

ULTRA HIGH VAC PART
FABRICATE PER FP-202-631-14

ITEM	STOCK OR PART NO	TITLE OR DESCRIPTION	QTY	ITEM	STOCK OR PART NO	TITLE OR DESCRIPTION	QTY	ITEM	STOCK OR PART NO	TITLE OR DESCRIPTION	QTY
68		NUT, HEX, 5/16-24 UNF-2B, STEEL	112	47	UCLA CONSTRUCT	PLASMA OVEN CHAMBER, AS DELIVERED	1	24	SC-258-603-64	BELLOWS, 249-153-2-EE	3
67		WASHER, FLAT NAR, 31 ID, SST 316	112	46	STANDARD BELLOWS	225-150-2-II	5	23	SC-250-013-01	6" OD FLANGE, CF, NR BLANK, THRU HOLES, SST	1
66		FLANGE BOLT 12 PT 5/16-24 X 2.25, SST, SILVER PLD	80	22	SA-258-604-01	VAC CONN SPOOL 83.00 L	1	21	SA-258-603-99	VAC CONN SPOOL 69.38 L	1
65		FLANGE BOLT 12 PT 5/16-24 X 2.00, SS, SILVER PLD	16	20	SA-258-603-58	VAC CONN SPOOL 15.90 L	1	19	SA-258-603-57	VAC CONN SPOOL 9.78 L	1
64		FLANGE BOLT 12 PT 5/16-24 X 1.25, SS, SILVER PLD	81	18	VAT 54032-GE02	ALL METAL ANGLE VALVE, 1 1/2, MANUAL	1	17	SA-258-603-59	VAC CONN SPOOL 4.51 L	1
63		FLANGE BOLT 12 PT 5/16-24 X 1.00, SST, SILVER PLD	48	16	VAT 48132-CE44	GATE VALVE, 40 MM BORE, PNEUMATIC ACTUATOR, ALL METAL	1	15	SA-258-603-87	VAC CONN SPOOL 1.50 L	1
62		FLANGE STUD, 5/16-24 X 1.75, SST, SILVER PLD	16	14	MDC 191017	GASKET, 8" OD FLANGE, OFHC COPPER	4	13	SA-257-402-91	OTR CUBE ASSY, 2.75 IN EXP	2
61		NUT, HEX, 250-28 UNF-2B, SST 316	234	12	MDC 191013	GASKET, 6" OD FLANGE, OFHC COPPER	6	11	SA-257-402-96	OTR CUBE ASSY, 2.75 IN	2
60		WASHER, FLAT NAR, 25 ID, SS 316	234	10	MDC 191009	GASKET, 4 1/2" OD FLANGE, OFHC COPPER	10	9	SA-257-402-56	MIRROR INSERTER, 3 INCH	1
59		FLANGE BOLT 12 PT 1/4-28 X 1.50, SST, SILVER PLD	72	8	MDC 191004	GASKET, 2 3/4 OD FLANGE, OFHC COPPER	43	7	SA-258-410-06	PEDESTAL ASSEMBLY 6 IN	1
58		FLANGE BOLT 12 PT 1/4-28 X .88, SST, SILVER PLD	13	6	MDC 402014	REDUCING NIPPLE, 6.0 X 2.75 CF, 2.5 LG	1	5	SA-258-410-32	PEDESTAL ASSEMBLY 4.5 IN	1
57		FLANGE STUD, 250-28 X 2.25, 316 SST, SILVER PLD	6	5	MDC 402018	NIPPLE REDUCER, 8.0 CF X 6.0 CF X 2.5LG	1	4	SA-380-746-20	BELLY BAND ASSY	1
56		FLANGE STUD, 250-28 X 2.00, 316 SST, SILVER PLD	12	4	MDC 405002	CROSS, 2.75 CF X 1.50 TUBE	2	3	SA-258-603-97	Be WINDOW INSERTER VALVE	1
55		FLANGE STUD, 250-28 X 1.75, 316 SST, SILVER PLD	12	3	MDC 406002	5-WAY CROSS, 2.75 CF, 1.50 OD TUBE, 304 SST	1	2	SA-258-410-37	BPM SUPPORT, 2.00" ID	1
54		FLANGE STUD, 250-28 X 1.5, 18-8 SST, SILVER PLD	12	2	MDC 450020	2.75 OD VIEWPORT, ZERO PROFILE QUARTZ	2	1	SA-258-603-80	MAGNET CHAMBER 49.29 L	1
53		FLANGE STUD, 250-28 X 1.25, 316 SST, SILVER PLD	102	1	MDC 450024	VIEWPORT 6" QUARTZ	2	0	SA-405-139-06	RESONANT CHARGE MONITOR	1
52	REF	SMITH PURCELL	1	0	MDC 190070	PLATE NUT 1/4-28	6		SA-258-410-44	VALVE SPRT, SERIES 010 DN40	1
51	REF	KRAKEN CHAMBER	1		MDC 408003	CUBE, 6 WAY, 4.50 CF FLANGE, SST	1		SA-258-410-26	CHARGE MONITOR SPRT ASSY	1
50	REF	2.75 DBL SIDED Be FOIL FLANGE	2		MDC 110018	FLANGE, 4.50 OD CF, BLANK, NON-ROTATABLE	4		SA-258-602-82	NIPPLE, CF8 X 2X CF2.75 X 3LG	2
49	REF	LASER DUMP FLANGE	1		MDC 150008	FLANGE, REDUCER, 4.50 X 2.75 CF, 1.50 ID, ZERO LG, 304 SST	4		SA-258-602-80	BELLOWS, WLD ASSY, 6.44 OD X 5.40 ID, 8825 NOM LG, 9 SEG, STYLE E, SST	2
48	REF	WIRE MONITOR	2		ID-257-403-10	TI FOIL, VAC CHMB	1		SA-258-602-60	PI INTEGRATION BOX ASSY	1

PRELIMINARY DESIGN
garyb
04-17-2014 04:42:45 PM

CHECK-PRINT
garyb
04-17-2014 04:42:45 PM

ESTIMATED MASS
4808.035 lbm

DIMENSIONING AND TOLERANCING IS IN ACCORDANCE WITH ASME Y14.5M-1994 AND Y14.41-2003.
 UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES.
 TOLERANCES:
 BREAK EDGES: 0.005-0.015
 INTERNAL CORNERS: R.015 MAX
 FRACTIONS: 1/16"
 DEC: .XXX
 .XXXX
 .XXXXX
 ANGLE: ± ALL SURF.

SCALE: 1:10
 DO NOT SCALE DRAWING

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ENGR D. WALZ
 DWN G. BOUCHARD 4-1-2014
 CHKR D. WALZ

DATE: 4-1-2014
 APPROVED BY: D. WALZ
 C. IVERSON

CAD FILE NAME: id25820017-0.dft

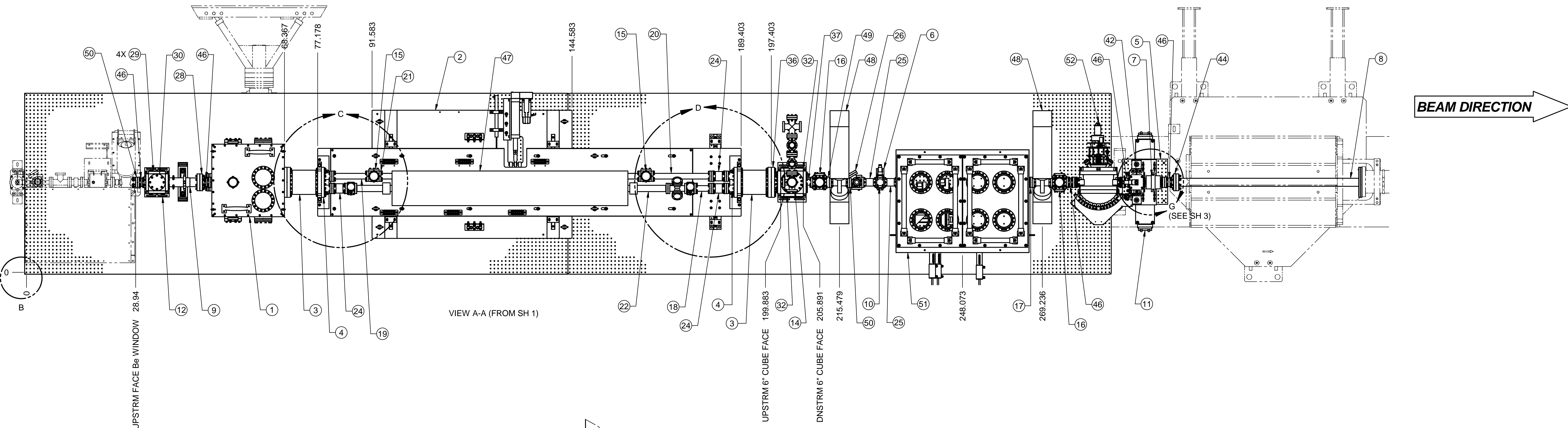
FACET INTEGRATION SYSTEMS
20-6 EXPERIMENTAL AREA
PLASMA LONG OVEN INSTL

DRAWING NUMBER: ID-258-200-17
REVISION NUMBER: 0

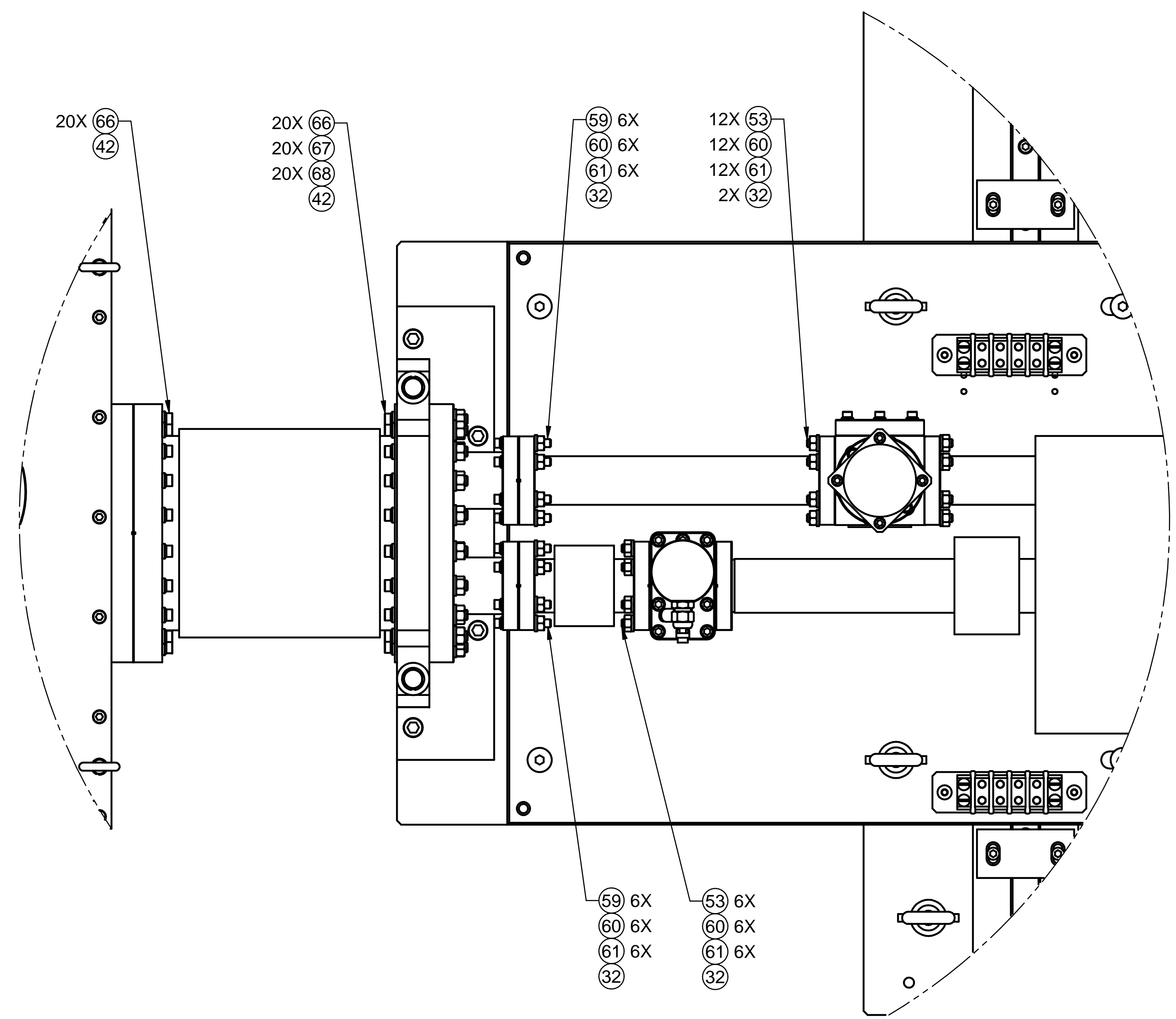
ID-258-200-17

(.250-20 UNC-2B)
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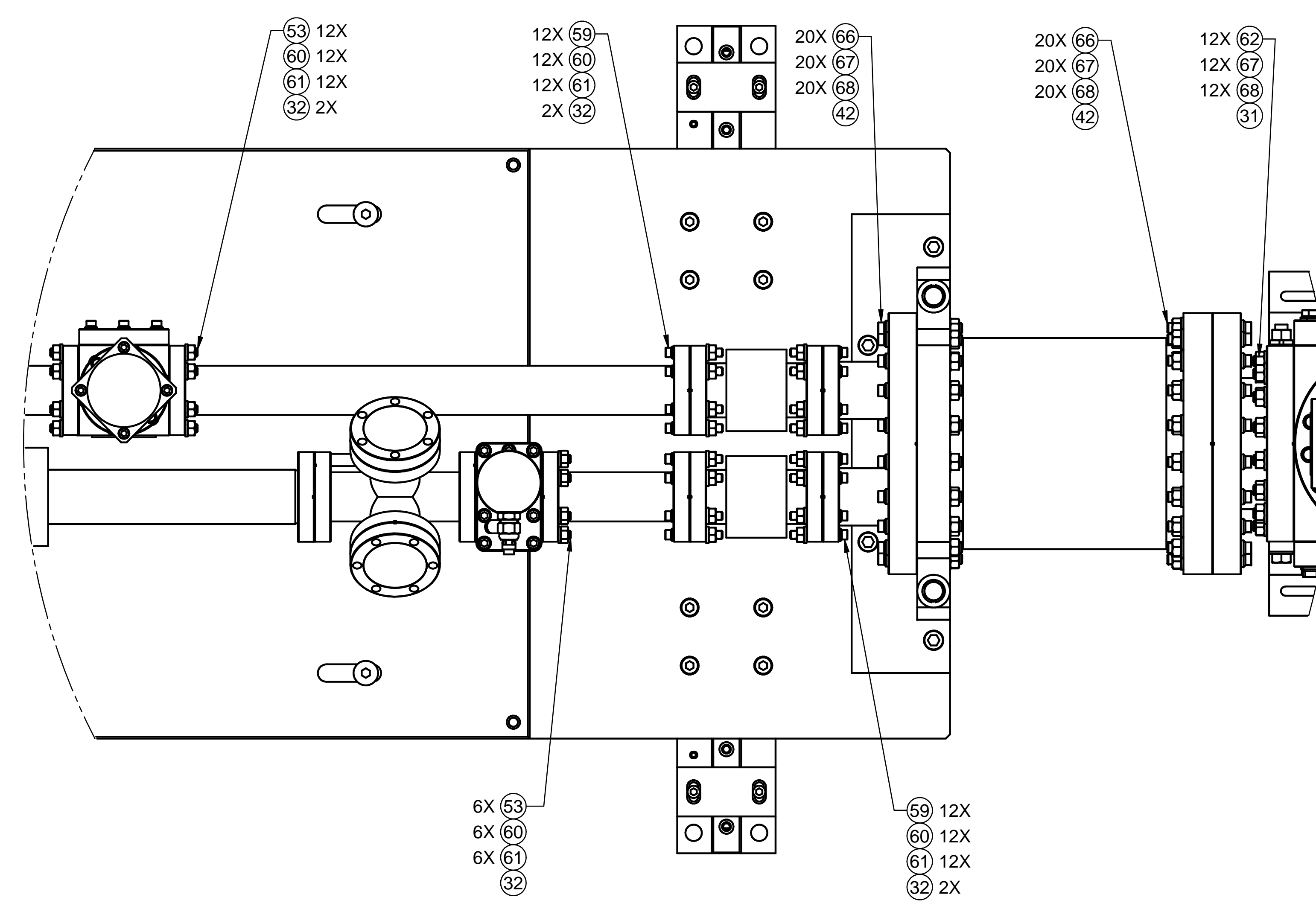
DETAIL B



BEAM DIRECTION



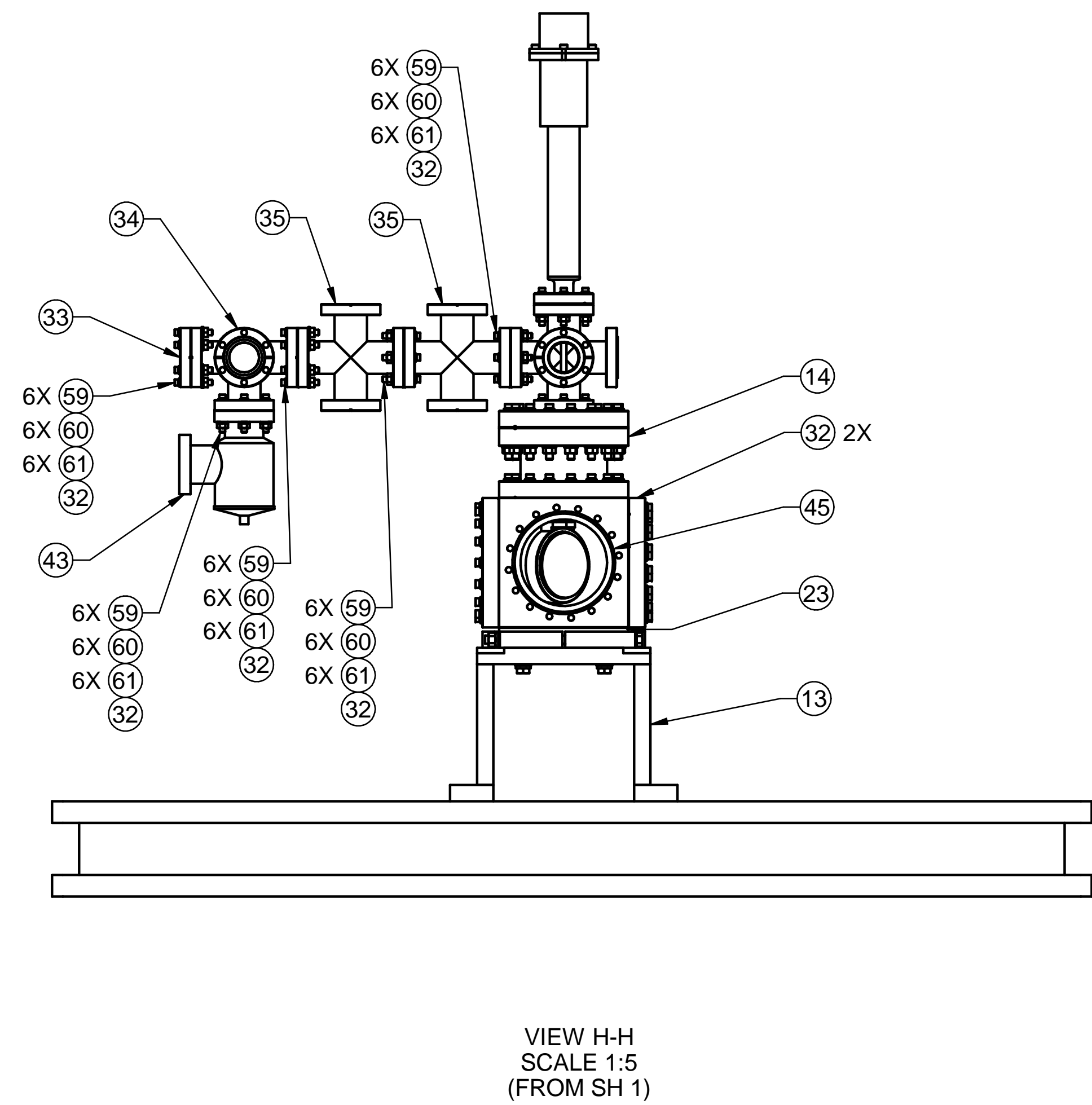
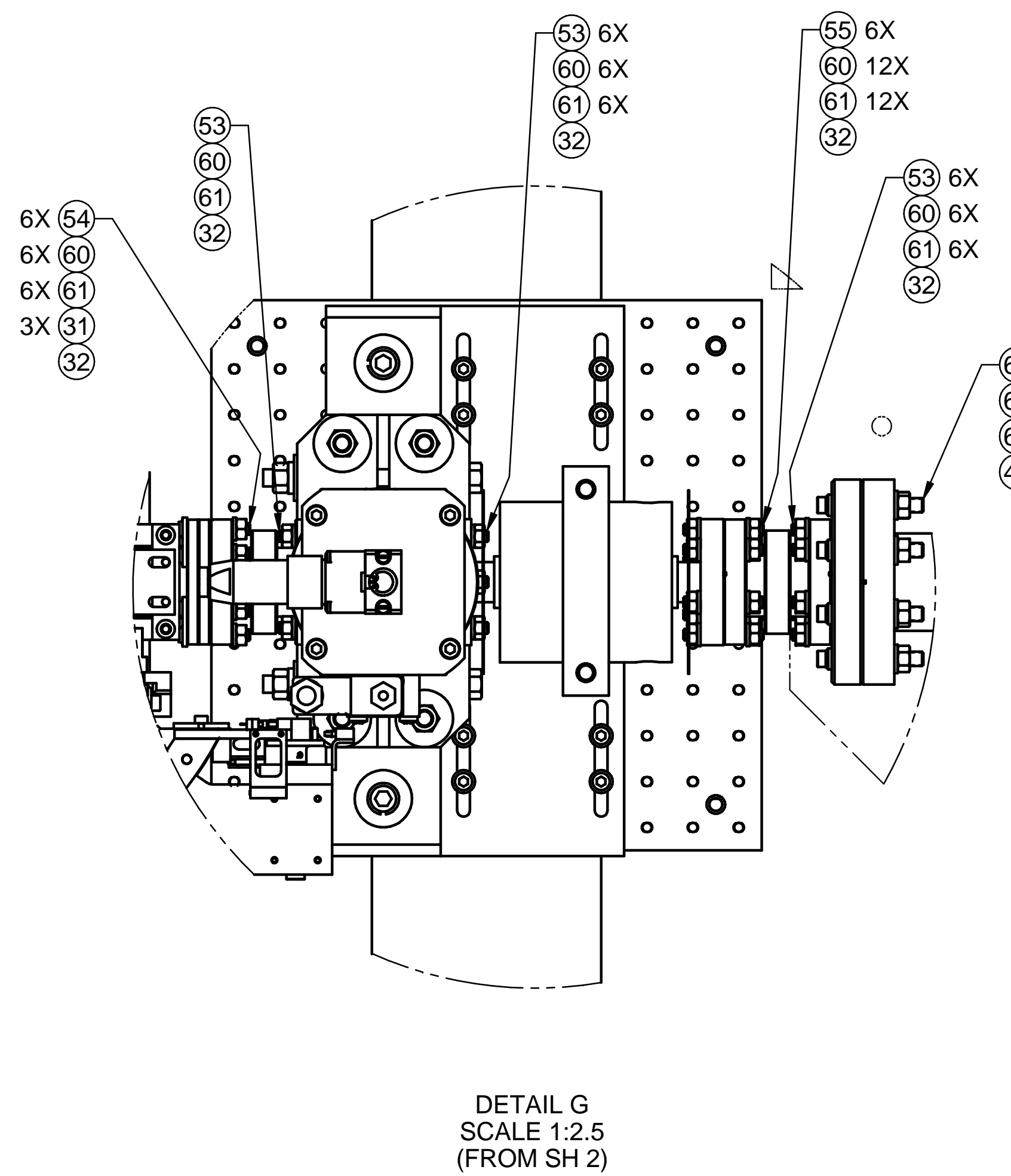
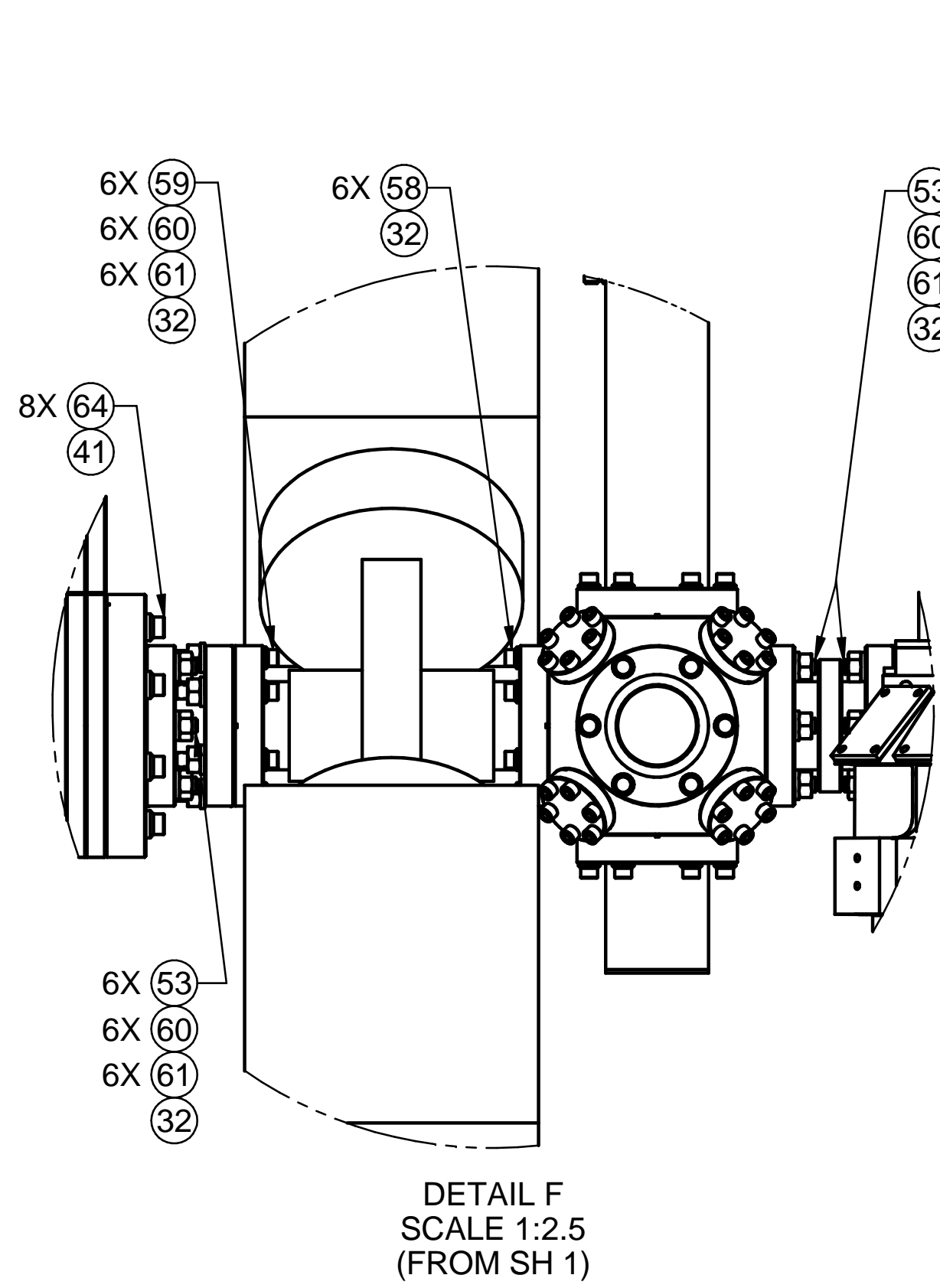
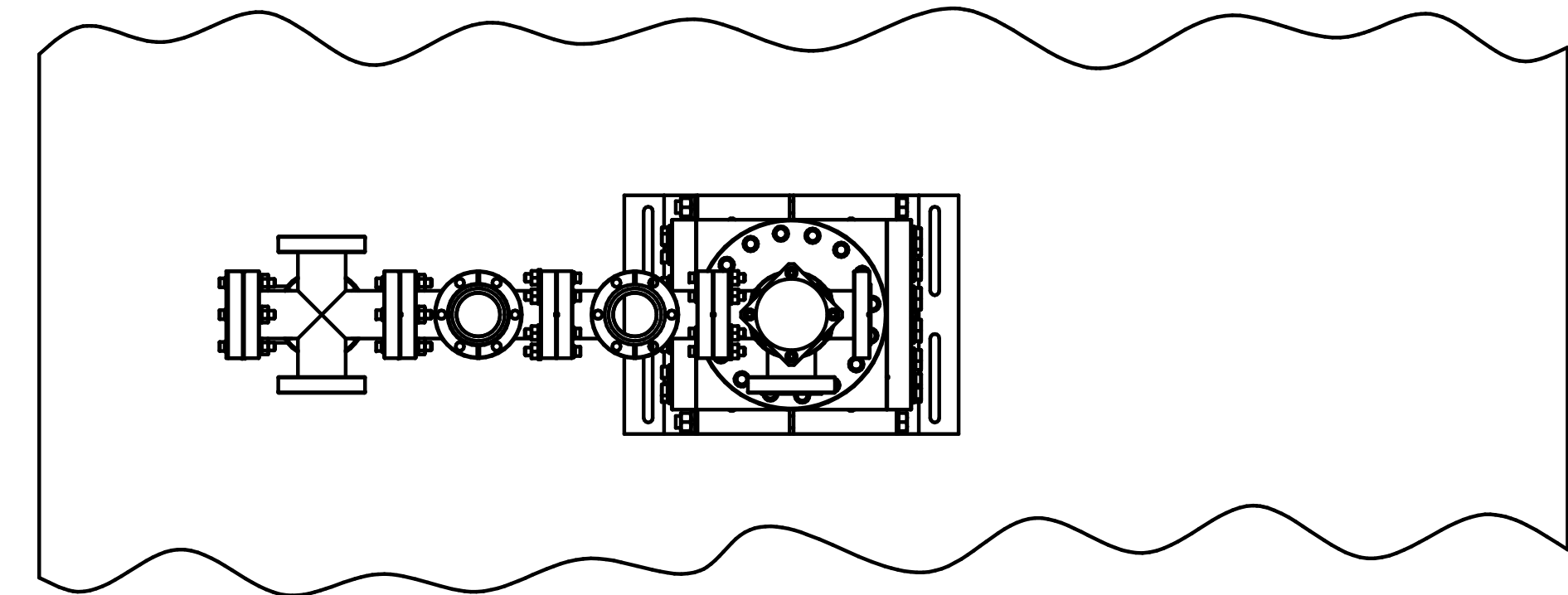
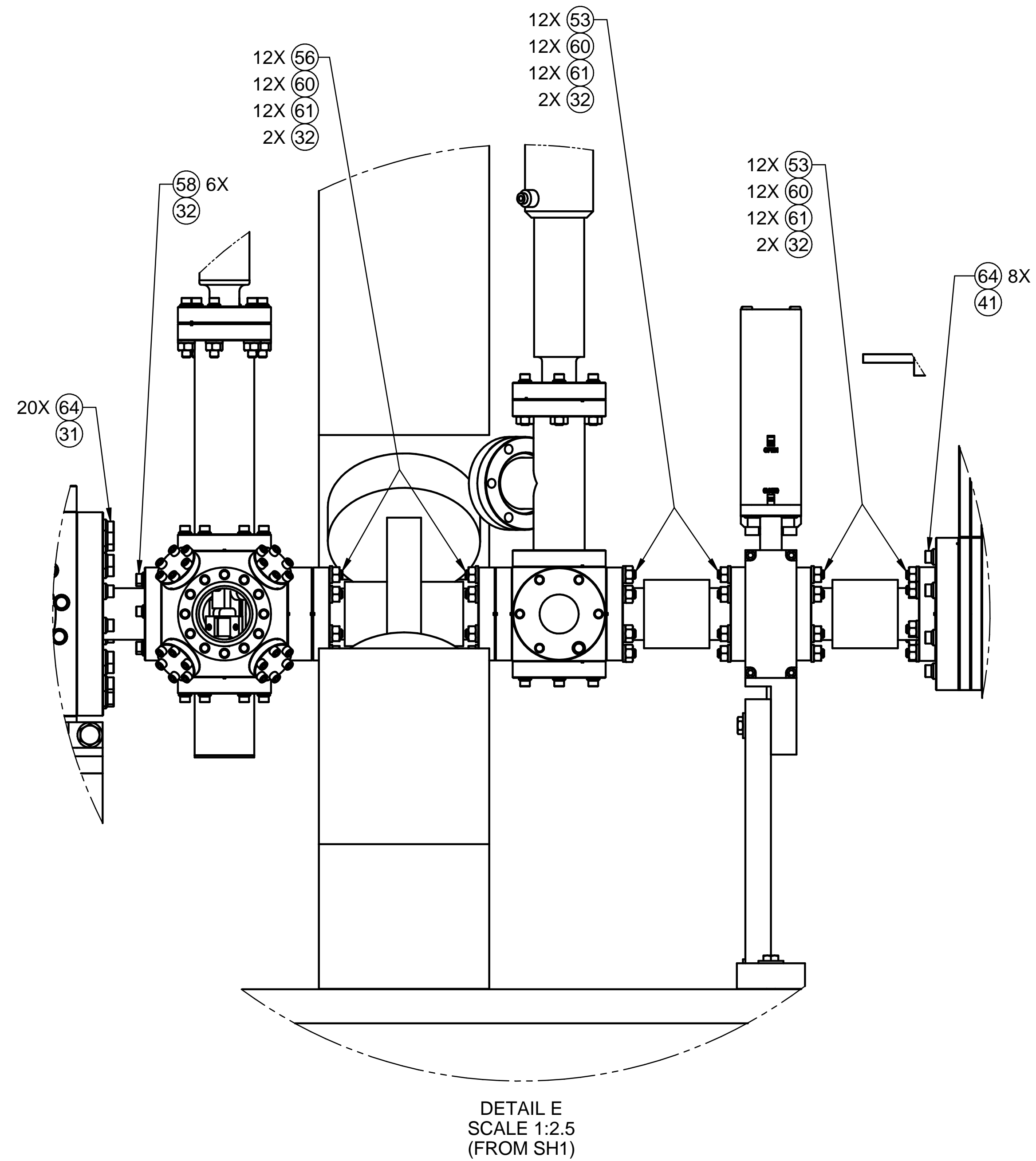
DETAIL C
 SCALE 1:2.5



DETAIL D
 SCALE 1:2.5

DIMENSIONING AND TOLERANCING IS MM UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES: BREAK EDGES: 009-015 INTERNAL CORNERS R.015 MAX FRACTIONS: 1/16 DEC: .XXX ANG: .XXX ALL SURF: ✓	SCALE: 1:10 DO NOT SCALE DRAWING	U.S. DEPARTMENT OF ENERGY SLAC NATIONAL ACCELERATOR LABORATORY	CAD FILE NAME: id25820017-0.dft
ID-257-500-56 NEXT ASSEMBLIES:	ENGR D. WALZ DWN G. BOUCHARD CHKR D. WALZ	DATE: 10/15/07 APPROVED BY: D. WALZ C. IVERSON	FACET INTEGRATION SYSTEMS 20-6 EXPERIMENTAL AREA PLASMA LONG OVEN INSTL DRAWING NUMBER: ID-258-200-17 REVISION NUMBER: 0

ID-258-200-17 0 E



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---	UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES. TOLERANCES ARE: BREAK EDGES: 0.009-0.015 INTERNAL CORNERS R.015 MAX FRACTIONS: 1/16	DO NOT SCALE DRAWING	U.S. DEPARTMENT OF ENERGY SLAC NATIONAL ACCELERATOR LABORATORY FACET INTEGRATION SYSTEMS 20-6 EXPERIMENTAL AREA PLASMA LONG OVEN INSTL
---	DEC: .XXX --- .XXXX --- .XXXXX --- ANGLE: ± --- ALL SURF. ✓	ENGR. D. WALZ DWN. G. BOUCHARD CHKR. D. WALZ	
---	ID-257-500-56 NEXT ASSEMBLIES:	DRAWING NUMBER: ID-258-200-17 REVISION NUMBER: 0	E

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