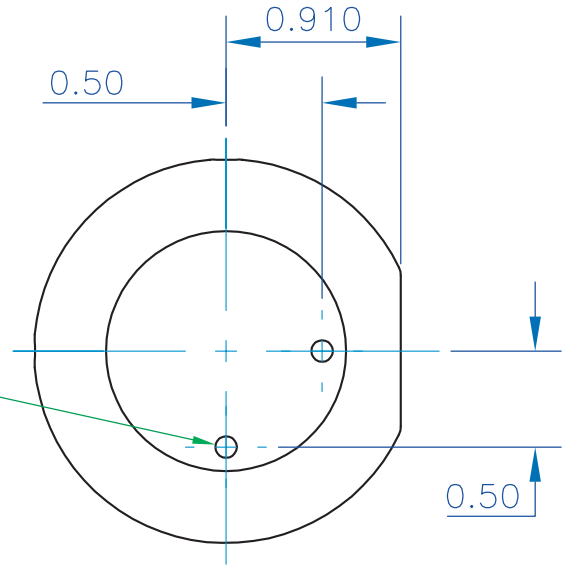
SECTION G–G











Notes:
1. RAW MATERIAL – MECHANICAL GRADE PTFE – TEFLON
2. PART IS TO BE FREE OF BURRS
3. EDGES OF THE FLAT SURFACE ON THE SIDE ARE TO BE BLENDED WITH A 0.1 ± 0.03 INCH RADIUS FILLET.
4. FIT TO END OF STAINLESS STEEL TUBE SHOULD BE TIGHT AND NOT WOBBEL WHEN ASSEMBLED
5. ASSEMBLY: SEE SHEETS 12 AND 14.

THIRD ANGLE
– DO NOT SCALE –
IF IN DOUBT, ASK.
UNLESS OTHERWISE SPECIFIED,
ALL DIMENSIONS ARE IN INCHES
.XXX ±0.005
.XX ±0.010

#	DESCRIPTION	DATE	APPROVED
B	TIGHTENED THE DIAMETER TO MATE TO THE STAINELSS STEEL TUBE TO PRVENT WOBBEL & CORRECTED DEPTH OF RECESS.	06/06/2003	mmiller

FILE NAME Transfer-Handel-RevB.dwg
CONTRACT NO –
DRAWN 07.30.2003 Mitch Miller
CHECK
APPR.
ISSUED

JCSG / SMB / SSRL / SLAC

CASSETTE TRANSFER HANDLE

TEFLON HANDLE

SIZE	FSCM NO	DWG NO	REV
B	–	—	B

SCALE 1:1 | WEIGHT | SHEET 8 OF 14

Notes:
1. RAW MATERIAL – 0.056" THK. ROWMARK ACRYLIC ENGRAVING STOCK. RED BACKGROUND WITH WHITE LETTERS.

2. TEXT SAYS "PUSH DOWN TO TURN" WITH AN ARROW INDICATING THE DIRECTION FOR "OFF" AND "ON". A 3–DIGIT SERIAL NUMBER IS ENGRAVED IN A SMALLER FONT UNDER "TO TURN".

3. LARGER TEXT HEIGHT IS TO BE 11±0.5 POINTS (0.153±0.007")ENGRAVED IN A SAN SERIF BOLD FONT (E.G. ARIAL BLACK OR ARIAL NARROW BOLD).

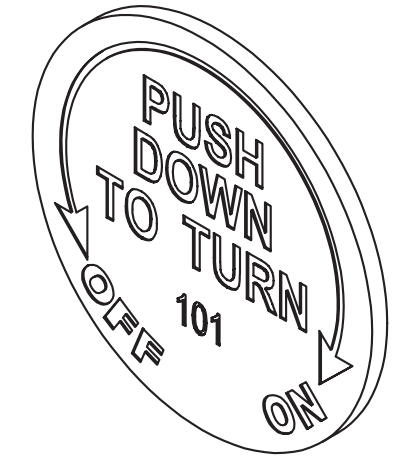
4. THE SERIAL NUMBER TEXT HEIGHT IS TO BE 7.5±0.5 POINTS (0.104±0.007") ENGRAVED USING A SAN SERIF FONT OF THE SAME TYPE FAMILY (E.G. ARIAL OR ARIAL NARROW).

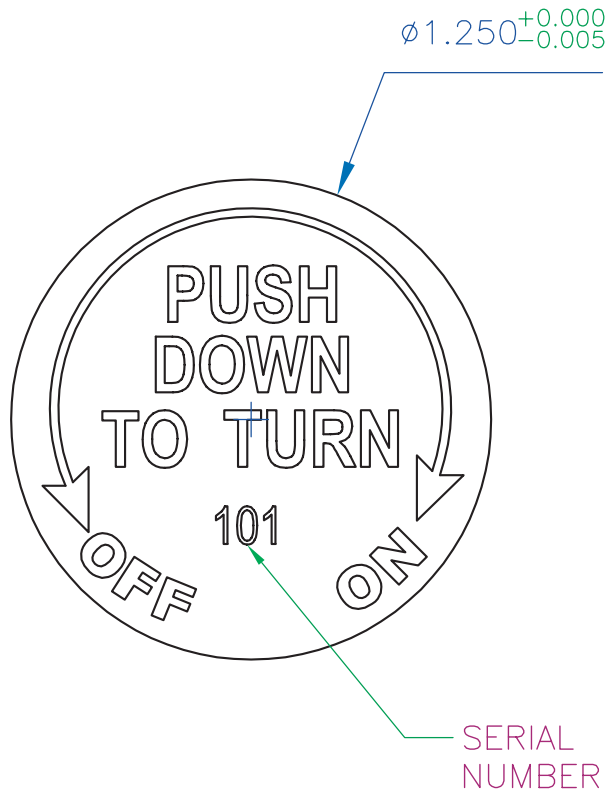
5. LAYOUT APPROVAL IS REQUIRED IF USING DIFFERENT FONTS FROM THOSE LISTED ABOVE.

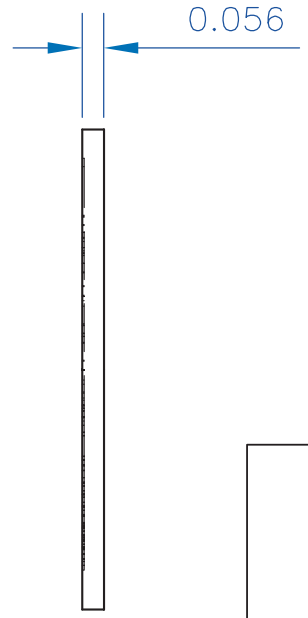
6. AN ADOBE ILLUSTRATOR OR AUTOCAD .DWG FILE CAN BE SUPPLIED WITH THE TEXT IF REQUESTED (PLEASE SPECIFY VERSION).

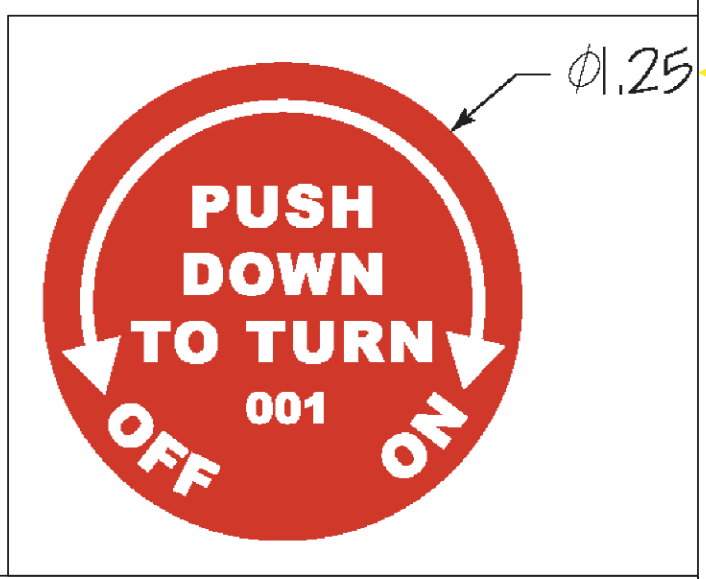
7. ALWAYS CONFIRM THE BEGINNING AND ENDING SERIAL NUMBERS BEFORE STARTING THE RUN.

8. ASSEMBLY: SEE SHEET 12









THIRD ANGLE
– DO NOT SCALE –
IF IN DOUBT, ASK.
UNLESS OTHERWISE SPECIFIED,
ALL DIMENSIONS ARE IN INCHES
.XXX ±0.005
.XX ±0.010

FILE NAME	Transfer-Handel-RevB.dwg
CONTRACT NO	–
DRAWN	07.30.2003 Mitch Miller
CHECK	
APPR.	
ISSUED	

JCSG / SMB / SSRL / SLAC

CASSETTE TRANSFER HANDLE
ENGRAVED LABEL

SIZE	FSCM NO	DWG NO	REV
AM_B	–	—	B
SCALE 2:1	WEIGHT	SHEET 9 OF 14	

Notes:
1. RAW MATERIAL – MECHANICAL GRADE PTFE – TEFLON

2. I.D. TOLERANCE IS TIGHTER THAN AS–568A SPEC.

3. SPECS FOR AS–568A–018 O–RINGS
   I.D. NOMINAL 3/4" I.D. 0.739±0.009
   C.S. NOMINL 1/16" C.S. 0.070±0.003
   O.D. NOMINAL 7/8"

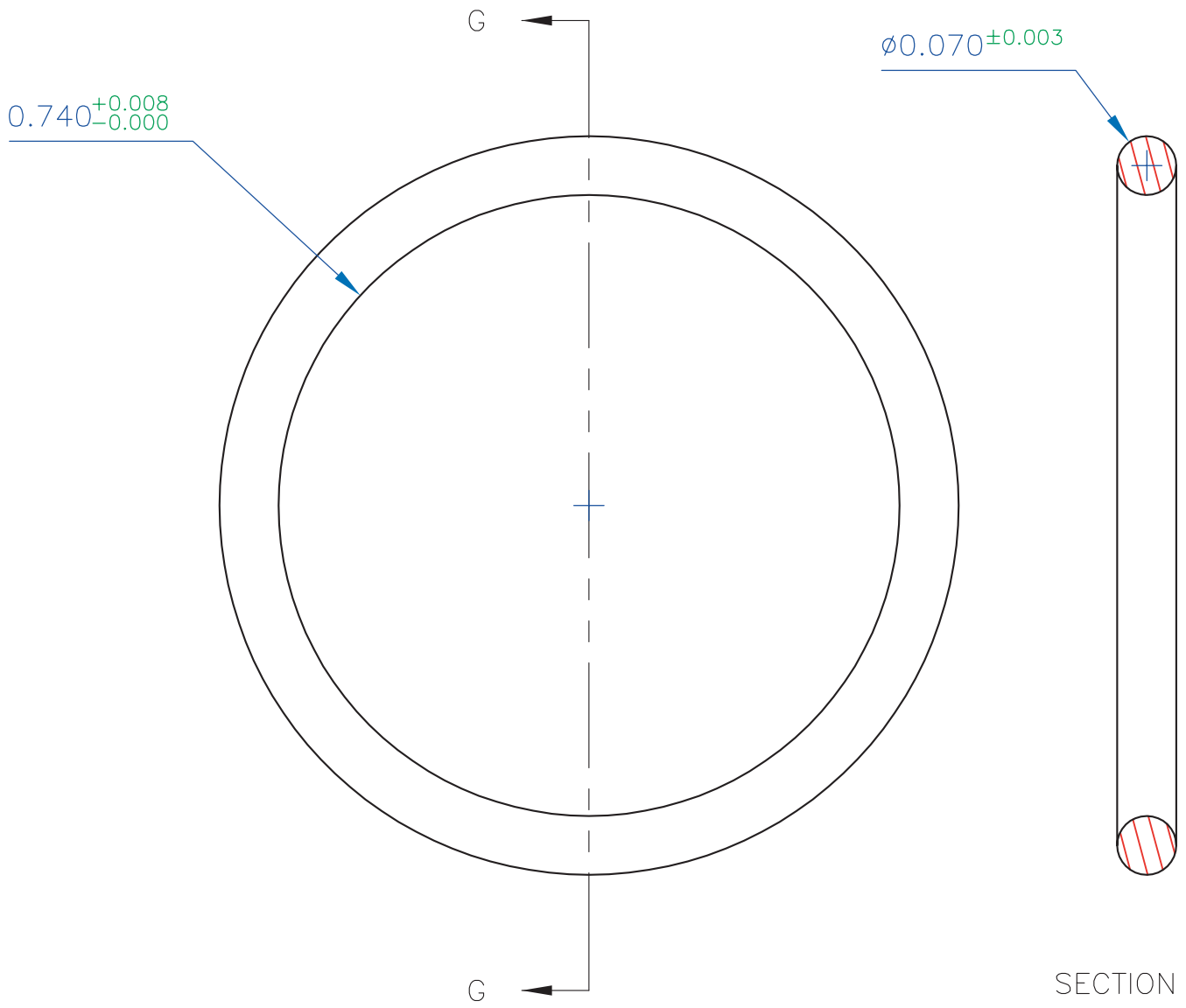
4. WE FOUND THAT WE ONLY REJECTED APPROX. 40–50 % OF THE O–RINGS IN A PACKAGE OF AS–568A–018 TEFLON O–RINGS (MSC PART# 31955313).

5. WE TESTED THE O–RINGS ON A GO/NO–GO TESTER. O–RINGS WERE ACCEPTED IF THE MOVED FREELY OVER A ø0.741 OD TUBE.

6. IF THE ID OF THE O–RINGS IS TOO SMALL, THE HANDEL WILL SEIZE WHEN USED UNDER LIQUID NITROGEN WHEN THE TEFLON CONTRACTS AGAINST THE WALLS OF THE STAINLESS STEEL TUBE.

7. WE MADE OUR TESTER FROM A SHORT PIECE OF 3/4" STAINLESS STEEL TUBING WHICH HAD BEEN TURNED DOWN. MOST OF THE TUBE WAS TURNED DOWN TO ø0.741 WITH ONE END TAPERING DOWN TO ø 0.735. THE OTHER END WAS LEFT FULL SIZE. THIS ALLOWED US TO QUICKLY TEST O–RINGS. IF THEY MOVED EASILY ACROSS THE ø0.741 SECTION, THEY COULD BE RETAINED ON THE TUBE BY THE FULL DIAMETER SECTION. ONES THAT DID NOT MOVE FREELY OVER THE ø 0.741 SECTION WERE PLACED IN A SEPARATE BIN.

8. ASSEMBLY: SEE SHEET 14



THIRD ANGLE
– DO NOT SCALE –
IF IN DOUBT, ASK.
UNLESS OTHERWISE SPECIFIED,
ALL DIMENSIONS ARE IN INCHES
.XXX ±0.005
.XX ±0.010

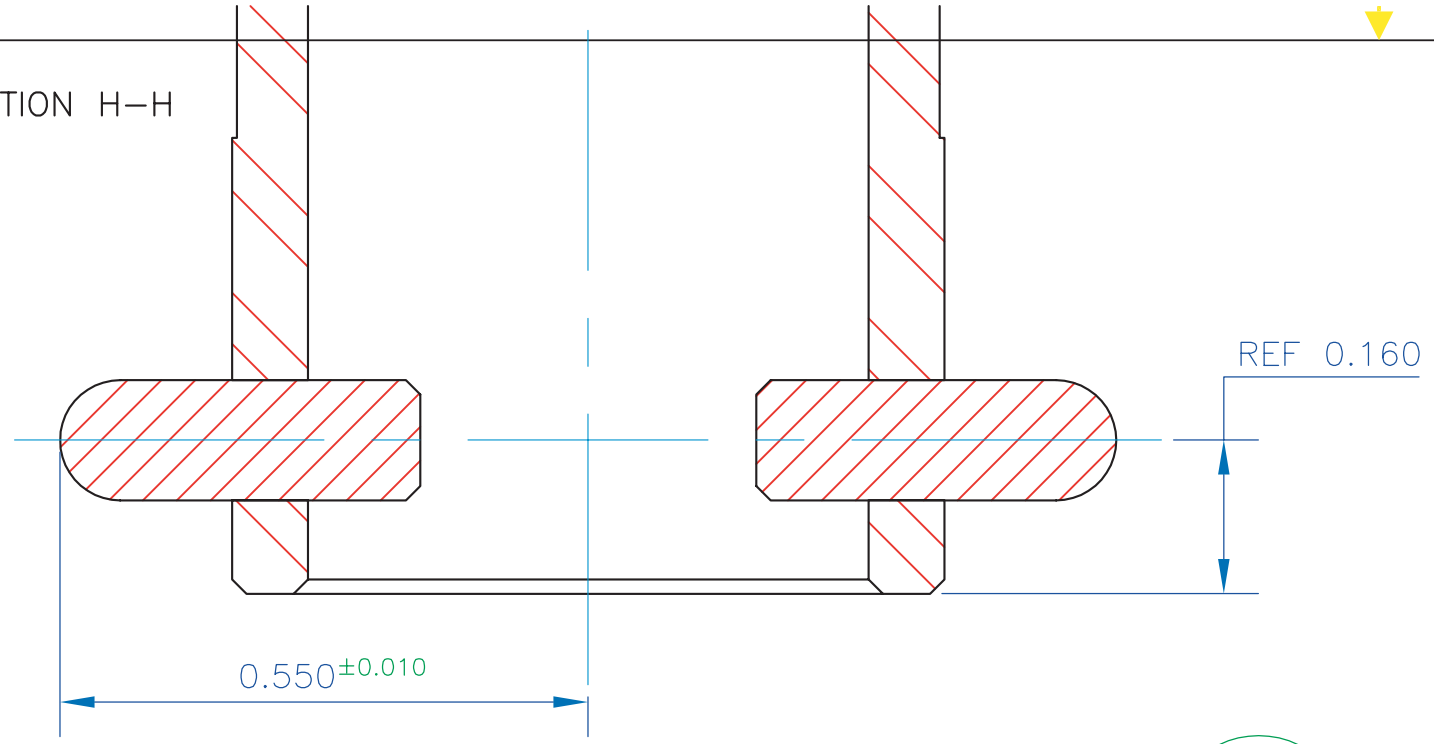
FILE NAME Transfer-Handel-RevB.dwg
CONTRACT NO –
DRAWN 07.30.2003 Mitch Miller
CHECK
APPR.
ISSUED

JCSG / SMB / SSRL / SLAC

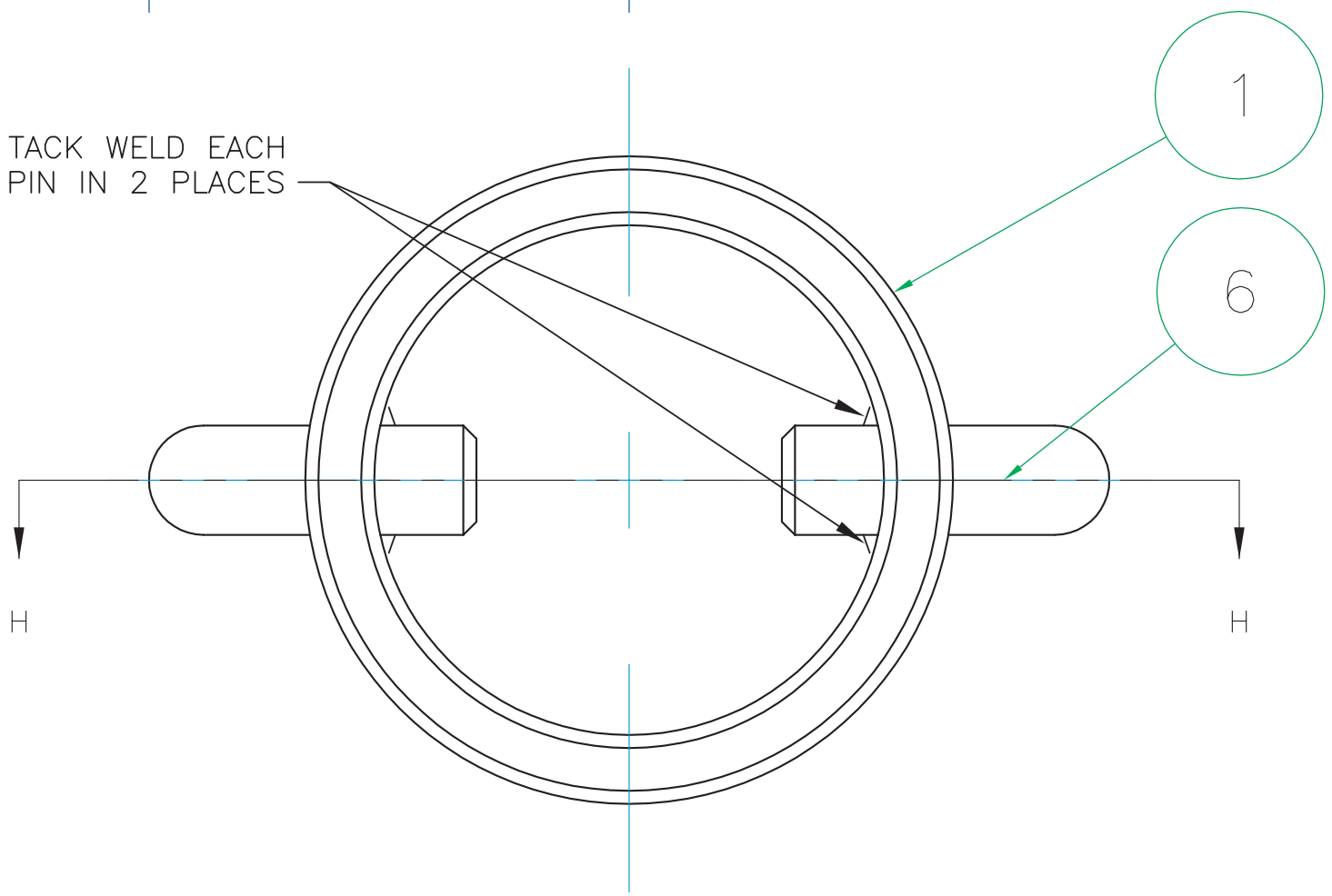
CASSETTE TRANSFER HANDLE
TEFLON O-RING -018

SIZE	FSCM NO	DWG NO	REV
AM_B	–	—	B
SCALE 5:1	WEIGHT	SHEET 10 OF 14	

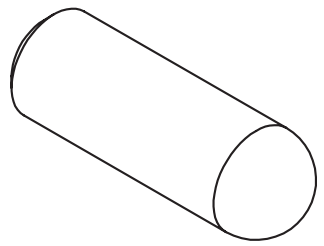
SECTION H–H

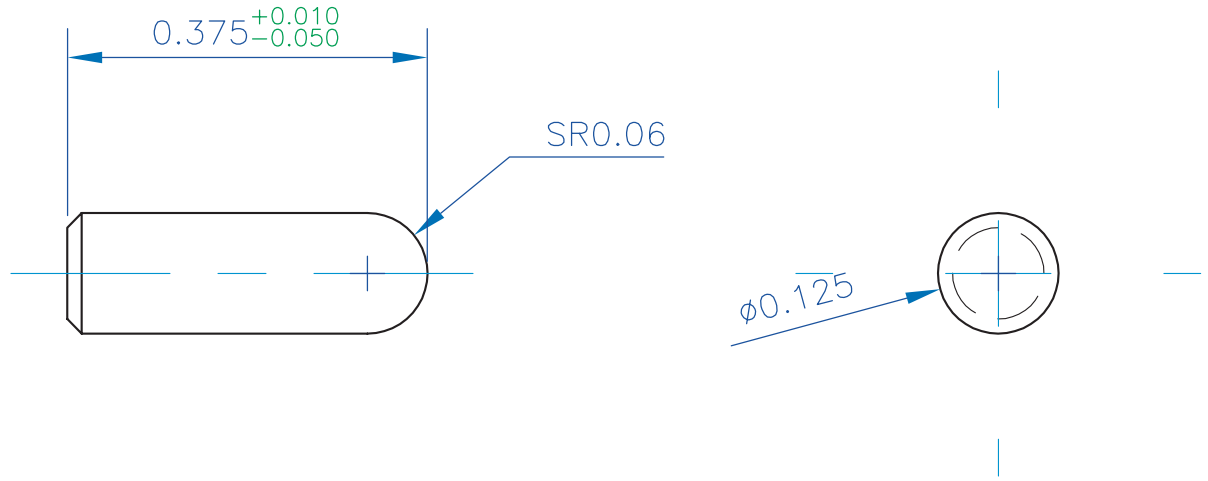


TACK WELD EACH PIN IN 2 PLACES



Notes:
1. RAW MATERIAL – STAINLESS STEEL GROUND DOWEL, ø1/8 x 3/8
2. ONE END IS TO BE TURNED SPHERICAL
3. ASSEMBLY: PRESS INTO HOLES IN STAINLESS STEEL TUBE AND TACK WELD AS SHOWN ON LEFT.





THIRD ANGLE
– DO NOT SCALE –
IF IN DOUBT, ASK.
UNLESS OTHERWISE SPECIFIED,
ALL DIMENSIONS ARE IN INCHES
.XXX ±0.005
.XX ±0.010

FILE NAME	Transfer-Handel-RevB.dwg
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JCSG / SMB / SSRL / SLAC

CASSETTE TRANSFER HANDLE

MODIFIED 1/8 DOWEL PIN

SIZE	FSCM NO	DWG NO	REV
B	–	—	B

SCALE	WEIGHT	SHEET
5:1		11 OF 14

ASSEMBLY NOTES:
ASSEMBLY OF THE ENGRAVED LABEL INTO THE TEFLON HANDLE IS AS FOLLOWS:

1. THE ENGRAVED LABEL (10) IS TO BE EMBEDDED INTO THE TOP OF THE TEFLON HANDLE (5) WITH LOCTITE HYSOL E-30CL ADHESIVE (50 ML CARTRIDGE IS LOCTITE #29329). THIS EPOXY BASED ADHESIVE HAS A 30 MINUTE POT LIFE.

2. AIR MUST BE PURGED FROM MIXING NOZZLE BEFORE BEGINNING ASSEMBLY. CARE MUST ME USED WHEN APPLYING THE EPOXY TO MINIMIZE THE INTRODUCTION OF AIR BUBBLES.

3. FIRST APPLY A SMALL AMOUNT OF ADHESIVE INTO THE TOP OF THE TEFLON HANDLE (5). THIS IS TO FILL THE BLIND HOLES AND UNDER THE LIP OF THE DOVETAIL.

4. NEXT PRESS THE ENGRAVED LABEL INTO RECESS IN THE TEFLON HANDLE. WORK AROUND SLIGHTLY TO ALLOW EPOXY TO COME UP OVER THE EDGES OF THE LABEL AND FILL DOVETAIL.

5. THE INSERT IS TO BE LEFT CLOSE TO CENTERED IN THE RECESSED OPENING WITH THE ENGRAVED LABEL ROTATED SUCH THAT FLAT IN THE HANDLE IS BELOW THE TEXT AND THE #40-40 CLEARANCE HOLES IN THE TEFLON HANDLE ARE PERPENDICULAR TO THE TEXT DIRECTION FROM ABOVE AND PARALLEL TO THE TEXT DIRECTION TO THE RIGHT AND THE BLIND HOLES TO THE BOTTOM AND LEFT (AS SHOWN).

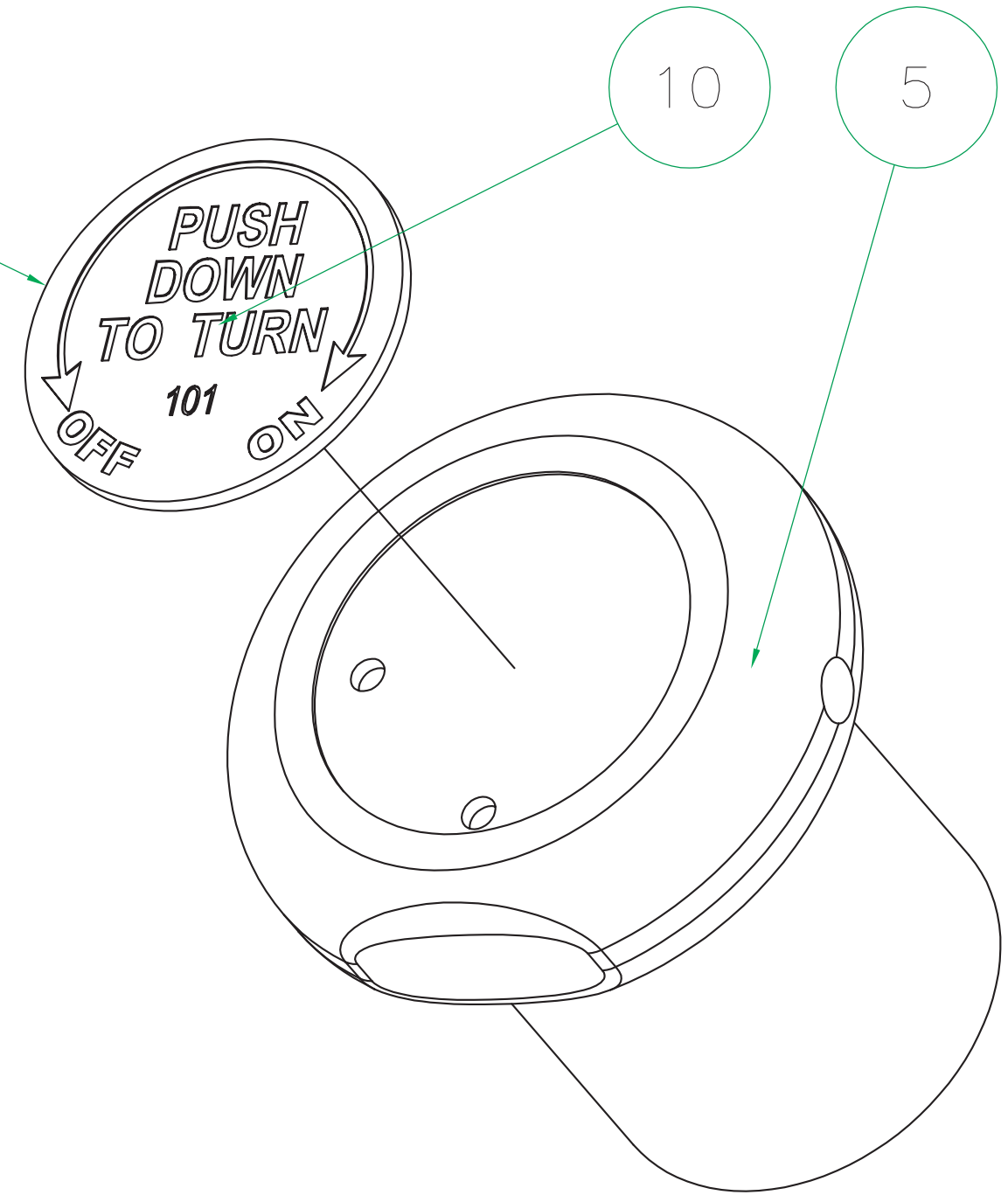
6. NOW FILL EPOXY OVER THE TOP OF THE LABEL UNTIL A SLIGHT POSITIVE MENISCUS IS FORMED. CARE SHOULD BE TAKEN TO AVOID THE INTRODUCTION OF AIR BUBBLES. A COUPLE (0-3) SMALL AIR BUBBLES MAY BE UNAVOIDABLE, BUT LARGE NUMBERS OR LARGE SIZE AIR BUBBLES ARE NOT ACCEPTABLE.

7. SET ASIDE TO CURE. NOTE THAT THE POT LIFE IS 30 MINUTES BUT IT TAKES OVER 24 HOURS FOR IT TO CURE. ALSO WE FOUND THAT THE SURFACE TAKES LONGER TO CURE FULLY. THE CLARITY OF THE SURFACE CAN BE DAMAGED BY FINGERPRINTS, OILS, OR PRESSURE FOR 3-7 DAYS. THE PARTS CAN BE HANDLED BEFORE THIS TIME WITH CARE NOT TO TOUCH THE EPOXY SURFACE. WE TYPICALLY MAKE AN EPOXY TEST PIECE TO DETERMINE WHEN THE PARTS HAVE CURED SUFFICIENTLY FOR HANDELING. CURING CAN BE ENHANCED IN LOW HUMIDITY ENVIRONMENTS AND AT ELEVATED TEMPERATURES (NOT TO EXCEED 176°F / 80°C).

8. MAKE SURE EPOXY IS CURED BEFORE COMPLETING ASSEMBLEY STEPS SHOWN ON SHEET 14.

9. IF YOU HAVE ANY QUESTIONS ABOUT THE PROCESS, PLEASE ASK. WE CAN LOAN YOU A SAMPLE TO DEMONSTRATE THE FINISHED EPOXY EMBEDDING IF NECESSARY.

SEE NOTE 5.
ORIENTATION OF LABEL TO HOLE PATTERN AND FLAT SURFACE ON SIDE



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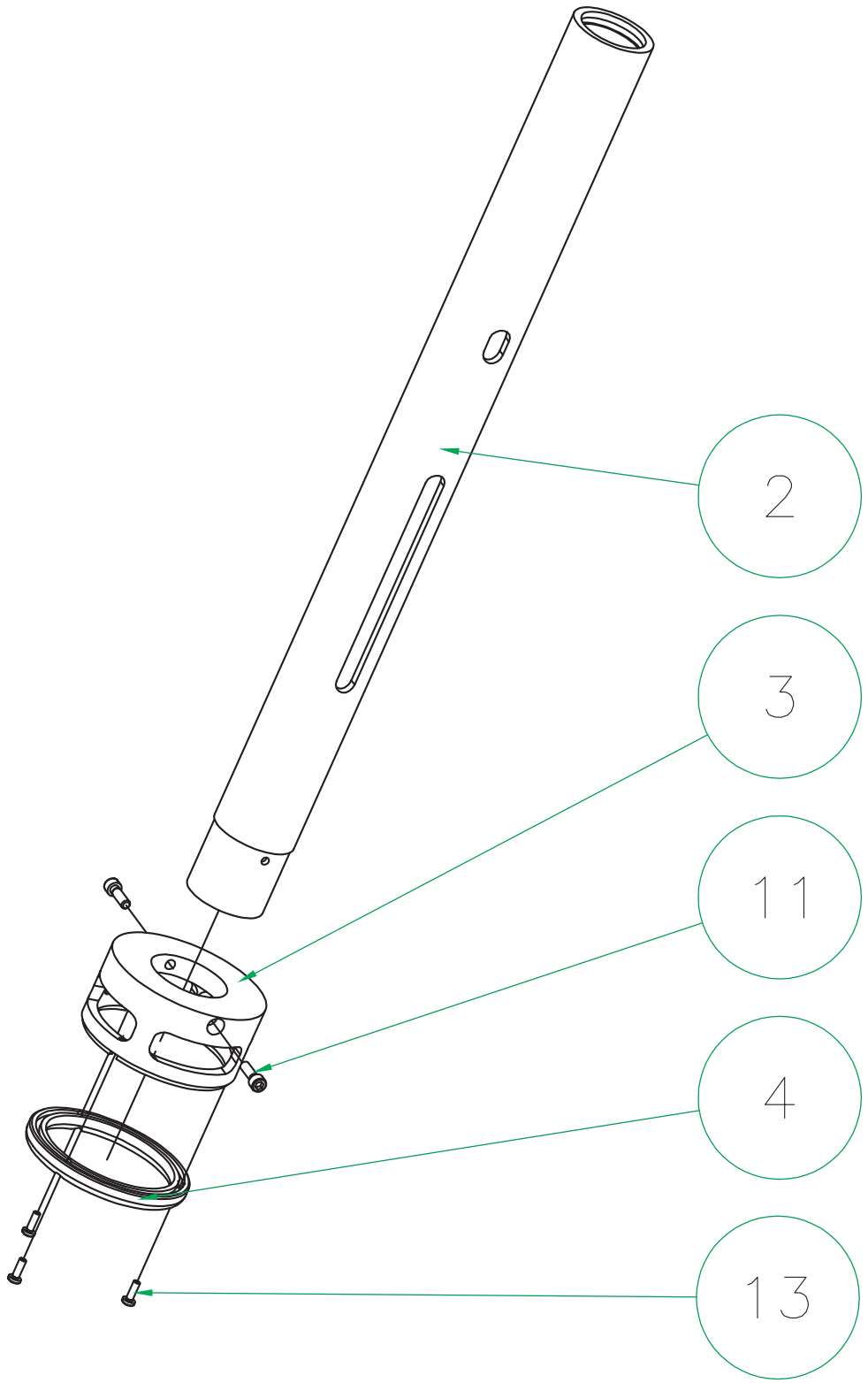
CASSETTE TRANSFER HANDLE

EXPLODED VIEW - HANDLE LABEL

SIZE	FSCM NO	DWG NO	REV
AM_B	–	—	B
SCALE 2:1	WEIGHT	SHEET 12 OF 14	



ASSEMBLY NOTES – OUTER TUBE:

1. PRESS TEFLON RING (4) ONTO BOTTOM CUP (3) AND ATTACH WITH #2–56 x 1/4" SLOTTED PAN HEAD MACHINE SCREW (13).

2. SLIDE BOTTOM CUP (3) ONTO OUTER ALUMINUM PIPE (2) AND ATTACH WITH #4–40 x 3/8" SOCKET HEAD CAP SCREWS (11).

FILE NAME Transfer-Handel-RevB.dwg	JCSG / SMB / SSRL / SLAC
CONTRACT NO –	CASSETTE TRANSFER HANDLE
DRAWN 07.30.2003 Mitch Miller	EXPLODED VIEW - OUTER ASSEMBLY 1
CHECK	
APPR.	
ISSUED	

SIZE	FSCM NO	DWG NO	REV
B	–	—	B
SCALE 1:2	WEIGHT	SHEET 13 OF 14	

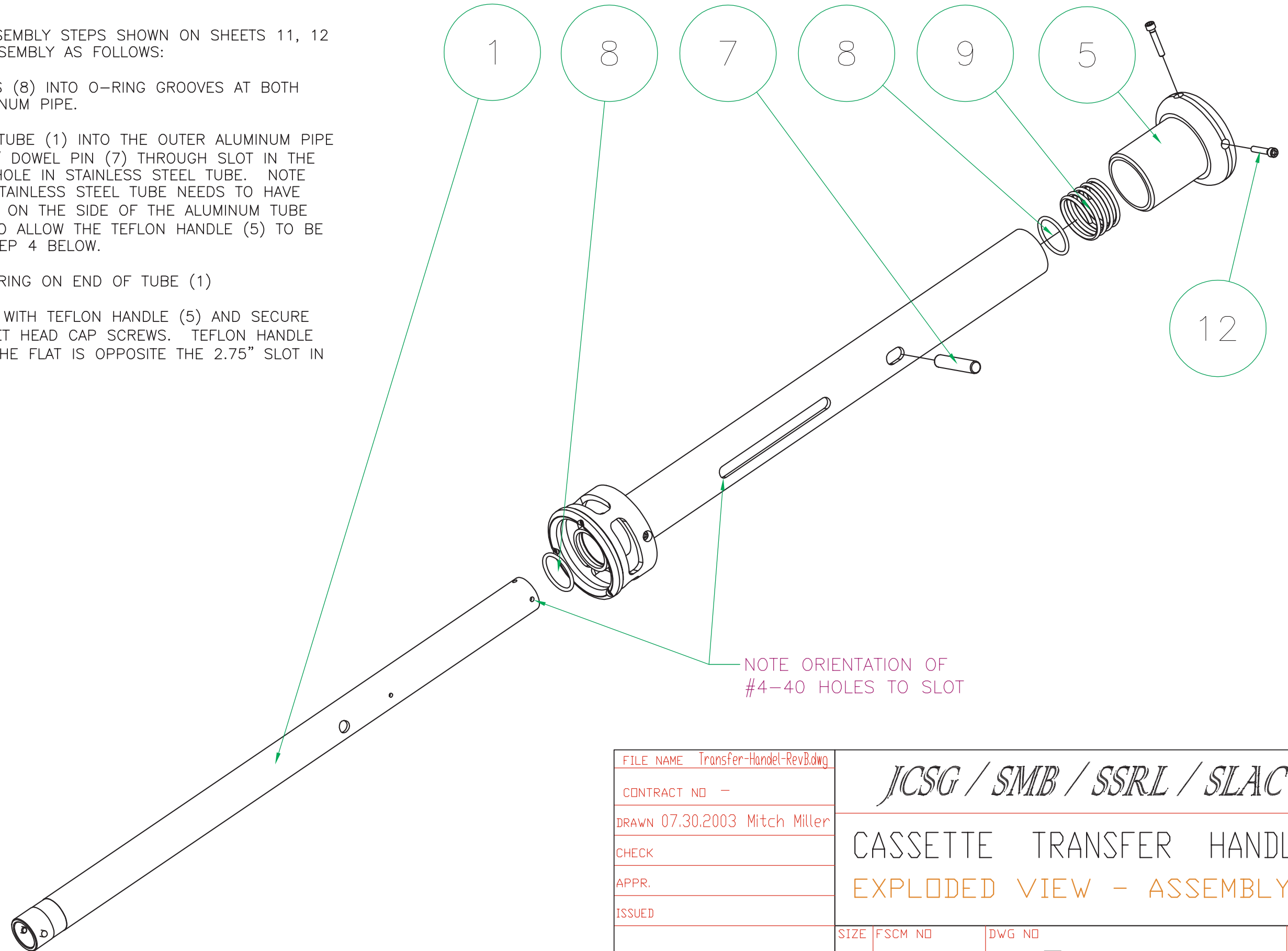
ASSEMBLY NOTES:
AFTER COMPLETING THE ASSEMBLY STEPS SHOWN ON SHEETS 11, 12 AND 13, COMPLETE THE ASSEMBLY AS FOLLOWS:

1. INSTALL TEFLON O-RINGS (8) INTO O-RING GROOVES AT BOTH ENDS OF THE OUTER ALUMINUM PIPE.

2. SLIDE INNER STAINLESS TUBE (1) INTO THE OUTER ALUMINUM PIPE AND PRESS 1/4" x 1 1/4" DOWEL PIN (7) THROUGH SLOT IN THE ALUMINUM PIPE AND INTO HOLE IN STAINLESS STEEL TUBE. NOTE THE ORIENTATION OF THE STAINLESS STEEL TUBE NEEDS TO HAVE ONE OF THE #4-40 HOLES ON THE SIDE OF THE ALUMINUM TUBE WITH THE SLOT. THIS IS TO ALLOW THE TEFLON HANDLE (5) TO BE ORIENTED CORRECTLY IN STEP 4 BELOW.

3. PLACE COMPRESSION SPRING ON END OF TUBE (1)

4. COMPRESS SPRING (9) WITH TEFLON HANDLE (5) AND SECURE WITH #4-40 X 5/8" SOCKET HEAD CAP SCREWS. TEFLON HANDLE SHOULD BE ORIENTED SO THE FLAT IS OPPOSITE THE 2.75" SLOT IN THE ALUMINUM OUTER PIPE.



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CASSETTE TRANSFER HANDLE

EXPLODED VIEW - ASSEMBLY 2

SIZE	FSCM NO	DWG NO	REV
B	-	—	B

SCALE 1:2 | WEIGHT | SHEET 14 OF 14