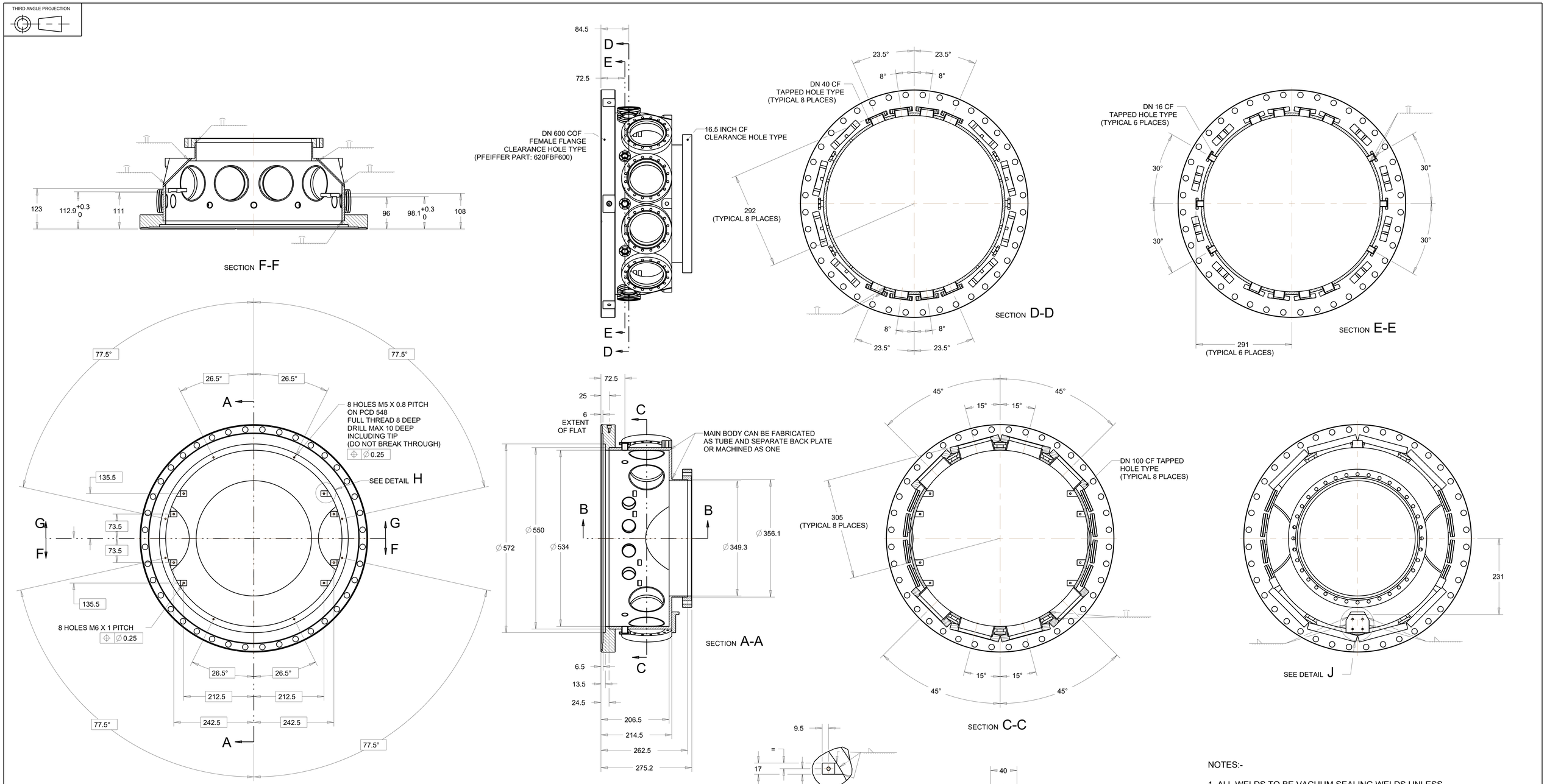
THIRD ANGLE PROJECTION



NOTES:-

1. ALL WELDS TO BE VACUUM SEALING WELDS UNLESS OTHERWISE STATED.
2. ALL VACUUM SEALING SURFACES TO BE FREE FROM RADIAL SCRATCHES AND VISIBLE DEFECTS SUCH AS PITTING, CRACKS AND INDENTATIONS.
3. VACUUM VESSEL IS TO BE MANUFACTURED TO DARESBURY LABORATORY SPECIFICATION ASTEC-VAC-QCD-spc-002
4. VACUUM VESSEL IS TO BE CLEANED IN ACCORDANCE WITH DARESBURY LABORATORY SPECIFICATION ASTEC-VAC-QCD-spc-003
5. VACUUM VESSEL IS TO BE TESTED TO A LEAK RATE <5e10^-12 mbar.l/s AND AN OUTGASSING RATE <5e10^-14 mbar.l/s/cm^2 IN ACCORDANCE WITH DARESBURY LABORATORY SPECIFICATION ASTEC-VAC-QCD-spc-004

ISSUE	DATE	NAME	DESCRIPTION
D	23-Apr-19	D.SEDDON	NOTE 5 CHANGED.
C	02-Apr-19	D.SEDDON	NOTE ADDED TO DN COF 600 FLANGE TO IDENTIFY IT AS PFEIFFER PART 620FBF600
B	17-Sep-18	D.SEDDON	MIDDLE L.H VIEW 6 HOLES M5 X 7 DEEP ON PCD 56 REMOVED. 8 HOLES M5 X 8 DEEP ON PCD 548 ADDED.
A	10-Apr-18	D.SEDDON	FIRST ISSUE

MODIFICATIONS

UNLESS OTHERWISE SPECIFIED:-	METRIC SCREW THREADS TO BS3643 CLASS 6H/6g	DRAWING PRACTICE AND TOLERANCE INTERPRETATION TO BS308	WELDING SYMBOLS TO BS 499
ALL DIMENSIONS IN MILLIMETRES	TOLERANCES UNLESS OTHERWISE SPECIFIED	MATERIAL: ST. STEEL	DRAWN: D.SEDDON
SURFACE TEXTURE VALUES IN MICROMETRES	MACHINED DIMS. ± 0.25	SPEC: 316L	DATE: 10-Apr-18
SURFACE TEXTURE TO BE N8 ✓	ANGULAR ± 0.15°	TREATMENT: NONE	CHECKED: -
MACHINE ALL OVER OR WHERE MARKED ✓		FINISH: NATURAL	APPROVED: -
REMOVE BURRS AND BREAK SHARP EDGES	DO NOT SCALE		

THE UNIVERSITY OF LIVERPOOL
DEPARTMENT OF PHYSICS

PROJECT: ISOL-WP2

TITLE: DSSSD WALL CHAMBER WELDED ASSEMBLY STANDARD DN 100 CF FLANGE VERSION

DRAWING NUMBER: NP70-01-4270

ARRGT. DRAWING: NP70-01-2190

SHEET 1 OF 2 SHEETS SCALE:- 0.250 A0