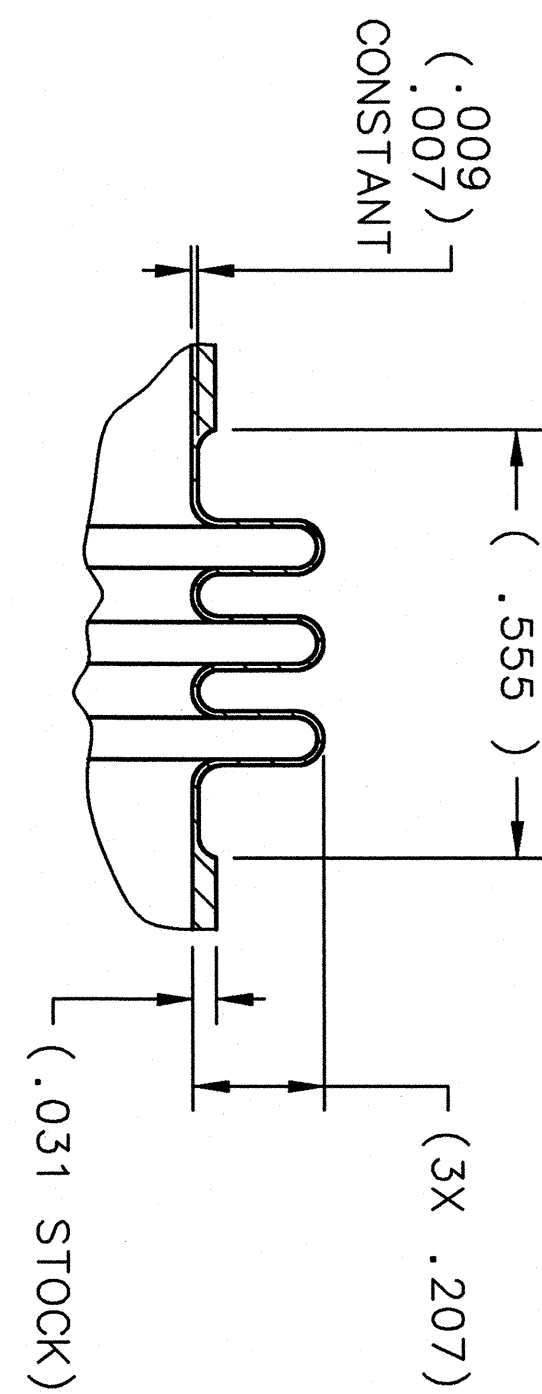


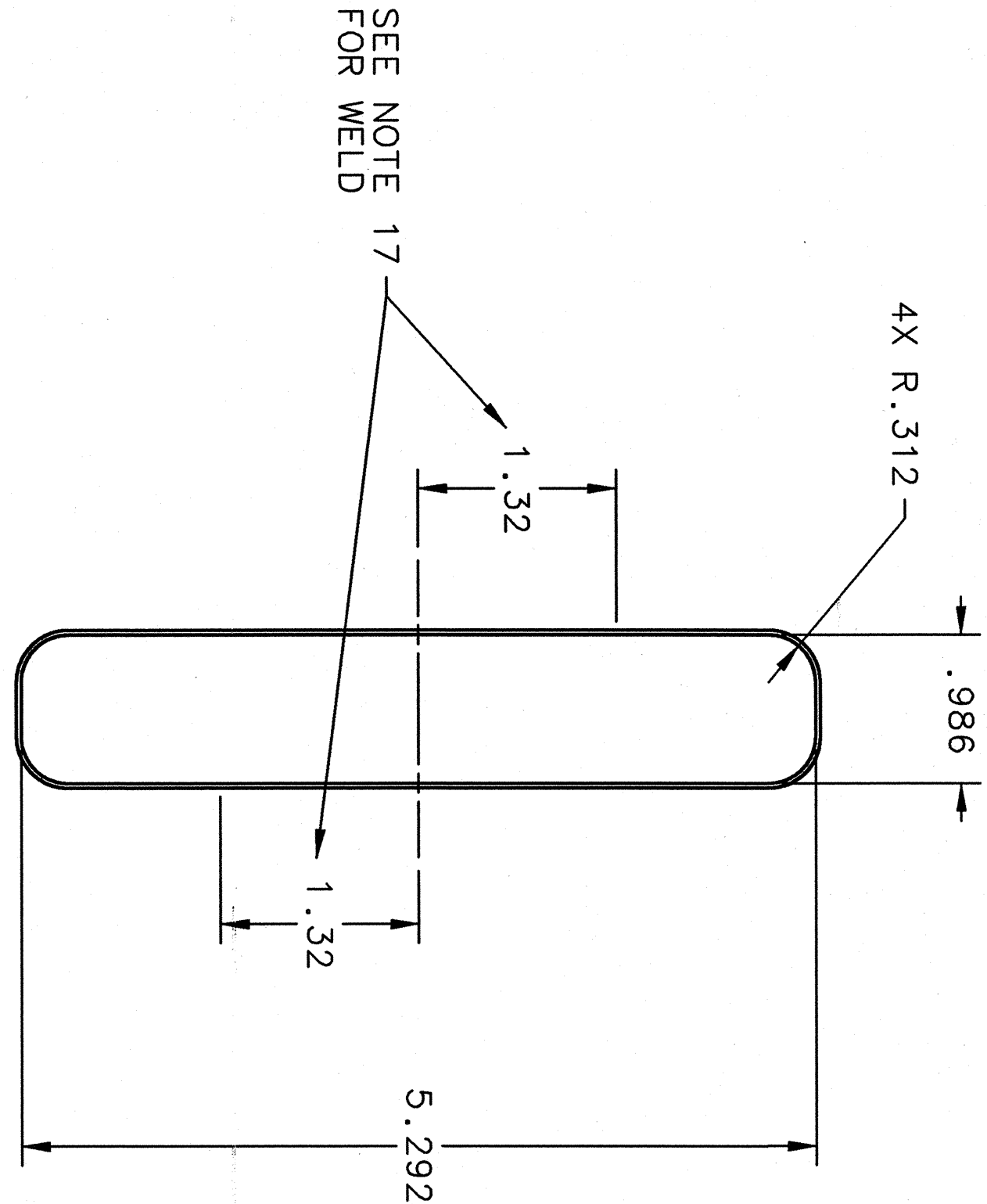


SECTION C-C

SCALE: 4:1

SCALE: 4:1

- NOTES:
1. MAXIMUM WALL THICKNESS: .031 INCH.
 2. NET AXIAL DISPLACEMENT: $\pm .06$ INCH MIN.
 3. NET LATERAL DISPLACEMENT: $\pm .30$ INCH MIN.
 4. AXIAL SPRING RATE: ~ 340 LB/IN.
 5. LATERAL SPRING RATE: ~ 500 LB/IN.
 6. OPERATING TEMPERATURE: 2K-350K, ITEM 4 TO BE HELD AT 50K.
 7. INTERNAL PRESSURE: 10-8 TORR TO ATM PRESSURE.
 8. EXTERNAL PRESSURE: 10-7 TORR TO ATM PRESSURE.
 9. CYCLES AT FULL TRAVEL: 1000.
 10. VSMR: 1.1 FOR FREQUENCY RANGE BETWEEN 1497 GHZ AND 5 GHZ.
1.3 FOR FREQUENCY RANGE BETWEEN 5 GHZ AND 10 GHZ.
THIS DESIGN MEETS THIS VSMR REQUIREMENT.
 11. IF THE SELLER ELECTS TO WELD STAINLESS STEEL WITH THE GTAW METHOD, THE WELDING SHALL BE IN ACCORDANCE WITH SPEC 22633-S-001. IF THE SELLER WISHES TO USE ANOTHER WELDING TECHNIQUE, WRITTEN PROCEDURES MUST BE SUBMITTED TO THE BUYER FOR APPROVAL PRIOR TO ASSEMBLY.
 12. ALL WELDING SHALL BE COMPLETED PRIOR TO BRAZING.
 13. COPPER PLATING OF INSIDE OF WAVEGUIDE SHALL BE PERFORMED IN ACCORDANCE WITH 115070-1001S REV "B".
 14. FURNACE BRAZE INTERCEPT PLATE ASSY, ITEM 2, TO WAVEGUIDE TUBE, ITEM 1, USING HARDY AND HARMAN ALLOY 604 (AMS CLASSIFICATION BV49-18 OR EQUAL). FURNACE BRAZE HEAD TRANSFER PLATE, ITEM 4, TO INTERCEPT PLATE ASSY, ITEM 2, USING PREVIOUSLY SPECIFIED BRAZE MATERIAL. INSURE THAT NO BRAZE MATERIAL IS DEPOSITED WITHIN ANY OF THE TAPPED HOLES ON ITEM 4.
 15. CLEAN AND HANDLE PER 22632-S-001 OR VENDOR SPEC APPROVED BY JEFFERSON LAB.
 16. PART SHALL BE LEAK TIGHT PER 111415S0029. TEST BEFORE AND AFTER COPPER PLATING (IF PLATED).
 17. ITEM #1 MAY BE FABRICATED BY FORMING, ROLLING AND WELDING. HOWEVER, THE WELD MUST BE PLACED ON THE BROAD SIDE OF THE ASSEMBLY, PER DIMENSIONS SHOWN, ABOVE OR BELOW THE HORIZONTAL CENTRAL LINE.



SECTION B-B

PROFILE OF ITEM 1
NOTE: ITEM 6 REMOVED FOR CLARITY

ITEM NO.	REV.	DESCRIPTION	QTY	UNIT	REMARKS
1	6	115120-1007C			WMEQUIDE-FPC FLANGE DETAIL
1	5	MOC 203947			WMEQUIDE FLANGE
2	4	CRM-100-7070-0003			HEAT TRANSFER PLATE DETAIL
6	3	115120-1003C			WMEQUIDE STIFFENER DETAIL
1	2	CRM-100-7070-0006			INTERCEPT PLATE ASSY
1	1	-			WMEQUIDE BELLGOWN TUBE
1	1	-			.031 STAINLESS STEEL

[illegible]