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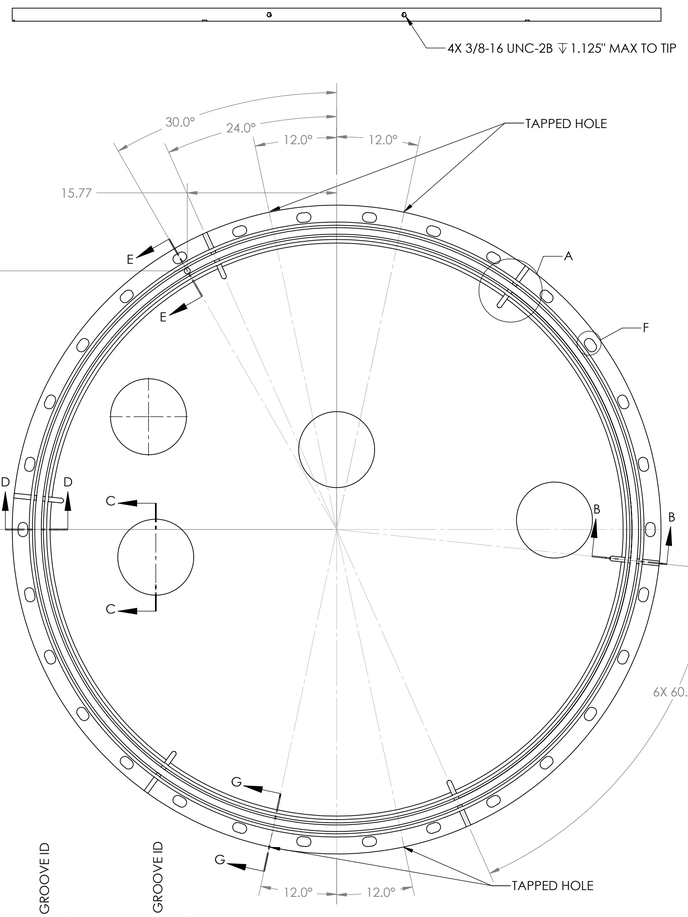
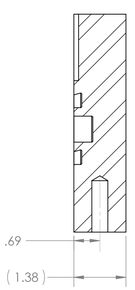
REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	RELEASED TO PRODUCTION	8/20/2010	MKM2

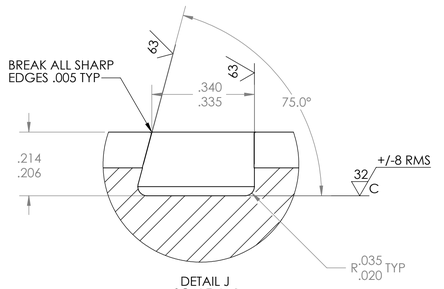


SECTION E-E
SCALE 1 : 1.5



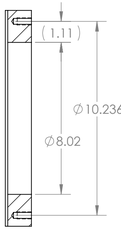
SECTION G-G
SCALE 1 : 2

TAPPED HOLE DETAIL
FOUR PLACES

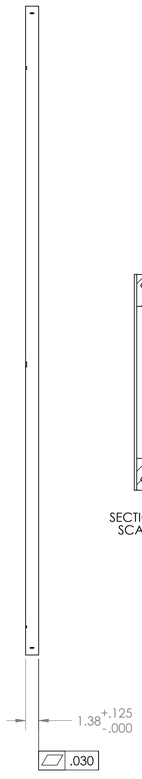


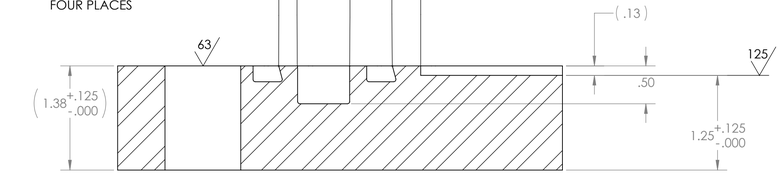
DETAIL J
SCALE 4 : 1

O-RING GROOVE DETAIL
.275 CROSS SECTION
TWO PLACES

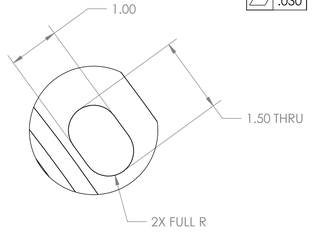


SECTION C-C
SCALE 1 : 4



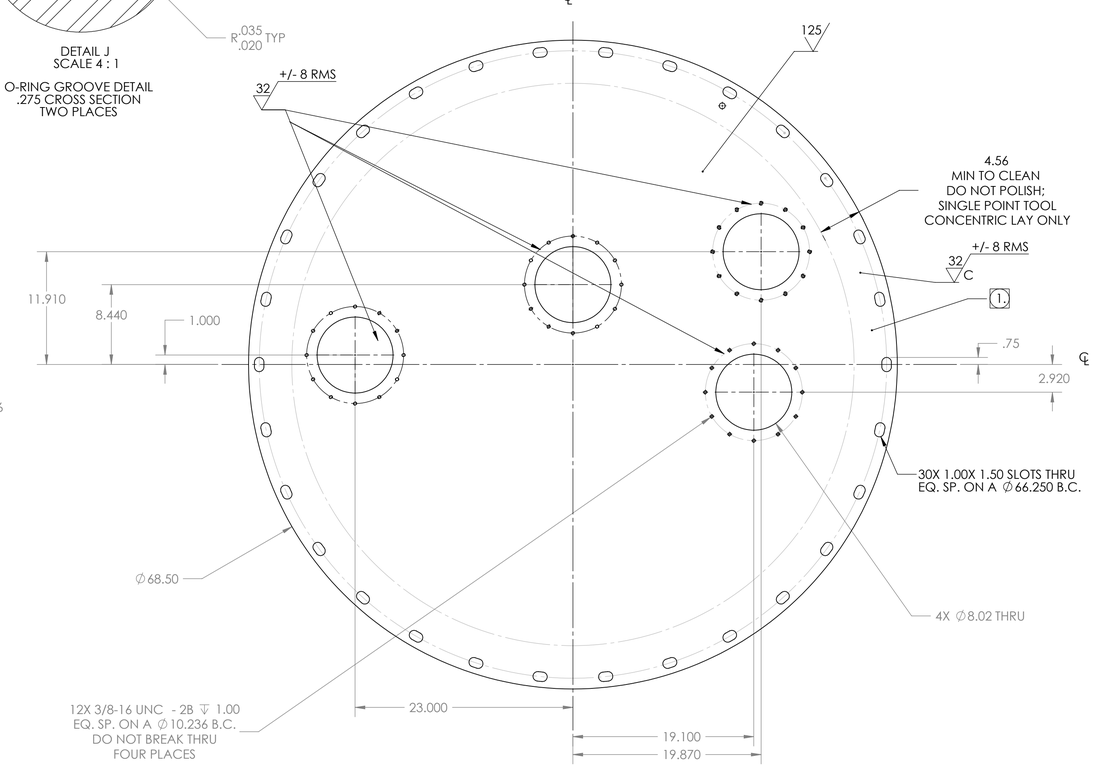


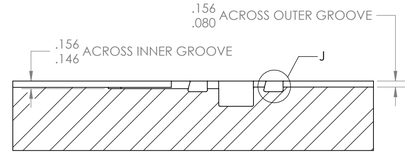
SECTION D-D
SCALE 1 : 1



DETAIL F
SCALE 1 : 1.5

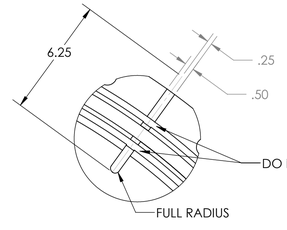
BOLT SLOT DETAIL
30 PLACES





SECTION B-B
SCALE 1 : 1.5

PUMP OUT GROOVE DETAIL
6 PLACES



DETAIL A
SCALE 1 : 4

PUMP OUT GROOVE DETAIL
6 PLACES

NOTES:

1. VACUUM SEALING SURFACE

2. BOTH SURFACES OF PLATE WILL BE USED IN ULTRA HIGH VACUUM SERVICE.
3. ALL SEALING SURFACES SHALL MEET THE FOLLOWING REQUIREMENTS:
   A. BASIC FINISH IS 32 RMS, CONCENTRIC LAY.
   B. THE FOLLOWING ARE NOT ALLOWED: GRINDING, HONING, LAPPING, POLISHING, BUFFING, SANDING, BLASTING, OR ANY OTHER PROCESS THAT DISTURBS THE CONCENTRIC MACHINING LAY, IMBEDS MATERIAL INTO THE SURFACE, OR SMEARS THE SURFACE.
4. USE ONLY TUNGSTEN CARBIDE TOOLING TO MACHINE THIS PART.
5. O-RING GROOVES AND VENT GROOVE MUST BE MACHINED DURING THE SAME SETUP.
6. NO ABRASIVE STONES, CLOTHS, OR GRINDING WHEELS MAY BE USED.
7. NO OIL BASED OR HYDROCARBON BASED CUTTING FLUIDS MAY BE USED. SEE QP1730-10 SECTION 4 FOR APPROVE FLUIDS. NO HYDROCARBONS ALLOWED IN THE COOLANT. COOLANT LIMITS AS FOLLOWS
   a. WATER LEACHABLE CHLORIDES: 100PPM
   b. TOTAL HALOGENS (INCLUDING CHLORIDES): 1000PPM
   c. TOTAL SULFUR: 1000PPM
8. DO NOT ALLOW PART TO BE CONTAMINATED BY CARBON STEEL OR IRON CONTACT.
9. MACHINING TO BE IN LINE WITH LIGO SPECIFICATION E0900406, LATEST REVISION.
10. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO DYES OR INKS) D1001665-V2 ON NOTED SURFACE OF THE PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER (I.E. 001). USE MINIMUM .12" HIGH CHARACTERS. A VIBRATORY TOOL MAY BE USED.
11. LEAK CHECK SEPTUM PLATE 10^-9 ATM-CC/SEC TO QP1750-A7.
12. PACKAGE, HANDLE, AND SHIP IN ACCORDANCE WITH BOTH QP1730-10 AND QP1750-R6.

DESCRIPTION: PLATE, 1.38 THK, 68.50 OD

MATERIAL: AISI 304/AISI 304L DUAL CERT PER SA240

UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN INCHES
TOLERANCES: FINISH
ANGULAR: ±0°30' 125
.XX ±.03
.XXX ±.005
UNSPECIFIED RADII: R.015
BREAK EDGES: .010x45°
REMOVE ALL BURRS
// ▱ ⊥ WITHIN .03
THIRD ANGLE PROJECTION

WEIGHT: 1242.31 #

APPROVALS		DATE
DRAFTER	MKM2	7/12/10
CHECKER	RW	7/22/10
ENGINEER	MKM2	7/12/10

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TITLE:
PLATE, SEPTUM, H2 INPUT

DO NOT SCALE DRAWING

DWG. NO. D 114424-04S REV A

SCALE: 1:8 SHEET 1 OF 1