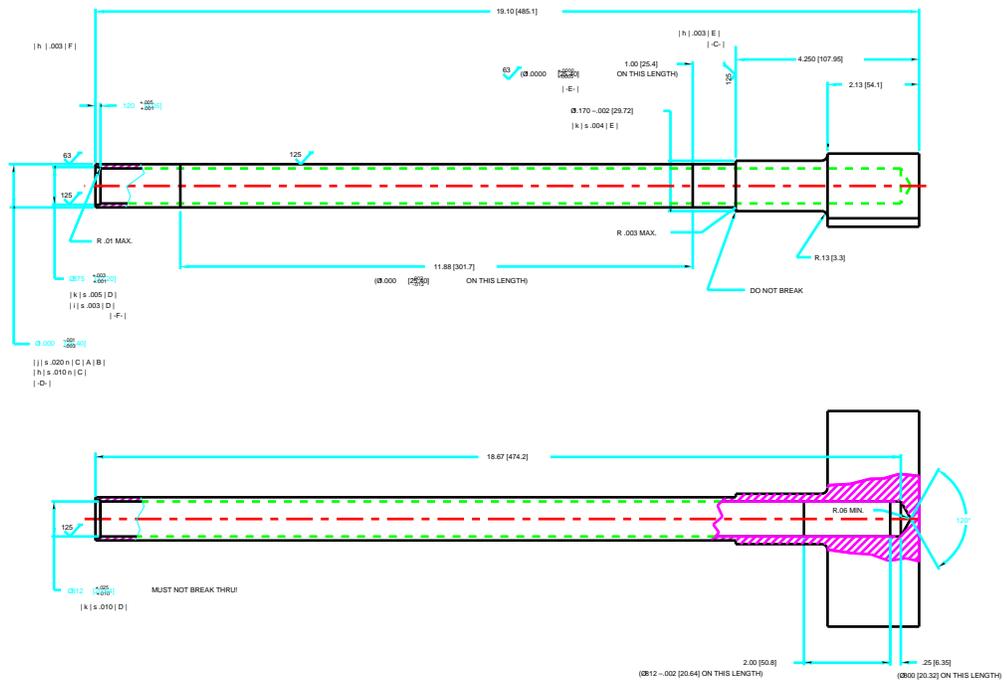


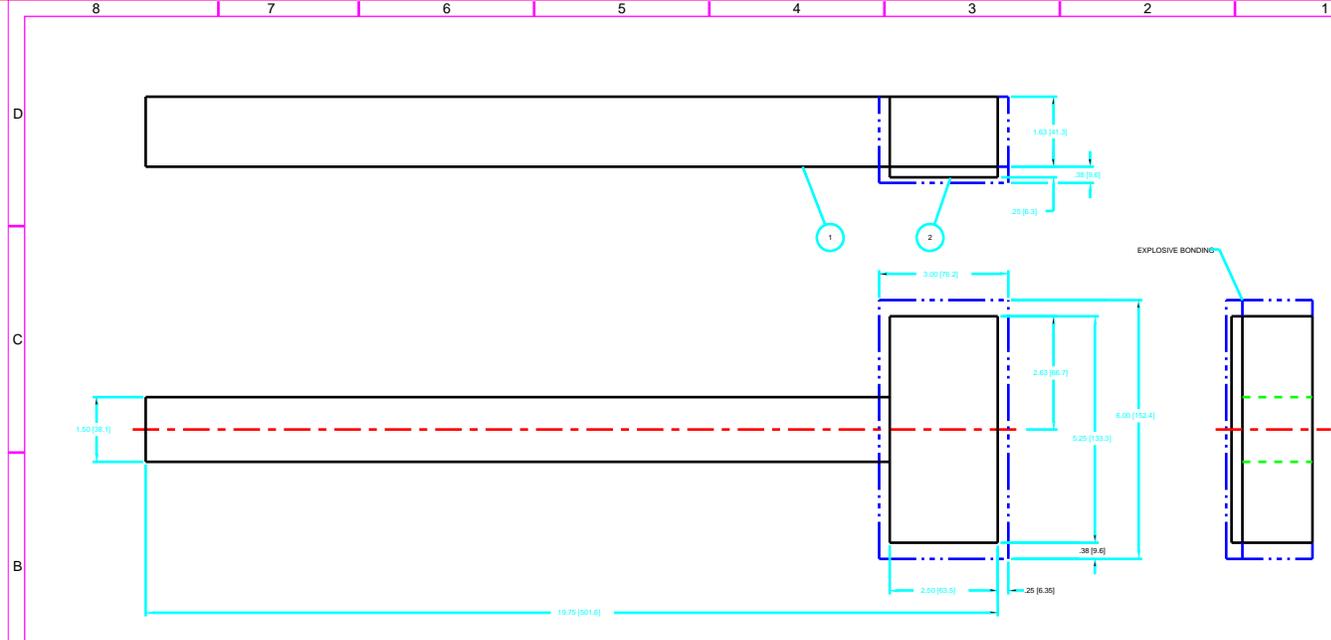
- NOTES:
1. THIS IS A LMV PART. ELECTROPOLISHING IS NEEDED BEFORE WELDING. PRIOR TO ELECTROPOLISHING, THE PART NEEDS TO GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOW DOWN.
  2. KEEP THE PART CLEAN, AND WRAP FOR LMV PACKING WITH ALUMINUM FOIL.
  3. WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:
    - A) CIMCOOL 5 STAR 49
    - B) TRIM SOL.
  4. ALL DIMENSIONS WITH ARE MILLIMETERS
  5. FINISH UNLESS OTHERWISE SPECIFIED



REV	DESCRIPTION	BY	DATE
1	ISSUED FOR FABRICATION	J.J.	10/17/14
2	ISSUED FOR FABRICATION	J.J.	10/17/14
3	ISSUED FOR FABRICATION	J.J.	10/17/14
4	ISSUED FOR FABRICATION	J.J.	10/17/14
5	ISSUED FOR FABRICATION	J.J.	10/17/14
6	ISSUED FOR FABRICATION	J.J.	10/17/14
7	ISSUED FOR FABRICATION	J.J.	10/17/14
8	ISSUED FOR FABRICATION	J.J.	10/17/14
9	ISSUED FOR FABRICATION	J.J.	10/17/14
10	ISSUED FOR FABRICATION	J.J.	10/17/14

REV	DESCRIPTION	BY	DATE
1	ISSUED FOR FABRICATION	J.J.	10/17/14
2	ISSUED FOR FABRICATION	J.J.	10/17/14
3	ISSUED FOR FABRICATION	J.J.	10/17/14
4	ISSUED FOR FABRICATION	J.J.	10/17/14
5	ISSUED FOR FABRICATION	J.J.	10/17/14
6	ISSUED FOR FABRICATION	J.J.	10/17/14
7	ISSUED FOR FABRICATION	J.J.	10/17/14
8	ISSUED FOR FABRICATION	J.J.	10/17/14
9	ISSUED FOR FABRICATION	J.J.	10/17/14
10	ISSUED FOR FABRICATION	J.J.	10/17/14



- NOTES:
1. THIS DRAWING IS FOR EXPLOSIVE BONDING USE ONLY.
  2. THIS IS A ULTRA-HIGH WELDMENT ASSEMBLY (UHV) ELECTROPOLISHING IS NEEDED BEFORE WELDING. PRIOR TO ELECTROPOLISHING, THE ASSEMBLY MUST GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING, AND DRY NITROGEN BLOW DOWN.
  3. ASSEMBLY SHALL BE ULTRASONICALLY TESTED AND CERTIFIED. CERTIFICATION OF ULTRA SONIC TEST SHALL BE SIGNED BY A CONTRACTOR REPRESENTATIVE TO SIGN SUCH CERTIFICATION
  4. ALL SURFACE FINISHES TO BE
  5. DIMENSIONS IN [ ] ARE MILLIMETERS AND FOR REF. ONLY
  6. SOLID LINES REPRESENT MACHINING AFTER EXPLOSIVE BONDING.
  - \* MACHINE AFTER EXPLOSIVE BONDING

REV	DESCRIPTION	BY	DATE
1	ISSUED FOR FABRICATION	J.J.	10/17/14
2	ISSUED FOR FABRICATION	J.J.	10/17/14
3	ISSUED FOR FABRICATION	J.J.	10/17/14
4	ISSUED FOR FABRICATION	J.J.	10/17/14
5	ISSUED FOR FABRICATION	J.J.	10/17/14
6	ISSUED FOR FABRICATION	J.J.	10/17/14
7	ISSUED FOR FABRICATION	J.J.	10/17/14
8	ISSUED FOR FABRICATION	J.J.	10/17/14
9	ISSUED FOR FABRICATION	J.J.	10/17/14
10	ISSUED FOR FABRICATION	J.J.	10/17/14

REV	DESCRIPTION	BY	DATE
1	ISSUED FOR FABRICATION	J.J.	10/17/14
2	ISSUED FOR FABRICATION	J.J.	10/17/14
3	ISSUED FOR FABRICATION	J.J.	10/17/14
4	ISSUED FOR FABRICATION	J.J.	10/17/14
5	ISSUED FOR FABRICATION	J.J.	10/17/14
6	ISSUED FOR FABRICATION	J.J.	10/17/14
7	ISSUED FOR FABRICATION	J.J.	10/17/14
8	ISSUED FOR FABRICATION	J.J.	10/17/14
9	ISSUED FOR FABRICATION	J.J.	10/17/14
10	ISSUED FOR FABRICATION	J.J.	10/17/14