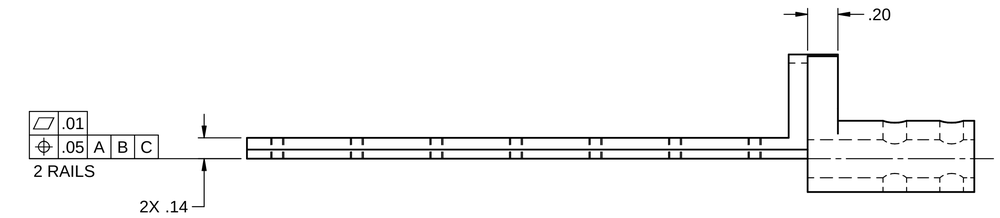
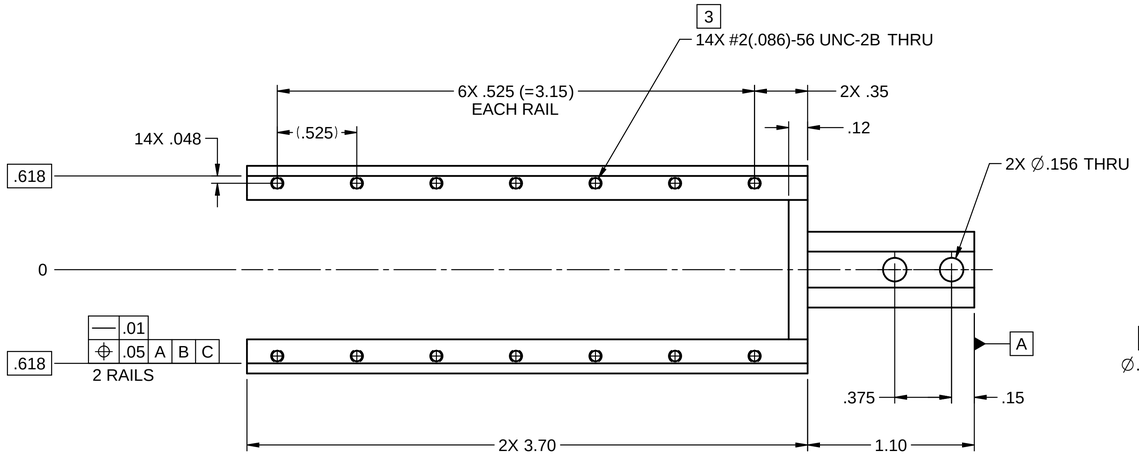
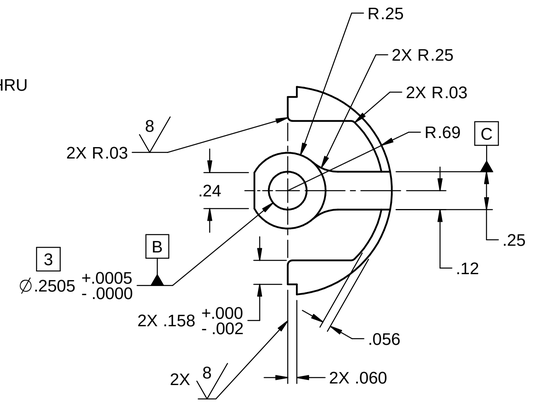
REV	DESCRIPTION	DWN	CHKR	APVD	DATE
D	PF-257-402-86 0				







NOTES: UNLESS OTHERWISE SPECIFIED

1 UHV HANDLING: AFTER UHV CLEANING OR PLATING, HANDLE WITH CLEAN LATEX OR NITRILE GLOVES IN/ON A CLEAN ROOM/SURFACE. FOR STORAGE OR SHIPPING: PLACE IN CLEAN, SEALED, VAC GRADE PLASTIC BAGS THAT ARE BACK-FILLED WITH NITROGEN, WITH PART NUMBER AND REV VISIBLE. ALTERNATIVELY, PARTS MAY BE WRAPPED IN CLEAN LINT FREE TISSUE AND UHV FOIL, AND SEALED IN CLEAN PLASTIC BAGS WITH PART NUMBER AND REV VISIBLE.

2 HEAT TREATMENT:
STEP 1: HARDEN MATERIAL BY HEATING IN A DRY HYDROGEN ATMOSPHERE TO 925-950C FOR 1/2 - 1 HR, THEN RAPIDLY COOL PART TO BELOW 150C
STEP 2: TEMPER MATERIAL BY HEATING IN A DRY HYDROGEN ATMOSPHERE TO 565-590C FOR 1/2 - 1 HR.

3 IF WIRE EDM IS USED AS A MANUFACTURING PROCESS, THEN ELECTROPOLISH, REMOVING .0003-.0005 PER SIDE. MASK THREADED HOLES AND ∅.2505 BORE BEFORE ELECTROPOLISHING.

ESTIMATED MASS
.106 lbm

UHV PART
SEE NOTE 1 FOR APPLICABLE SECTIONS OF FP-202-631-14

	SST AISI TYPE 410
STOCK NO	MATERIAL DESCRIPTION

SA-257-402-85
NEXT ASSEMBLIES:

DIMENSIONING AND TOLERANCING IS IAW ASME Y14.5M-1994 AND Y14.41-2003

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES.
TOLERANCES:
BREAK EDGES .005-.015
INTERNAL CORNERS R.015 MAX
FRACTIONS ± ---
DEC .XX± .01
.XXX± .005
.XXXX± ---
ANGLE ± ---
125 ALL SURF

SCALE: 2:1 DO NOT SCALE DRAWING

CAD FILE NAME: pf25740286-0.dft

U.S. DEPARTMENT OF ENERGY
SLAC NATIONAL ACCELERATOR LABORATORY

		APPROVALS	DATE
ENGR	D. WALZ	D. WALZ	
DWN	G. BOUCHARD 10/29/2012	J. STIEBER	
CHKR	D. WALZ	---	

FACET DIAGNOSTICS PLASMA OVEN OTR FOIL AND DISK FORK

DRAWING NUMBER: PF-257-402-86
REVISION NUMBER: 0
D
SH 1 OF 1

FACET DIAG PLASMA FOIL DISK FK