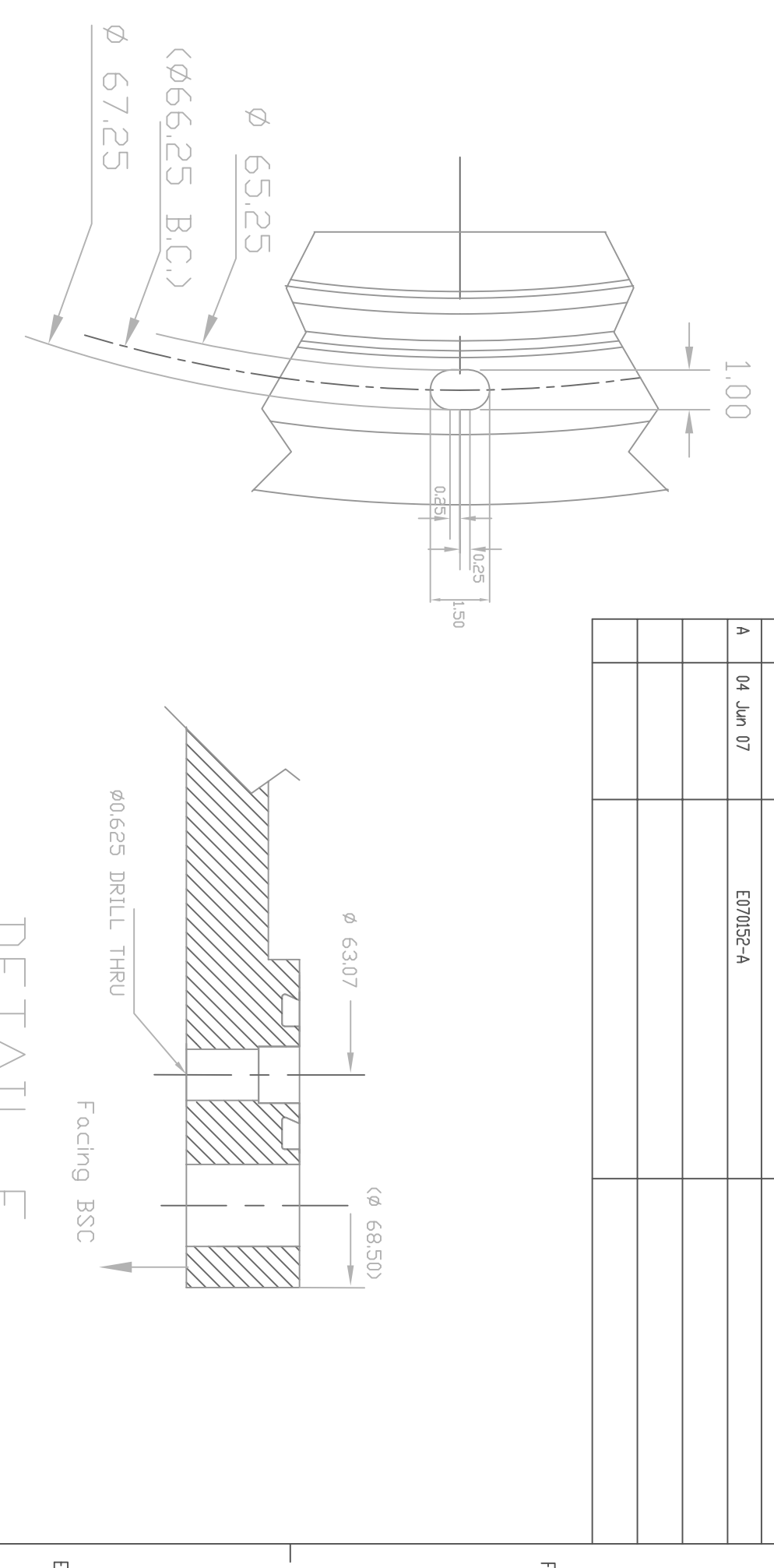
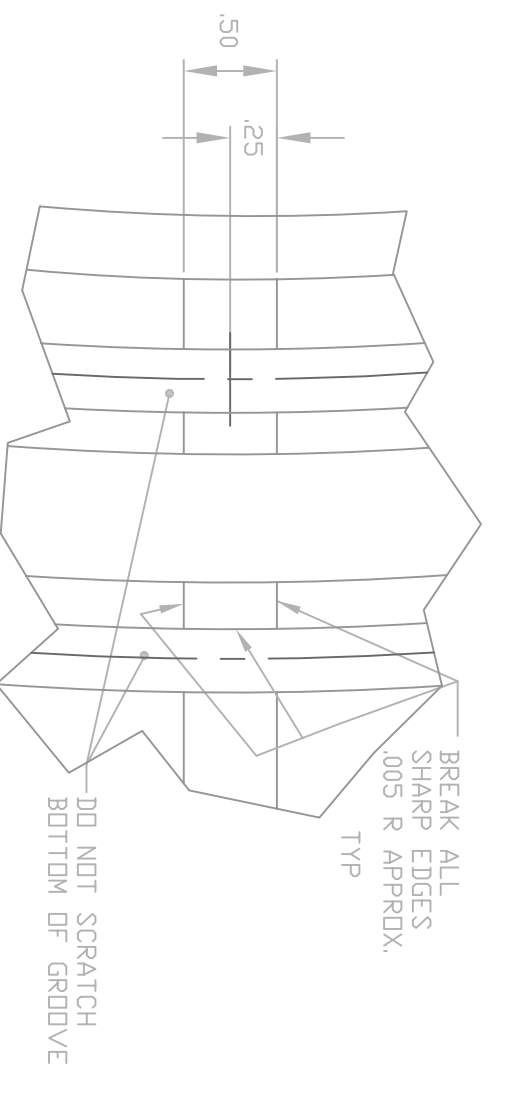


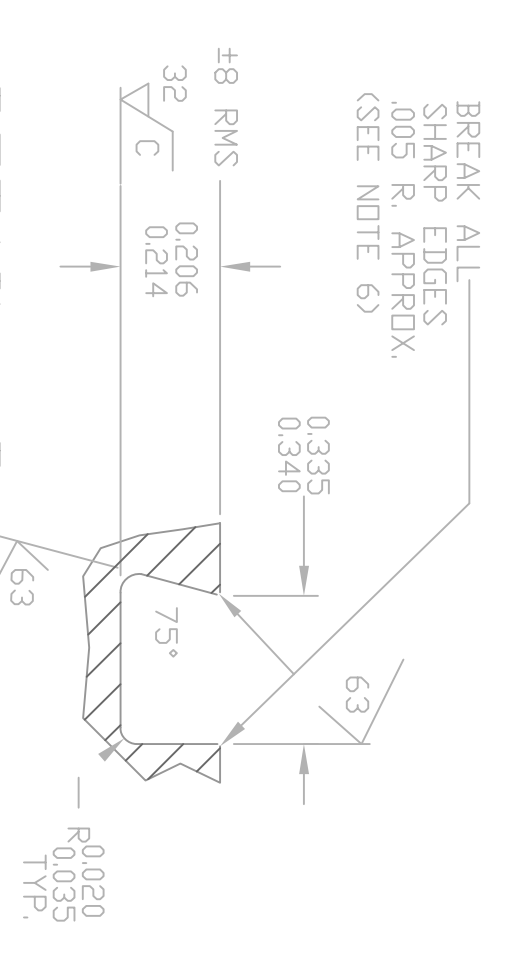
REV	DATE	BY	CHKD	APP'D	DWG. NO.	SCALE
A	04 Jun 07	EDMURA-A			D070169	DO NOT SCALE DRAWING



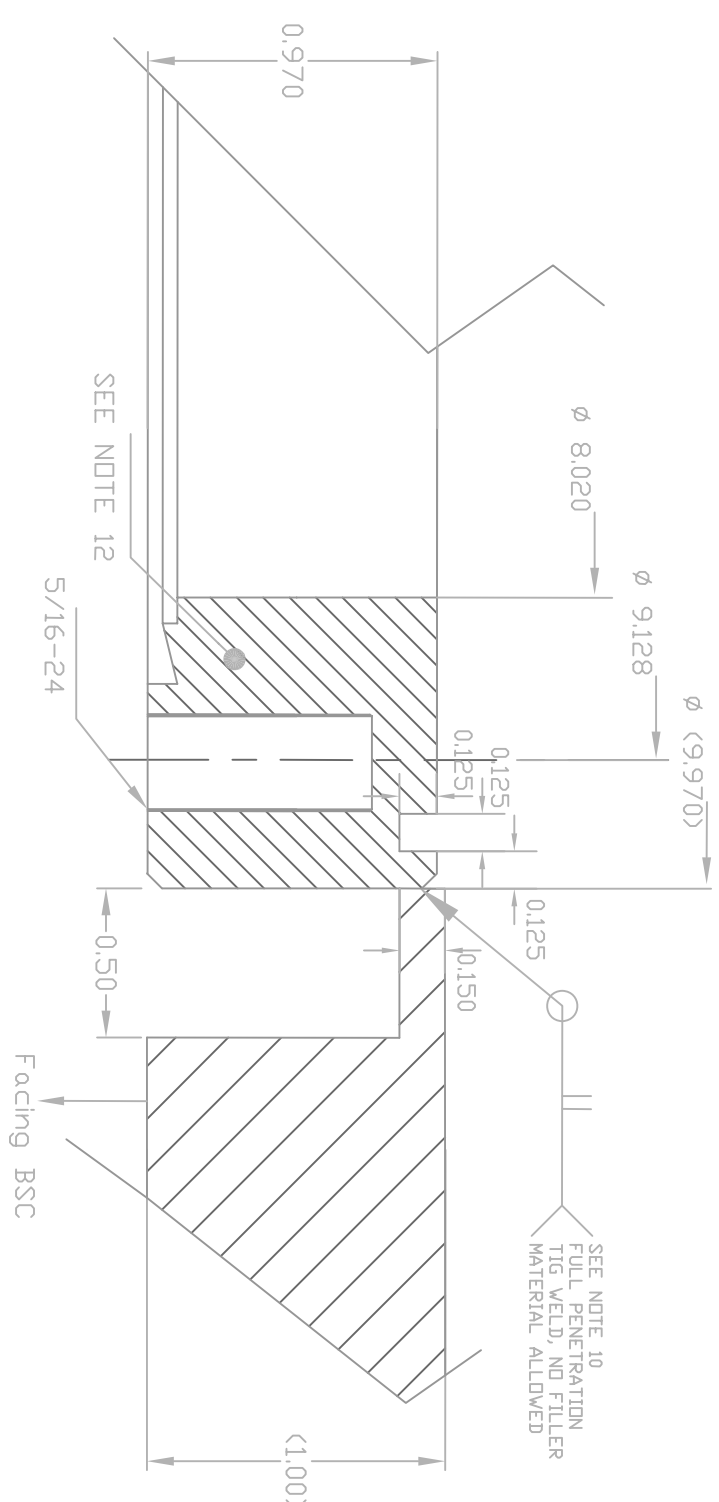
SLOT DETAIL



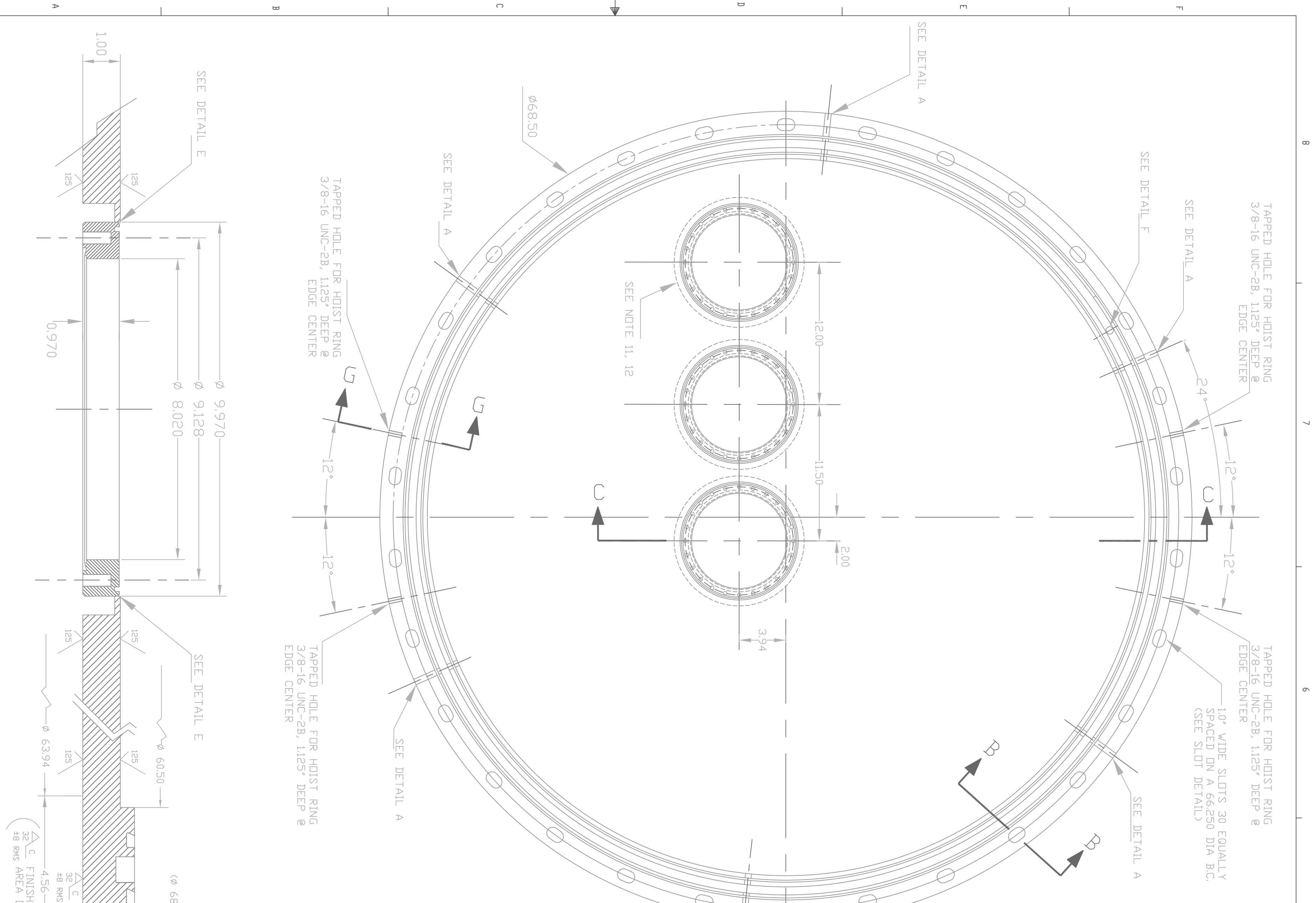
DETAIL A



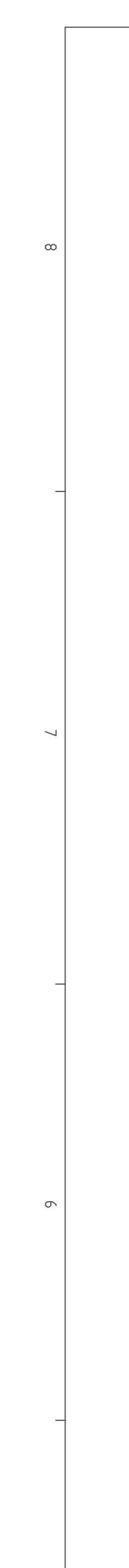
DETAIL D



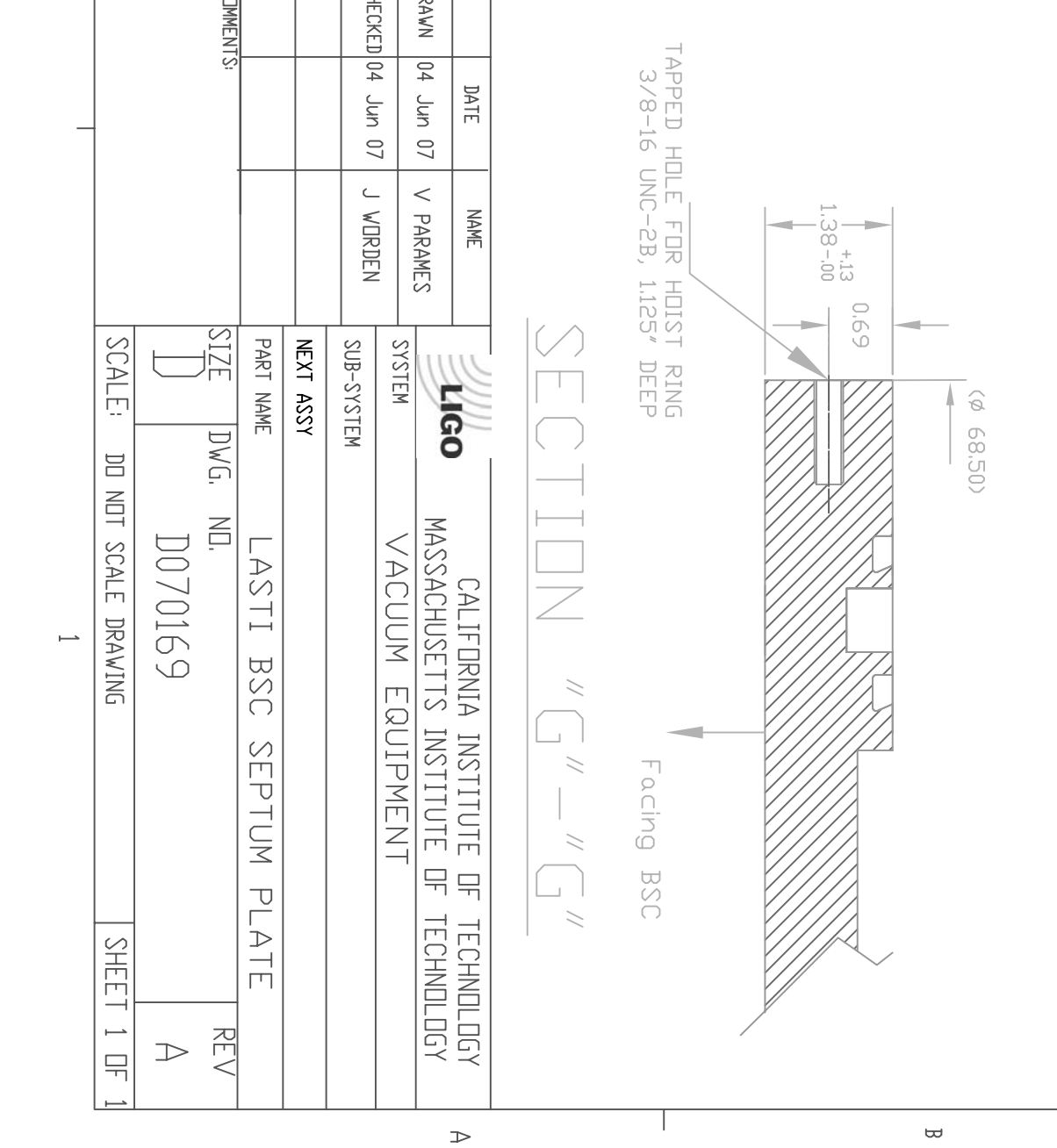
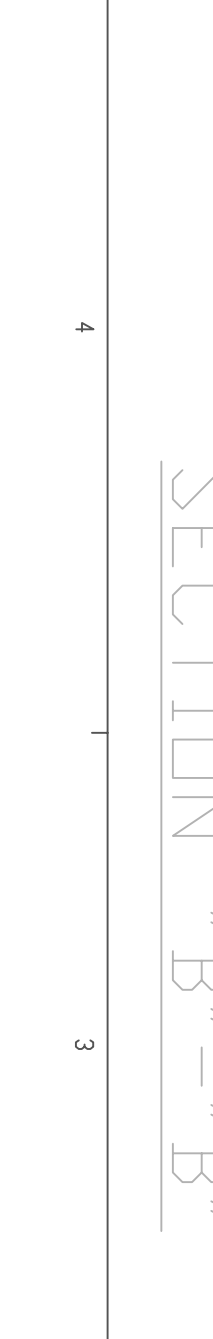
DETAIL E



SECTION "C"- "C"



SECTION "B"- "B"



UNLESS OTHERWISE SPECIFIED			DATE		
DIMENSIONS ARE IN INCHES			04 Jun 07		
TOLERANCES:			MFG		
XX = ±.1	DRAWN		V. PARONIS		
XXX = ±.03	CHECKED		04 Jun 07		
XXX = ±.01	J. WARDEN				
ANGULARS = ±.30'			SUB-SYSTEM		
MATERIAL			NEXT ASSY		
304L			LASTI BSC SEPTUM PLATE		
FINISH			DWG. NO.		
			D070169		
SCALE: DO NOT SCALE DRAWING			REV		
			A		

- NOTES:
- BOTH SURFACES OF PLATE WILL BE USED IN ULTRA HIGH VACUUM SERVICE.
 - ALL MATERIAL TO BE 304L STAINLESS STEEL. MATERIAL CERTIFICATION IS REQUIRED
 - ALL SEALING SURFACES SHALL MEET THE FOLLOWING REQUIREMENTS:
BASIC FINISH REQUIRED: 32 RMS. CONCENTRIC LAY FINISH TOLERANCE +/- 8 RMS)
THE FOLLOWING PROCESSES ARE NOT ALLOWED: GRINDING, HONING, LAPING, POLISHING, BUFFING, SANDING, BLASTING, OR ANY OTHER PROCESS THAT DISTURBS THE CONCENTRIC MACHINING LAY, IMBEDS MATERIAL INTO THE SURFACE, OR SMears THE SURFACE.
 - D-RING GROOVES AND VENT GROOVE MUST BE MACHINED DURING THE SAME SETUP.
 - NO ABRASIVE STONES, CLOTHS OR GRINDING WHEELS MAY BE USED.
 - NO OIL BASED OR HYDROCARBON BASED CUTTING FLUIDS TO BE USED.
 - NO CARBON STEEL OR OTHER SOURCE OF IRON CONTAMINATION ARE TO COME IN CONTACT WITH THE PLATE DURING MANUFACTURING OR HANDLING.
 - MARK D070107-A ON OUTER EDGE OF PLATE. SCRIBE, ENGRAVE OR MECHANICALLY STAMP (NO DYES OR INKS) PART NUMBER ON NOTED SURFACE OF PART FOLLOWED BY THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER 001. USE MINIMUM 012" HIGH CHARACTERS. A VIBRATORY TOOL MAY BE USED.
 - BREAK ALL SHARP EDGES.
 - VENDOR SHALL PROPOSE ANY ALTERNATIVE WELD PREPP/WELD
 - WELD THREE NIR-CAL MODIFIED CF FLANGES OR APPROVED EQUIVALENT TO PLATE AT LOCATIONS AS SHOWN. ASSEMBLY THE THREE CONFLATS WITH GASKETS AND BLANK FLANGES.
 - LEAK TEST TO 10⁻⁹ atm-cc/sec.
 - VENDOR SHALL PROPOSE PLATE CLEANING TECHNIQUES. ALL CLEANING AND PACKING SHALL BE APPROVED BY LIGO.
 - VENDOR SHALL PROPOSE BAKE PROCEDURE, IF POSSIBLE.
 - PLATE MUST BE PACKAGED, HANDLED, AND SHIPPED IN SUCH A MANNER AS TO MAINTAIN SPECIFIED SURFACE FINISHES.