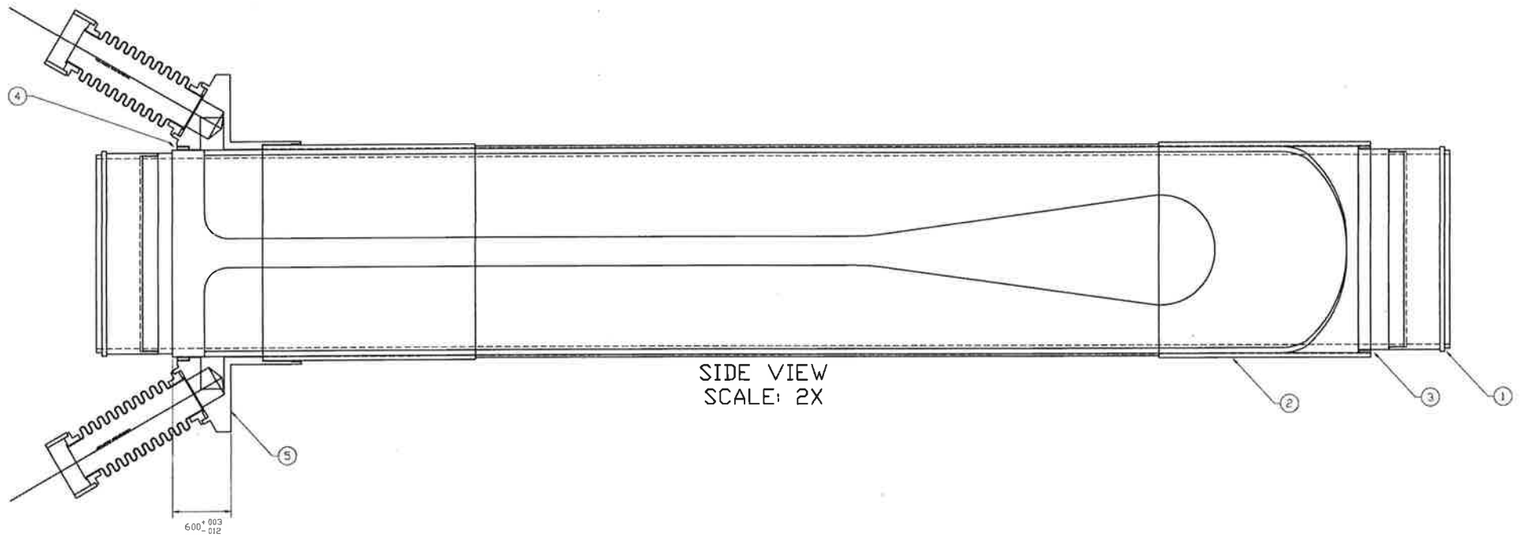
PROJECTION

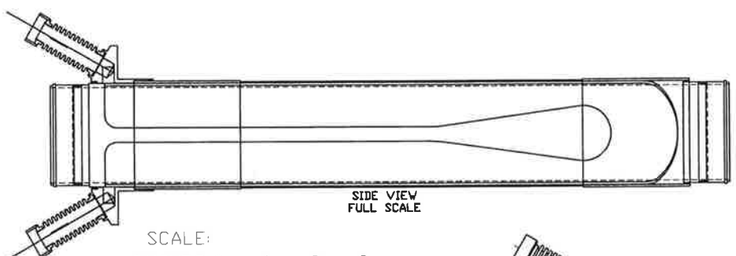
REV	DESCRIPTION	DRN	CHK	APP	DATE
1	REVISED PER VENDOR INPUT	KSVII	[illegible]	[illegible]	[illegible]

SA-343-410-01 A1

NOTES
1 ASSEMBLE AND CHECK FIT OF ALL COMPONENTS
  INSPECT PAINT
2 SLIDE CLEAN COMPONENTS ON TO BEAM PIPE AND CAP ENDS
  MOUNT BRAZEMENT IN A FIXTURE TO ASSURE CORRECT ROTATIONAL ORIENTATION
  USE AN ALUMINUM TEMPLATE AND A SQUARE TO OBTAIN CORRECT ROTATIONAL AND LONGITUDINAL ALIGNMENT OF THE MANIFOLD
  (THE FLATS ON THE MANIFOLD AND THE SIDE RIBS ON THE BRAZEMENT SHOULD BE ALIGNED TO WITHIN 0.7°)
  APPLY SLAC APPROVED EPOXY NEAR ENDS OF WATER JACKET.
  SLIDE WATER SHELL BACK AND FORTH OVER GLUE (±.25")
  APPLY GLUE TO OUTSIDE OF WATER JACKET NEAR MANIFOLD AND SLIDE MANIFOLD ON.
  APPLY GLUE TO EACH GLUE RING AND SLIDE INTO POSITION
  CURE EPOXY (ELEVATED TEMP)
3 FLOW BR154 THROUGH WATER CHANNELS
  BAKE BR154 TO CURE
  IF THE PAINT SAMPLES SHOW THAT THE FLOWED PAINT IS LESS THAN .0004" THICK, A SECOND FLOW THROUGH AND BAKE MAY BE REQUIRED
4 PAINT AND ADHESIVE MUST NOT BLOCK PASSAGES
5 FABRICATE PER SLAC SPECIFICATION # PS-343-410-40

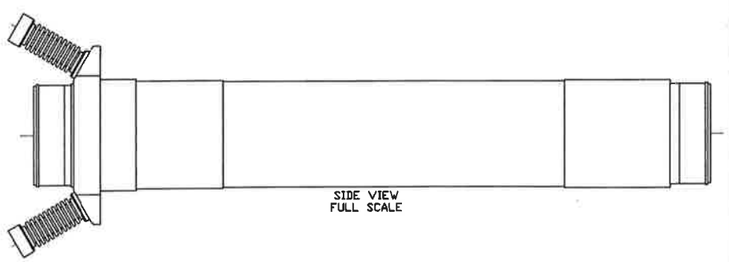


SIDE VIEW
SCALE: 2X



SIDE VIEW
FULL SCALE

SCALE:
INCHES 0 1 2 3
CM 0 5 10



SIDE VIEW
FULL SCALE

ULTRA HIGH VAC PART
FABRICATE PER PS-343-410-40

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ITEM NO	PREF	BASE	SUFF	TITLE OR DESCRIPTION	QTY
	STOCK OR PART NO				
5	SA-343-410-08			MANIFOLD WELDMENT	1
4	PF-343-410-07			MANIFOLD GLUE RING	1
3	PF-343-410-06			WATER JACKET GLUE RING	1
2	PF-343-410-05			WATER JACKET	1
1	SA-343-410-02			BEAM PIPE BRAZEMENT	1

DIMENSIONING AND TOLERANCING IS IN ACCORDANCE WITH ANSI Y14.5M-1982
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES
BREAK EDGES .005
INTERNAL CORNERS .015 R MAX
FRACTIONS ± 1/64
DEC x ± .1
xx ± .01
xxx ± .004
ANGLES ± 1/2°
63 ALL SURFS

SCALE: PER VIEW
DO NOT SCALE DRAWING
NEXT ASSEMBLY: SA-343-410-00

STANFORD LINEAR ACCELERATOR CENTER
US DEPARTMENT OF ENERGY
STANFORD UNIVERSITY STANFORD, CALIFORNIA

ENGR KNUT SKARPAAS 2-5-97
DRWN KNUT SKARPAAS
CHKD MARTIN NORDBY MARTIN NORDBY
APPROVALS
KNUT SKARPAAS
MARTIN NORDBY
NANCY PALMER

PEP-II IR VACUUM
VERTEX VAC CHAM ASSY
BEAM PIPE ASSY

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SH 1 OF 1

PEP2 IR VAC VTX CH ASSY
11FA1