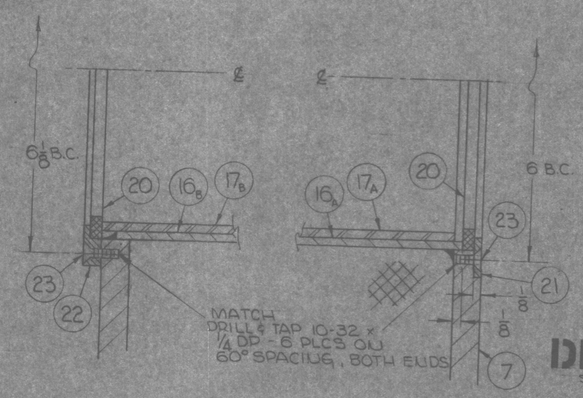
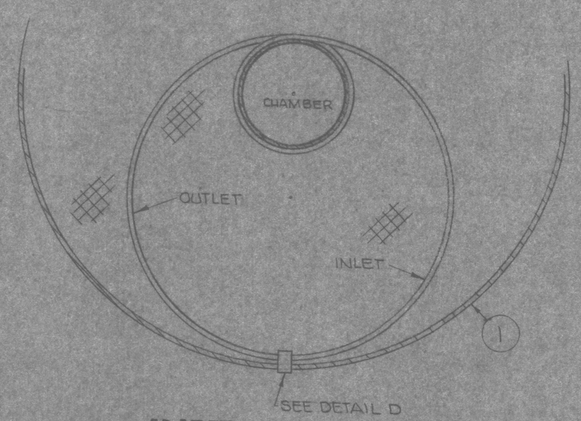
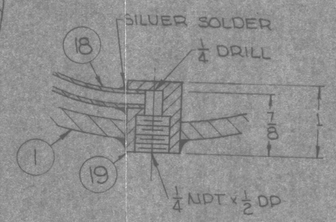


DETAIL A
SCALE: FULL

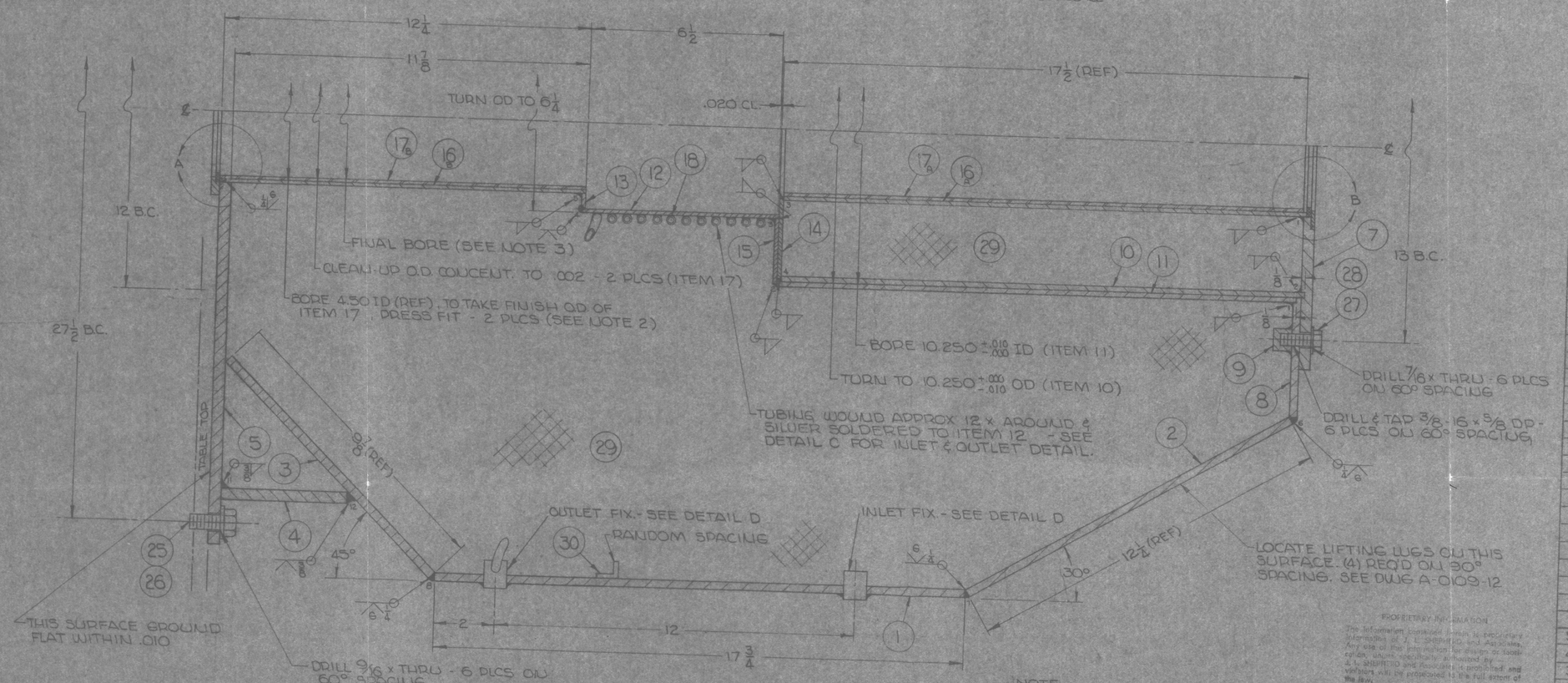
DETAIL B
SCALE: FULL



DETAIL C
DO NOT SCALE



DETAIL D
SCALE: FULL



ITEM	REQ'D	DESCRIPTION
30	12	3/4 x 3/8 x 1/8 STL CHANNEL x 1" LG
29	A/R	LEAD - 97% PURE, COM'L GRADE
28	6	3/64 THK STL WASHER x 1" OD x 7/16" ID
27	6	3/8-16 HEX HD MACH BOLT x 3/4" LG
26	6	7/64 THK STL WASHER x 13/8 OD x 9/16 ID
25	6	1/2-13 HEX HD MACH BOLT x 1" LG
23	12	10-32 FLT HD SCKT SCR x 1/4 LG
22	1	DWG A-0109-11
21	1	DWG A-0109-11
20	2	4 3/4 OD x 4.210 ID FELT WIPER
19	2	3/4 DIA STN STL ROD x 1" LG
18	A/R	1/4 OD x .035 W STD STL TUBE
17B	1	4 1/2 OD x 3 1/2 ID 'AMPCO' 18CC x 12 1/4 LG
17A	1	4 1/2 OD x 3 1/2 ID 'AMPCO' 18CC x 17 5/16 LG
16B	1	4 3/4 OD x 4 3/8 ID CS TUBE x 12 1/4 LG
16A	1	4 3/4 OD x 4 3/8 ID CS TUBE x 17 7/16 LG
15	1	1/4 THK STD STL PLT x 10 1/4 OD x 6 1/2 ID
14	1	1/4 THK STD STL PLT x 10 OD x 4 1/2 ID
13	1	3/16 THK STD STL PLT x 6.0 OD x 4 3/4 ID
12	1	6 1/2 OD x .25 W STD STL TUBE x 6 1/16 LG
11	1	10 1/2 OD x 10 ID CS TUBE x 17 5/16 LG
10	1	10 1/4 OD x 9 3/4 ID CS TUBE x 17 7/16 LG
9	6	3/4 DIA CS ROD x 5/8 LG
8	1	5/8 THK HR PLT x 18 OD x 10 1/4 ID
7	1	3/8 THK HR PLT x 15 OD x 4 3/4 ID
5	1	1/2 THK HR PLT x 29 OD x 4 7/8 ID
4	1	26 OD CS PIPE, 3/8 THK x 4 1/8 LG
3	1	1/4 THK HR PLT - ROLLED CONE
2	1	1/4 THK HR PLT - ROLLED CONE
1	1	1/4 THK HR PLT - ROLLED TO 31" OD

NOTE
1. ALL HELIARC WELD CONSTR. WELD JOINTS NUMBERED FOR ASSY SEQUENCE. REF DWG A-0109-50
2. ITEMS 17A 17B 16A 16B MUST BE ASSY, BORED ALIGNED ETC. ON COMMON CENTERLINE.
3. FINAL BORE OF ITEM 17A & 17B (4.250 REF) TO PROVIDE .020-.030 CL (TOTAL DIA) WITH FINISHED OD OF DRAWER ASSY - DWG A-0109-20

4. THIS ASSY ATTACHED TO TABLE ASSY - DWG A-0109-30
5. ALL STL SURFACES TO BE SANDBLAST & PRIMERED WITH ZINC CHROMATE. FINAL FINISH REF DWG A-0109-50

6. ITEM 5 & 8 PARALLEL TO 1/32
7. CENTERLINE WITHIN .004 OVERALL LG
8. DIM TOL ± 1/32 U.O.S.
9. ITEM 23, 25, 26, 27 & 28 TO BE PLATED OR STN STL.

PROPRIETARY INFORMATION
The information contained herein is proprietary information of J. L. SHEPHERD and Associates. Any use of this information for design or construction unless specifically authorized by J. L. SHEPHERD and Associates is prohibited and violators will be prosecuted to it's full extent of the law.

J. L. SHEPHERD and Associates

SCALE: HALF	APPROVED BY:
DATE: 3 FEB 70	DRAWN BY: DMH
	REVISED:

MODEL 109 IRRADIATOR

SHIELD - DETAIL

DRAWING NUMBER A-0109-10