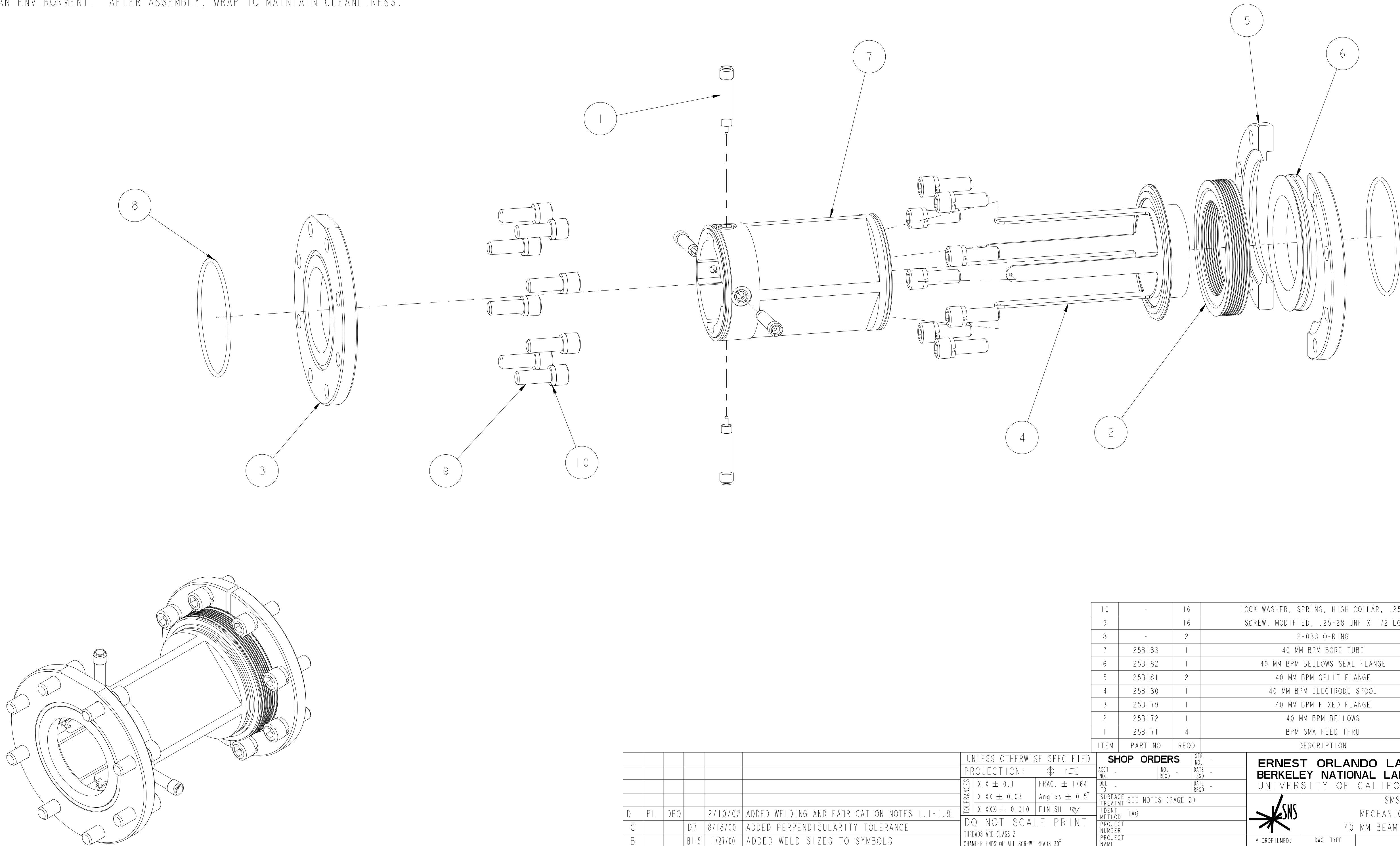


NOTES

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 (25B183) WITH ELECTRODE SPOOL (25B180) 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 TOOLS 25B676-4 AND 25B676-5. 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 (25B179). SECURE WITH TOOL 25B676-2 AND WELD.
 - 1.6. USE AEROSEAL CLAMP OR EQUAL TO ALIGN SEAL FLANGE (25B182) WITH BELLOWS (25B172). 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	SCREW, MODIFIED, .25-28 UNF X .72 LG	SS 18-8
8	-	2	2-033 O-RING	VITON
7	25B183	1	40 MM BPM BORE TUBE	316 STAINLESS STEEL
6	25B182	1	40 MM BPM BELLOWS SEAL FLANGE	316 STAINLESS STEEL
5	25B181	2	40 MM BPM SPLIT FLANGE	316 STAINLESS STEEL
4	25B180	1	40 MM BPM ELECTRODE SPOOL	316 STAINLESS STEEL
3	25B179	1	40 MM BPM FIXED FLANGE	316 STAINLESS STEEL
2	25B172	1	40 MM BPM BELLOWS	347 STAINLESS STEEL
1	25B171	4	BPM SMA FEED THRU	-
ITEM	PART NO	REQD	DESCRIPTION	MATERIAL

					UNLESS OTHERWISE SPECIFIED		SHOP ORDERS		SER NO. -		ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY UNIVERSITY OF CALIFORNIA - BERKELEY  SMS-FES MEBT MECHANICAL SUBSYSTEMS 40 MM BEAM POSITION MONITOR			
					PROJECTION: 		ACCT NO. -		NO. -					
					TOLERANCES		DEL TO -		DATE -					
					X.X ± 0.1		FRAC. ± 1/64		SEE NOTES (PAGE 2)					
					X.XX ± 0.03		Angles ± 0.5°		SURFACE TREATMT		DO NOT SCALE PRINTS			
					X.XXX ± 0.010		FINISH 125/		IDENT METHOD TAG		SCALE: 1/1			
					DO NOT SCALE PRINT		PROJECT NUMBER		PROJECT NAME		MICROFILMED:			
							DWG BY TREVOR GOULDING		DATE 11-Jan-00		DWG. TYPE ASSEM			
							CHK BY		DATE		SHOWN ON			
							APR BY		DATE -		CATEGORY CODE FE3313			
					IN ACCORDANCE WITH ASME Y14.5M & B46.1		PATENT CLEAR:		DESIGN ACCT. NO.		DWG. NO. 25B1844			
											SIZE D			
REV	DWG	CHK	ZONE	DATE	CHANGES									

