



- NOTES:
- ASSEMBLE PARTS AS SHOWN. MACHINING ENTIRE SURFACE (INCLUDING HEAD OF BOLTS) TO DIMENSION SHOWN.
  - THE PARTS NEED TO GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOWDOWN. THEN TO BE ELECTROPOLISHED BEFORE ASSEMBLY WITH BELLOW & FLANGE ASSEMBLY DWG #A4-840200-00-300
  - THIS IS A UHV SUB-ASSEMBLY. KEEP THE UHV PARTS CLEAN DURING ASSEMBLY, AND USE UHV PACKING WITH ALUMINUM FOIL.
  - WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR BASED CUTTING FLUIDS IS PROHIBITED. USE THE FOLLOWING:
    - WHEEL STAR 49
    - TRIM SCOR
  - ALL DIMENSIONS WITH ARE MILLIMETERS

FOR REFERENCE ONLY

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
5		Ø1/2 x 1/2 LG. SHOULDER SCREW	SST (SILVER PLATED)	2
4		5/16-18 UNC-2B SOC HD SCR x 7/8 LG.	SST (SILVER PLATED)	2
3	A4-840203-00	A4-84 LOWER MTG. PLATE	SST 304	1
2	A4-840202-00	A4-84 UPPER MTG. PLATE	SST 304	1
1	A4-840201-00	A4-84 ROD WELDMENT		1

  

UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES		TOLERANCES	
DECIMALS	ANGULAR	DECIMALS	ANGULAR
x - .03	- .25	x - .03	- .25
xx - .01		xx - .01	
xxx - .005		xxx - .005	

  

DATE	BY	CHKD	DATE
7/19/99	J. CHANG	M.J.M.	11/9/99
12/9/99	J. CHANG	J.C.	11/9/99
7/19/99	CHANG/MUSCIA		

  

DATE	DATE	DATE	DATE
7/19/99	7/19/99	12/12/99	1/6/00

  

SCALE	SIZE	SHEET	DRAWING NUMBER
1=1	D	2 of 2	A4-840200-01-2

PLOT SCALE: 1=1