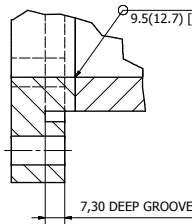
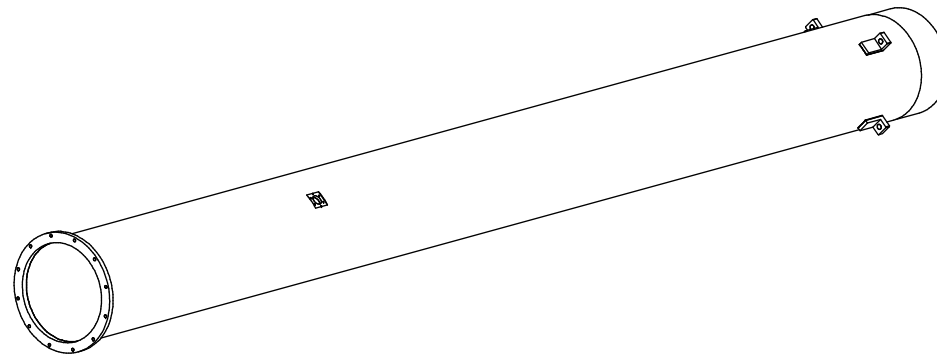


K (1:1)



CHAMFERS ON BOTH PIECES  
GMAW  
60 DEGREE V GROOVE WELD  
CONTINUOUS WELDING IF POSSIBLE  
REMOVE OIL, DIRT AND OXIDE BEFORE WELDING.



#### Notes:

1. See drawing No. MROI-086. 4 Places. Location of brackets is not critical, but shall be within  $\pm 1$ mm in location (longitudinally and circumferentially) and  $\pm 0.2^\circ$  in perpendicularity of the face of the bracket to the normal axis of the pipe (See note 3). Mounting jig will be supplied by NMT.
2. Ends to be machined or ground using some appropriate process for removing scratches and burrs with no longitudinal effects. The chamfers of the inner edges at both pipe ends should not be larger than  $0.25 \times 45^\circ$ .
3. The nominal axis is defined by a line joining the centre of each end of pipe.

	Material: BS1470 6061	Tolerances: x ± 1.0; xx ± 0.15; xxx ± 0.05	Drawn by: X.S	Date: 26/12/07	Quantity: 1 off	Dwg. No. MROI-084-03
	University of Cambridge, Department of Physics CAVENDISH LABORATORY	Project: MROI	Title: Pipe Section 3	Scale: 1:4	Size: A1	