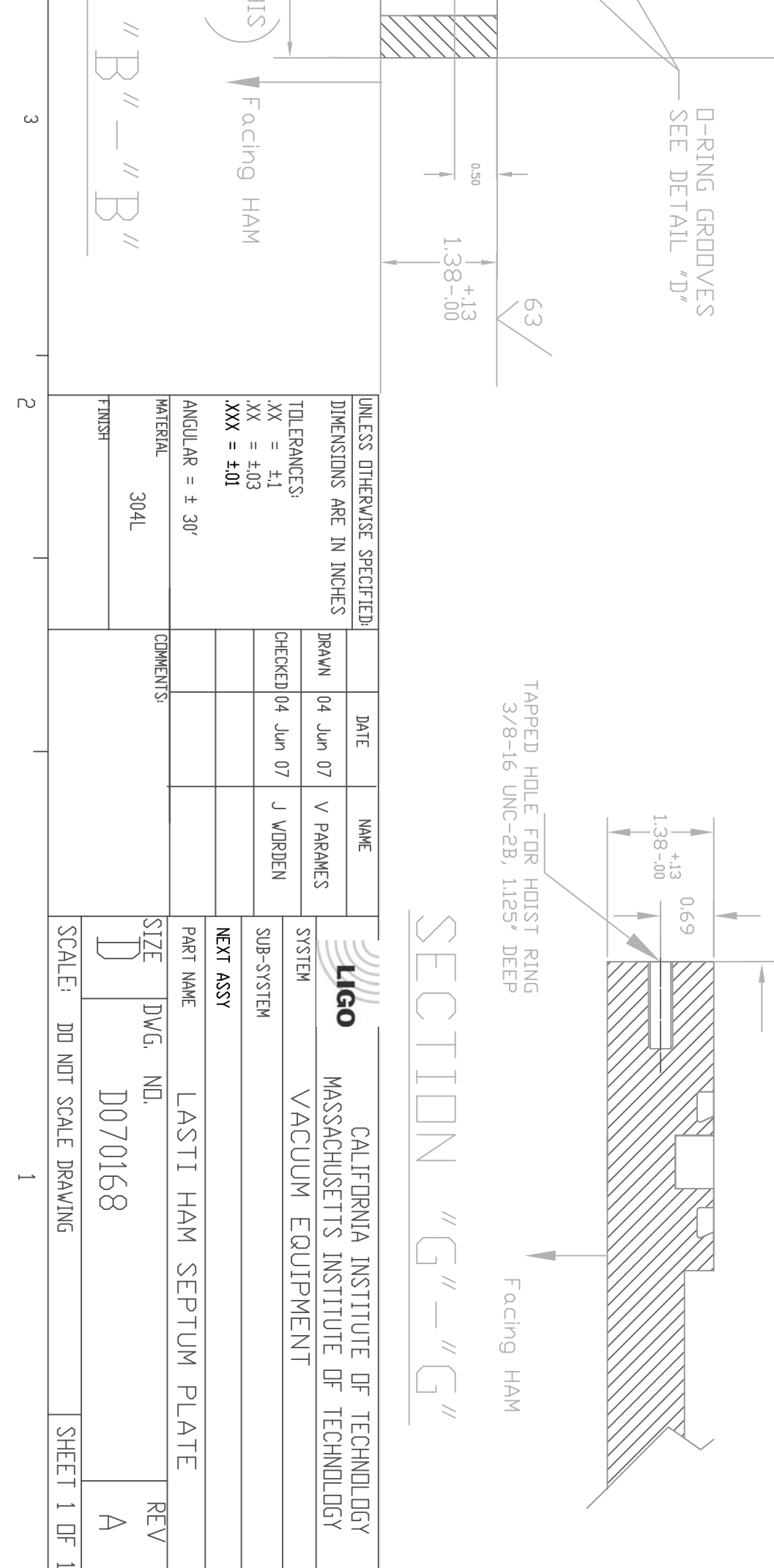
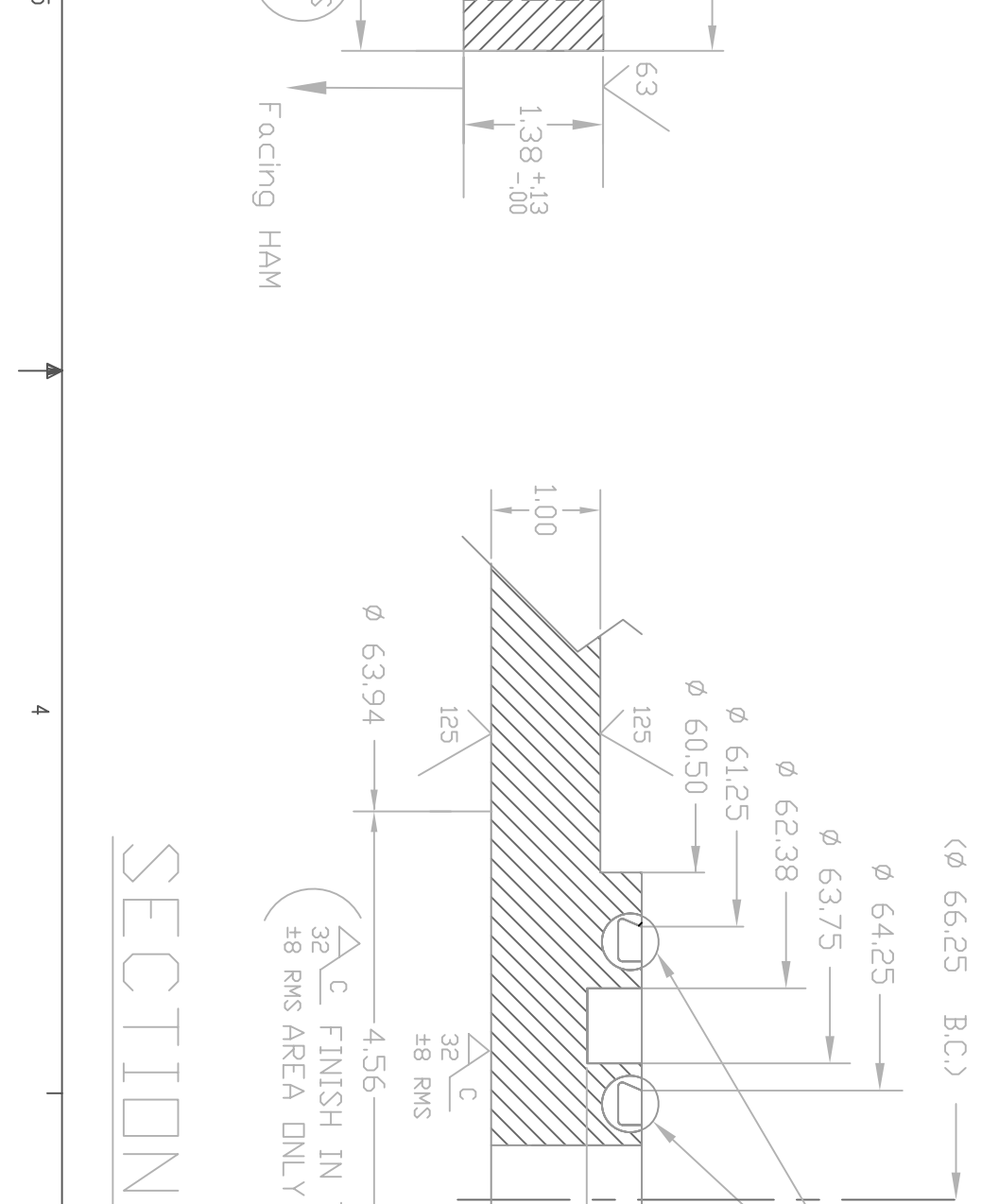
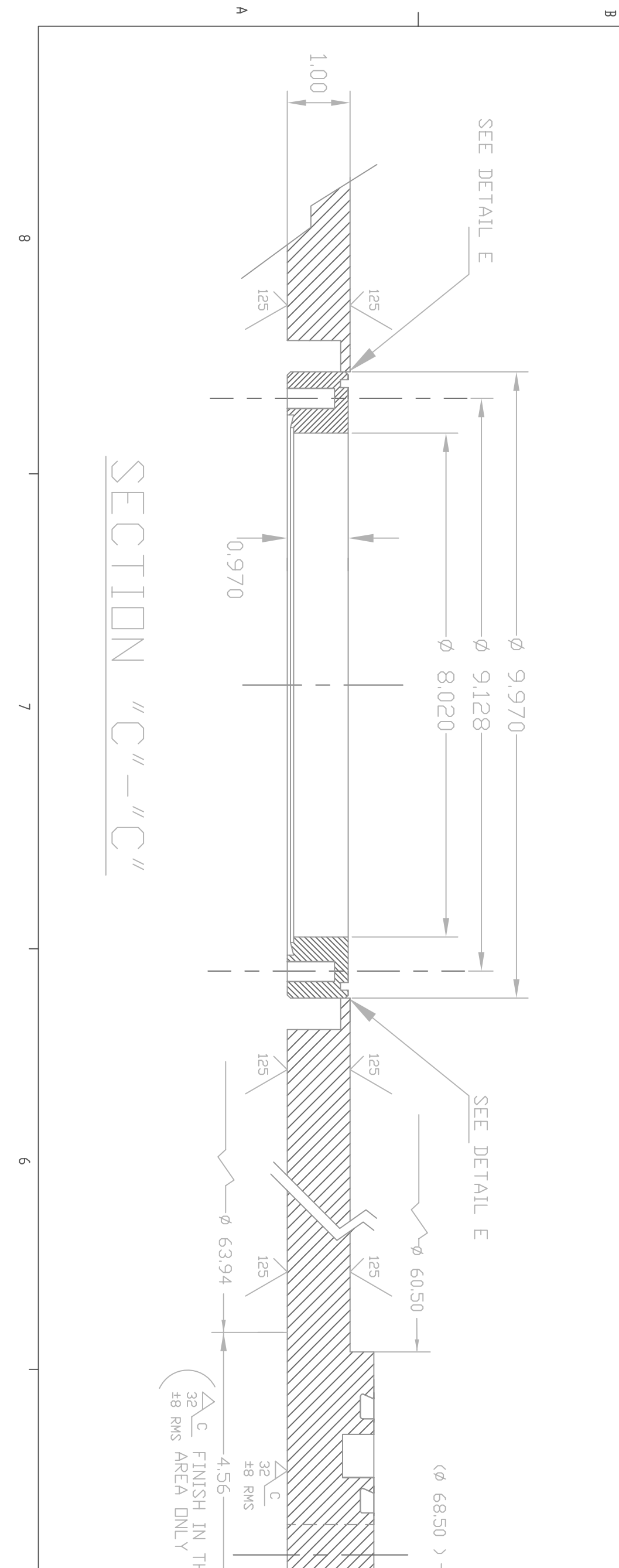
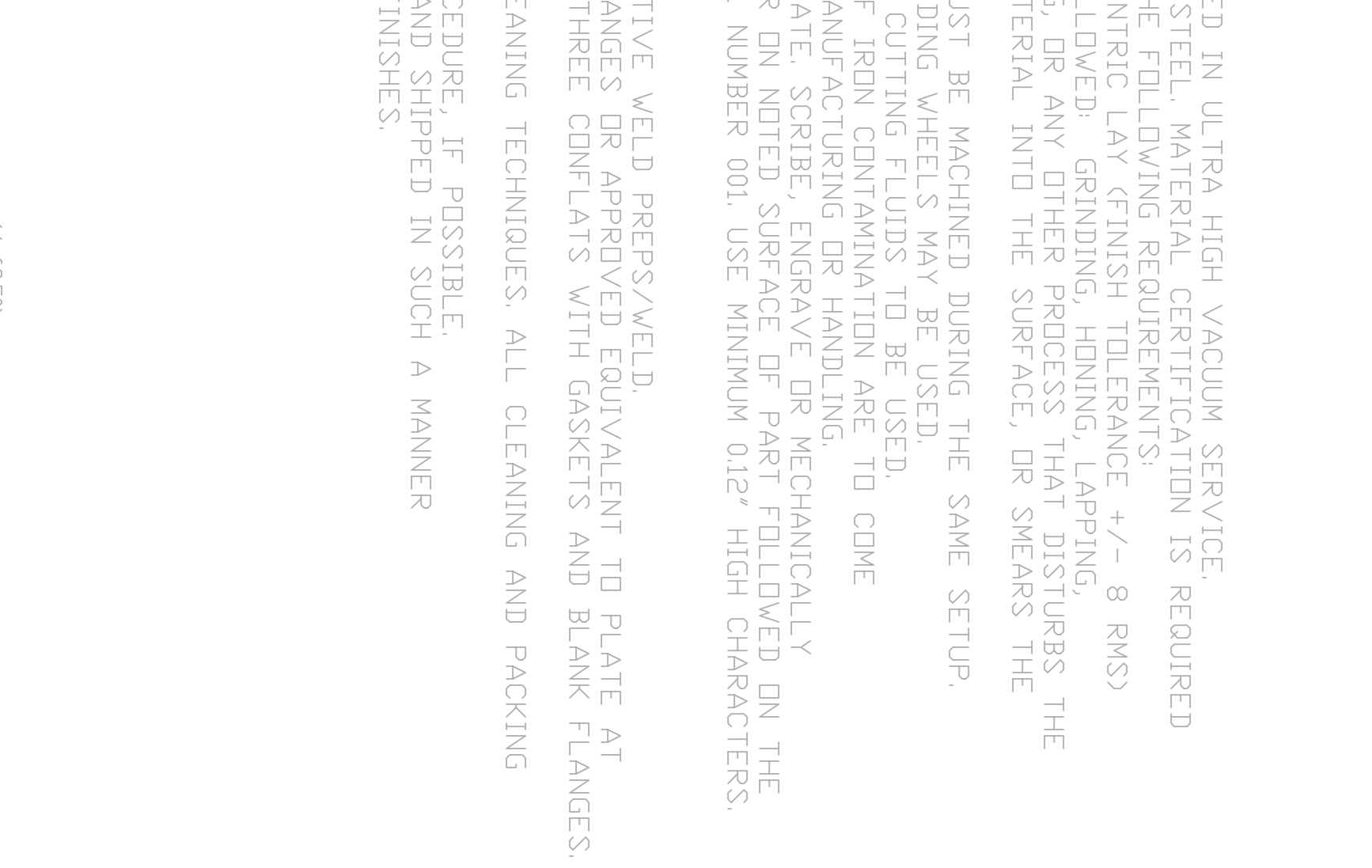
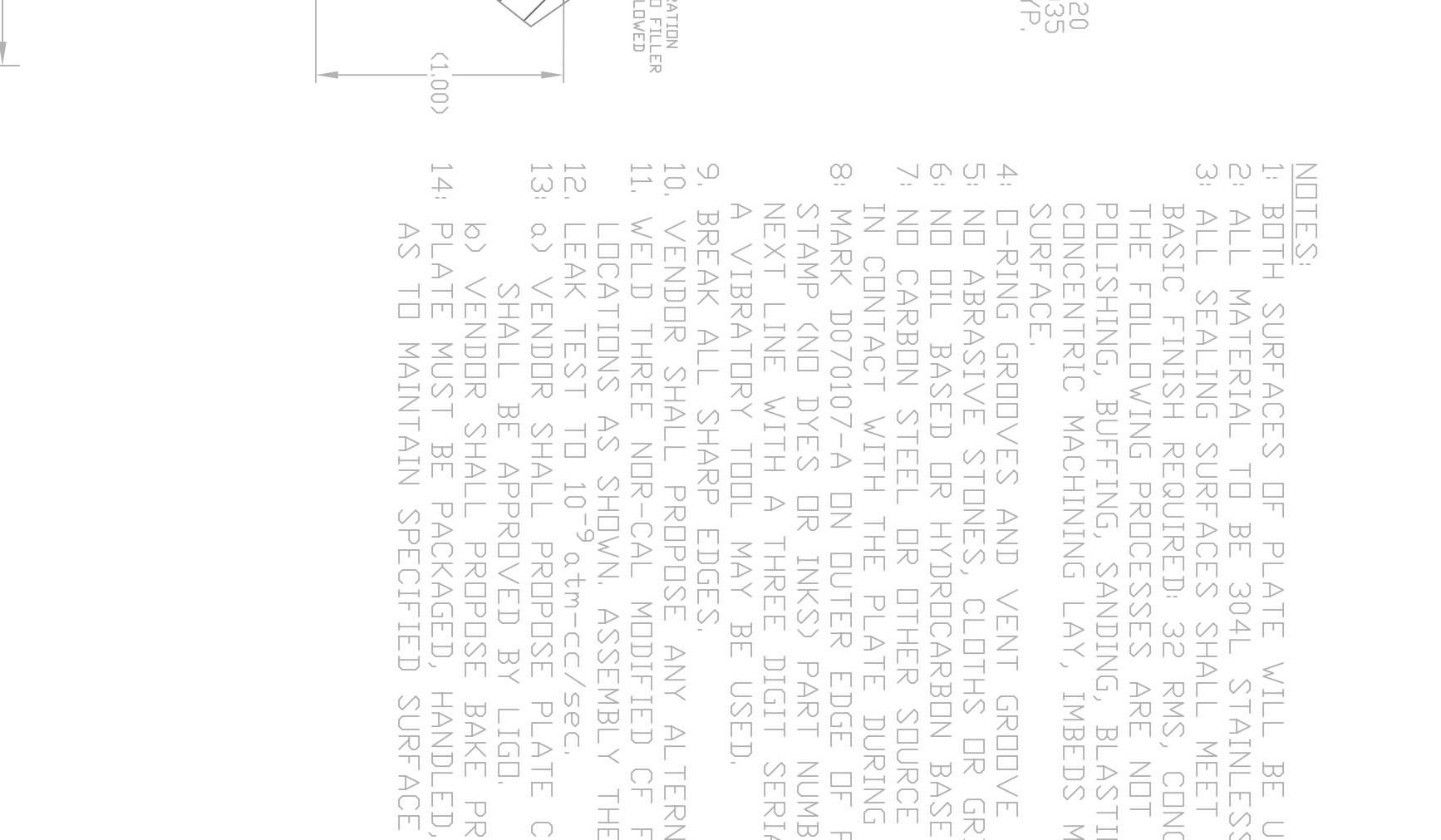
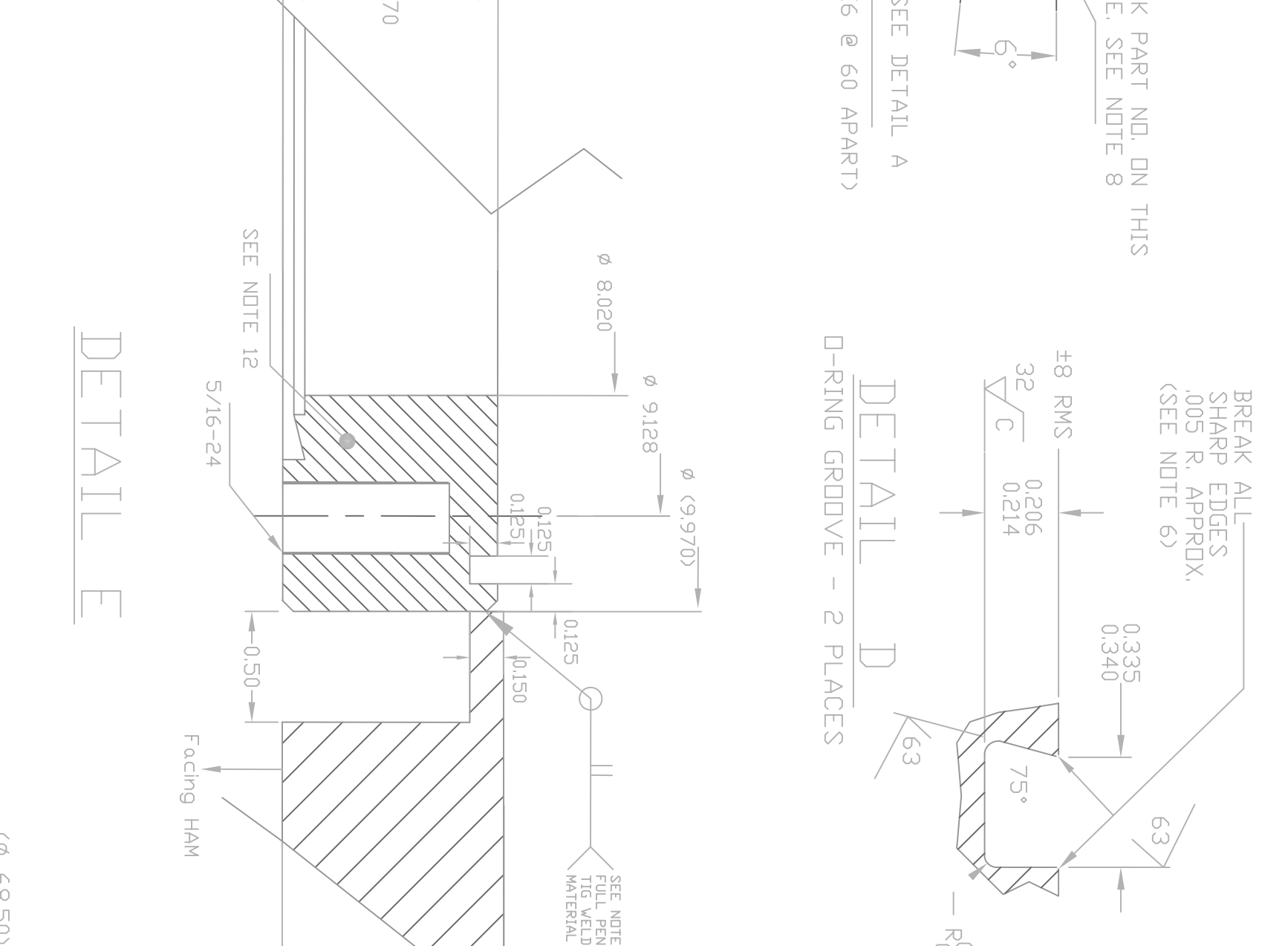
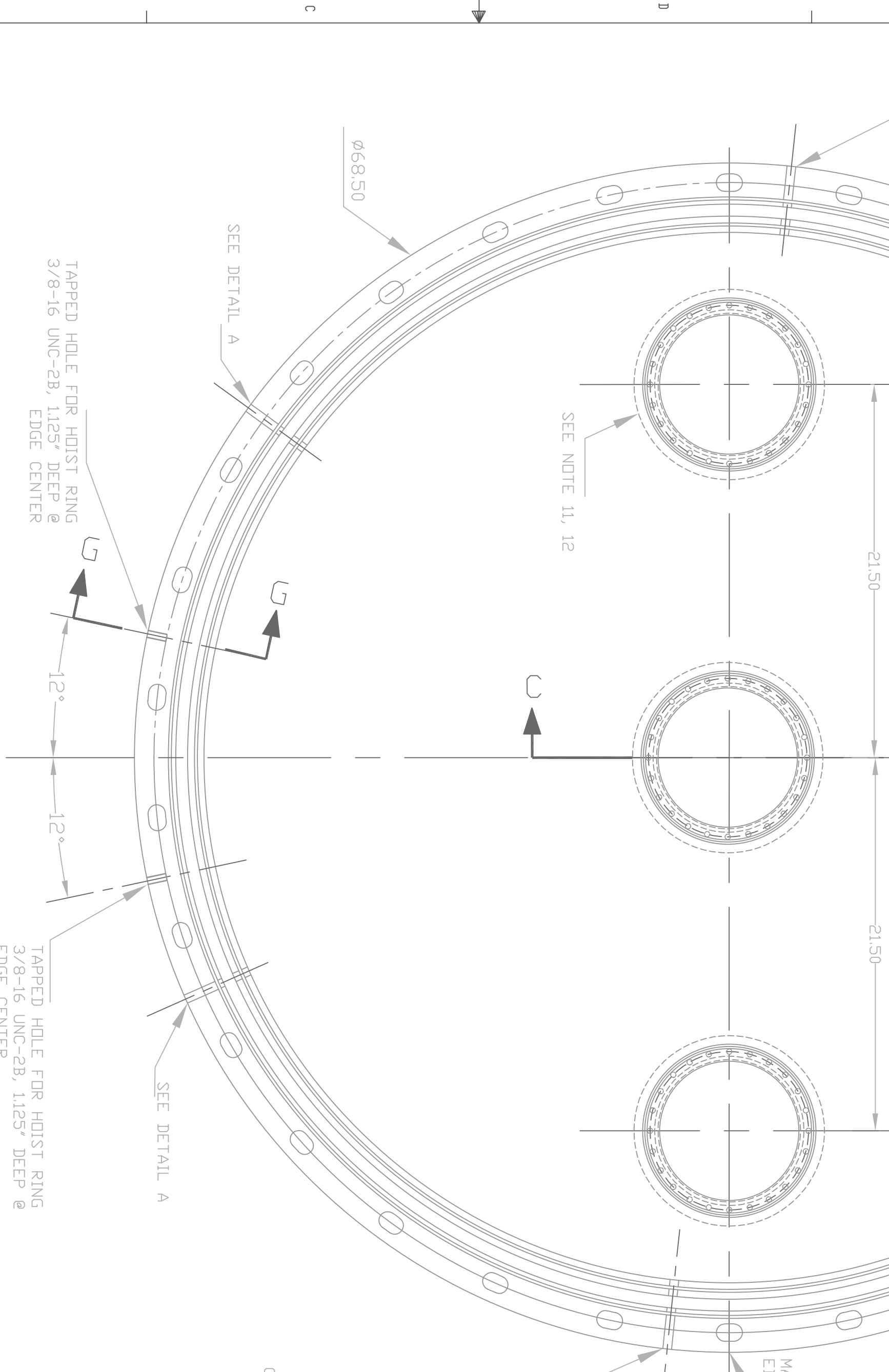
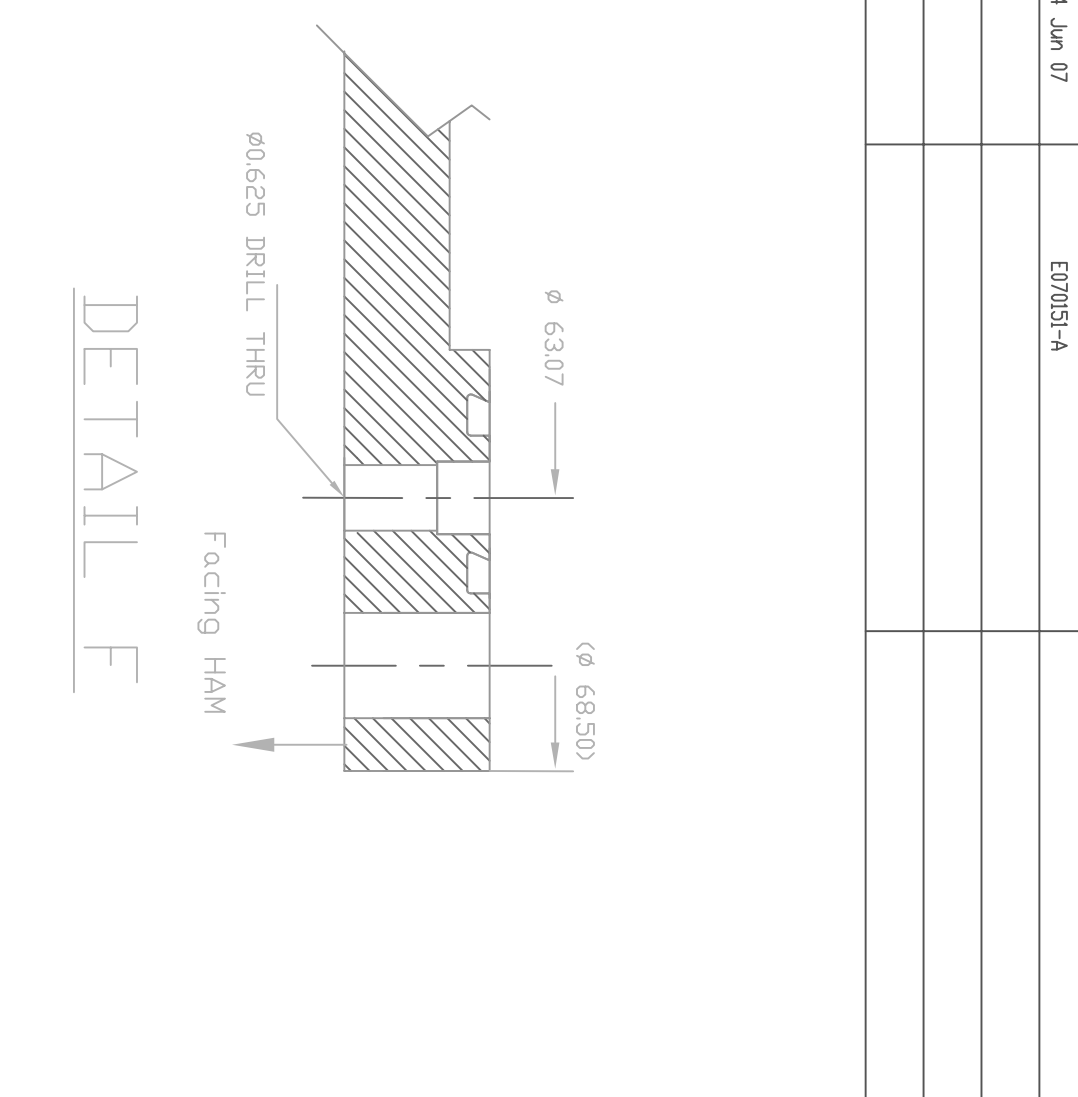
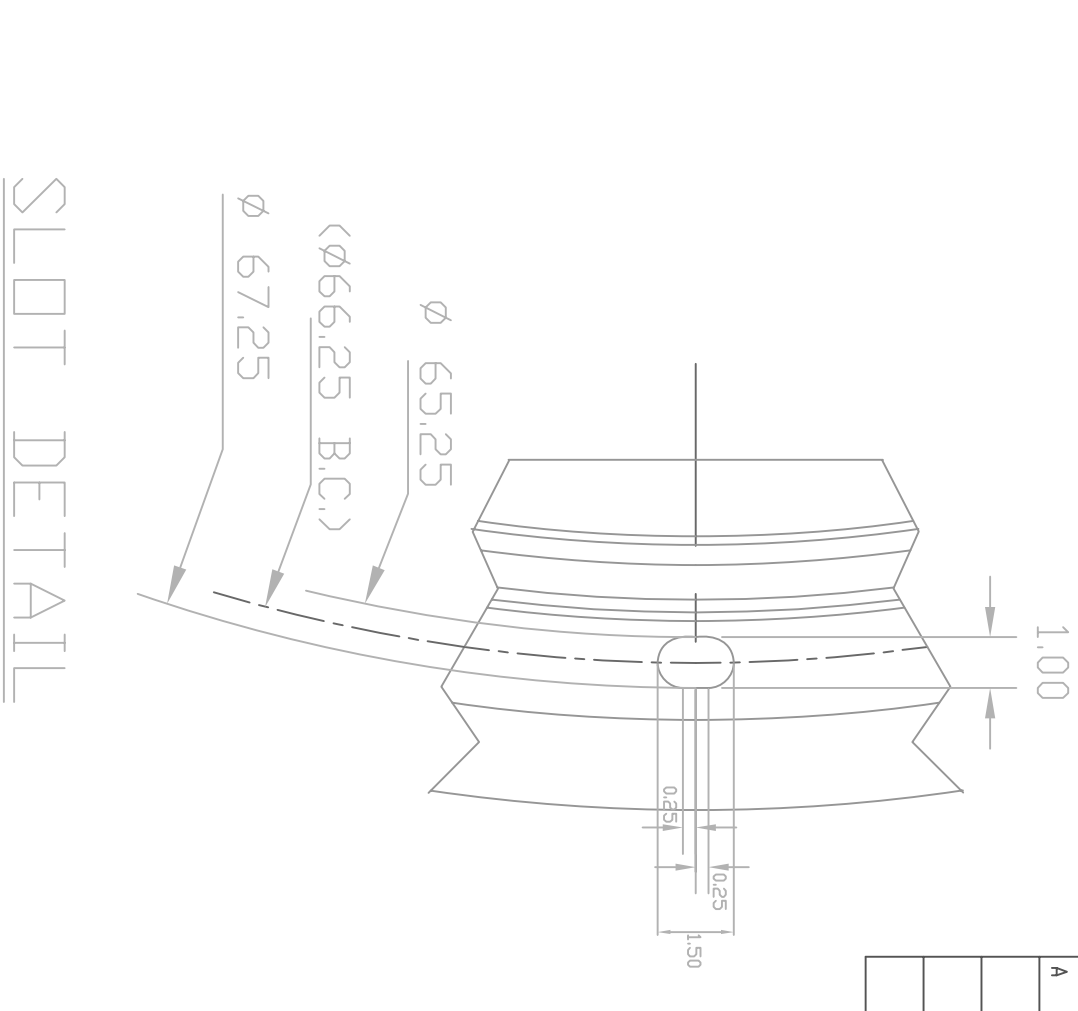
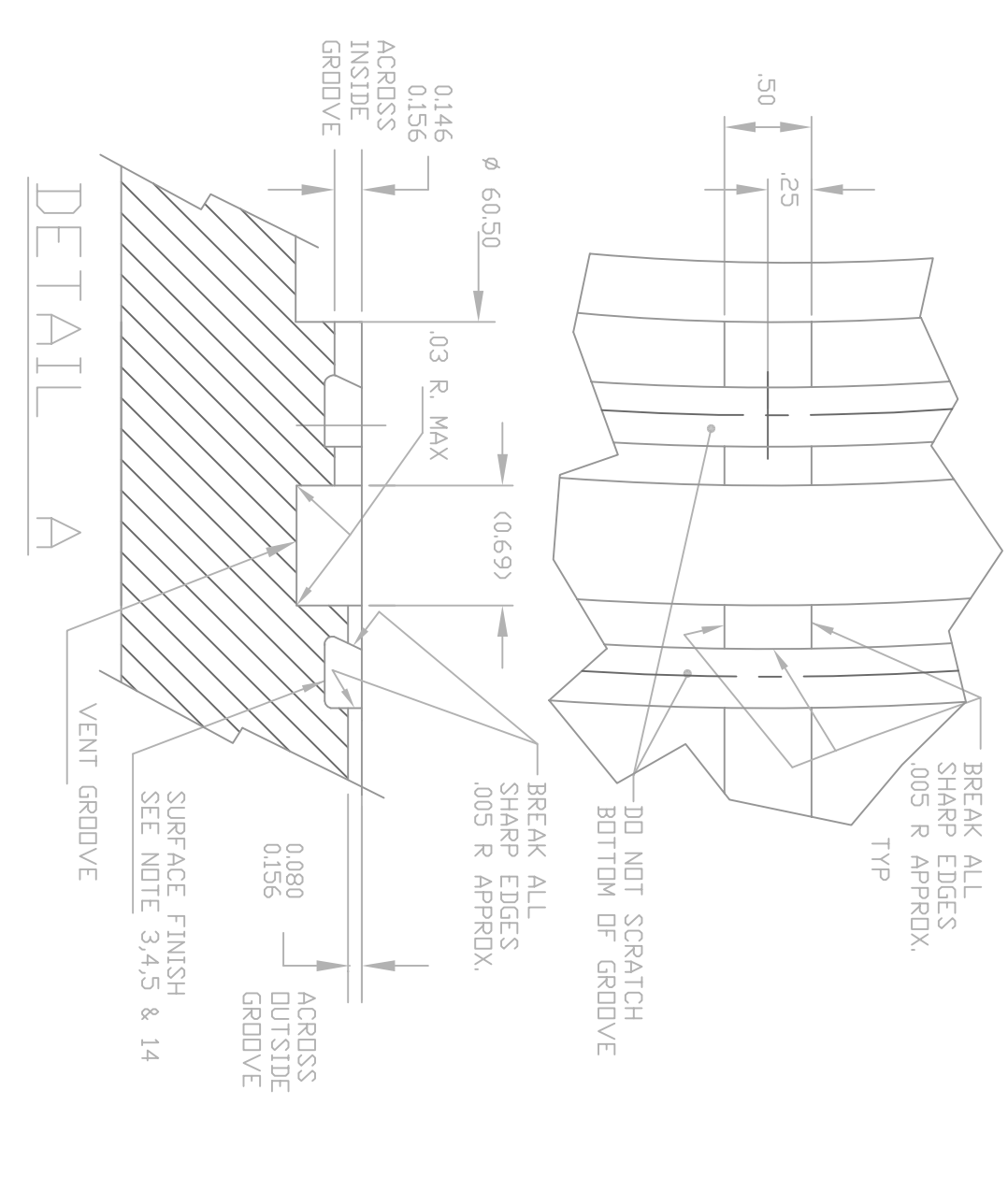
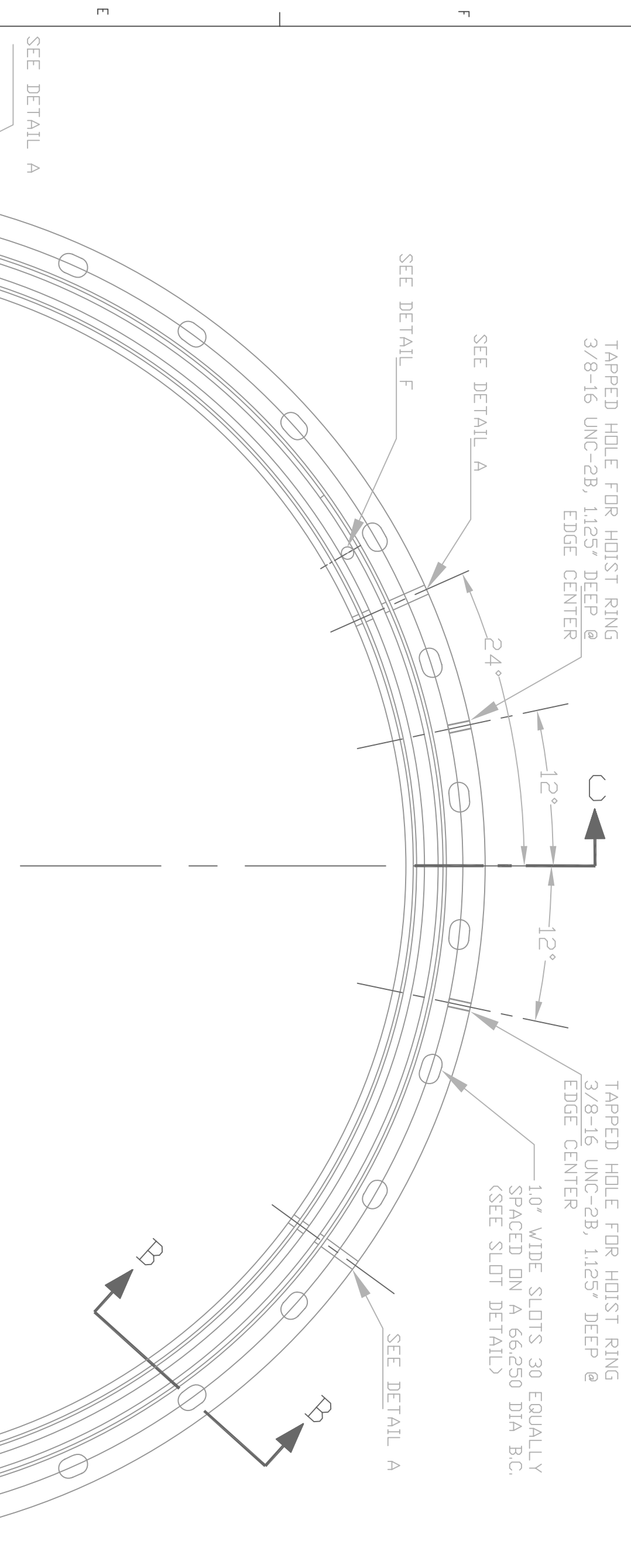


| REV | DATE      | DRW #    | DRAWING TITLE |
|-----|-----------|----------|---------------|
| A   | 04 Jun 07 | EM0818-A |               |
|     |           |          |               |
|     |           |          |               |
|     |           |          |               |



|                             |                   |           |
|-----------------------------|-------------------|-----------|
| UNLESS OTHERWISE SPECIFIED  | DATE              | NAME      |
| DIMENSIONS ARE IN INCHES    | 04 Jun 07         | V PARSONS |
| TOLERANCES:                 | CHECKED 04 Jun 07 | J WARBREN |
| XX = ±.1                    |                   |           |
| XXX = ±.03                  |                   |           |
| XXX = ±.01                  |                   |           |
| ANGULARS = ± 30'            |                   |           |
| MATERIAL                    |                   |           |
| FINISH                      |                   |           |
| 304L                        |                   |           |
| COMMENTS:                   |                   |           |
| LASTI HAM SEPTUM PLATE      |                   |           |
| DWG. NO. D070168            |                   |           |
| SCALE: DO NOT SCALE DRAWING |                   |           |
| SHEET 1 OF 1                |                   |           |

- NOTES:
- 1: BOTH SURFACES OF PLATE WILL BE USED IN ULTRA HIGH VACUUM SERVICE.
  - 2: ALL MATERIAL TO BE 304L STAINLESS STEEL. MATERIAL CERTIFICATION IS REQUIRED
  - 3: ALL SEALING SURFACES SHALL MEET THE FOLLOWING REQUIREMENTS:  
BASIC FINISH REQUIRED: 32 RMS, CONCENTRIC LAY FINISH TOLERANCE +/- 8 RMS)  
THE FOLLOWING PROCESSES ARE NOT ALLOWED: GRINDING, HONING, LAPING,  
POLISHING, BUFFING, SANDING, BLASTING, OR ANY OTHER PROCESS THAT DISTURBS THE  
CONCENTRIC MACHINING LAY, IMBEDS MATERIAL INTO THE SURFACE, OR SMears THE  
SURFACE.
  - 4: D-RING GROOVES AND VENT GROOVE MUST BE MACHINED DURING THE SAME SETUP.
  - 5: NO ABRASIVE STONES, CLOTHS OR GRINDING WHEELS MAY BE USED.
  - 6: NO DIL BASED OR HYDROCARBON BASED CUTTING FLUIDS TO BE USED.
  - 7: NO CARBON STEEL OR OTHER SOURCE OF IRON CONTAMINATION ARE TO COME  
IN CONTACT WITH THE PLATE DURING MANUFACTURING OR HANDLING.
  - 8: MARK D070107-A ON OUTER EDGE OF PLATE. SCRIBE, ENGRAVE OR MECHANICALLY  
STAMP (NO DYES OR INKS) PART NUMBER ON NOTED SURFACE OF PART FOLLOWED BY THE  
NEXT LINE WITH A THREE DIGIT SERIAL NUMBER 001. USE MINIMUM 0.12" HIGH CHARACTERS.  
A VIBRATORY TOOL MAY BE USED.
  - 9: BREAK ALL SHARP EDGES.
  - 10: VENDOR SHALL PROPOSE ANY ALTERNATIVE WELD PREPS/WELD
  - 11: WELD THREE NDR-CAL MODIFIED CF FLANGES OR APPROVED EQUIVALENT TO PLATE AT  
LOCATIONS AS SHOWN. ASSEMBLY THE THREE CONFLATS WITH GASKETS AND BLANK FLANGES.
  - 12: LEAK TEST TO 10<sup>-9</sup> atm-cc/sec.
  - 13: a) VENDOR SHALL PROPOSE PLATE CLEANING TECHNIQUES. ALL CLEANING AND PACKING  
SHALL BE APPROVED BY LIGO.  
b) VENDOR SHALL PROPOSE BAKE PROCEDURE, IF POSSIBLE.
  - 14: PLATE MUST BE PACKAGED, HANDLED, AND SHIPPED IN SUCH A MANNER  
AS TO MAINTAIN SPECIFIED SURFACE FINISHES.

SECTION "C"- "C"

SECTION "B"- "B"