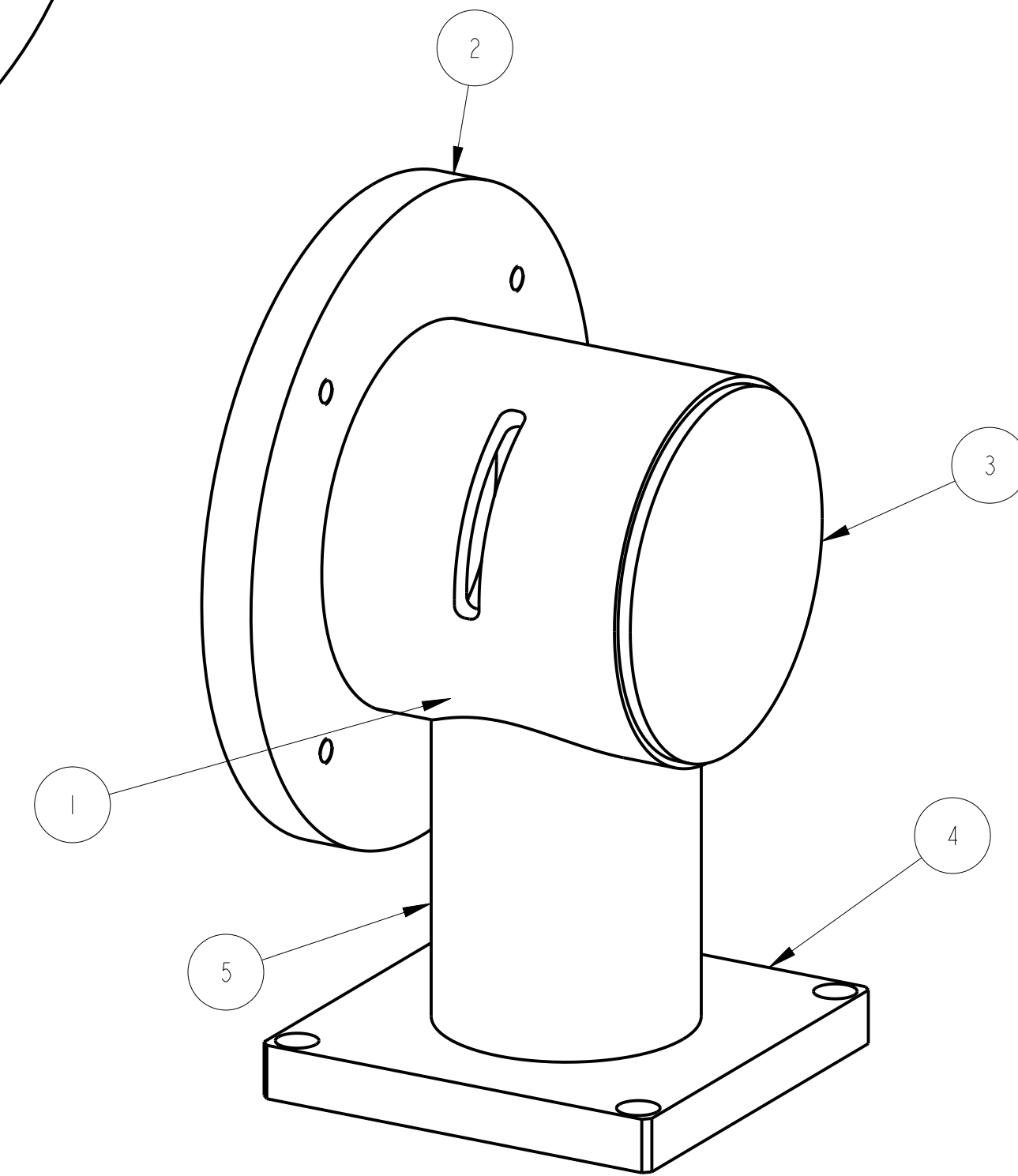
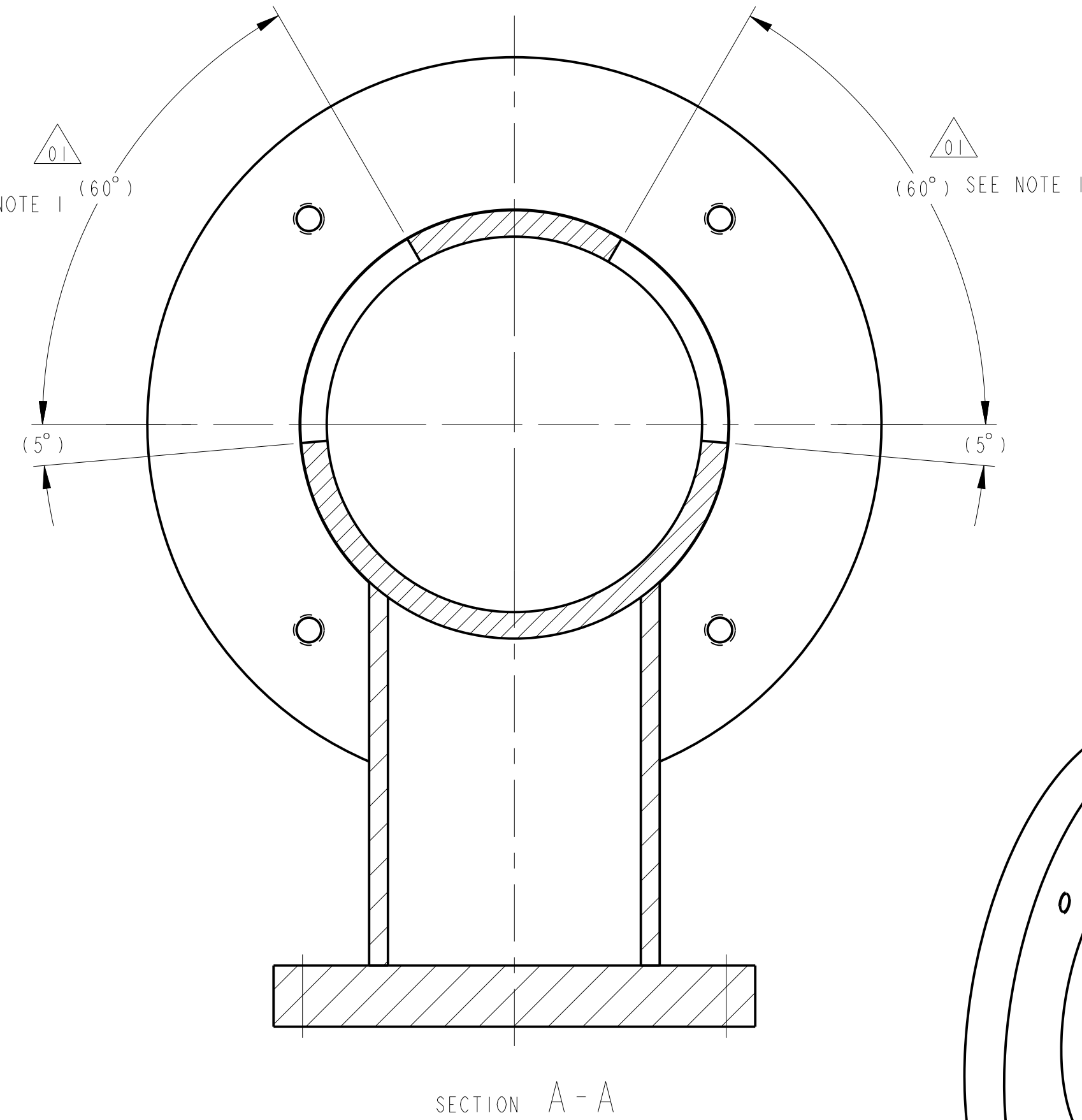
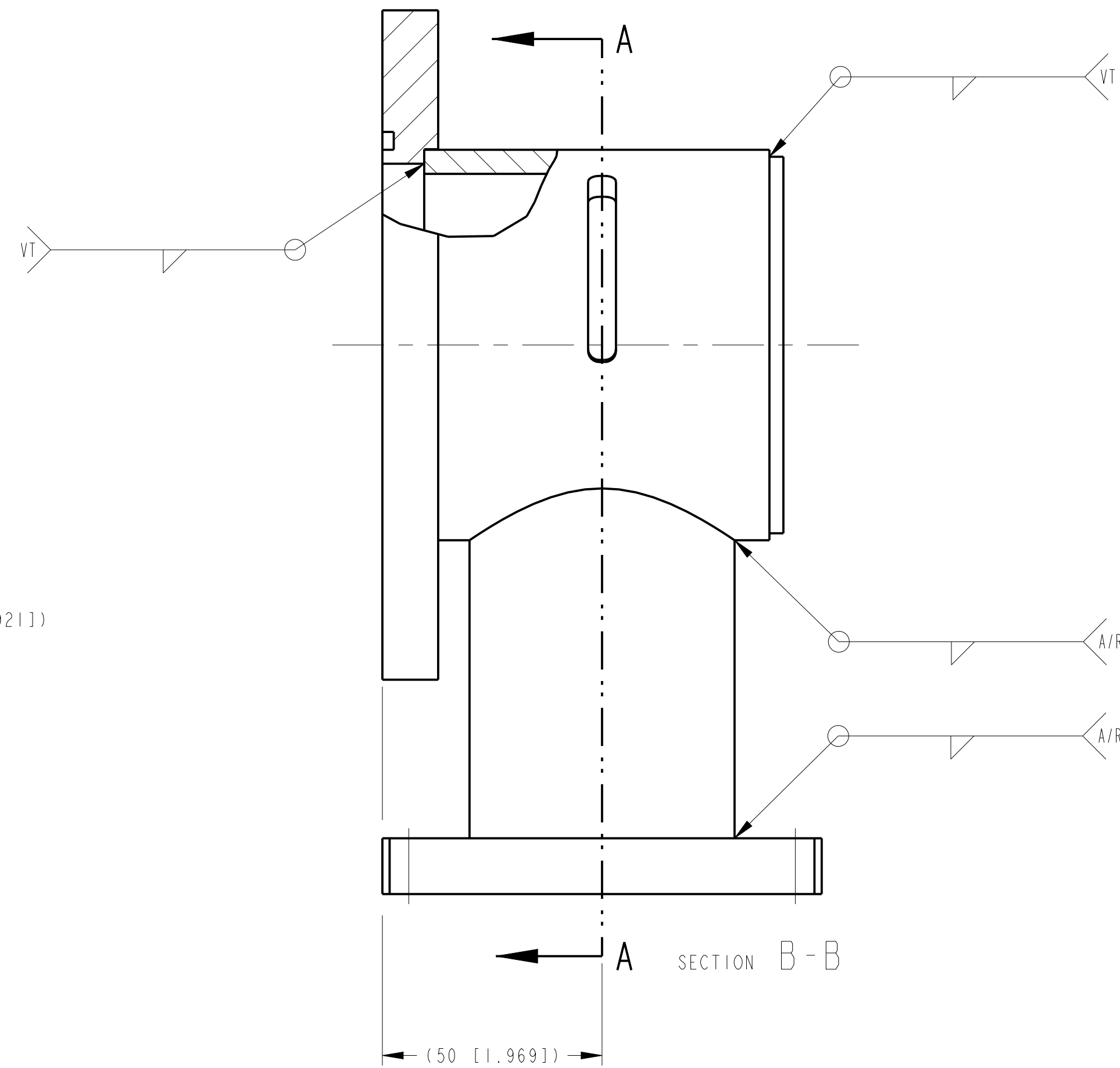
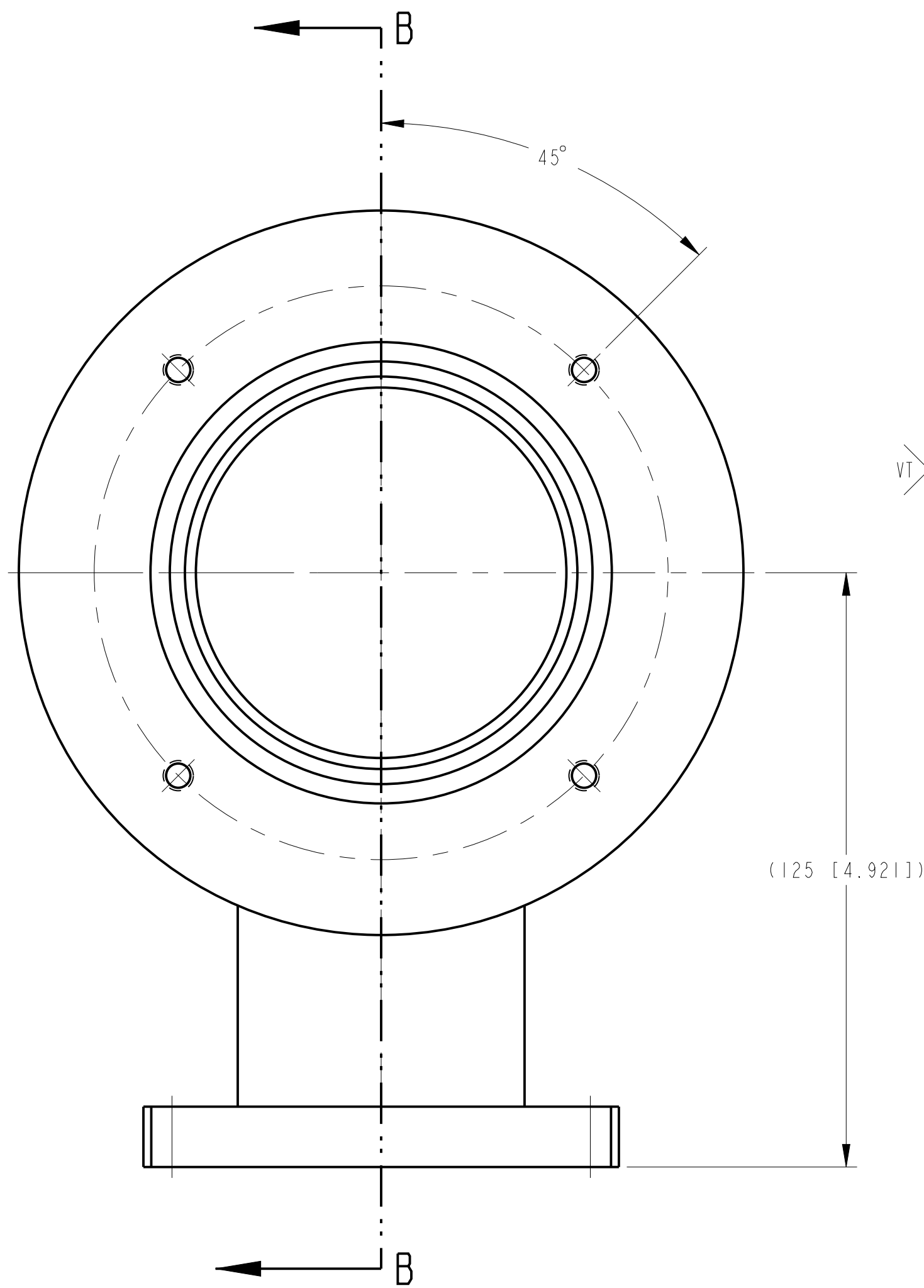


REVISIONS						
ZONE	REV	DESCRIPTION	BY	APPROVED	DATE	
	01	DCN NO. 170118-15	PNP	BMR	01/19/17	



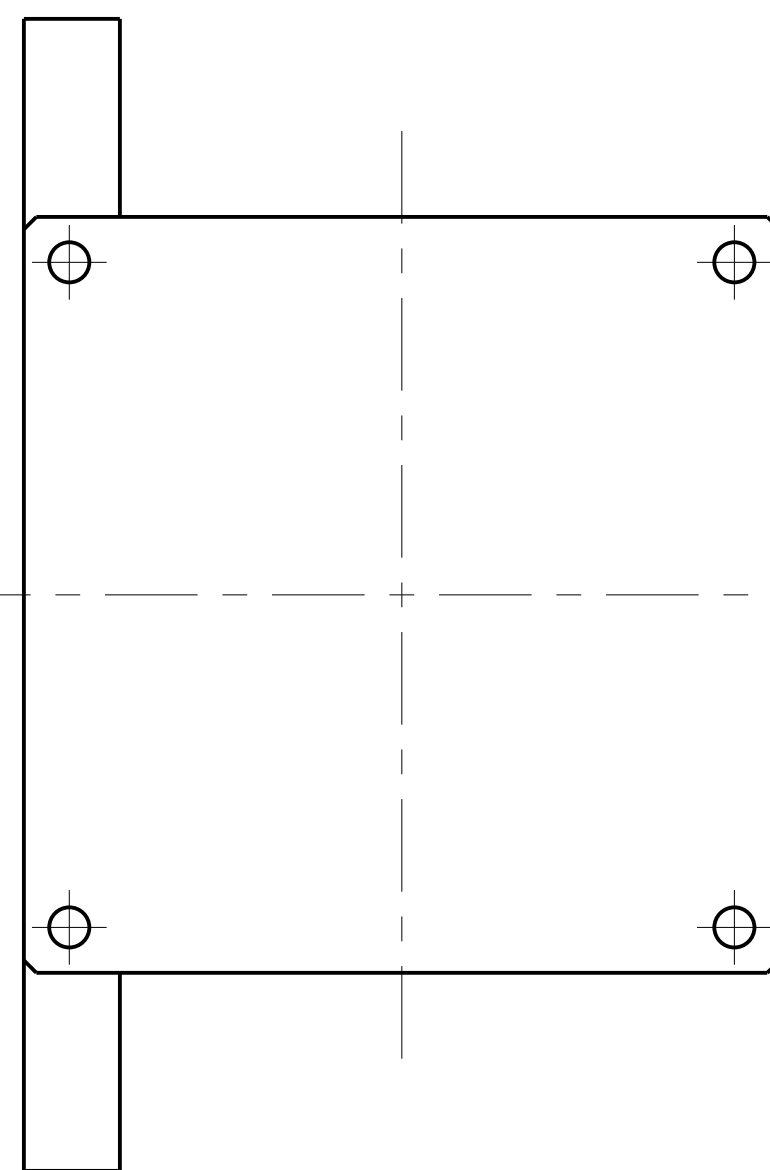
SCALE 3:4

- NOTES:
1. REVISION #01 PROVIDES INFORMATION ON HOW TO MODIFY AN EXISTING WELDMENT. ITEM 1 WAS REVISED TO SHOWS HOW THE COMPONENT WOULD BE MACHINED IF IT WAS BEING FABRICATED INITIALLY, BUT THAT COMPONENT IS ALREADY PART OF AN EXISTING WELDMENT AND WILL BE MODIFIED IN-SITU.
 2. 2 X 0.25 WIDE SLOTS WERE CHANGED TO 60° (OVERALL 65°) WAS 40°.
 3. MACHINING NOTE WAS REVISED TO REFLECT THAT CARE SHOULD BE TAKEN TO KEEP COMPONENT CONTAMINATION FREE, BUT THIS WELDMENT WILL NOT BE USED IN UHV. IT IS A ROUGH VACUUM WELDMENT.

MACHINING:
THIS WELDMENT IS INTENDED FOR ROUGH VACUUM SERVICE. TO MINIMIZE CONTAMINANTS THE USE OF SILICON, SULFUR, PHOSPHORUS, OR HALOGEN BASED FLUIDS IS PROHIBITED. USE TRIMSOL OF APPROVED EQUIVALENT.

WELDING:
ALL WELD ARE GAS TUNGSTEN ARC WELDS (GTAW), FOR COMPLETE WELDING SPECIFICATIONS, SEE DOCUMENT NO. AMS 2865D. PARTS SHOULD BE CLEANED USING UHV CLEANING PRACTICES PRIOR TO WELDING. WELDMENT IS NOT UHV ASSEMBLY, IT ONLY OPERATES IN ROUGH VACUUM.

TESTING:
THIS WELDMENT HAS TWO WINDOW OPENINGS THAT WILL BE COVERED WITH KAPTON. WELDMENT SHOULD BE LEAK CHECKED TO VERIFY THAT IT CAN ACHIEVE ROUGH VACUUM.



THIS IS A SKETCH PRINT FOR QUOTATION PURPOSES ONLY
DO NOT TOOL
REVISIONS TO THIS UNISSUED DRAWING WITH THE SK DENOTED WILL BE A LETTER REVISION, I.E. A, B, ETC. WHEN ISSUED FOR TOOLING THE SK WILL BE REMOVED AND THE DRAWING WILL BE ISSUED AT REV. 00

ITEM	DRAWING / PART NUMBER	REV	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC.	QTY
5	430802-100005	00	SUPPORT TUBE	ALUMINUM	1
4	430802-100004	00	SUPPORT BASE	ALUMINUM	1
3	430802-100003	00	END CAP	ALUMINUM	1
2	430802-100002	00	FLANGE	ALUMINUM	1
1	430802-100001	01	CHAMBER TUBE	ALUMINUM	1

PARTS LIST / BILL OF MATERIALS					
DRAPER:	O. SCHMIDT	DATE:	20-Jan-17	THIS DRAWING IS THE PROPERTY OF	
CHECKER:		DATE:		ADVANCED PHOTON SOURCE	
DESIGNER:		DATE:	20-Jan-17	EXPERIMENTAL FACILITIES	
RESPONSIBLE ENGINEER:	O. SCHMIDT	DATE:		BEAMLINE ID	
GROUP LEADER/PROJECT LEADER/CAN:	A. SANDY	DATE:		SECTOR 8 ID	
APPROVER:	B. RUSTHOVEN	DATE:		INSTRUMENTATION	
RELEASE LEVEL:	WIP	MODEL VER:	2	DRW VER:	2
MATERIAL:	ALUMINUM	SIZE:	D	DRAWING NUMBER:	430802-100010
		SCALE:	1:1	REV:	01