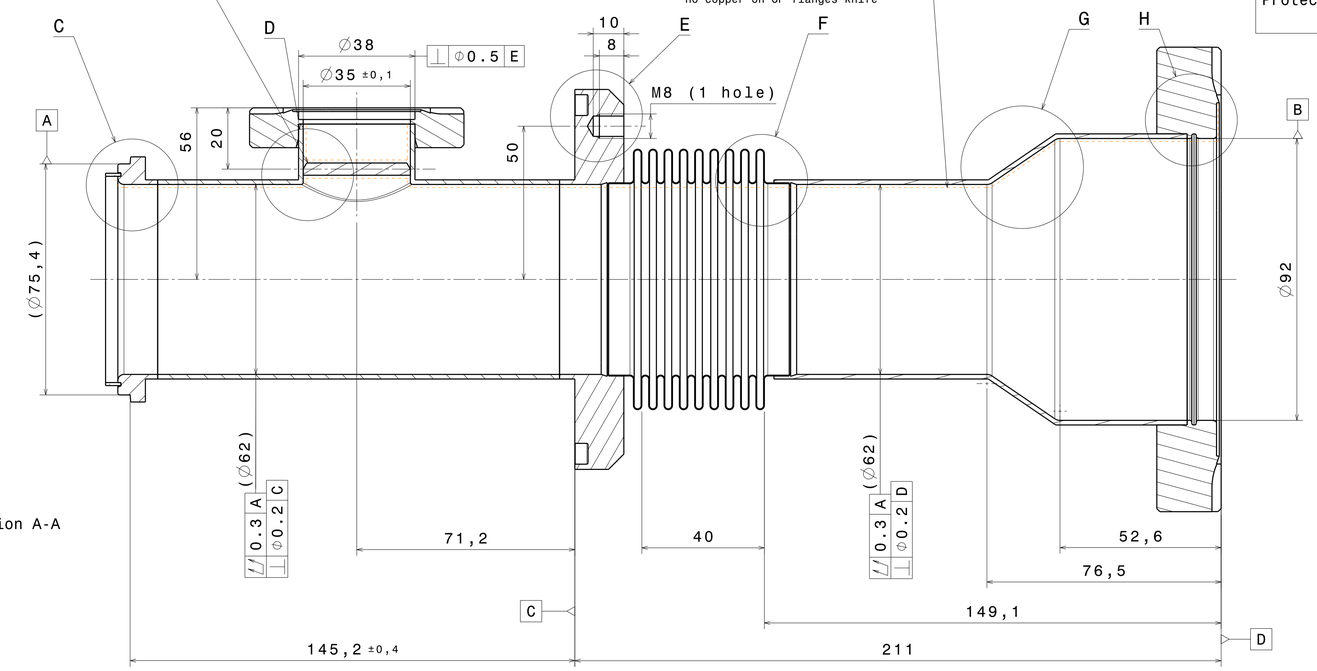
Rounded edges R0,6 all around

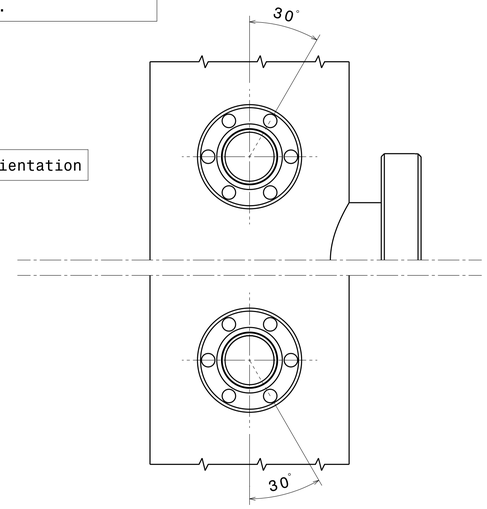
Copper platling of internal surfaces 10±5µm
no copper on CF flanges knife

Protect copper ring and flanges (knife) and contact surfaces from scratches or any damage.



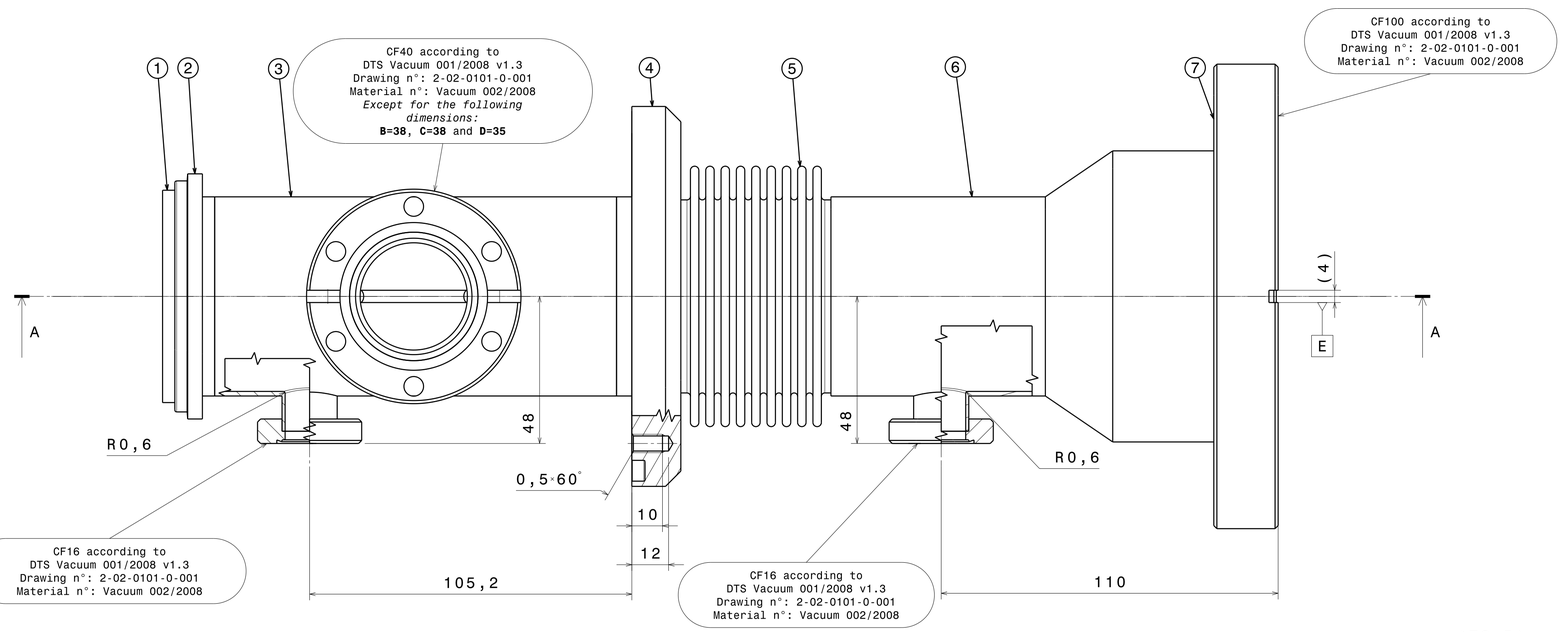
Section A-A

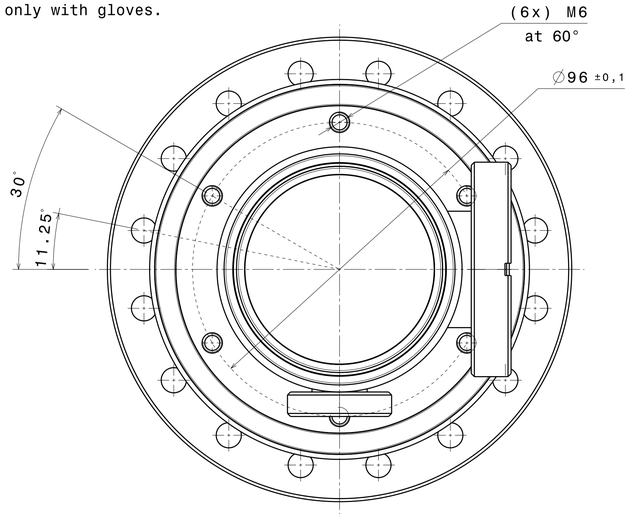
Respect the angular orientation

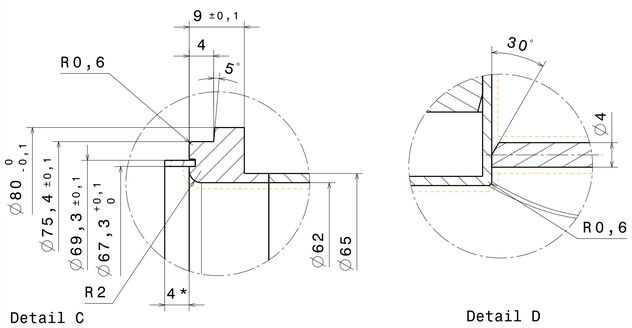


1) All parts to be washed, cleaned and dried with N2.
2) Weld stainless parts together. Internal welds smoothed out (no peaks nor ridges).
3) H2 degas in clean vacuum oven at 950°C for 2 hours.
4) Braze under vacuum copper ring.
5) Copper plating of internal surfaces 10±5µ without H2:
   -copper plating also on face of big flange.
   -presence of copper plating inside the tubular junction for CF16 flange is acceptable.
6) Bake the assembly for 2 hours at 400°C under vacuum.

Handle only with gloves.

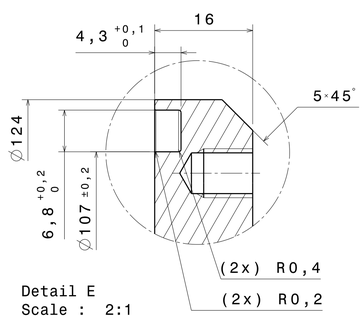






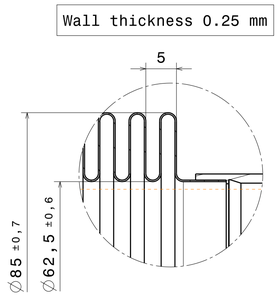
Detail C
Scale : 2:1 * Adjust according to I72-WP-001

Detail D
Scale : 2:1

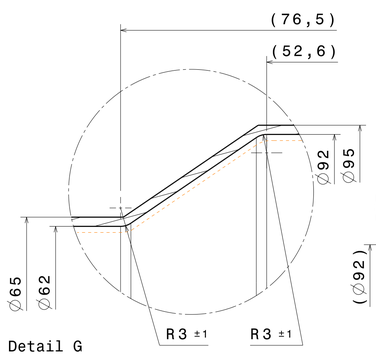


Detail E
Scale : 2:1

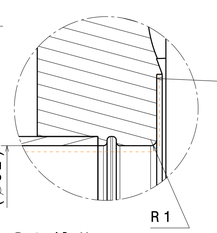
Wall thickness 0.25 mm



Detail F
Scale : 2:1



Detail G
Scale : 2:1



Detail H
Scale : 2:1

Copper plating ends here

Rep.	Designation	Material
1	Copper ring	Cu OFHC
2	Left ring	316L
3	Warm tube	316L
4	Flange on vacuum vessel	316L
5	Warm bellow (9 waves)	316L
6	Conical tube	316L
7	CF100 flange	316LN

Format A1

Ind.	Date	Modification	By

X-FEL Coupler

Warm Part

Warm external Conductor

Gen. Tol.: -ISO 8015 -ISO 2768 class mH
Surface finish: -ISO 1302 Ra 1.6
Material

Drawn by	Y.PEINAUD	30/11/09
Checked by	M.LACROIX	30/11/09
Approved by	A.FALOU/W-D.MÖLLER	

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Scale 1/1 | I72-WP-003 | Index A