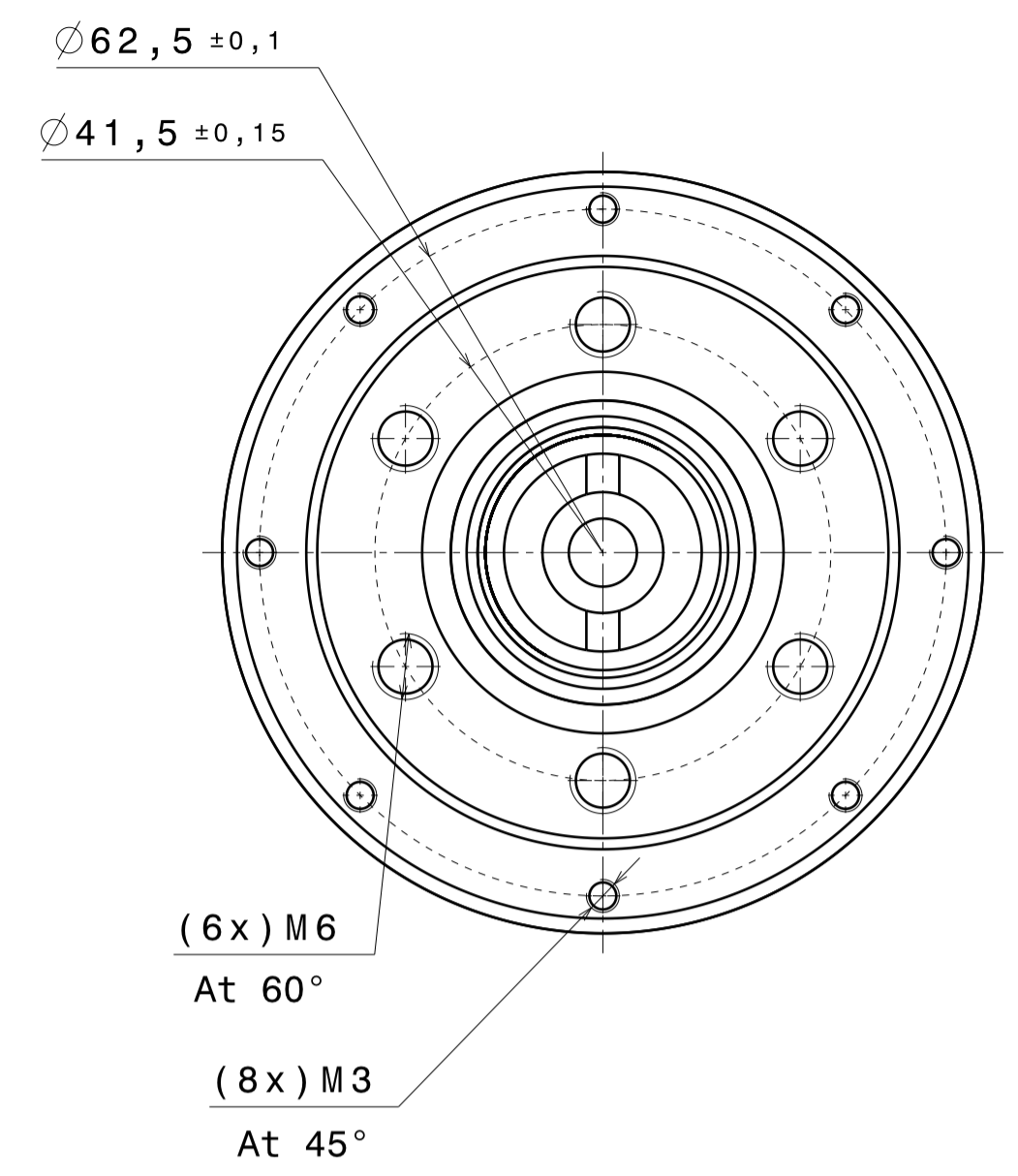


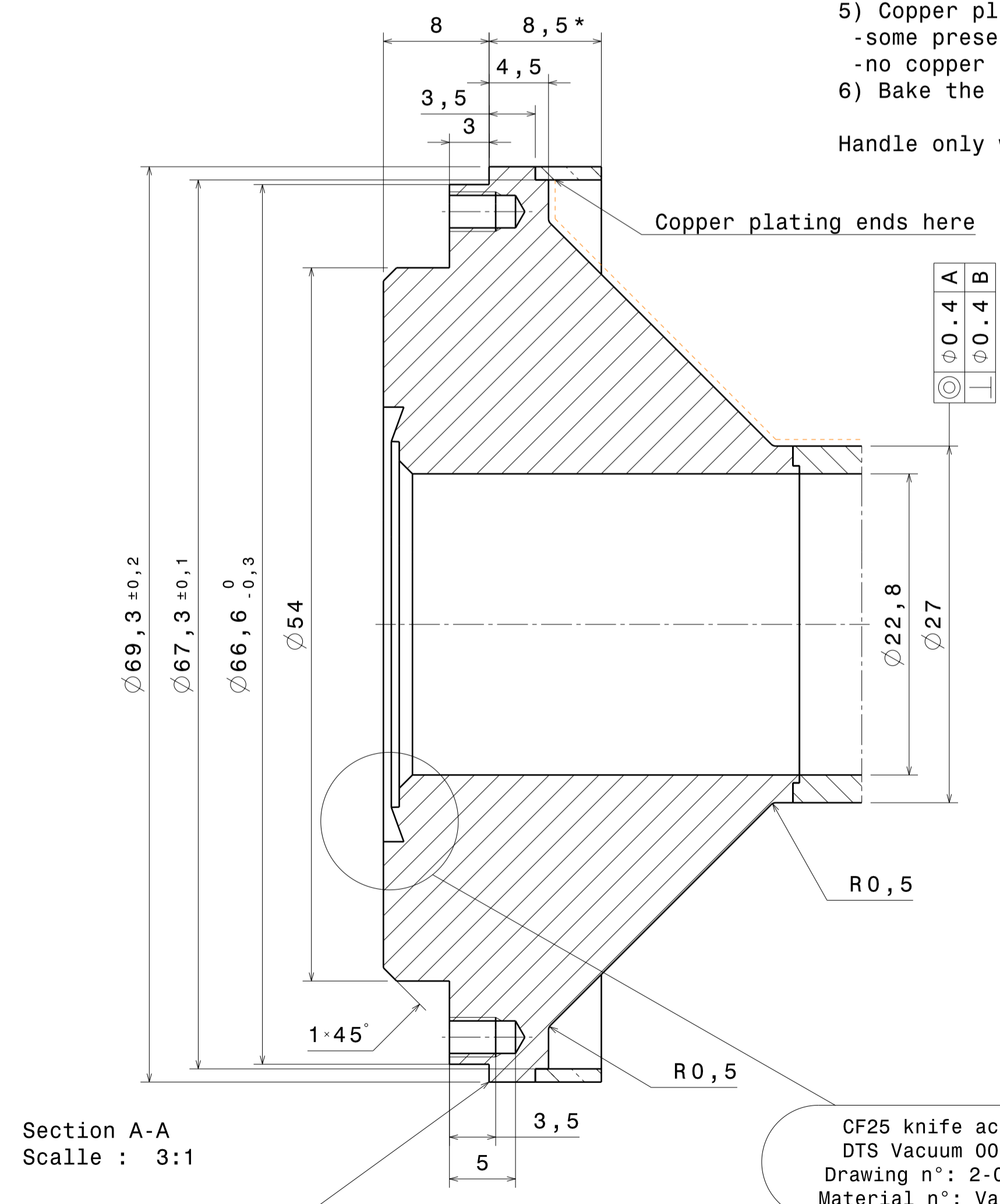
Protect copper ring, flange (knife) and contact edges or surfaces from scratches or any damage.

Respect the angular orientation



- 1) All parts to be washed, cleaned and dried with N2.
- 2) Weld stainless parts together. External surface of welds should be smoothed out (no peaks, no ridges).
- 3) H2 degas in clean vacuum oven at 950°C for 2 hours.
- 4) Braze under vacuum copper ring.
- 5) Copper plating of external surfaces 30±10µm without H2
-some presence of copper plating on internal surfaces is acceptable
-no copper on contact surface of doorknob
- 6) Bake the assembly for 2 hours at 400°C under vacuum.

Handle only with gloves.

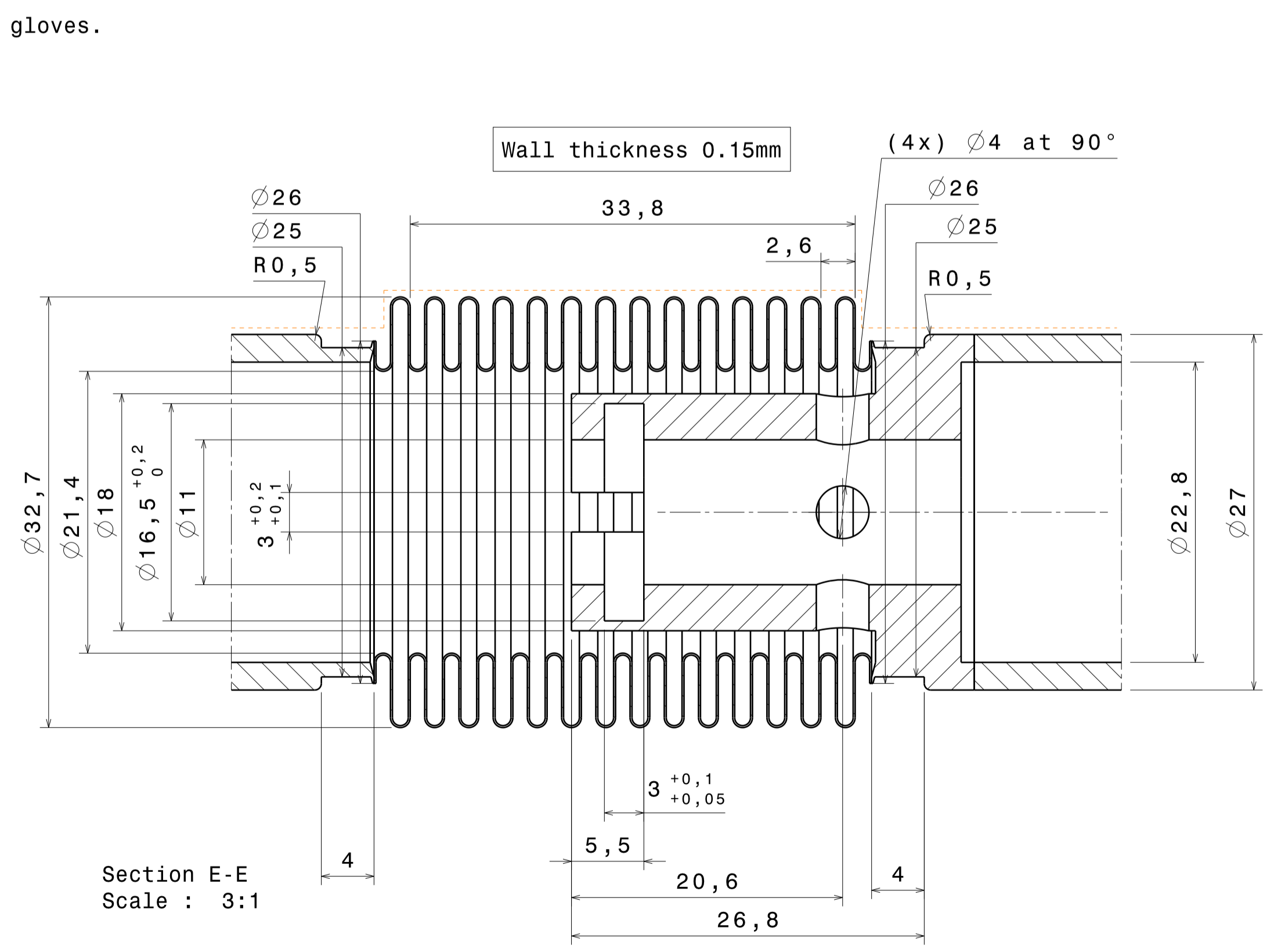


Section A-A
Scale : 3:1

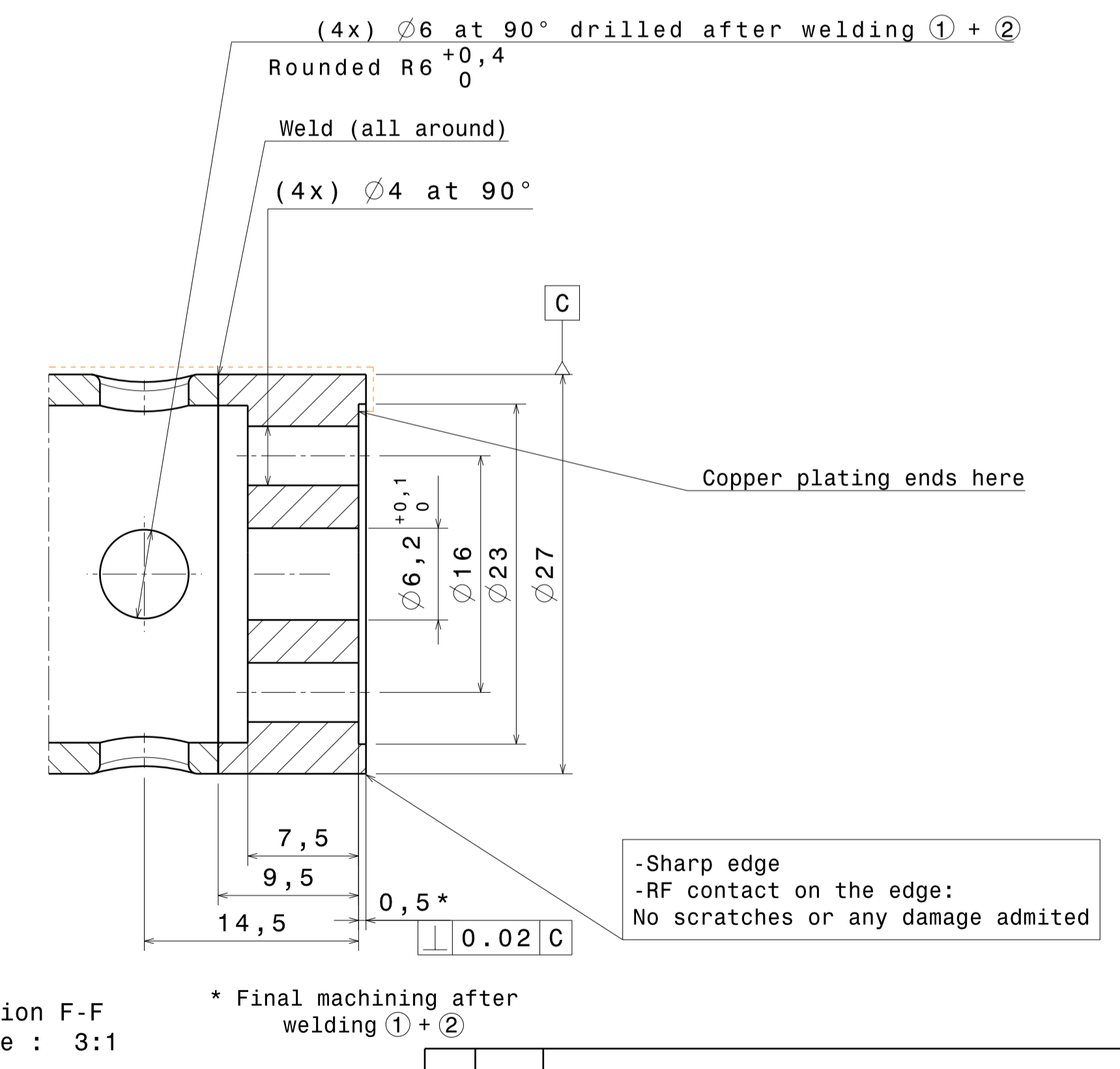
CF25 knife according to DTS Vacuum 001/2008 v1.3
Drawing n°: 2-02-0101-0-001
Material n°: Vacuum 002/2008

RF contact on the edge:
No scratches or any damage admitted

* Adjust according to I72-WP-001



Section E-E
Scale : 3:1



Section F-F
Scale : 3:1

* Final machining after welding ① + ②

-Sharp edge
-RF contact on the edge:
No scratches or any damage admitted

Rep.	Designation	Material
1	Right Tip	316L
2	Right Tube	316L
3	Inner socket	316L
4	Inner warm bellow (14.5 waves)	316L
5	Left Tube	316L
6	Doorknob	316LN
7	Copper ring	Cu-OFHC

Ind.		Date	Modification		By
X-FEL Coupler					
Warm Part					
Warm internal Conductor					
Gen. Tol.: ±0.015		class mH		Surface finish: Ra 1.6	
Bat. 208, BP 34, 91898 ORSAY CEDEX		Tel. +331 64 46 83 00		Scale 3/2	
LABORATOIRE DE L'ACCELERATEUR LINEAIRE		Scale 3/2		Index A	
Drawn by Y. PEINAUD		30/11/09		30/11/09	
Checked by M. LACROIX		30/11/09		Approved by A. FALOU/W.-D. MÖLLER	
I72-WP-002					

Format A1