

Sistema Canna e testina per HPR

Si richiede la quotazione per la realizzazione delle parti di seguito descritte

Dis. N°

ESS-CB-01.00.00 (Complessivo)

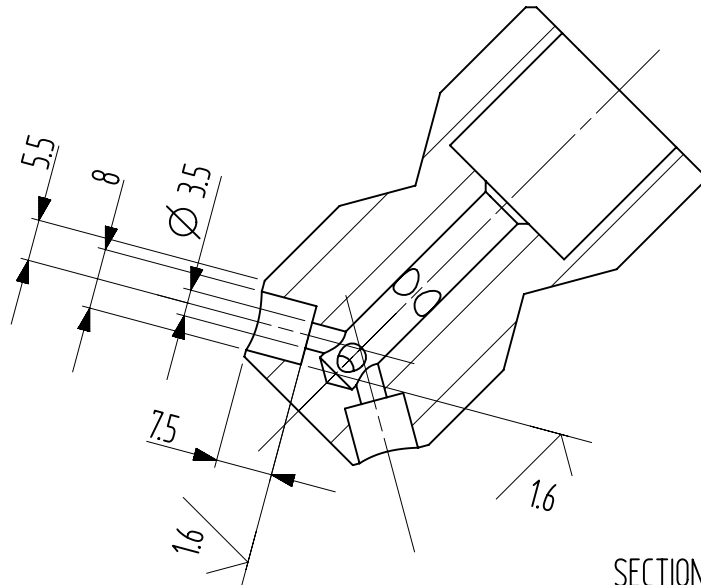
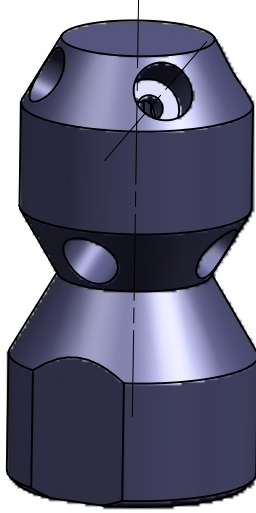
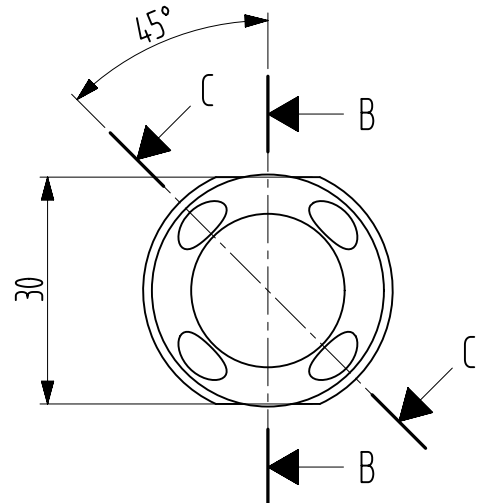
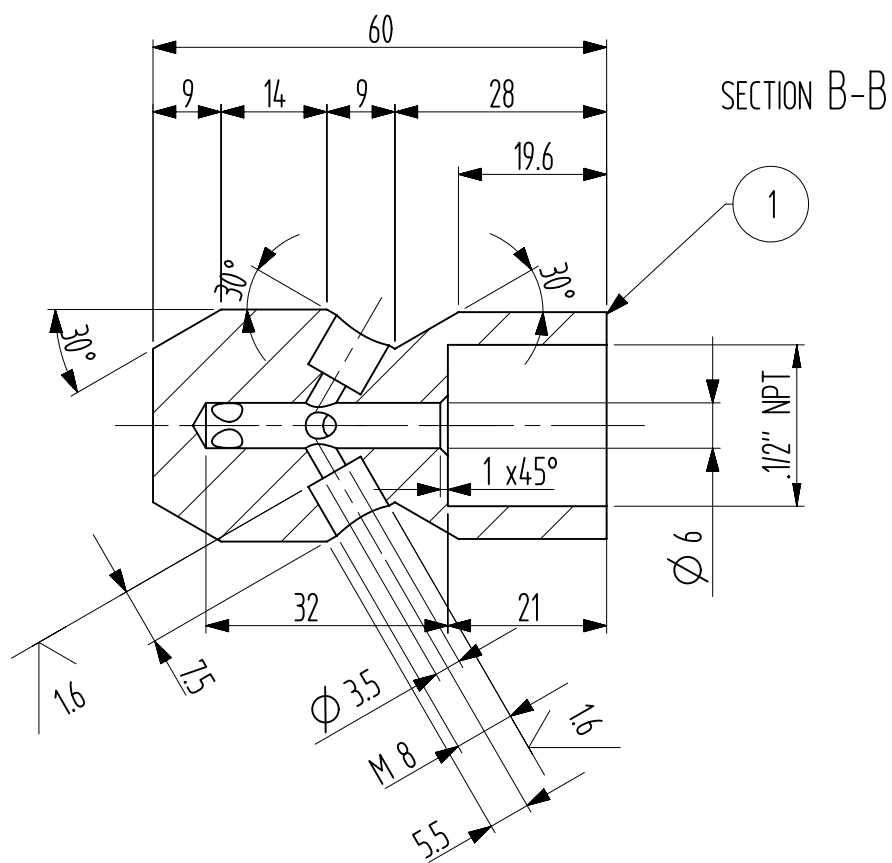
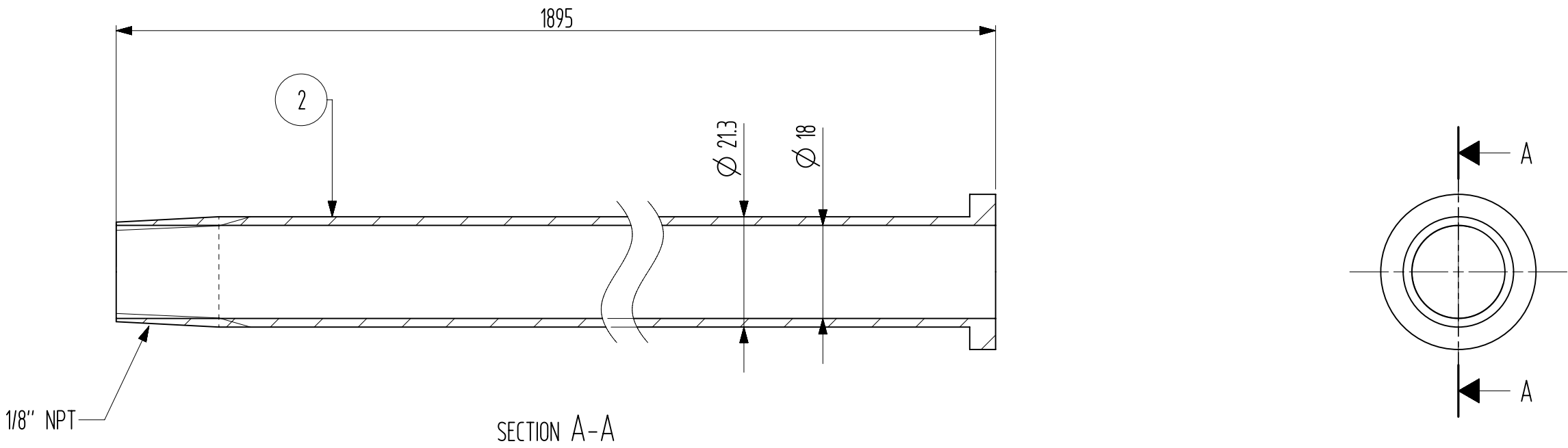
ESS-CB-01.01.00 (Particolari)

Descrizione:

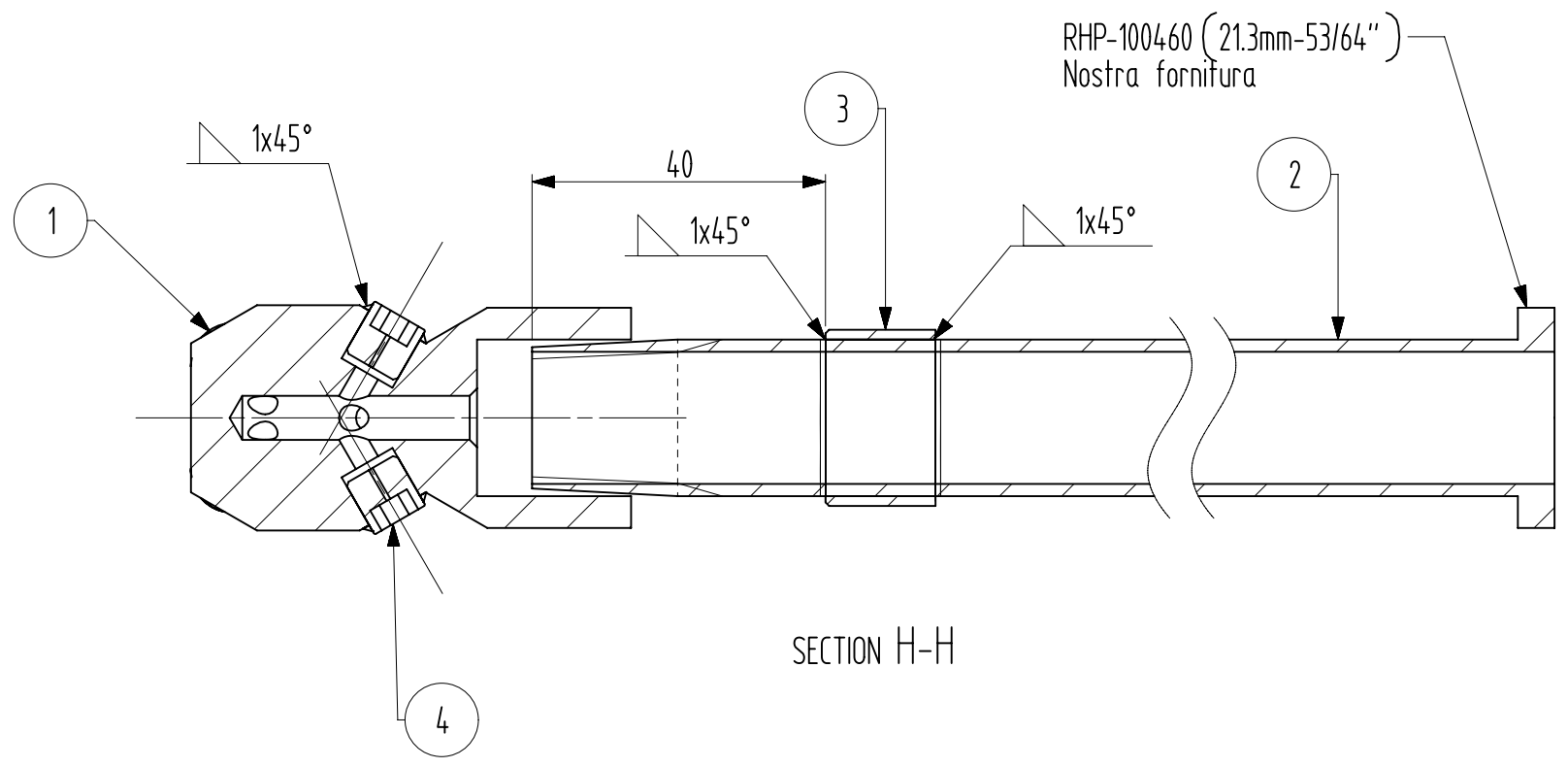
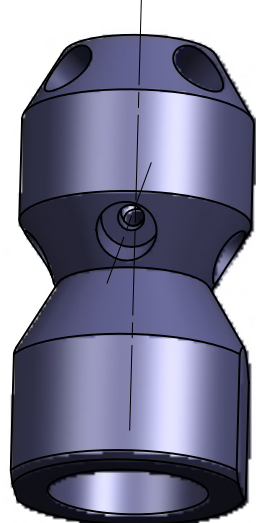
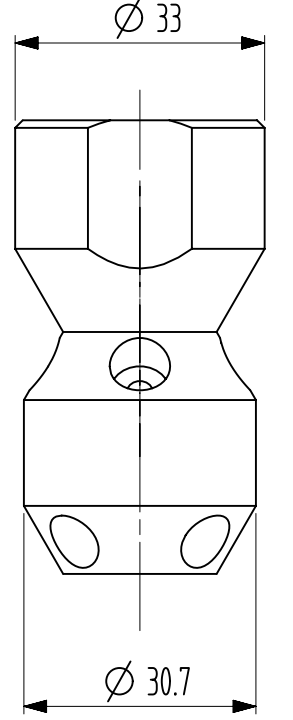
Canna in AISI composta da tubo Elettrolucidato sia dentro che fuori flangiata alle 2 estremità con attacchi ad alta pressione

Testina in AISI flangiata con attacco ad alta pressione e ugelli saldati

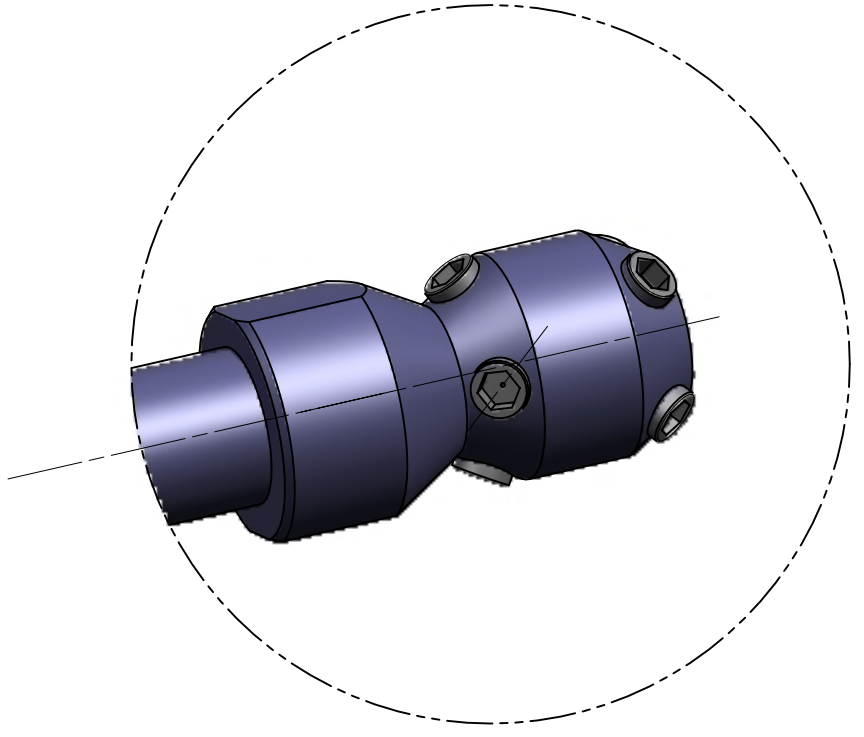
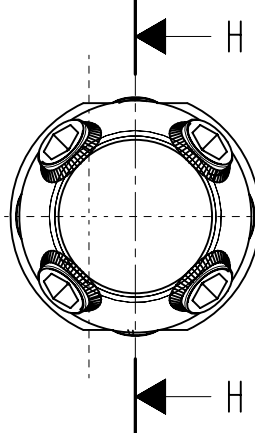
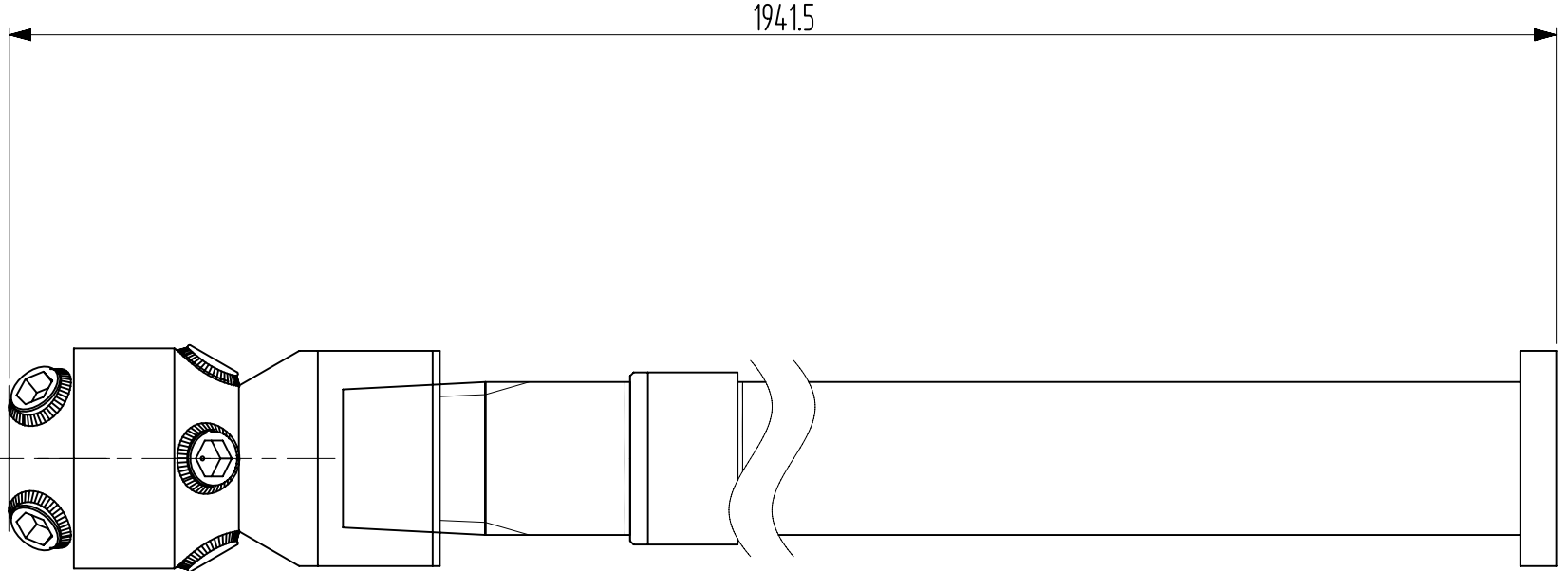
GENERAL TOLERANCES	-30	30-120	120-315	315-1000	1000-2000	2000-4000	4000-8000	8000-12000	12000-16000	16000-20000	20000-		
FOR PLATES WORKING	± 1	± 2	± 2	± 3	± 4	± 6	± 8	± 10	± 12	± 14	± 16		
FOR MECHANICAL MACHINING OF SIZE WITHOUT CLEARANCE	-6	6-30	30-120	120-315	315-1000	1000-2000	2000-4000	4000-	ANG. DIM.	-6°	6°-30°	30°-120°	120°-
TOLERANCES NOT SPECIFIED	± 0.1	± 0.2	± 0.3	± 0.5	± 0.8	± 1.2	± 2	± 3		± 1°	± 30'	± 20'	± 10'
WORKING SURFACES ROUGHNESS	ISO	N 10	N 9	N 8	N 7	N 6	N 5	N 4	N 3	N 2			
	N LCA Ra	18 12.5	17 6.3	16 3.2	15 1.6	14 0.8	13 0.4	12 0.2	11 0.1	10 0.05			



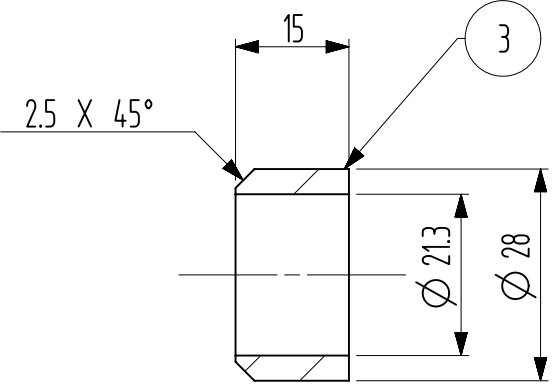
SECTION C-C



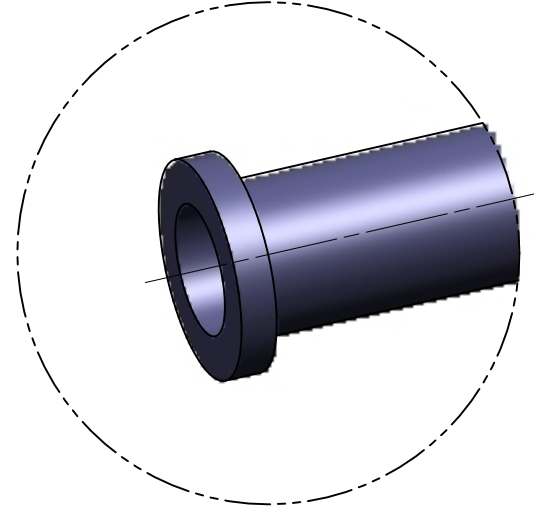
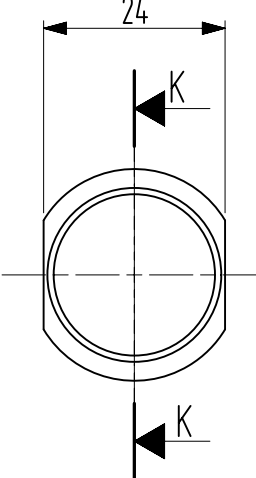
SECTION H-H



DETAIL F
SCALE 1:1



SECTION K-K



DETAIL J
SCALE 1:1



Pezzi elettrolucidati internamente e esternamente
Pressione di funzionamento 100 bar con Acqua

4	Ugello-VS-320-M8-06 Spraying-System	8			Nostra fornitura	3
3	Boccola-canna-ESS	1	AlSi-316L			24
2	Asta-per-testina	1	AlSi-316L			154.3
1	Testina-ESS	2	AlSi-316L			221
Pos.	Part Name	Qty	Material	Drawing	Note	Weight
INFN Milano - LASA via Fratelli Cervi, 201 20090 Segrate (MI)		Size:	DWG: DWG-ASSY-Canna-ESS		Revision:	0
Experience: ESS		Drawn by:	M. Bonezzi	Date:	2016/05/05	Sheet 1 of 1
Object: Canna-Testina HPR		Checked by:	P. Michelato	Scale:	1:1/1.5	
3D part: ASSY-Canna-ESS		Approved by:	P. Michelato	Units:	mm	
		File name:	R:\Project\HPR\Supporto-canna\Canna\DWG-ASSY-Canna-ESS.prt			

Canotti piastre e distanziali in camera bianca per sostegno cavità

Gruppo meccanica

Si richiede la quotazione per la realizzazione delle parti di seguito descritte

Dis. N°

ESS-CB-01.00.00 (Complessivo)

ESS-CB-01.02.02 (Particolari)

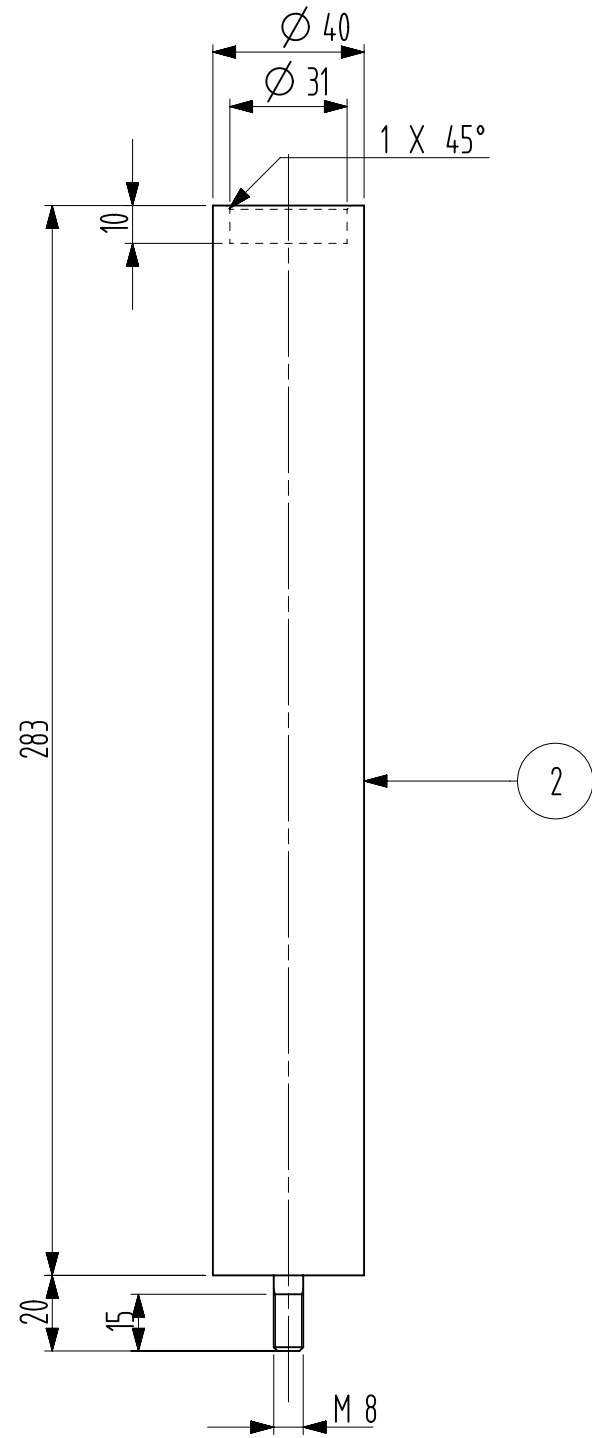
La fornitura deve comprendere anche le parti unificate indicate in tabella

Pos. 9-10-11 (viti, rondelle, dadi ecc.)

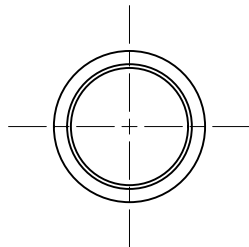
Descrizione:

Piastre tondi distanziali in AISI Elettrolucidati

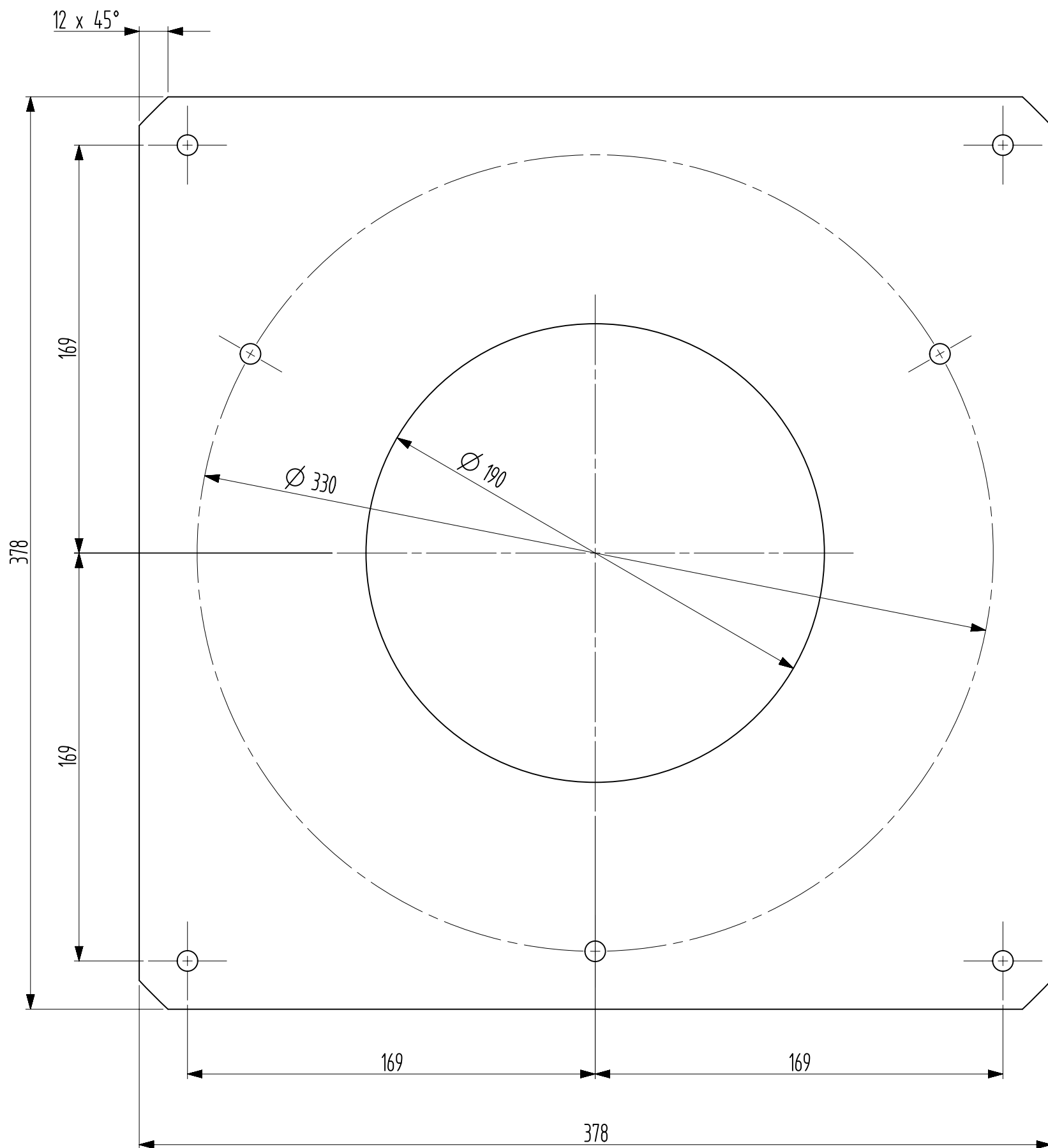
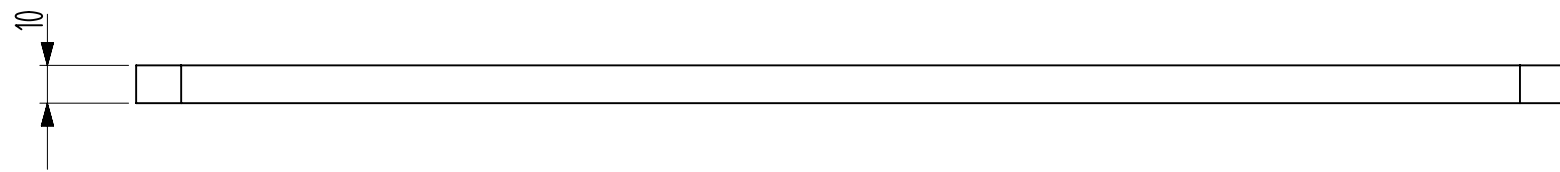
GENERAL TOLERANCES	-30	30-120	120-315	315-1000	1000-2.000	2000-4.000	4.000-8000	8000-12000	12000-60000	60000-200000	200000-		
FOR PLATES WORKING	± 1	± 2	± 2	± 3	± 4	± 6	± 8	± 10	± 12	± 14	± 16		
FOR MECHANICAL MACHINING OF SIZE WITHOUT CLEREANCE	-6	6-30	30-120	120-315	315-1000	1000-2000	2000-4.000	4.000-	ANG. DIM.	-6°	6°-30°	30°-120°	120°-
TOLERANCES NOT SPECIFIED	± 0.1	± 0.2	± 0.3	± 0.5	± 0.8	± 1.2	± 2	± 3		± 1°	± 30'	± 20'	± 10'
WORKING SURFACES ROUGHNESS	ISO	N 10	N 9	N 8	N 7	N 6	N 5	N 4	N 3	N 2			
	N LCA	18	17	16	15	14	13	12	11	10			
	Ra	12.5	6.3	3.2	1.6	0.8	0.4	0.2	0.1	0.05			



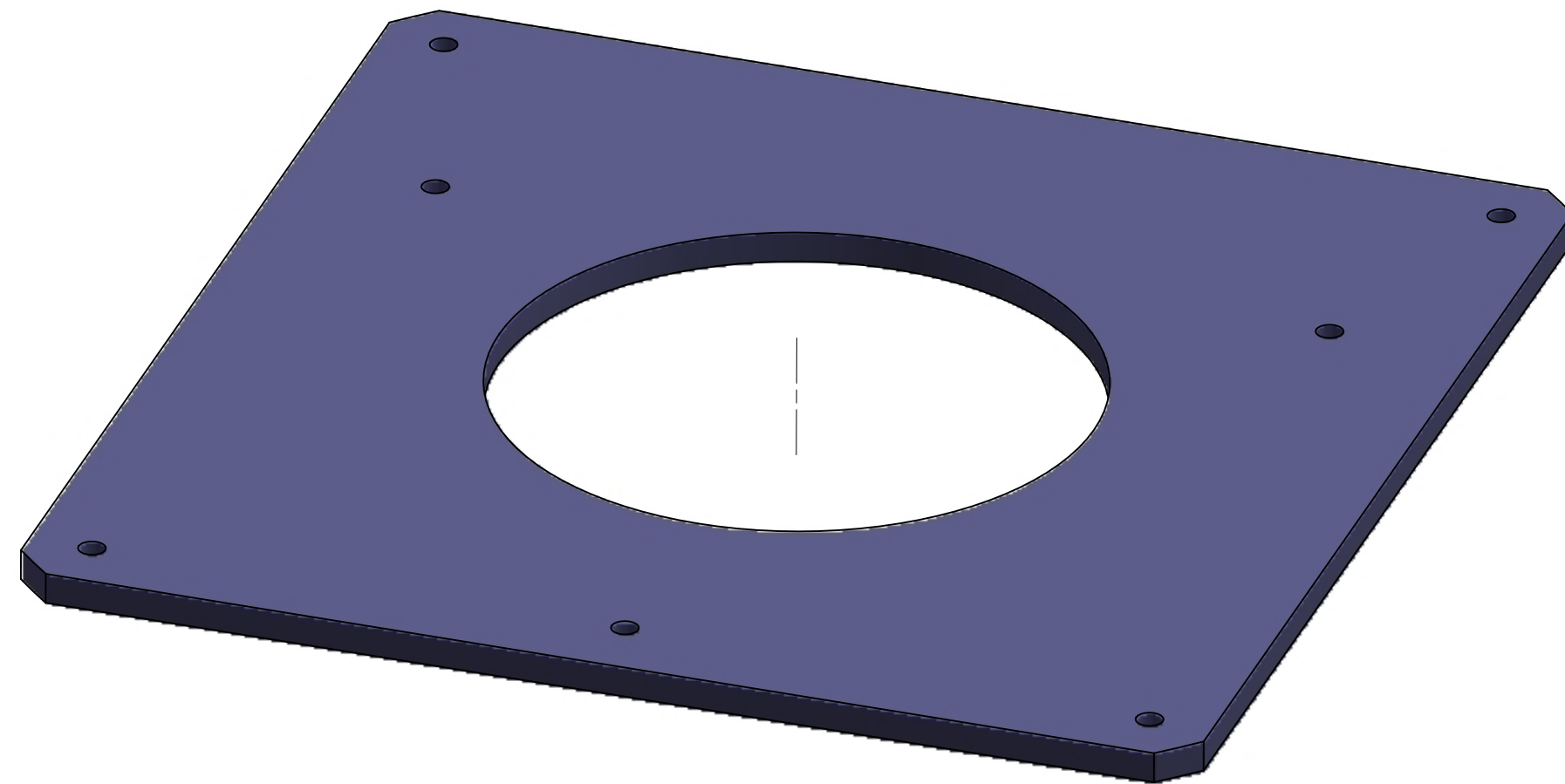
2



Elettrolucidato



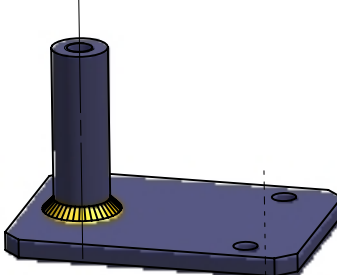
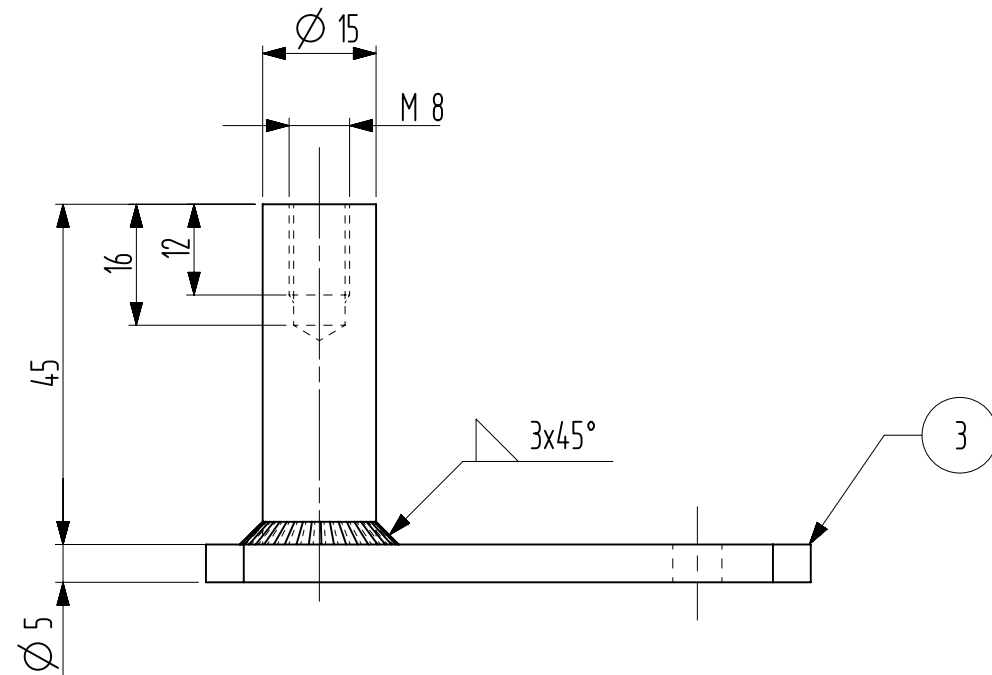
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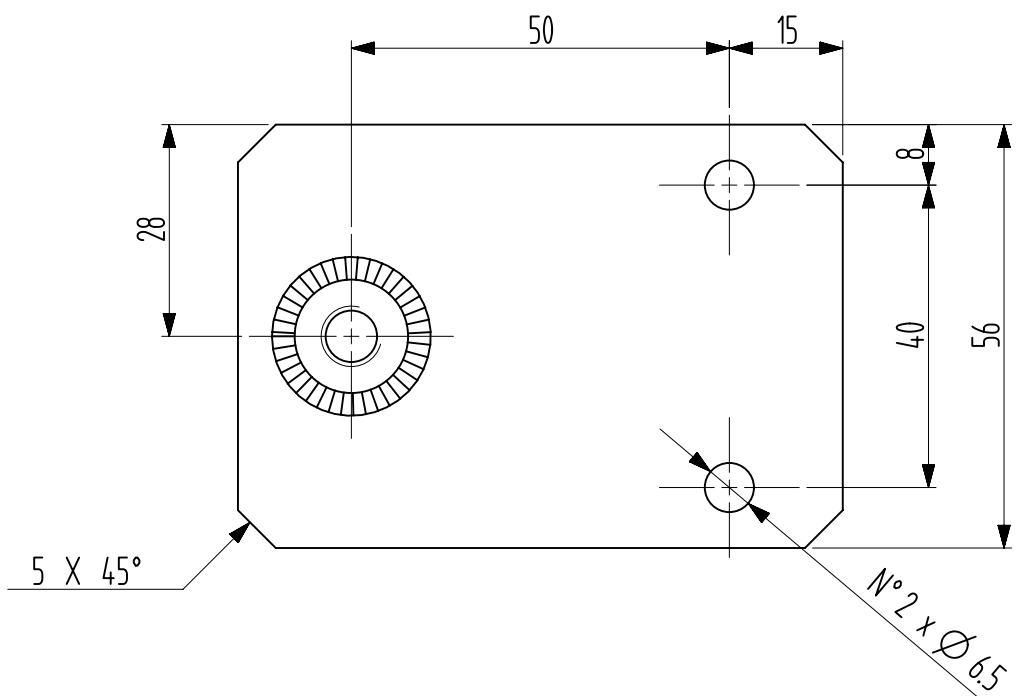
1.6

Elettrolucidato

Smussi non indicati 0.3x45°



3



Elettrolucidato

5	VTE-M6x0-UNI-5627	9	A2			0
4	Rosetta-6.4x12.5-UNI-6592	9	A2			1
3	Distanziale-giostra-ESS-MB	3	ANSI-304			
2	Bicchierino-cavita-ESS-MB	4	ANSI-304			2733
1	Piastra-cavita-ESS-MB	1	ANSI-304			8916
Pos.	Part Name	Qty	Material	Drawing	Note	Weight
 INFN Milano - LASA via Fratelli Cervi, 201 20090 Segrate (MI)		Size:	DWG: DWG-ASSY-Giostra-CB-ESS-MB		Revision:	
		A1	ESS-CB-01.02.02		0	
Experience: ESS		Drawn by:	M. Bonezzi	Date:	2016/04/12	Sheet 1 of 1
Object: HPR-Supporti		Checked by:		Scale:	1 : 2	
3D part: ASSY-Giostra-CB-ESS-MB		Approved by:	P. Michelato	Units:	mm	
		File name:	R:\Project\HPR\Giostra-CB\DWG-Assy-Giostra-CB-ESS-MB.prt			

Gasket per cavita ESS

Si richiede la quotazione per la realizzazione delle parti di seguito descritte

Dis. N°

ESS-AT-04.00.00 (Pos. 5-6-7 quantità indicate a disegno)

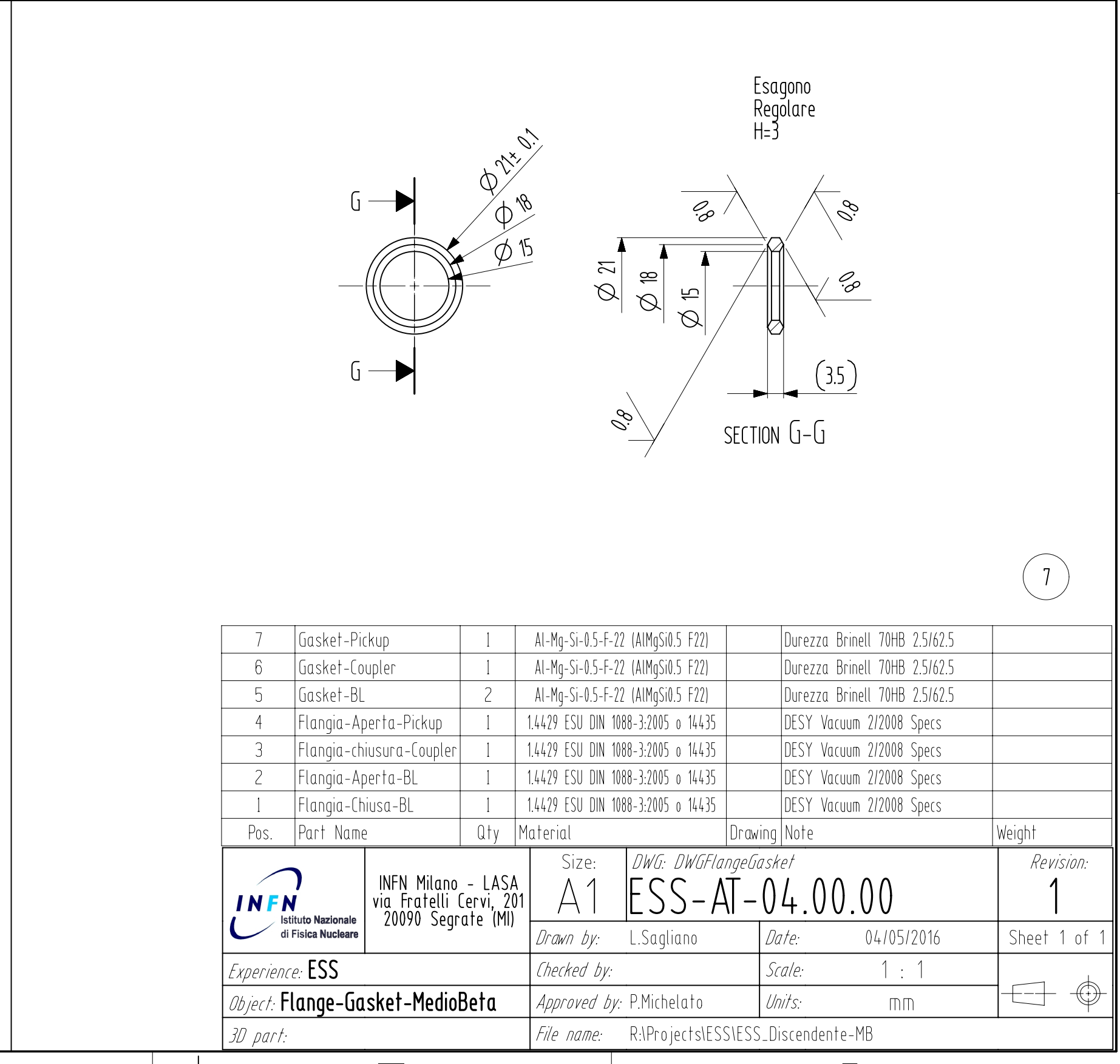
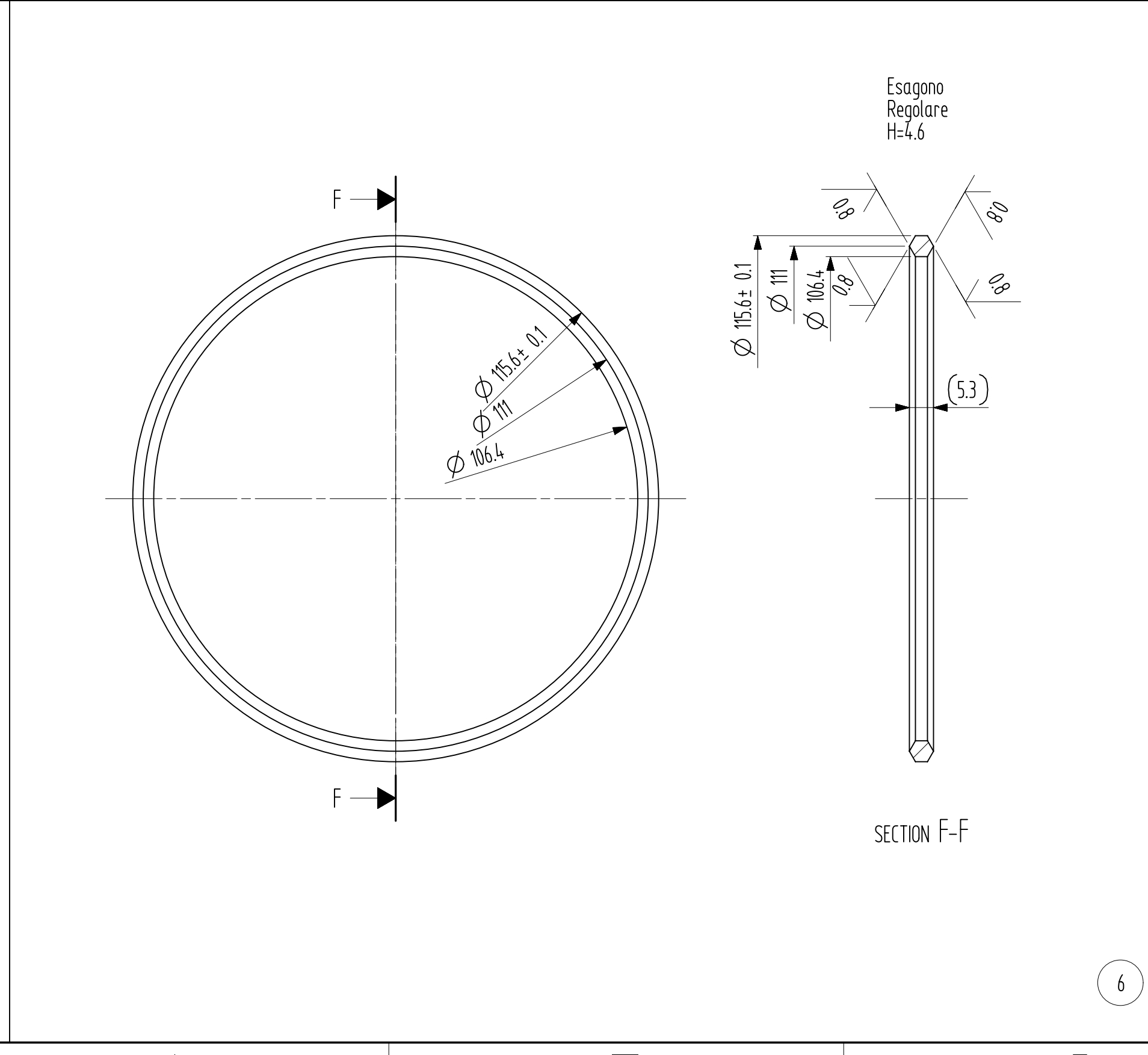
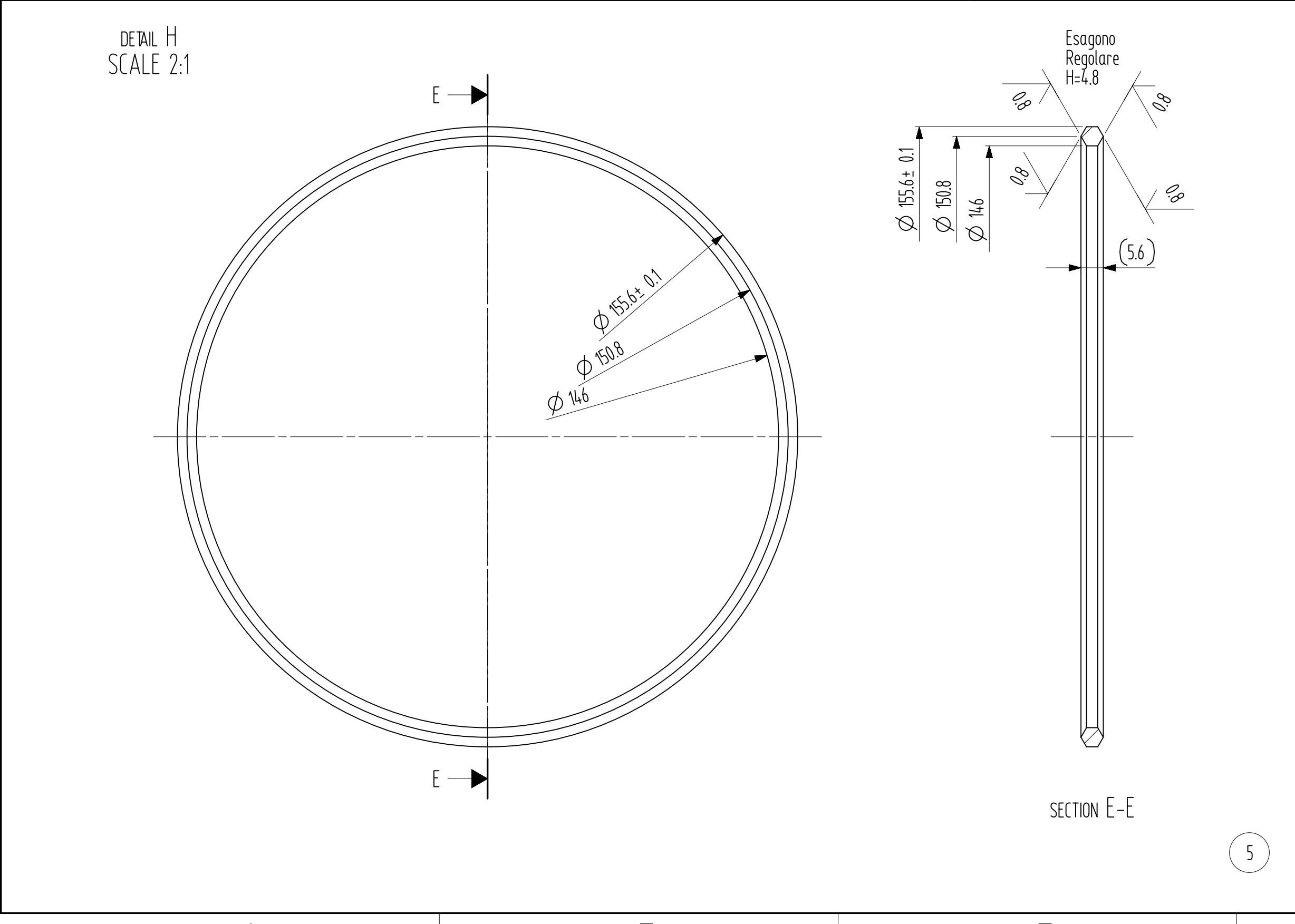
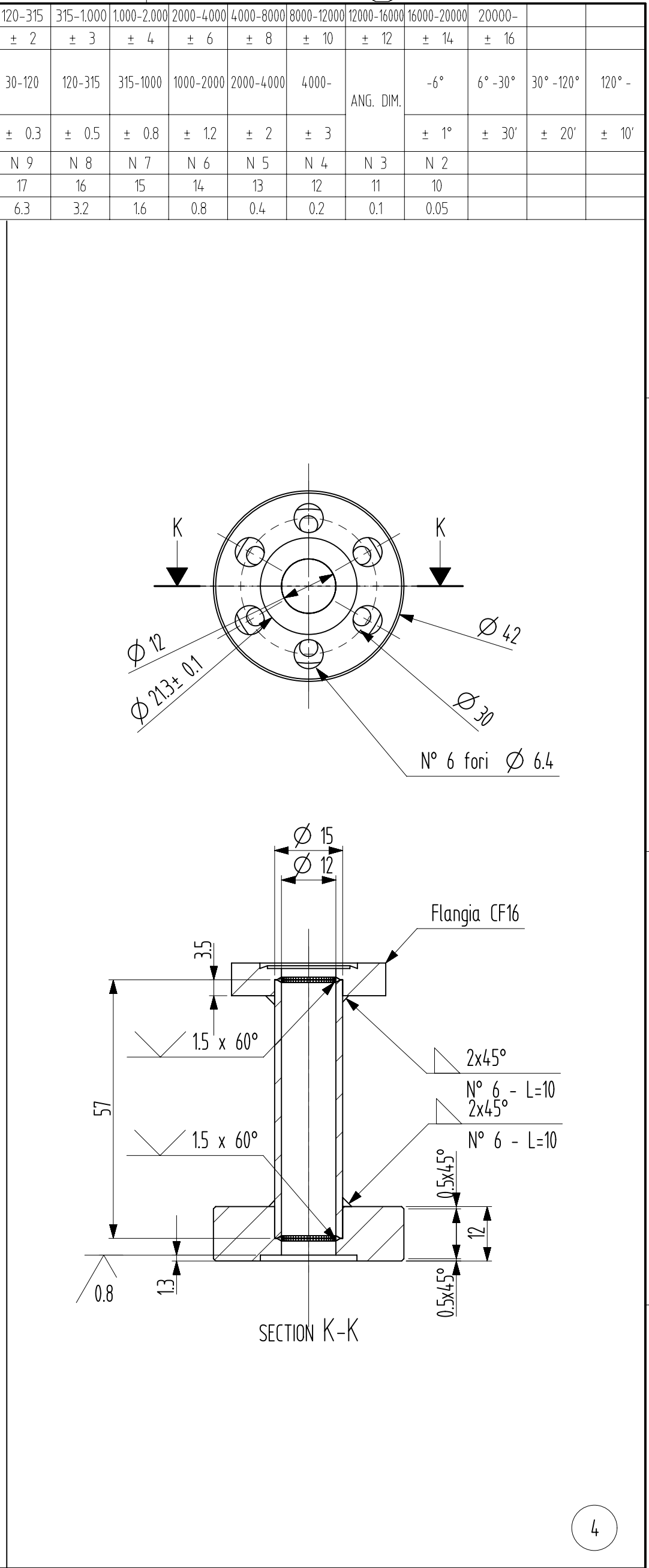
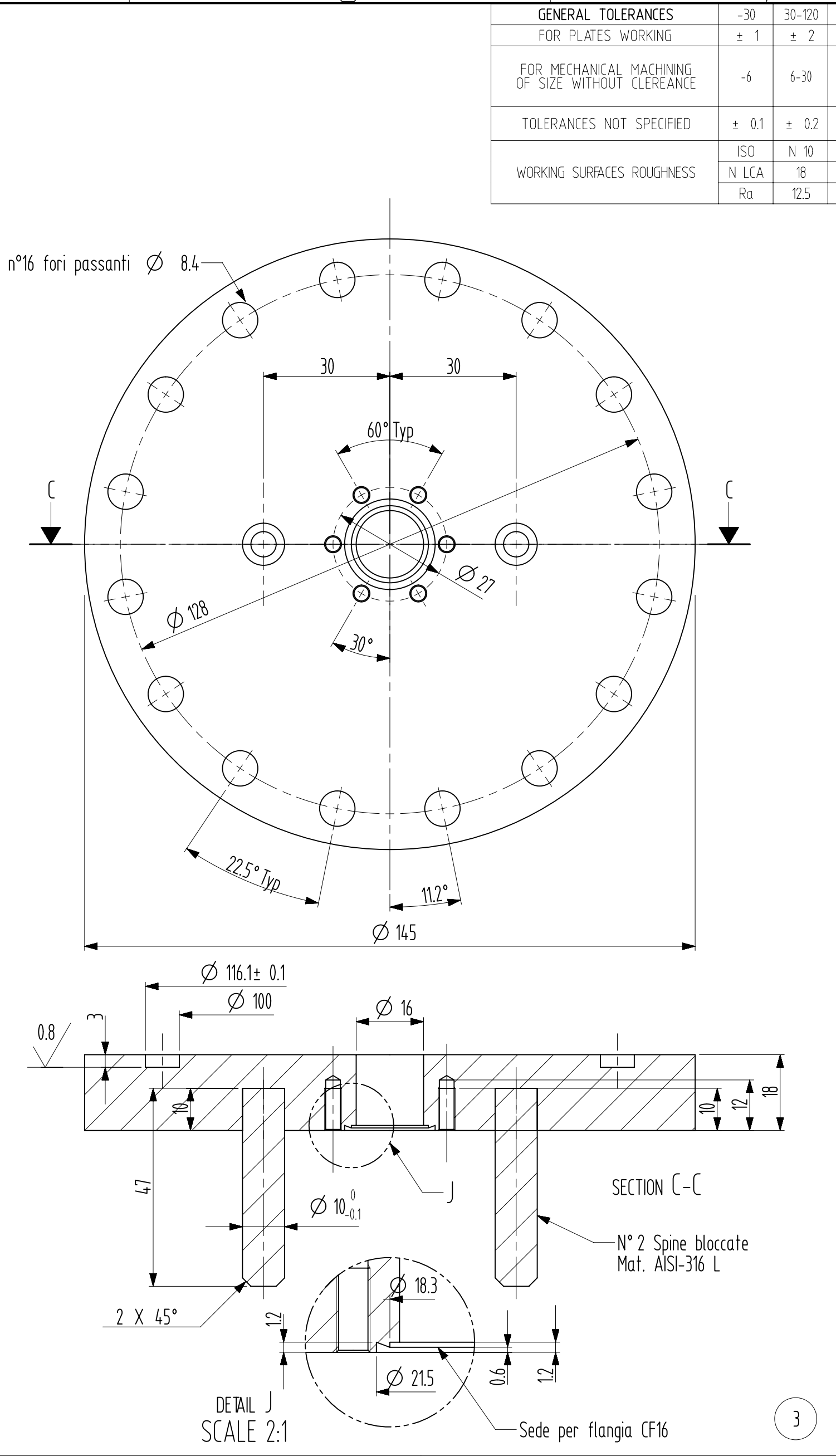
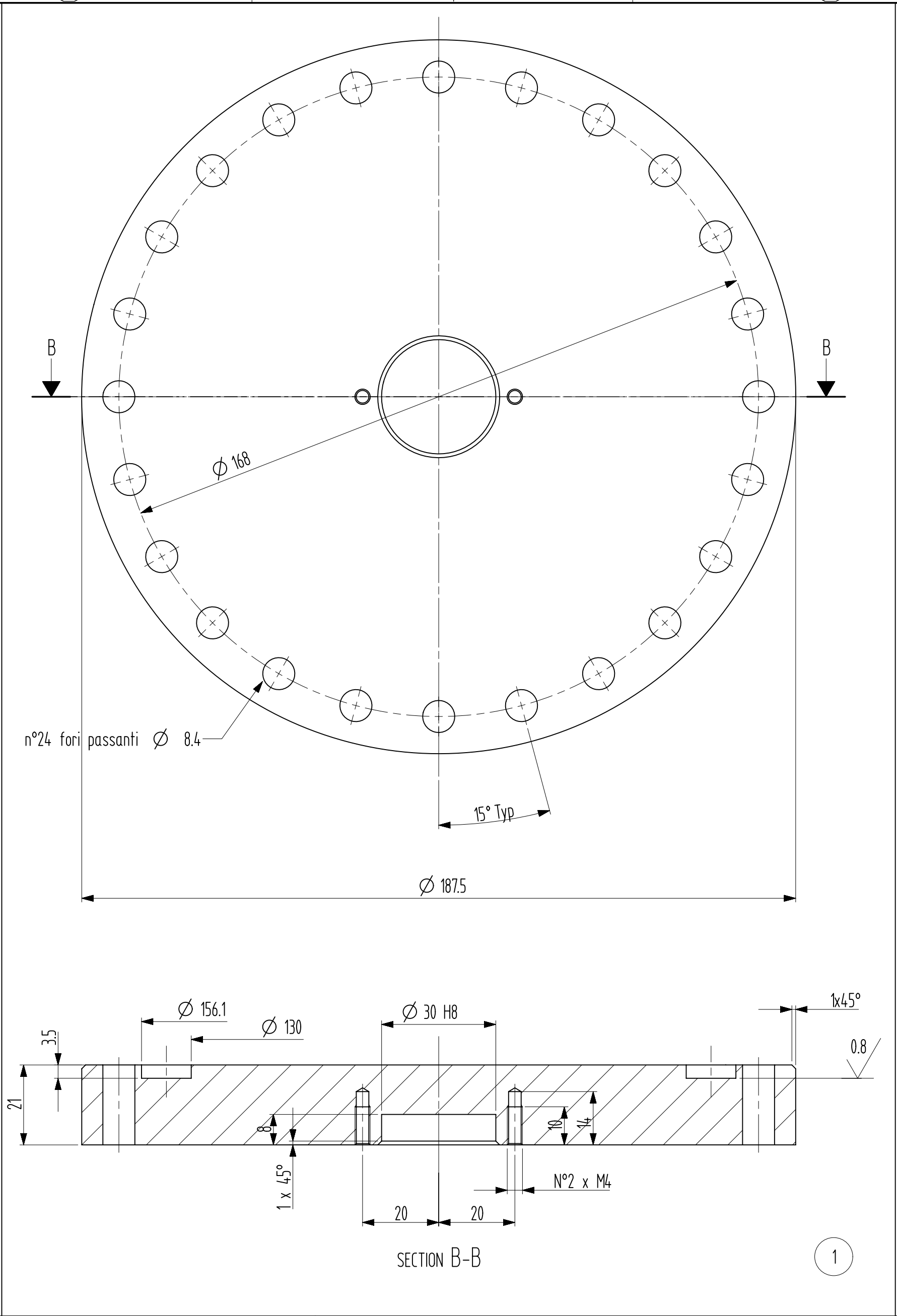
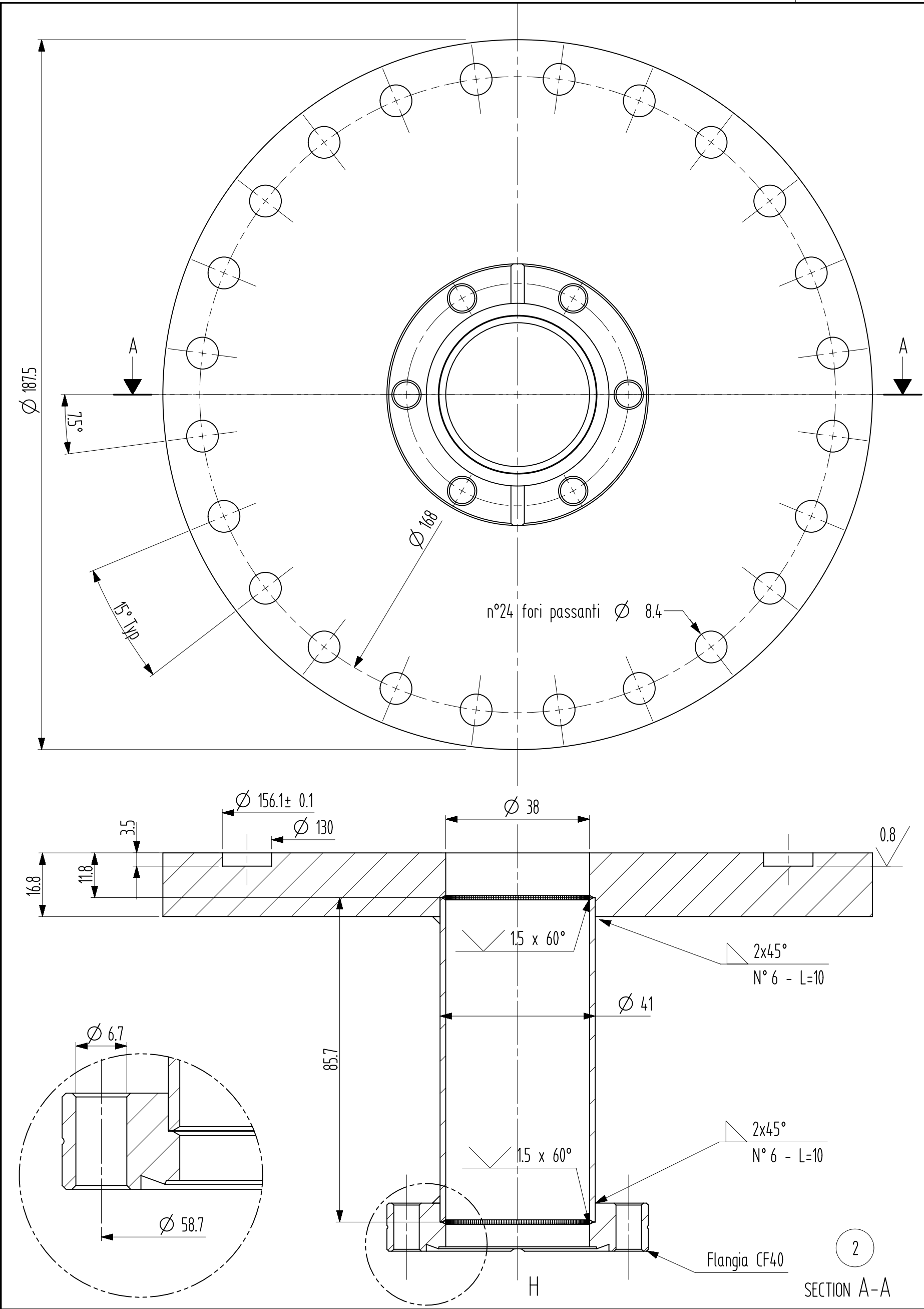
AUX-01.01-HOM-Gasket (N° 30 pezzi)

La fornitura deve essere consegnata con un gasket per ogni sacchetto

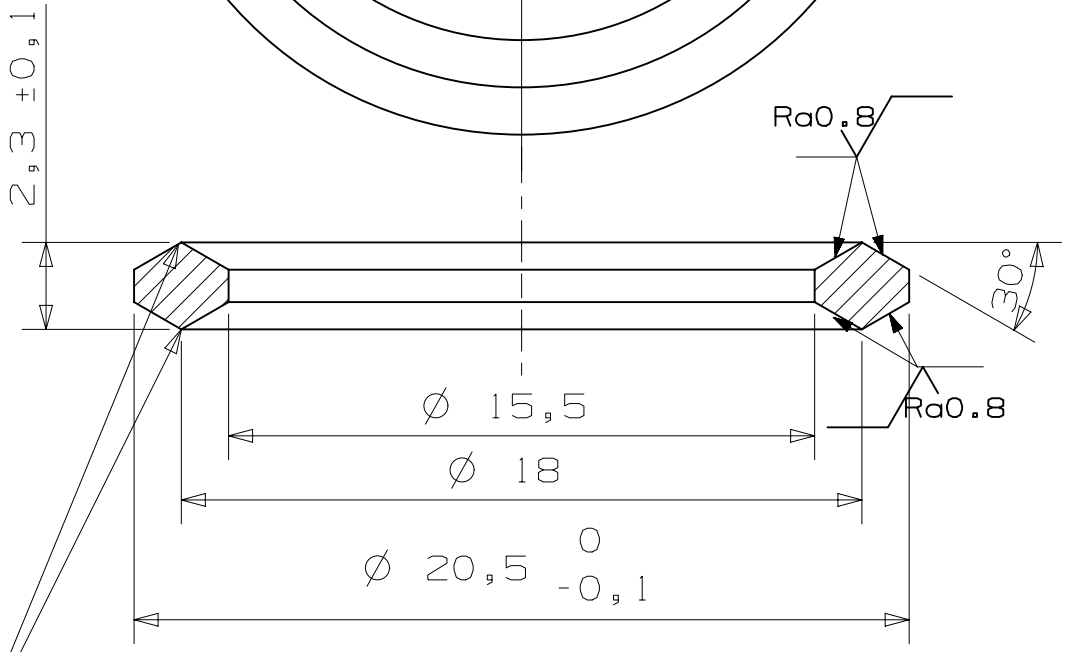
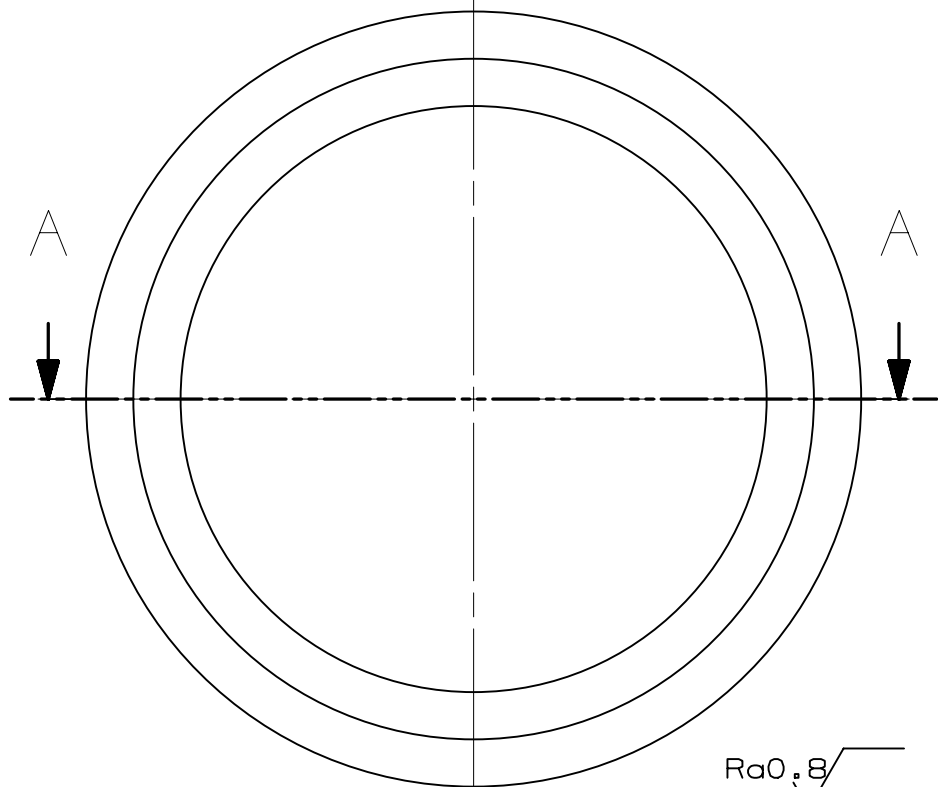
Non sovrapporre i pezzi

Descrizione:

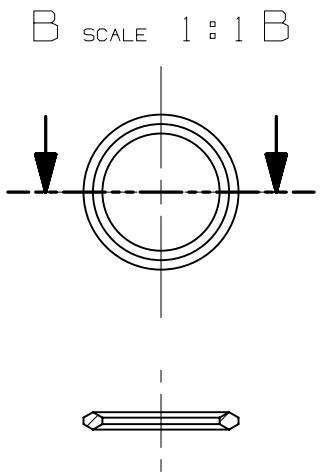
Gasket in alluminio a sezione esagonale



7	Gasket-Pickup	1	Al-Mg-Si-0.5-F-22 (AlMgSi0.5 F22)	Durezza Brinell 70HB 25/62.5	
6	Gasket-Coupler	1	Al-Mg-Si-0.5-F-22 (AlMgSi0.5 F22)	Durezza Brinell 70HB 25/62.5	
5	Gasket-BL	2	Al-Mg-Si-0.5-F-22 (AlMgSi0.5 F22)	Durezza Brinell 70HB 25/62.5	
4	Flangia-Aperta-Pickup	1	14429 ESU DIN 1088-3:2005 o 14435	DESY Vacuum 2/2008 Specs	
3	Flangia-chiusura-Coupler	1	14429 ESU DIN 1088-3:2005 o 14435	DESY Vacuum 2/2008 Specs	
2	Flangia-Aperta-BL	1	14429 ESU DIN 1088-3:2005 o 14435	DESY Vacuum 2/2008 Specs	
1	Flangia-Chiusa-BL	1	14429 ESU DIN 1088-3:2005 o 14435	DESY Vacuum 2/2008 Specs	
Pos.	Part Name	Qty	Material	Drawing Note	Weight
 INFN Milano - LASA via. Fratelli Cervi, 201 20090 Segrate (MI) Size: DWG: DWGFlangeGasket A1 ESS-AT-04.00.00 Drawn by: L.Sagliano Date: 04/05/2016 Checked by: Scale: 1 : 1 Object: Flange-Gasket-MedioBeta Approved by: P.Michelato Units: mm 3D part: File name: R:\Projects\ESS\ESS_Discendente-MB Revision: 1 Sheet 1 of 1					



SECTION A - A



SECTION B - B

Protect seal edges from damage.
Edges are to be sharp.

Parts are to be clean and degreased

$Ra1.6$

Note! Brinell 70HB 2.5/62.5

I	Gasket, small size	I	Al (AlMgSi0.5 F22)	Matl. Spec: 3.3206.71	I
Pos.	Part Name	Qty	Material	Note	Weight

 Istituto Nazionale di Fisica Nucleare	INFN Milano - LASA via Fratelli Cervi, 201 20090 Segrate (MI)	Size:	DWG:		Revision:
		A4	AUX-01.01		0
Experience: XFEL WP46		Original by:	DESY	Date:	3/2/2009
Object: HOM/PU Gasket		EDMS #:	4 02 1465 I A.001	Scale:	5 : 1
3D part: HOM-Gasket		Approved by:	P. Pierini	Units:	mm
		File name:	R:/Project/XFEL/3rd-harm/Flanges/Pickup-HOM		

Flangia-cavita-MB-BL-Inferiore

Si richiede la quotazione per la realizzazione delle parti di seguito descritte

Dis. N°

ESS-AT-04.00.01 (Pos. 1-2-3)

Descrizione:

Flangia con gomito flangiato CF-40 saldato

F

A

A

5

Piastra prolunga slitta per HPR

Si richiede la quotazione per la realizzazione delle parti di seguito descritte

Dis. N°

ESS-CB-01.00.00 (Complessivo)

ESS-CB-01.02.01 (Particolare)

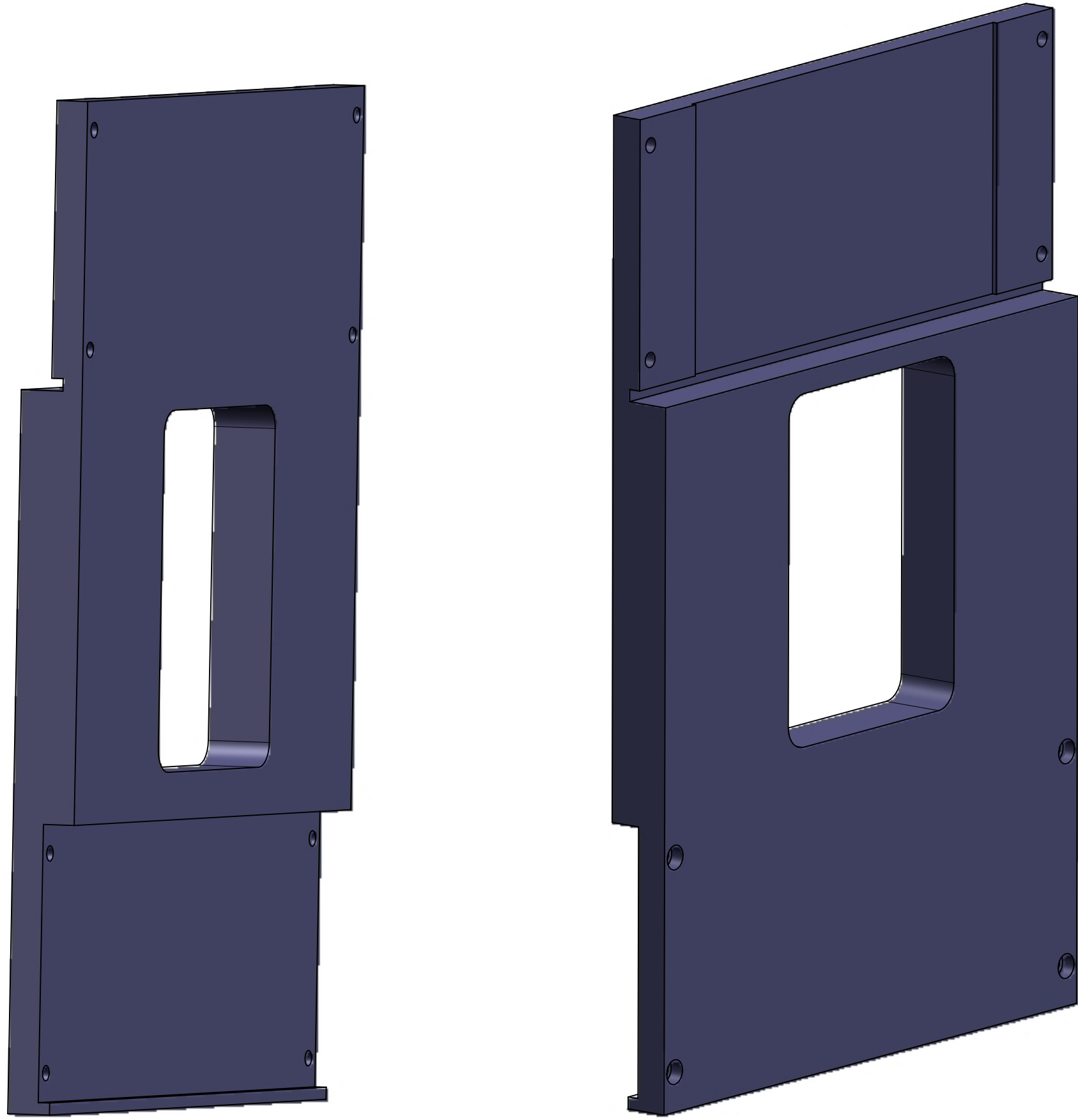
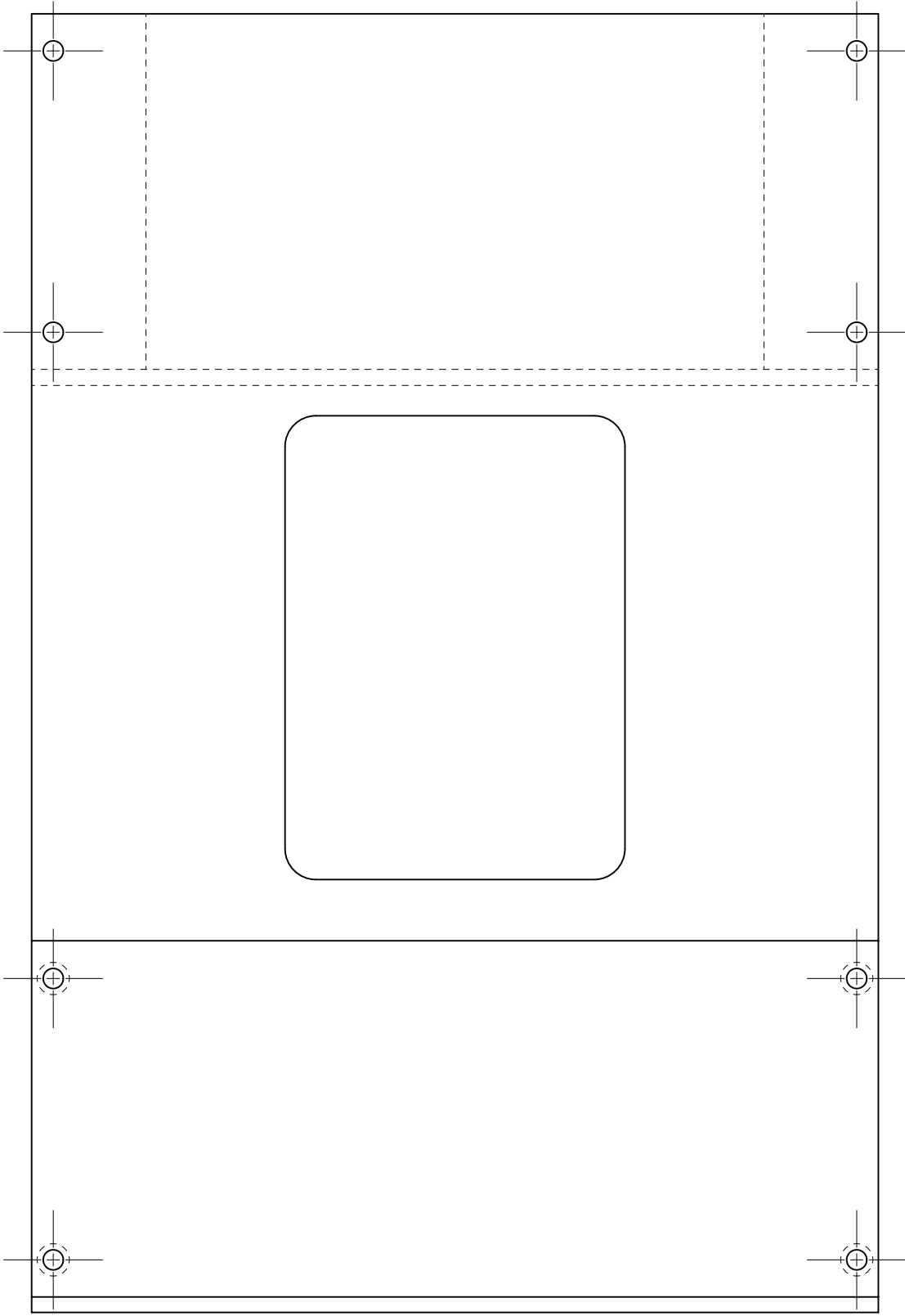
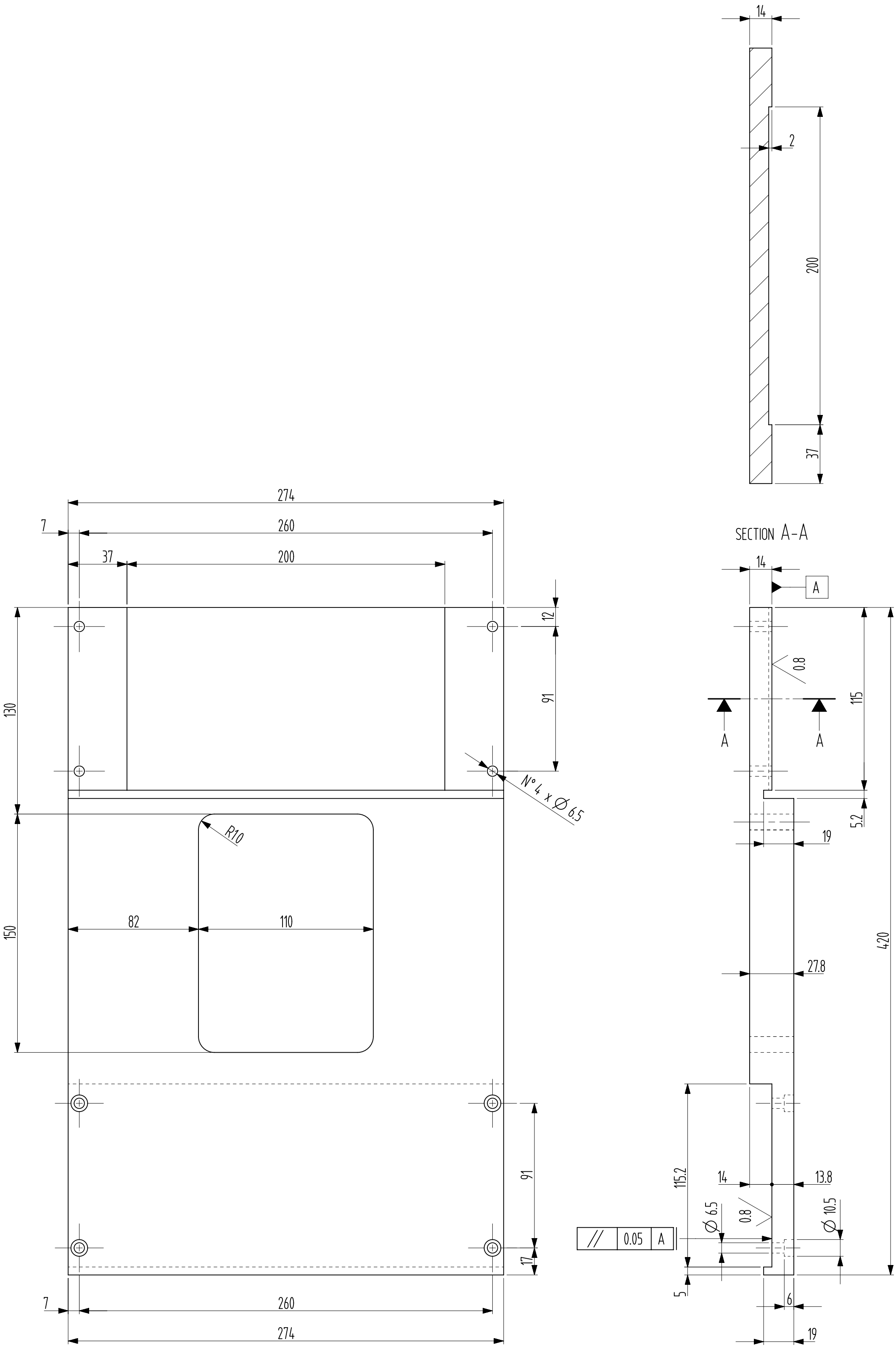
La fornitura deve comprendere anche le parti unificate indicate in tabella

Pos. 3-4-5 (viti, rondelle, dadi ecc.)

Descrizione:

Piastra in Anticorodal

GENERAL TOLERANCES	-30	30-120	120-315	315-1000	1000-2.000	2000-4.000	4.000-8.000	8.000-12.000	12.000-50.000	50.000-100.000	100.000-200.000	200.000-		
FOR PLATES WORKING	± 1	± 2	± 2	± 3	± 4	± 6	± 8	± 10	± 12	± 14	± 16			
FOR MECHANICAL MACHINING OF SIZE WITHOUT CLEREANCE	-6	6-30	30-120	120-315	315-1000	1000-2000	2000-4.000	4.000-	ANG. DIM.	-6°	6°-30°	30°-120°	120°-	
TOLERANCES NOT SPECIFIED	± 0.1	± 0.2	± 0.3	± 0.5	± 0.8	± 1.2	± 2	± 3		± 1°	± 30'	± 20'	± 10'	
WORKING SURFACES ROUGHNESS	ISO	N 10	N 9	N 8	N 7	N 6	N 5	N 4	N 3	N 2				
	N LCA	18	17	16	15	14	13	12	11	10				
	Ra	12.5	6.3	3.2	1.6	0.8	0.4	0.2	0.1	0.05				



1.6

Smussi non indicati 0.2x45°
Anodizzato nero

I Prolunga-slitta		I Anticorodal				
Pos.	Part Name	Qty	Material	Drawing	Note	Weight
	INFN Milano - LASA via Fratelli Cervi, 201 20090 Segrate (MI)	Size:	DWG: DWG-Prolunga-Slitta-vert			Revision:
		A1	ESS-CB-01.02.01			0
		Drawn by:	M. Bonezzi	Date:	2016/04/12	Sheet 1 of 1
		Checked by:		Scale:	1 : 2	
		Experience: ESS	Approved by: P. Michelato			Units: mm
Object: HPR-Prolunga-slitta		File name: R:\Project\HPR\Supporto-cannaMov-vert\DWG-Prolunga-slitta.prt				
3D part: Prolunga-Slitta-vert						

Piastra Sistema riscaldante

Si richiede la quotazione per la realizzazione delle parti di seguito descritte

Dis. N°

ESS-AT-02.03.01 (particolare)

Particolare a disegno

Descrizione:

Piastra in Anticorodal

