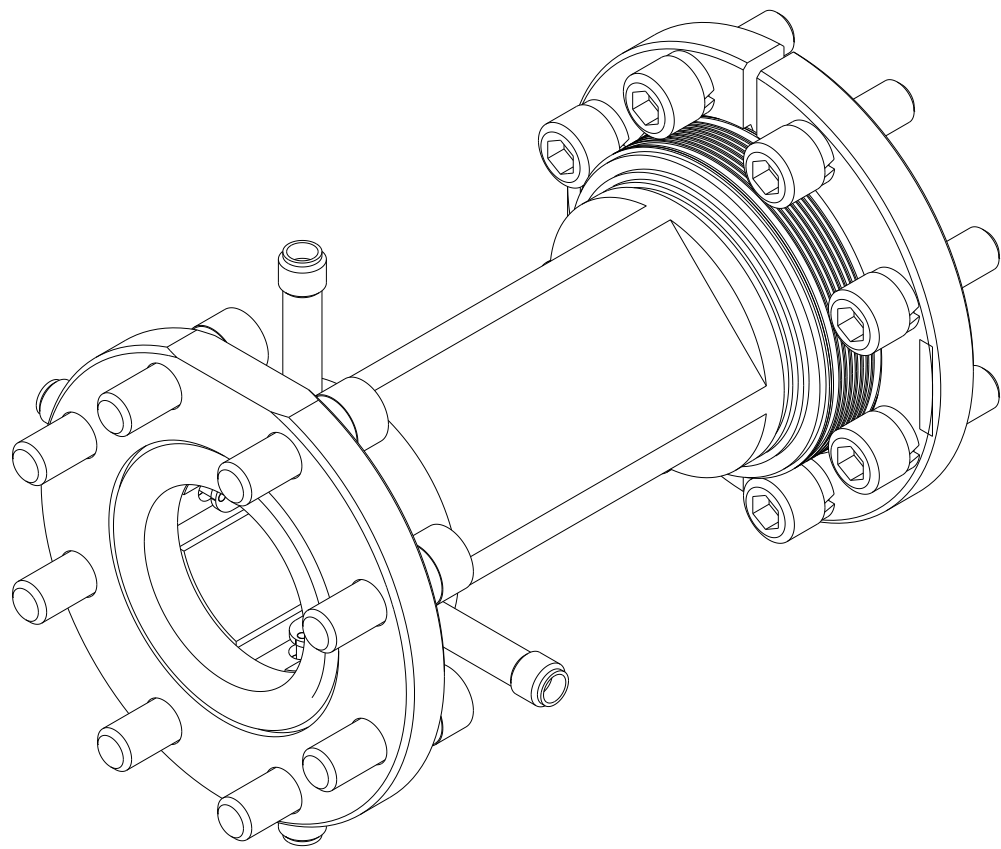
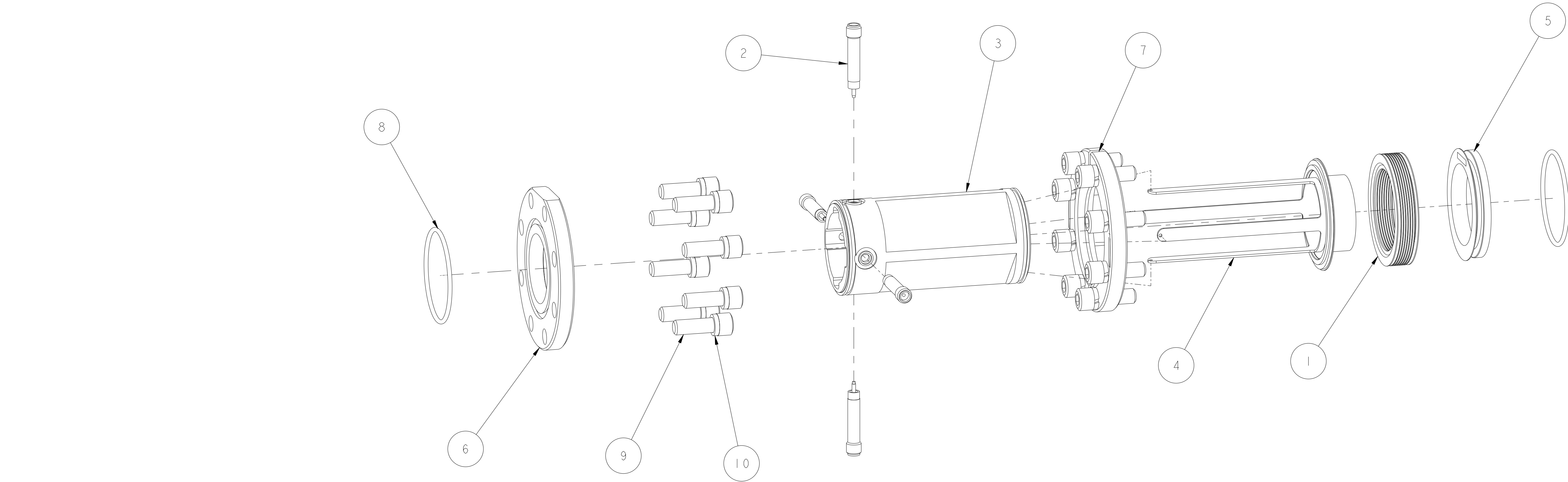


NOTES

1. FINISHED PART TO BE VACUUM TIGHT. LEAK RATE NOT TO EXCEED 1×10^{-8} torr l/sec. He.
ALL WELDS ARE TO BE MINIMUM HEAT FUSION WELDS. ASSEMBLE AS FOLLOWS:
- 1.1. ALIGN BORE TUBE (25B173) WITH ELECTRODE SPOOL (25B174) USING ASSEMBLY TOOL 25B676-1.
SECURE WITH TOOL 25B626-2, AND WELD.
 - 1.2. MOUNT HEAT SINK 25B676-3 TO SMA FEED THRU (25B171), ASSEMBLE TO SUB-ASSEMBLY OF 1.1, (ABOVE).
SECURE WITH TOOL 25B676-4 AND WELD, 4 PLACES. DO NOT OVERHEAT FEED THRU.
 - 1.3. LEAK CHECK ASSEMBLY AND REPAIR IF REQUIRED.
 - 1.4. SPOT WELD PER LBNL ENGINEERING NOTE FE-ME-042. LEAK CHECK ASSEMBLY.
 - 1.5. ALIGN SUB-ASSEMBLY OF 1.4 (ABOVE) WITH FIXED FLANGE (25B176). SECURE WITH TOOL 25B676-2 AND WELD.
 - 1.6. USE AEROSEAL CLAMP OR EQUAL TO ALIGN SEAL FLANGE (25B175) WITH BELLWS (25B170). WELD.
 - 1.7. ALIGN SUB-ASSEMBLY OF 1.5 (ABOVE) WITH SUB-ASSEMBLY OF 1.6 (ABOVE) AS DESCRIBED IN 1.6. WELD.
 - 1.8. LEAK CHECK.
2. ASSEMBLE IN CLEAN ENVIRONMENT. AFTER ASSEMBLY, WRAP TO MAINTAIN CLEANLINESS.



10	-	16	LOCK WASHER, SPRING, HIGH COLLAR, .25"	SS 18-8
9		16	SCR, SCH, .25-28 UNF X .75 LG	SS 18-8
8		2	2-029 O-RING SEAL	VITON
7	25B177	1	30 MM BP/ BPM SPLIT FLANGE	SS 304L
6	25B176	1	30 MM BPM FIXED FLANGE	316 STAINLESS STEEL
5	25B175	1	30 MM BPM/BP BELLWS SEAL FLANGE	316 STAINLESS STEEL
4	25B174	1	30 MM BPM ELECTRODE SPOOL	316 STAINLESS STEEL
3	25B173	1	30 MM BPM BORE TUBE	316 STAINLESS STEEL
2	25B171	4	BPM SMA FEED THRU	-
1	25B170	1	30 MM BPM BELLWS	347 STAINLESS STEEL
ITEM	PART NO	REQD	DESCRIPTION	MATERIAL

F	PL	DPO	2/10/02	ADDED NOTES 1.1-1.8. 1/4-28 SCREWS WERE 1/4-20. 1/4" HI-COLLAR WASHERS WERE FLAT, NARROW. B/M ITEMS RENUMBERED.	UNLESS OTHERWISE SPECIFIED PROJECTION:	ACCT NO. - REQD NO. - DATE ISSD - DATE RECD -	SER NO. - DATE - ISSD - DATE RECD -	ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY UNIVERSITY OF CALIFORNIA - BERKELEY		SMS-FES MEBT MECHANICAL SUBSYSTEMS 30 MM BEAM POSITION MONITOR	DO NOT SCALE PRINTS
E			9/26/01	UPDATED ASSEMBLY MODEL	TOLERANCES X.X ± 0.1 X.XX ± 0.03 X.XXX ± 0.010	FRAC. ± 1/64 Angles ± 0.5° FINISH 125/	SURFACE TREATMT SEE NOTES (PAGE 2)				
D			11/20/00	UPDATED ASSEMBLY MODEL	DO NOT SCALE PRINT	THREADS ARE CLASS 2	IDENT METHOD TAG				
C		D7	8/18/00	ADDED PERPENDICULARITY TOLERANCE	CUT ROUNDED ENDS OF ALL SCREW TREADS 30°	CHAMFER ENDS OF ALL SCREW TREADS 30°	PROJECT NUMBER				
B		B1-5	1/27/00	ADDED WELD SIZES TO SYMBOLS	CUT ROUNDED ENDS OF ALL SCREW TREADS 30°	CHAMFER ENDS OF ALL SCREW TREADS 30°	PROJECT NAME				
B			1/27/00	CHANGED ORIENTATION OF EXPLODED VIEW	BREAK EDGES .016 MAX. ON MACHINED WORK	REMOVE BURRS, WELD SPLATTER & LOOSE SCALE	DWG BY TREVOR GOULDING	DATE 17-Dec-99			
B			1/27/00	ADDED NOTE & UPDATED TITLE BLOCK	IN ACCORDANCE WITH ASME Y14.5M & B46.1		CHK BY	DATE 12-Jan-00	PATENT CLEAR:		
REV	DWG	CHK	ZONE	DATE	CHANGES		APR BY	DATE -	DESIGN ACCT. NO.	FE3313	

