

13. CLOCKING OF VENT HOLES ARBITRARY.

25 mm

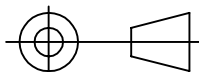
REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
A	BASELINE RELEASE	7/10/97	D.S.
B	DEL. VENT HOLES IN 8079 ADD VENT SLOTS IN 8081	8/20/97	J.S.

NOTES (UNLESS SPECIFIED OTHERWISE):

- NICKEL PLATING OF KOVAR PARTS ALLOWED AS A BRAZE PREP.
- ALL ITEMS TO BE LOCATED WITHIN A TOLERANCE OF $\text{C}\text{O}\text{D}\text{O}1\text{B}$
- CLEAN AND DEGREASE ALL PARTS PRIOR TO BRAZING. CERAMIC PARTS TO BE KEPT FREE OF METAL MARKS.
- BRAZE PARTS USING .002" CUSIL PREFORM DIMENSIONED AS REQ'D TO MEET FOLLOWING BRAZE FILL/RUNOUT SPECIFICATION.
- BRAZE RUNOUT ONTO UNMETALLIZED CERAMIC FACES NOT TO EXCEED 0.2mm. AT EACH JOINT BRAZE MUST JOIN AT LEAST 95% OF NOMINAL CONTACT SURFACE AREA.
- LEAK PATHS THRU BRAZE JOINT NOT ALLOWED. ASSEMBLY MUST BE HERMETIC TO 1×10^{-10} ATM-CC/SEC HELIUM.
- DIMENSIONS AND TOLERANCES TO BE MAINTAINED ON FINISHED ASSEMBLY.
- MATERIAL CERT'S AND LEAK CHECK TEST DATA REQUIRED.
- AT DISCRETION OF VENDOR, AN ELECTROPOLISHING STEP MAY FOLLOW BRAZING TO REMOVE ANY RESIDUAL CONTAMINANTS, OXIDES, BURRS, ETC. THOROUGHLY REMOVE ELECTROPOLISHING SOLUTION.
- PACKAGE PARTS TO PROTECT FROM MOISTURE, CONTAMINATION, AND OTHER DAMAGE THAT MIGHT NORMALLY OCCUR DURING SHIPMENT.
- NO BRAZE MATERIAL ON CURVED SURFACE.
- AT DISCRETION OF VENDOR, A FINAL MACHINING STEP MAY BE DESIRED TO COMPLETE PART (CURVED SURFACE AND I.D.) TO SPECIFICATIONS.

5	1	8083-A3 (PREV. 8561)	TOP FLANGE	
4	1	8082-A3 (PREV. 8560)	UPPER CERAMIC	
3	1	8081-A3 (PREV. 8559)	MCP OUTPUT FLANGE	
2	1	8080-A3 (PREV. 8558)	LOWER CERAMIC	
1	1	8079-A3 (PREV. 8557)	BOTTOM FLANGE	
ITEM#	QTY	PART NUMBER	NOMENCLATURE	MATERIAL SPECIFICATION

THIRD ANGLE PROJECTION



TOLERANCES (EXCEPT AS SPECIFIED)		
OVER	TO	TOLERANCE
0	49.99	± 0.1
50	249.9	± 0.5
250	-	± 1
ANGLES		
		$\pm 0.1^\circ$

SURFACE FINISH

SURFACE TREATMENT

MASS

DO NOT SCALE DRAWING
METRIC DRAWING
(UNITS: mm)

INTERPRET PER ANSI Y14.5-1982
WELDING SYMBOLS PER ANSI/AWS A2.4-79

APPROVALS

DATE

DRAWN J. STOCK 7/1/97

CHECKED D.S. 7/2/97

ISSUED J. STOCK 7/10/97

Experimental Astrophysics Group
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DWG TITLE
BRAZED ASSEMBLY
WIC DETECTOR

SIZE B PROGRAM IMAGE DWG. NO. 8078-A3 REV B
PREV. 8556

SCALE 2:1 SHEET 1 OF 1

NEXT QTY REQD PER ASSY	FINAL	NEXT ASSY	USED ON
			APPLICATION