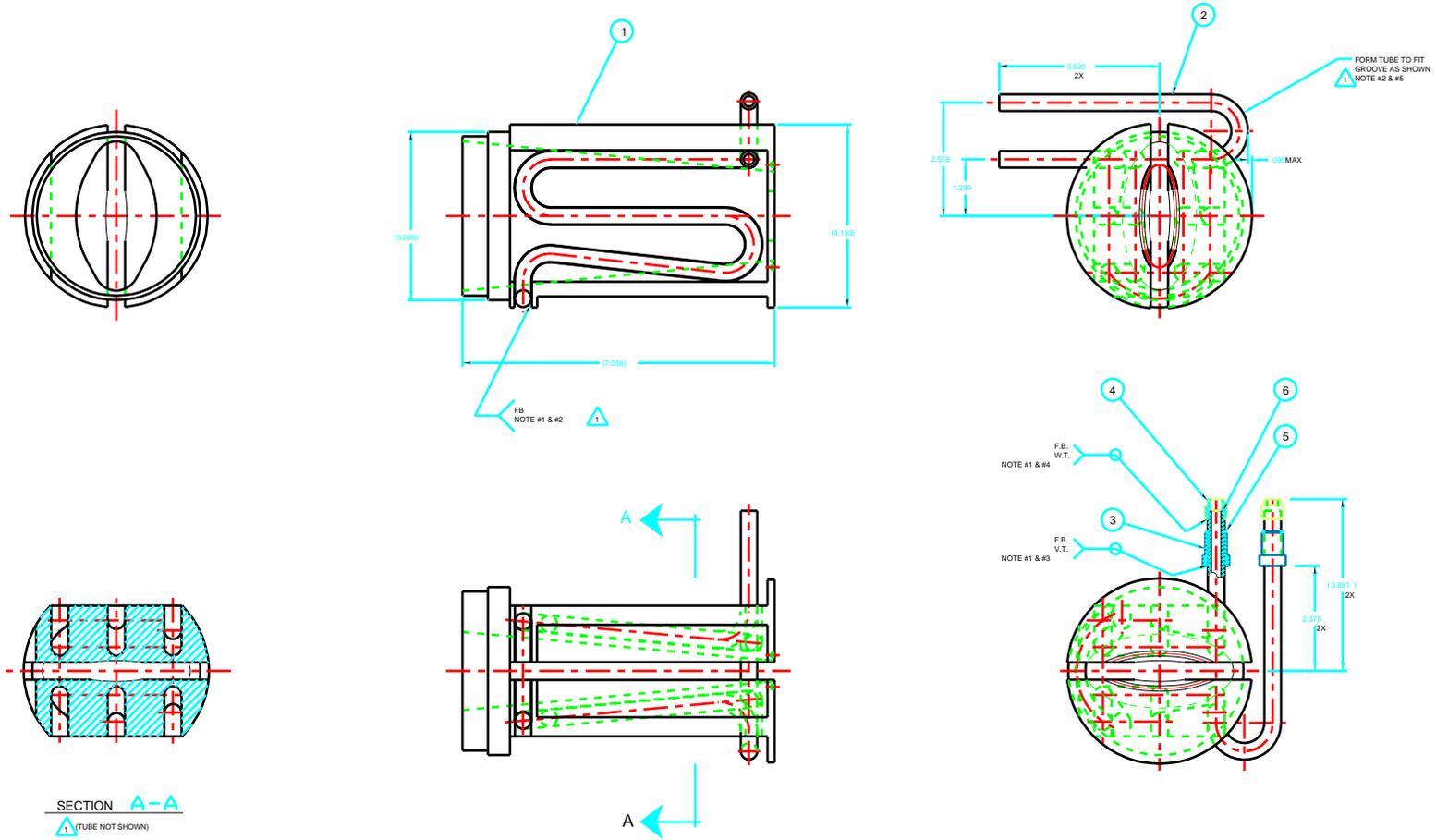


REVISIONS				
DATE	BY	DESCRIPTION	BY	DATE
01		UPDATED DRAWING	PRB	10/9/95



ITEM 7 NOT SHOWN

- NOTES:**
- FURNACE BRAZE PER ML-8-7883 IN HIGH VACUUM (10⁻⁶ TORR OR BETTER) USING BRAZE FILLER METAL BVAg4, GRADE 2 (AWS CLASSIFICATION) i.e. HANDY & HARMON BRAZE 721 OR EQUIVALENT.
 - ASSEMBLY IS FOR ULTRA HIGH VACUUM SERVICE. ITEM #2 MUST BE FORMED, FIXTURED AND BRAZED TO AVOID TRAPPED VOLUMES BETWEEN ITEM #1 AND ITEM #2.
 - VT BRAZE JOINT IS VACUUM TIGHT. AFTER BUSHING IS WELDED IN NEXT STEP, ASSEMBLY WILL BE LEAK TESTED WITH A HELIUM MASS SPECTROMETER AT A MINIMUM SENSITIVITY OF 2 x 10⁻¹⁰ STANFORD CO/SEC. INSPECT BRAZE JOINT FOR CONTINUITY AND ABSENCE OF POROSITY.
 - WT BRAZE JOINT IS WATER TIGHT. AFTER ADAPTER IS WELDED IN NEXT STEP, ASSEMBLY MUST SHOW NO EVIDENCE OF LEAKAGE WHEN TESTED AT 225 PSL. INSPECT BRAZE JOINT FOR CONTINUITY AND ABSENCE OF POROSITY.
 - MACHINING & TUBE FORMING MUST BE DONE DRY OR USING A WATER-SOLUBLE COOLING FLUID THAT IS FREE OF SILICONE, SULFUR, PHOSPHORUS OR HALOGENS. TRISOL OR CIMCOOL DILUTED TO 5% CONCENTRATION IN DEIONIZED (DI) WATER, ARE RECOMMENDED.

ITEM	DESCRIPTION / PART NUMBER	QUANTITY	UNIT	MATERIAL / SPEC	QTY
7	FOIL .003 THK. OR POWDER			SEE NOTE #1	A/R
6	RING Ø875 I.D. x .051			SEE NOTE #1	2
5	RING Ø875 O.D. x .040			SEE NOTE #1	2
4	410103-100104			ADAPTER	2
3	410103-100602			BUSHING	2
2	TUBE, Ø875 O.D. x .065 W.			COPPER	A/R
1	P410103-100611			CONE, SOLID	1

DESIGNED / PART NUMBER		PARTS LIST / BILL OF MATERIALS	
DESIGNED BY	PIECHGAZMAN	DATE	08/93
DESIGNED BY	EMIL TRAKTENBERG	DATE	6-1-95
DESIGNED BY	EPM GLUSKIN	DATE	8-1-94

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