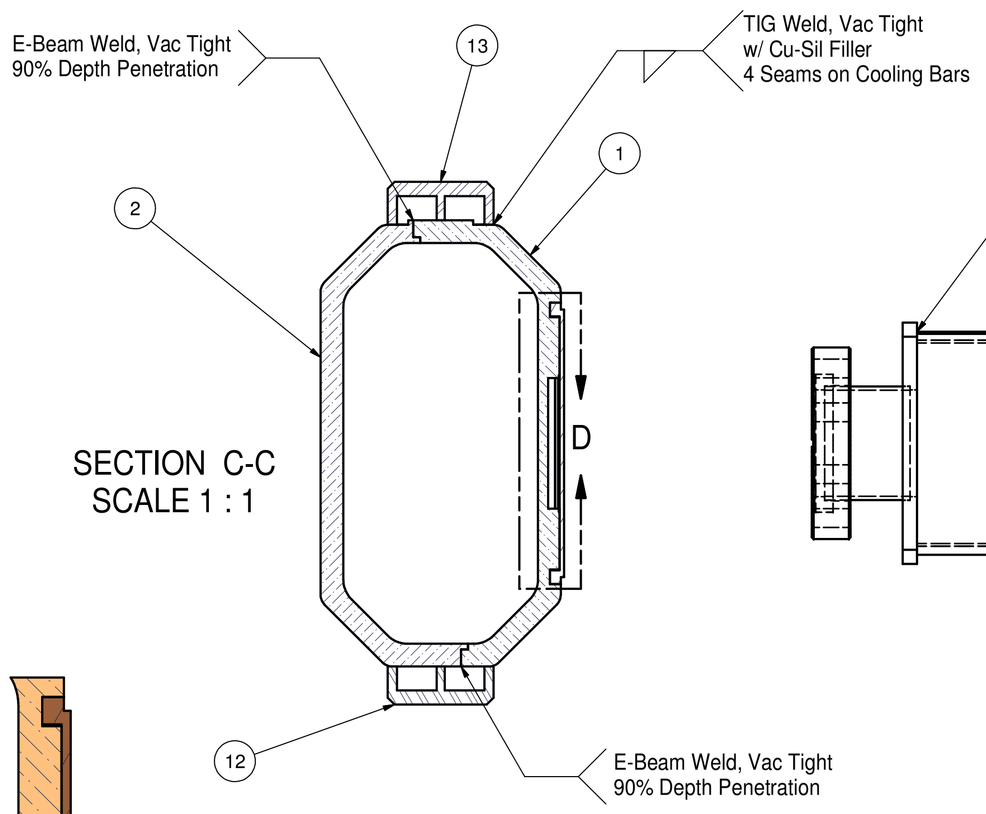
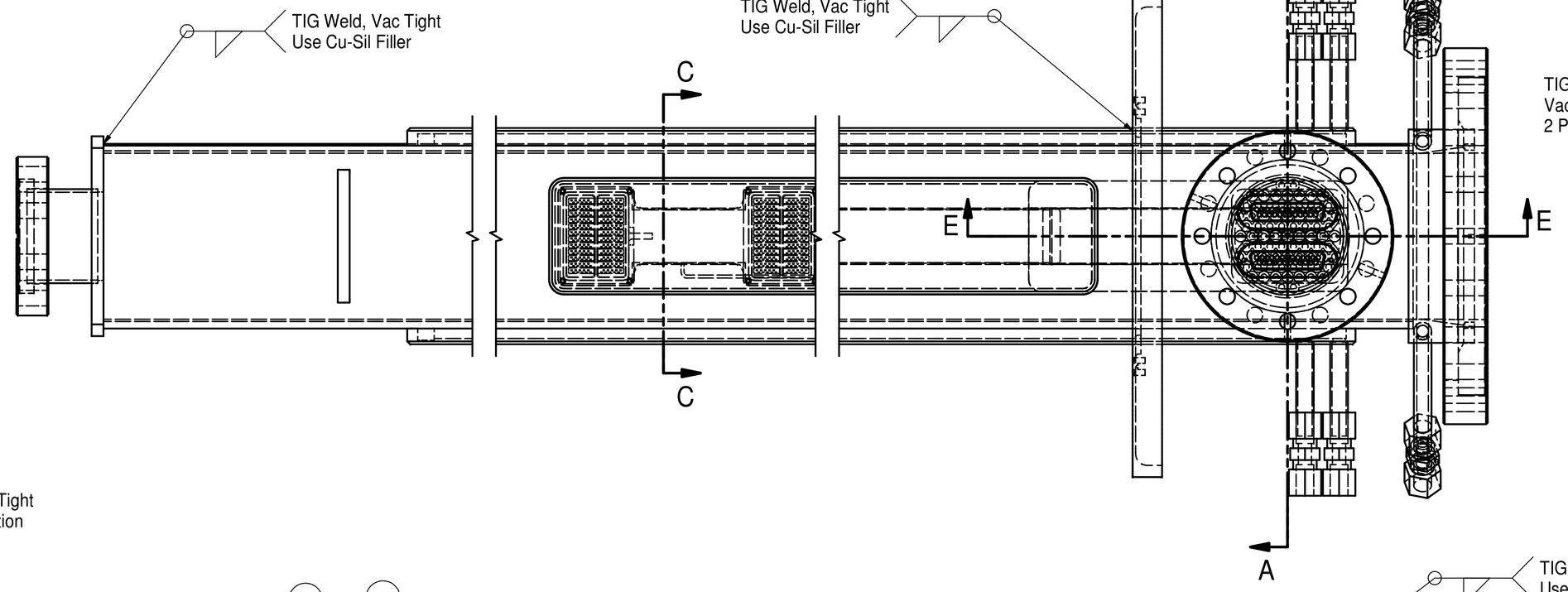
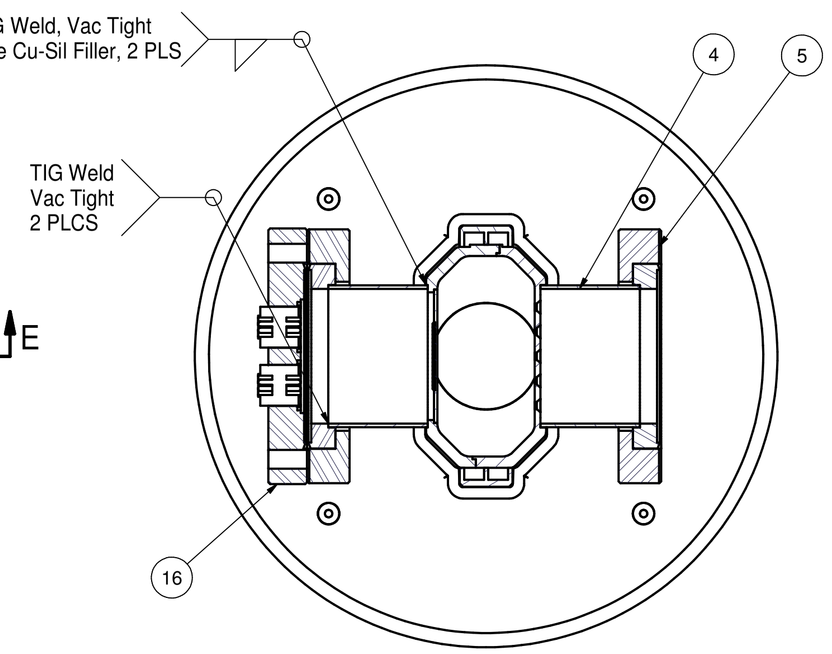
REVISIONS				
SYM.	ZONE	DESCRIPTION	DATE	APP.

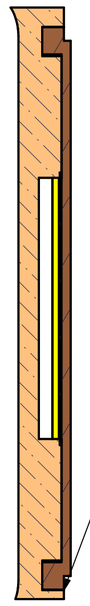


SECTION C-C
SCALE 1 : 1

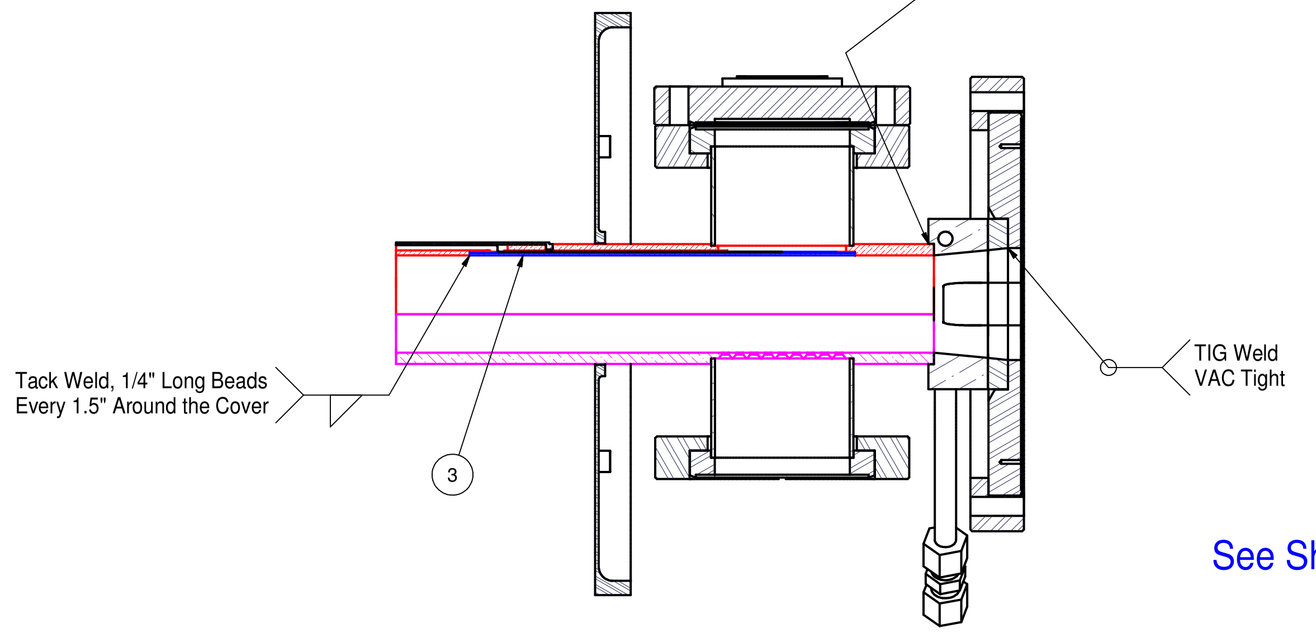




SECTION A-A
SCALE 1 / 2



DETAIL D
SCALE 2 : 1



SECTION E-E
SCALE 1 / 2

See Sheet 2 for More Assembly Views

1. Wiggler UHV Beam Pipe with Thin RFA, as Delivered for Testing. The assembly shown here will be shortened and inserted into CESR-c Wiggler Magnet after RFA Testing.
2. Recommended assemling/welding sequences are shown on Sheets 18 through 21

ITEM	DWG. NO.	DESCRIPTION	QUANTITY G1	QUANTITY G2	QUANTITY G3	REMARKS	REV.
16	Purchased	4.50" Flange with 2XD25 Feedthroughs	1			Accu-Glass P/N 100225	
15	Sheet 17	8" Rotabable Flange	2				
14	Sheet 15	Flexiable Disk	2				
13	Sheet 14	Cooling Channel #2	1				
12	Sheet 13	Cooling Channel #1	1				
11	Sheet 12	Temporary End Flange Asm	1				
9	Sheet 10	SST_Cu Transition	2				
8	Sheet 7	RFA Vacuum Cover	1				
7	Sheet 22	Flex Circuit Strip	1				
6	Sheet 8	Sandwitched Grid	3				
5	Purchased	F450X250R	2				
4	Sheet 7	2.50" Port Tube	2				
3	Sheet 7	RFA Tunnel Cover	1				
2	Sheet 6	SLAC PIPE Bottom Half	1				
1	Sheet 4,5	SLAC PIPE TOP Half	1				

FOR MACHINING LUBRICANT USE ONLY
ALKALINE DETERGENT LUBRICANT CIMSTAR 40
OR EQUIVALENT APPROVED BY CORNELL LEPP

TECHNICAL RESOURCE APPROVALS REQUIRED BEFORE FABRICATION	OK	DATE	N/A
DRAFTING (O'Connel):			
MACHINE SHOP (Kaminski):			
CHEMISTRY (Conklin):			
ELECTRONICS SHOP (Barley):			
FURNACE BRAZING (Sherwood):			
BEAM WELDING (Sears):			
WELDING OTHER (Gallagher):			
UTILITIES INTEGRATION (Gallagher):			
STOCKROOMS (Lockwood):			

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PLOT DATE: 2/4/2008
CAD FILE NAME: 6085-003.idw

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TOLERANCES ON:
.00 ± .010
.000 ± .005
FRACTIONS ± 1/64
ANGLES ± 0.5°
ALL SURFACES

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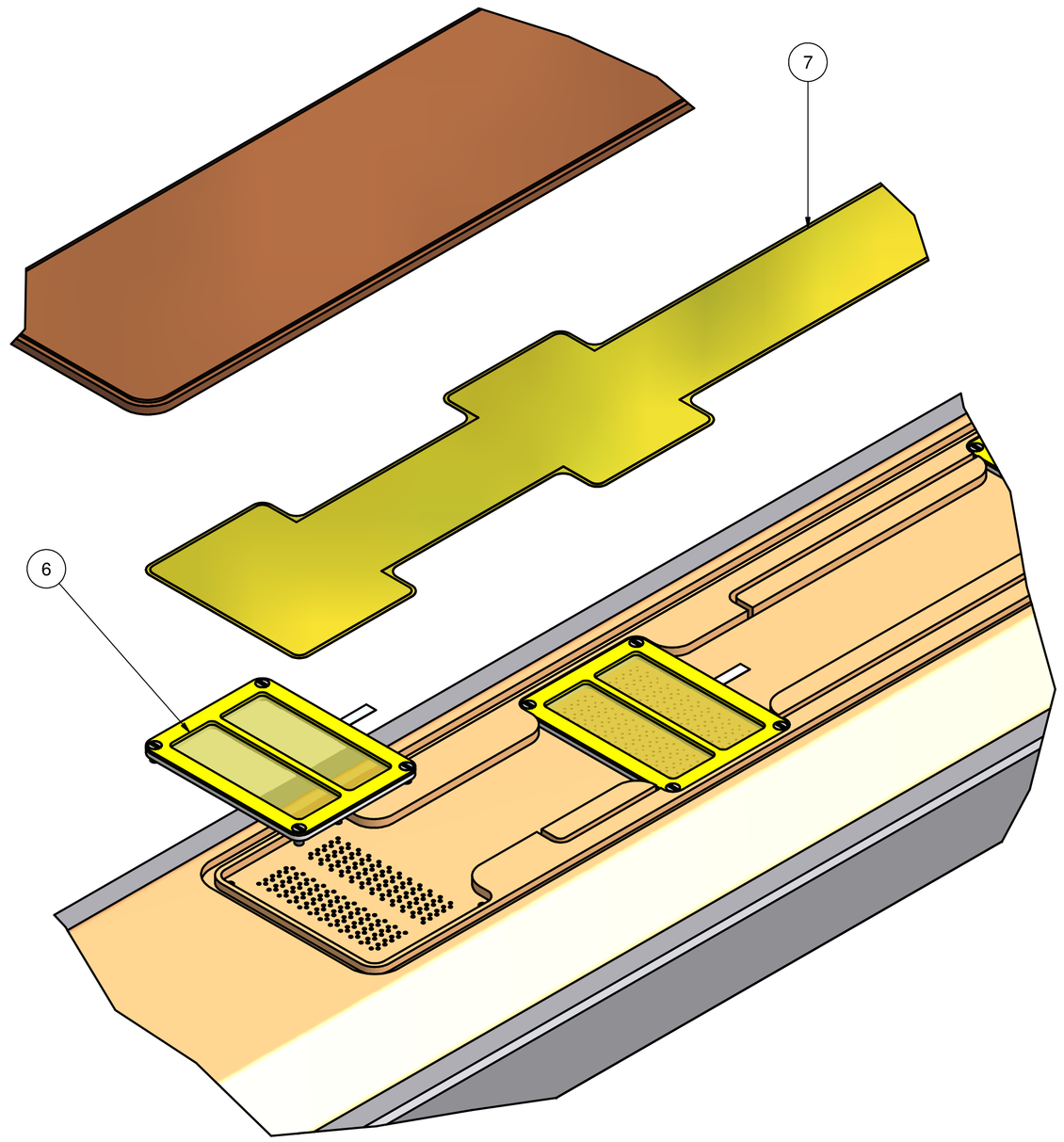
Ithaca, NY 14853

CESR Wiggler Chamber with Thin RFA

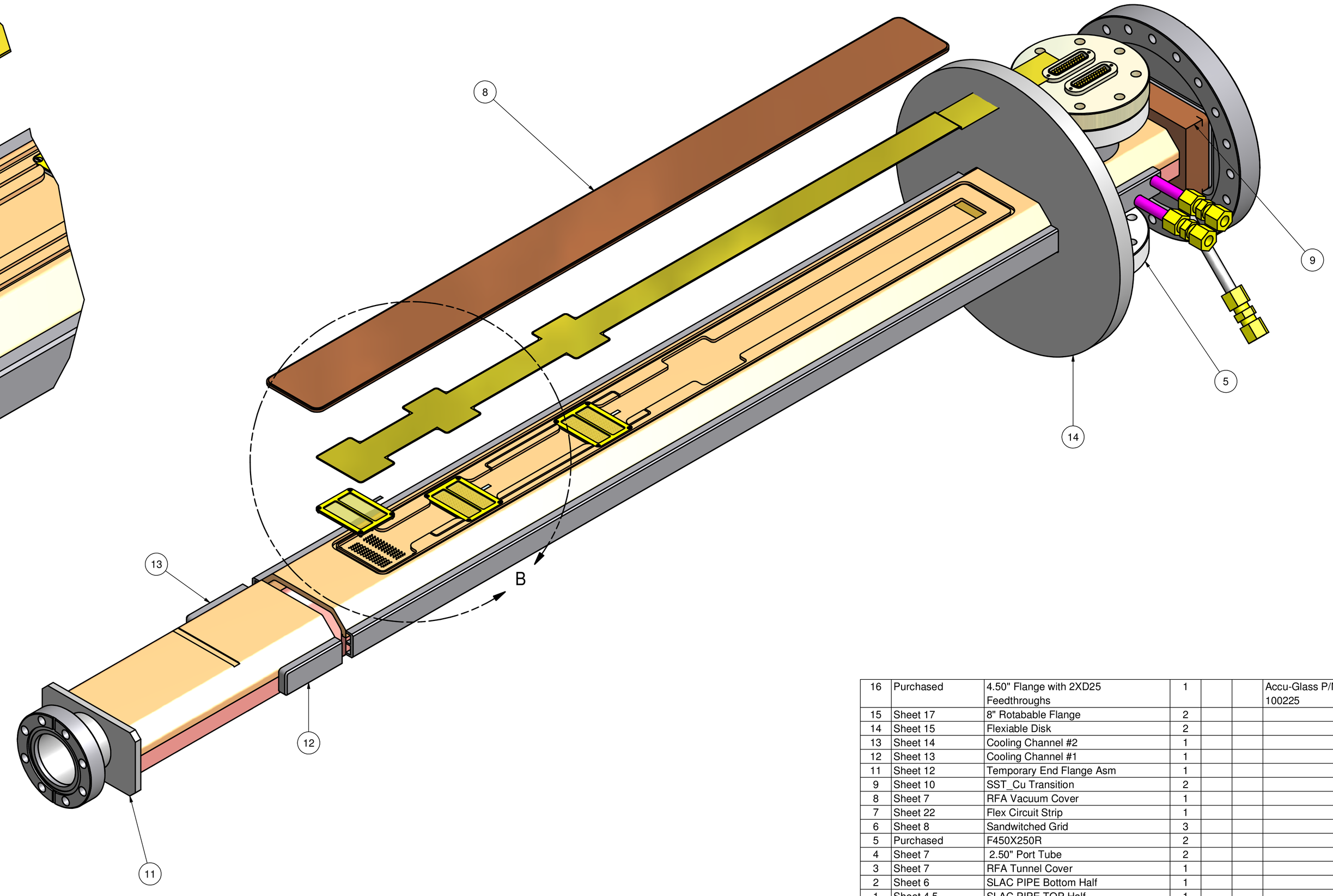
DRAWN BY	DRAWN FOR	DATE	SCALE			REV.
Yulin Li	Yulin Li	1/29/2008		D	6085-003 SH. NO. 1 OF 22	

6085-003 SH. NO. 1 OF 22 REV.

REVISIONS				
SYM.	ZONE	DESCRIPTION	DATE	APP.



DETAIL B
SCALE 1 : 1



ITEM	DWG. NO.	DESCRIPTION	QUANTITY G1	G2	G3	REMARKS	REV.
16	Purchased	4.50" Flange with 2XD25 Feedthroughs	1			Accu-Glass P/N 100225	
15	Sheet 17	8" Rotabable Flange	2				
14	Sheet 15	Flexiable Disk	2				
13	Sheet 14	Cooling Channel #2	1				
12	Sheet 13	Cooling Channel #1	1				
11	Sheet 12	Temporary End Flange Asm	1				
9	Sheet 10	SST_Cu Transition	2				
8	Sheet 7	RFA Vacuum Cover	1				
7	Sheet 22	Flex Circuit Strip	1				
6	Sheet 8	Sandwitched Grid	3				
5	Purchased	F450X250R	2				
4	Sheet 7	2.50" Port Tube	2				
3	Sheet 7	RFA Tunnel Cover	1				
2	Sheet 6	SLAC PIPE Bottom Half	1				
1	Sheet 4,5	SLAC PIPE TOP Half	1				

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OR EQUIVALENT APPROVED BY CORNELL LEPP

TECHNICAL RESOURCE APPROVALS REQUIRED BEFORE FABRICATION	OK	DATE	N/A
DRAFTING (O'Connel):			
MACHINE SHOP (Kaminski):			
CHEMISTRY (Conklin):			
ELECTRONICS SHOP (Barley):			
FURNACE BRAZING (Sherwood):			
BEAM WELDING (Sears):			
WELDING OTHER (Gallagher):			
UTILITIES INTEGRATION (Gallagher):			
STOCKROOMS (Lockwood):			

D

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CR-1

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.00 ±.010
.000 ±.005
FRACTIONS ±1/64
ANGLES ±0.5°
ALL SURFACES 63

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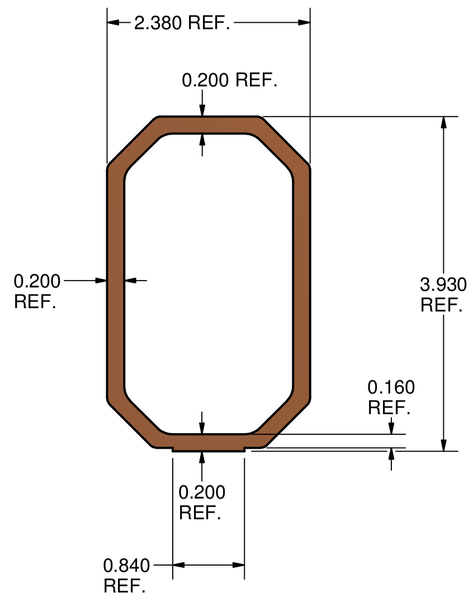
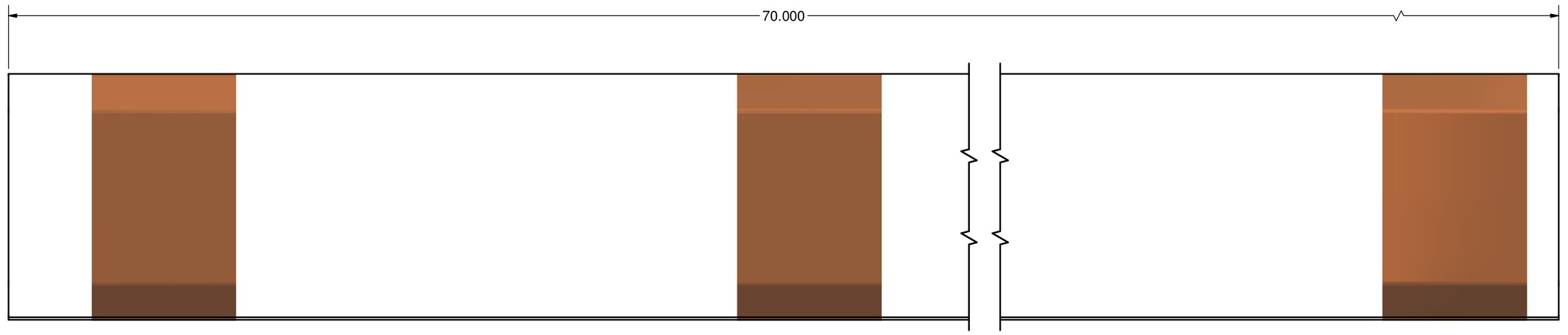
CESR Wiggler Chamber with Thin RFA

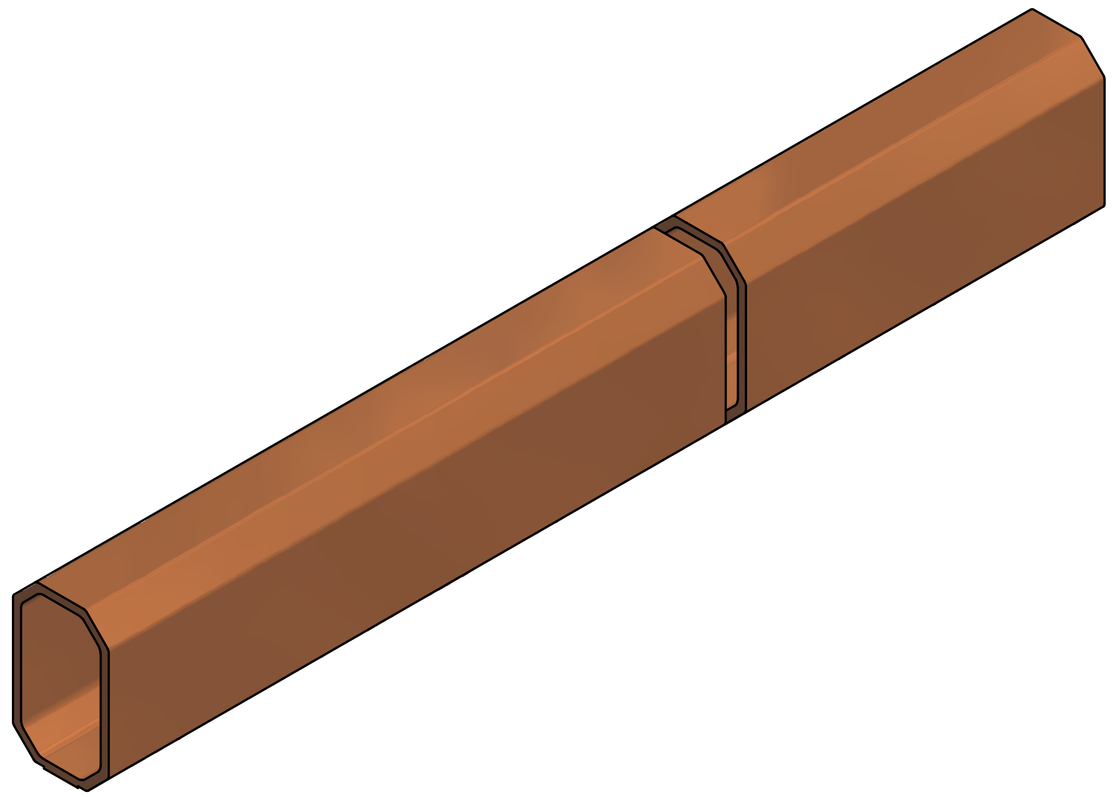
DRAWN BY	DRAWN FOR	DATE	SCALE			REV.
Yulin Li	Yulin Li	1/29/2008		D	6085-003 SH. NO. 2 OF 22	

6085-003 SH. NO. 2 OF 22 REV. D

REVISIONS				
SYM.	ZONE	DESCRIPTION	DATE	APP.







1. Parts 1 and 2 are made from SLAC Copper Quad Beam Pipe
2. Recommended slicing lines are shown as above
3. Details of Part 1 are given in Sheets 4 and 5
4. Details of Part 2 are given in Sheet 6

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OR EQUIVALENT APPROVED BY CORNELL LEPP

TECHNICAL RESOURCE APPROVALS REQUIRED BEFORE FABRICATION	OK	DATE	N/A
DRAFTING (O'Connel):			
MACHINE SHOP (Kaminski):			
CHEMISTRY (Conklin):			
ELECTRONICS SHOP (Barley):			
FURNACE BRAZING (Sherwood):			
BEAM WELDING (Sears):			
WELDING OTHER (Gallagher):			
UTILITIES INTEGRATION (Gallagher):			
STOCKROOMS (Lockwood):			

ITEM	DWG. NO.	DESCRIPTION	G1	G2	G3	REMARKS	REV.
			QUANTITY				

D

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PLOT DATE: 2/4/2008
CAD FILE NAME: 6085-003.idw

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Ithaca, NY 14853

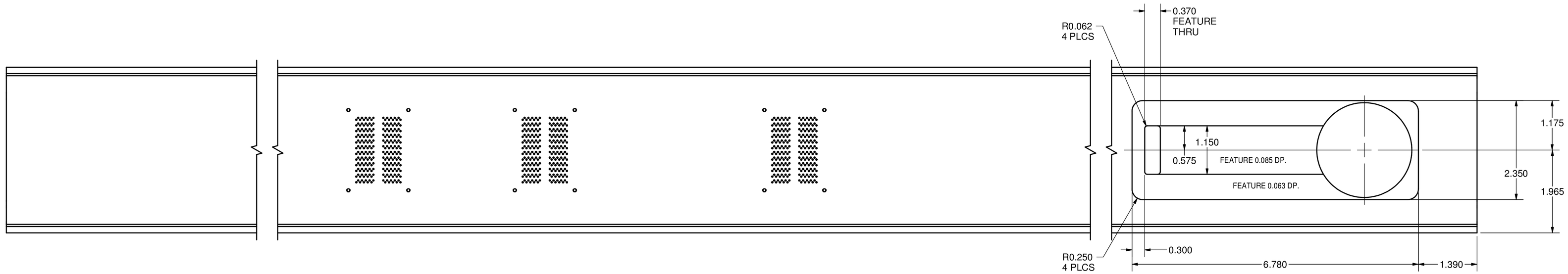
CESR Wiggler Chamber with Thin RFA

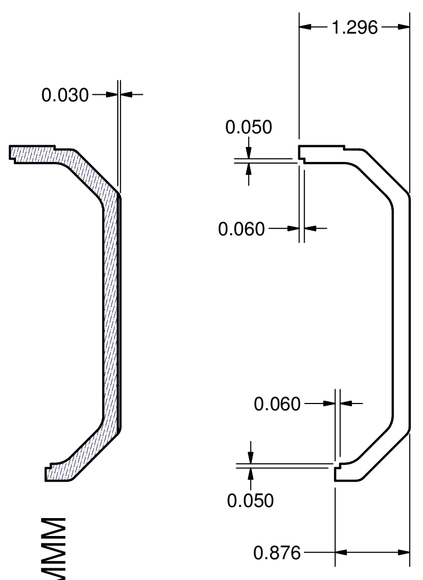
CHECKED BY:
APPROVED BY:

DRAWN BY	DRAWN FOR	DATE	SCALE			REV.
Yulin Li	Yulin Li	1/29/2008		D	6085-003 SH. NO. 3 OF 22	

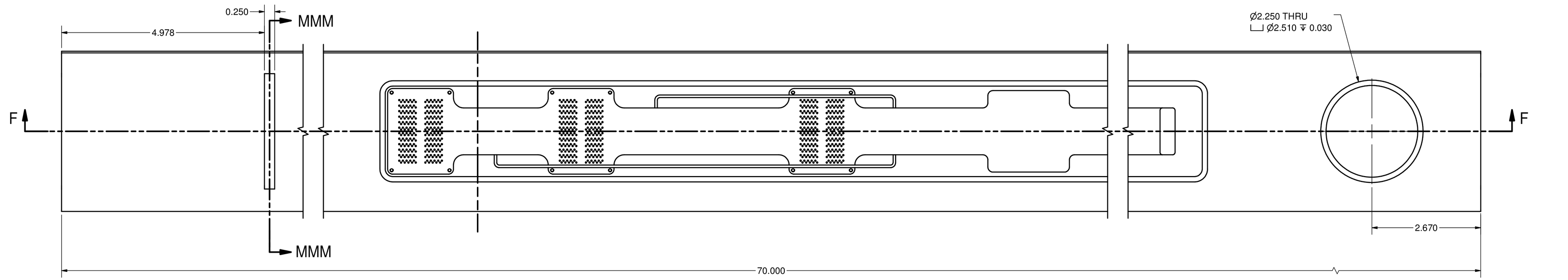
6085-003 SH. NO. 3 OF 22 REV.

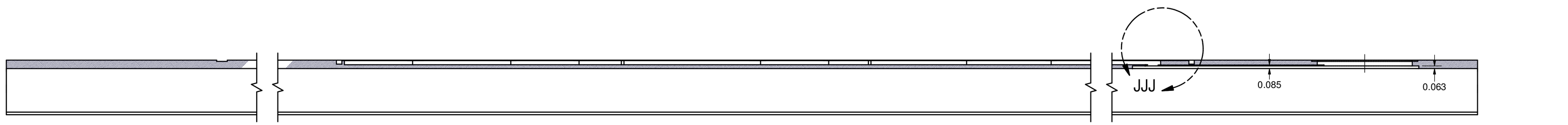
REVISIONS				
SYM.	ZONE	DESCRIPTION	DATE	APP.

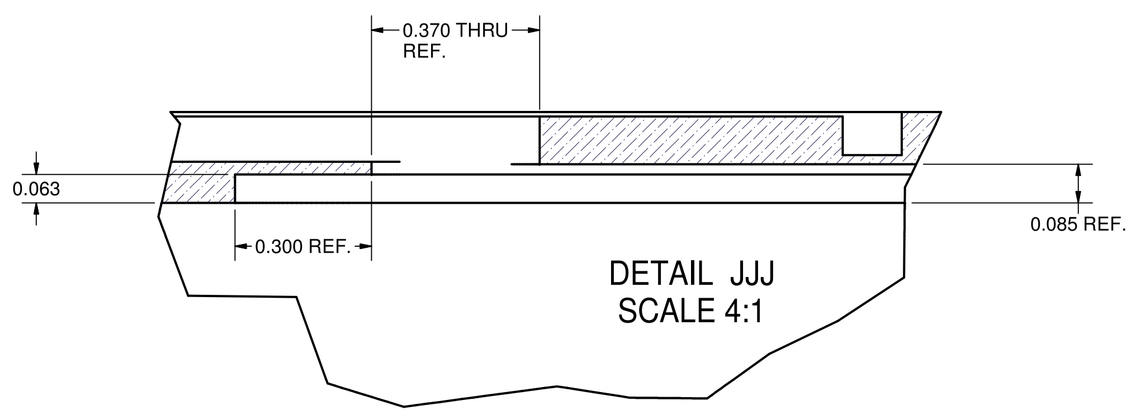




SECTION MMM-MMM
SCALE 3 : 4







DETAIL JJJ
SCALE 4:1

SECTION F-F
SCALE 3 : 4

1A Beam Pipe -- Top Half

FILE NAME: 6085-003
SHEET NO.: 4
DFT. SCALE: 3 : 4
MATERIAL: Copper, See Sheet 2
QTY: 1
NOTES: SEE NEXT SH. FOR MORE DIMENSIONS

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ALKALINE DETERGENT LUBRICANT CIMSTAR 40
OR EQUIVALENT APPROVED BY CORNELL LEPP

TECHNICAL RESOURCE APPROVALS REQUIRED BEFORE FABRICATION			
	OK	DATE	N/A
DRAFTING (O'Connel):			
MACHINE SHOP (Kaminski):			
CHEMISTRY (Conklin):			
ELECTRONICS SHOP (Barley):			
FURNACE BRAZING (Sherwood):			
BEAM WELDING (Sears):			
WELDING OTHER (Gallagher):			
UTILITIES INTEGRATION (Gallagher):			
STOCKROOMS (Lockwood):			

ITEM	DWG. NO.	DESCRIPTION	QUANTITY G1	G2	G3	REMARKS	REV.

D | PRINT DISTR. CR-1

PLOT DATE: 2/4/2008
CAD FILE NAME: 6085-003.idw

SH. NO. 4 6085-003 OF 22 REV.

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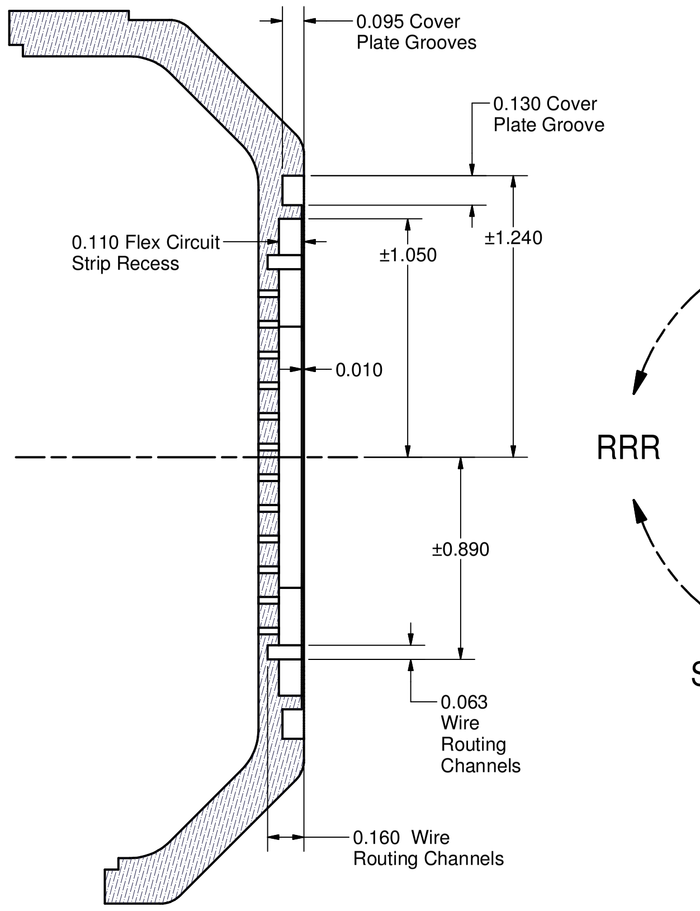
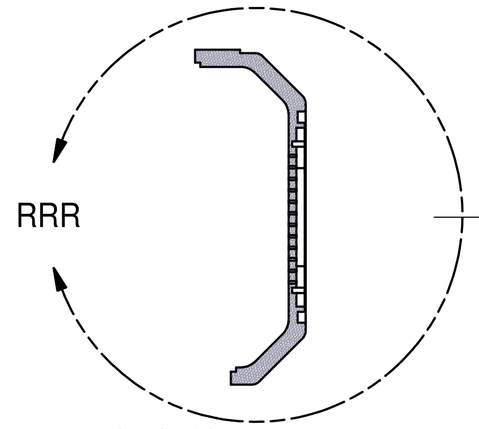
CESR Wiggler Chamber with Thin RFA
Beam Pipe Top Half, Detail

DRAWN BY	DRAWN FOR	DATE	SCALE			REV.
Yulin Li	Yulin Li	1/29/2008		D	6085-003 SH. NO. 4 OF 22	

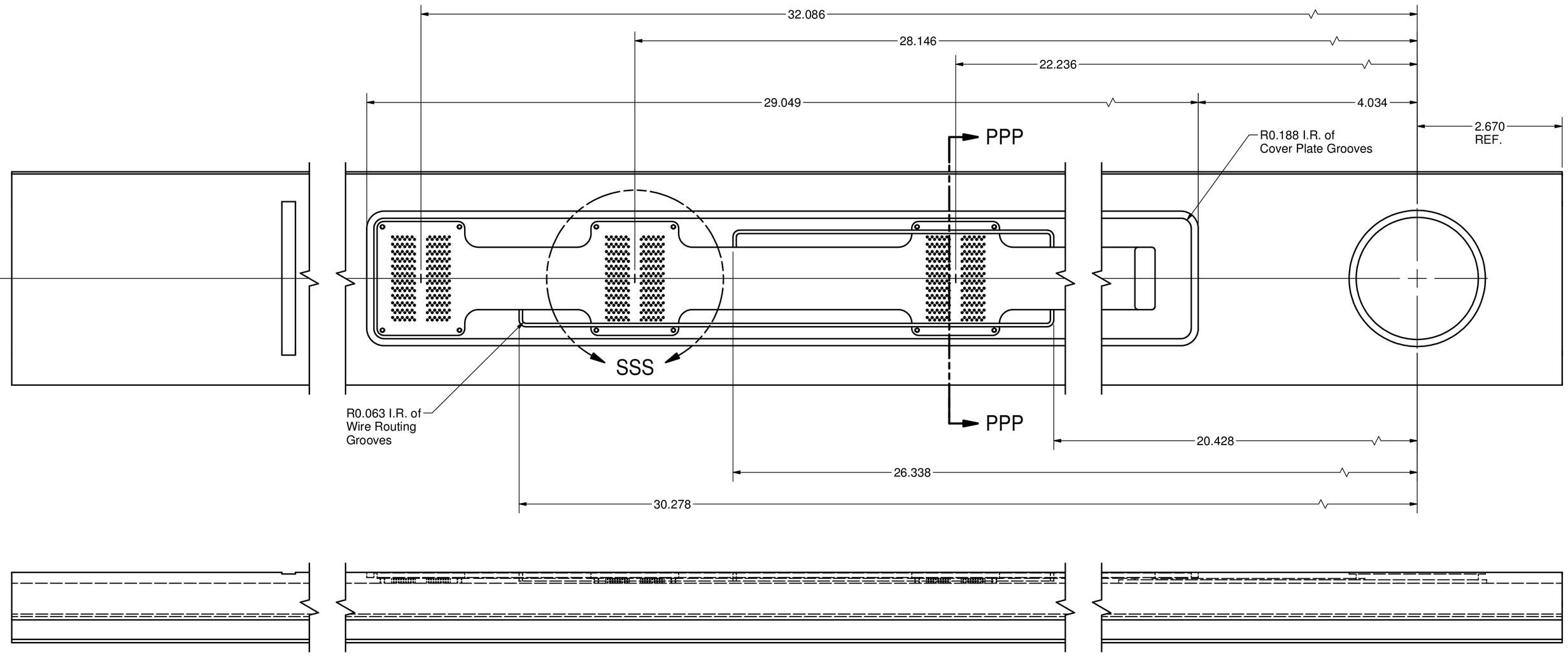
REVISIONS				
SYM.	ZONE	DESCRIPTION	DATE	APP.

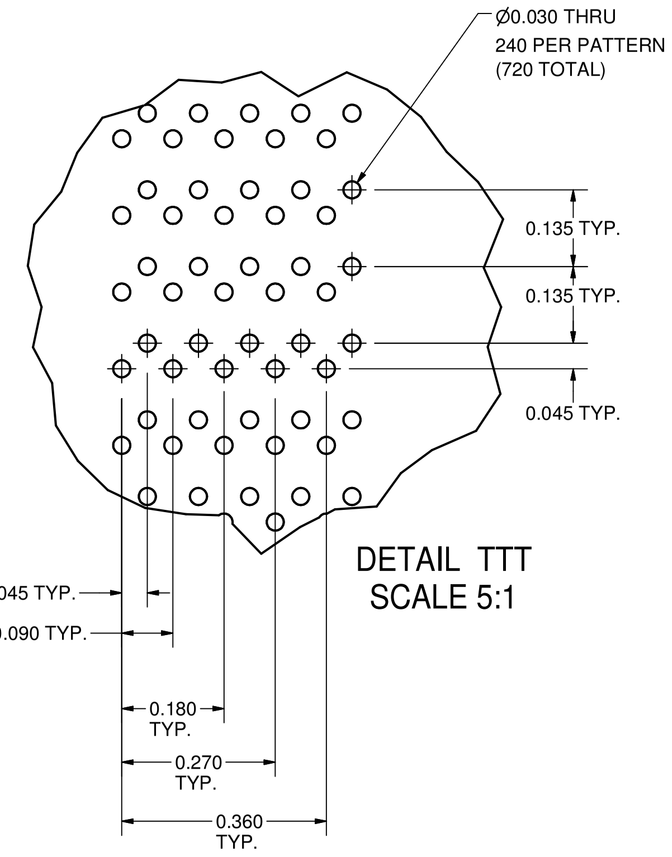


DETAIL RRR
SCALE 2:1

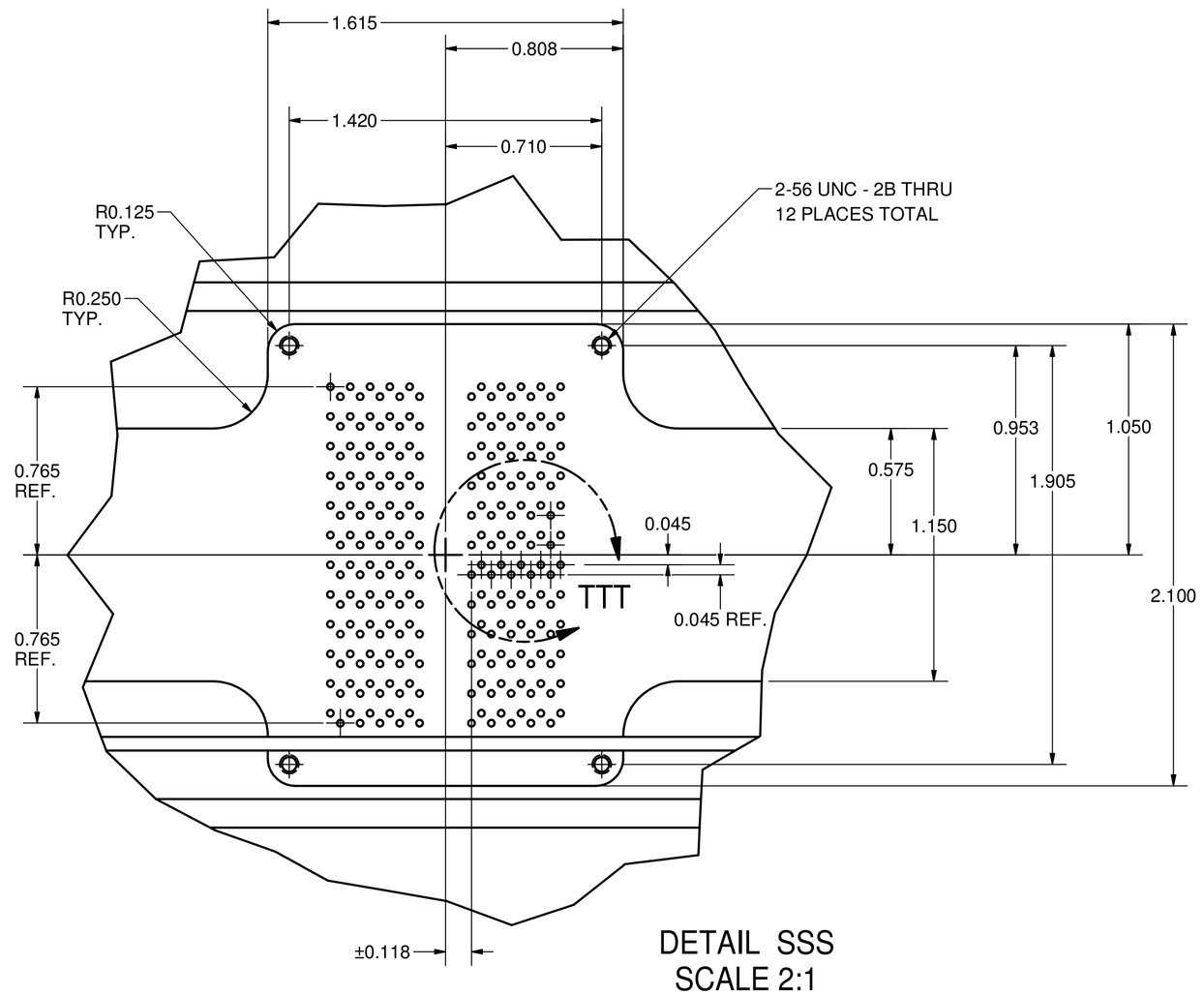


SECTION PPP-PPP
SCALE 3:4





DETAIL TTT
SCALE 5:1



DETAIL SSS
SCALE 2:1

1B **Beam Pipe -- Top Half**

FILE NAME: 6085-003
SHEET NO.: 5
DFT. SCALE: 3 : 4
MATERIAL: Copper, See Sheet 2
QTY: 1
NOTES: SEE PREVIOUS SH. FOR MORE DIMENSIONS

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ALKALINE DETERGENT LUBRICANT CIMSTAR 40
OR EQUIVALENT APPROVED BY CORNELL LEPP

TECHNICAL RESOURCE APPROVALS REQUIRED BEFORE FABRICATION			
	OK	DATE	N/A
DRAFTING (O'Connel):			
MACHINE SHOP (Kaminski):			
CHEMISTRY (Conklin):			
ELECTRONICS SHOP (Barley):			
FURNACE BRAZING (Sherwood):			
BEAM WELDING (Sears):			
WELDING OTHER (Gallagher):			
UTILITIES INTEGRATION (Gallagher):			
STOCKROOMS (Lockwood):			

ITEM	DWG. NO.	DESCRIPTION	QUANTITY G1	G2	G3	REMARKS	REV.

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SH. NO. 5 | 6085-003 | OF 22 | REV.

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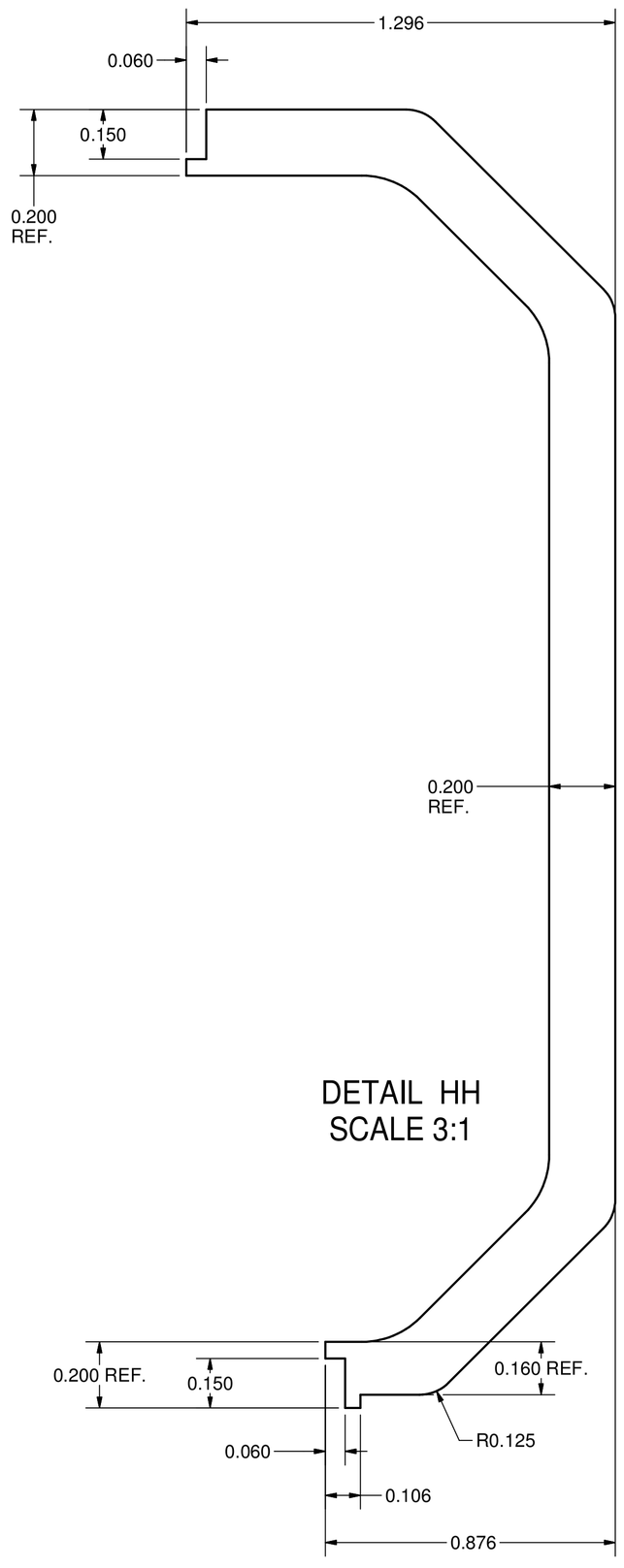
CESR Wiggler Chamber with Thin RFA

Beam Pipe Top Half, Detail

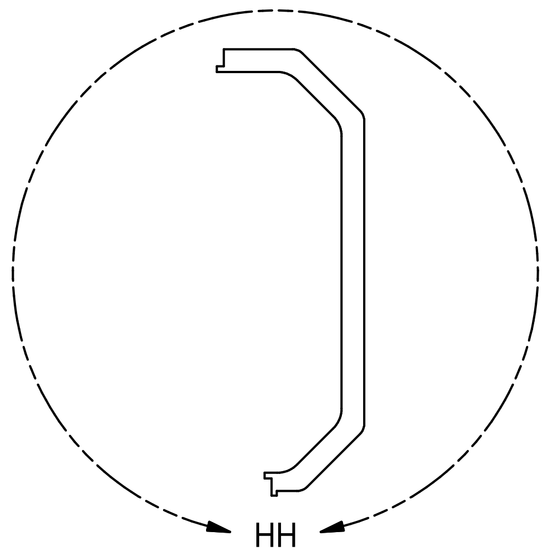
CHECKED BY:
APPROVED BY:

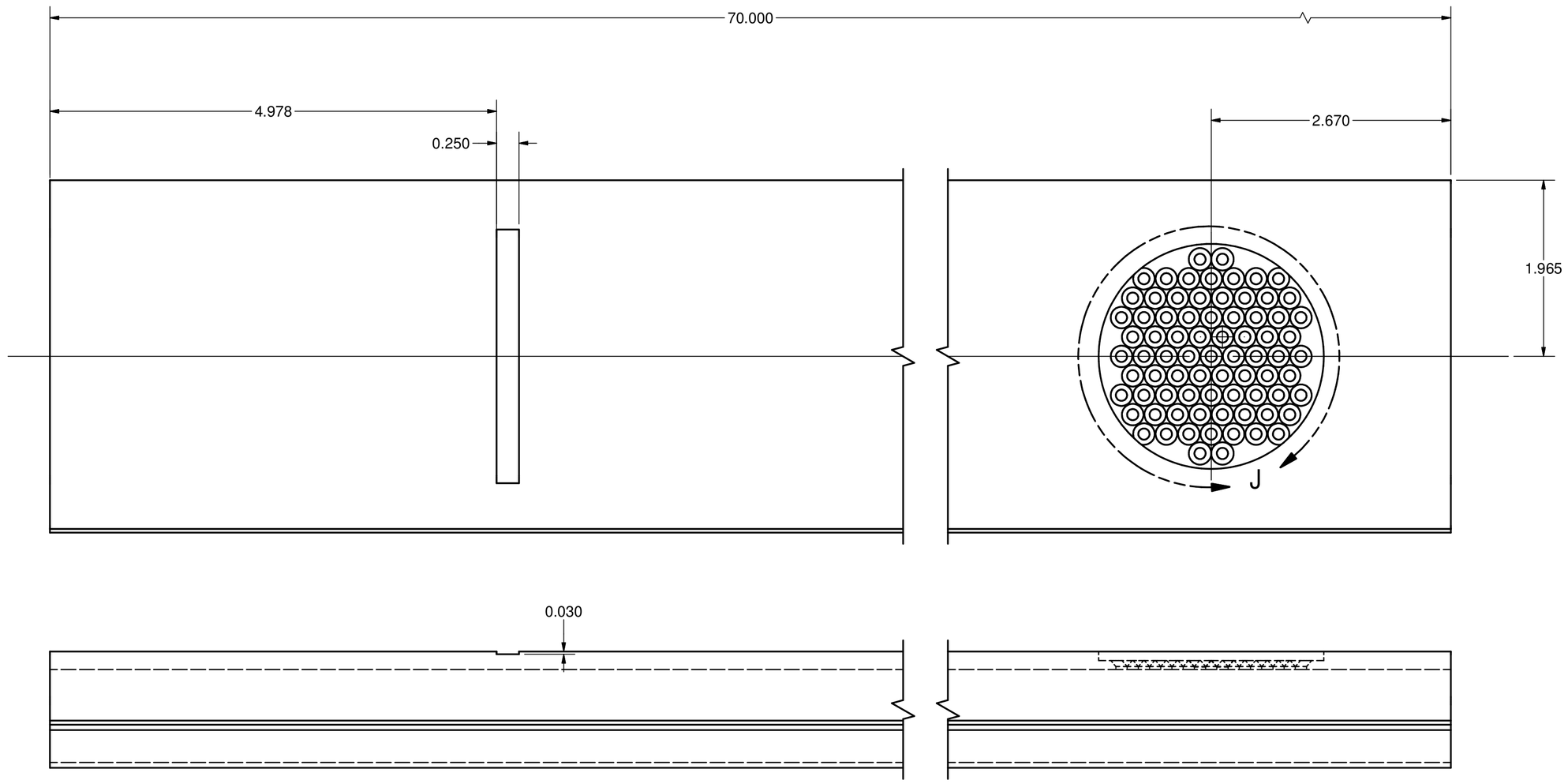
DRAWN BY	DRAWN FOR	DATE	SCALE			REV.
Yulin Li	Yulin Li	1/29/2008		D	6085-003 SH. NO. 5 OF 22	

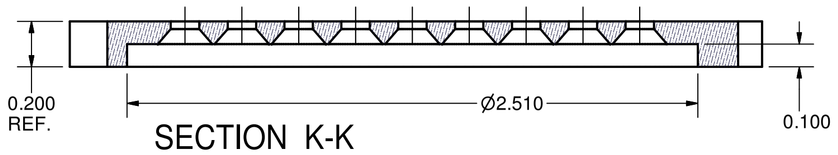
REVISIONS				
SYM.	ZONE	DESCRIPTION	DATE	APP.



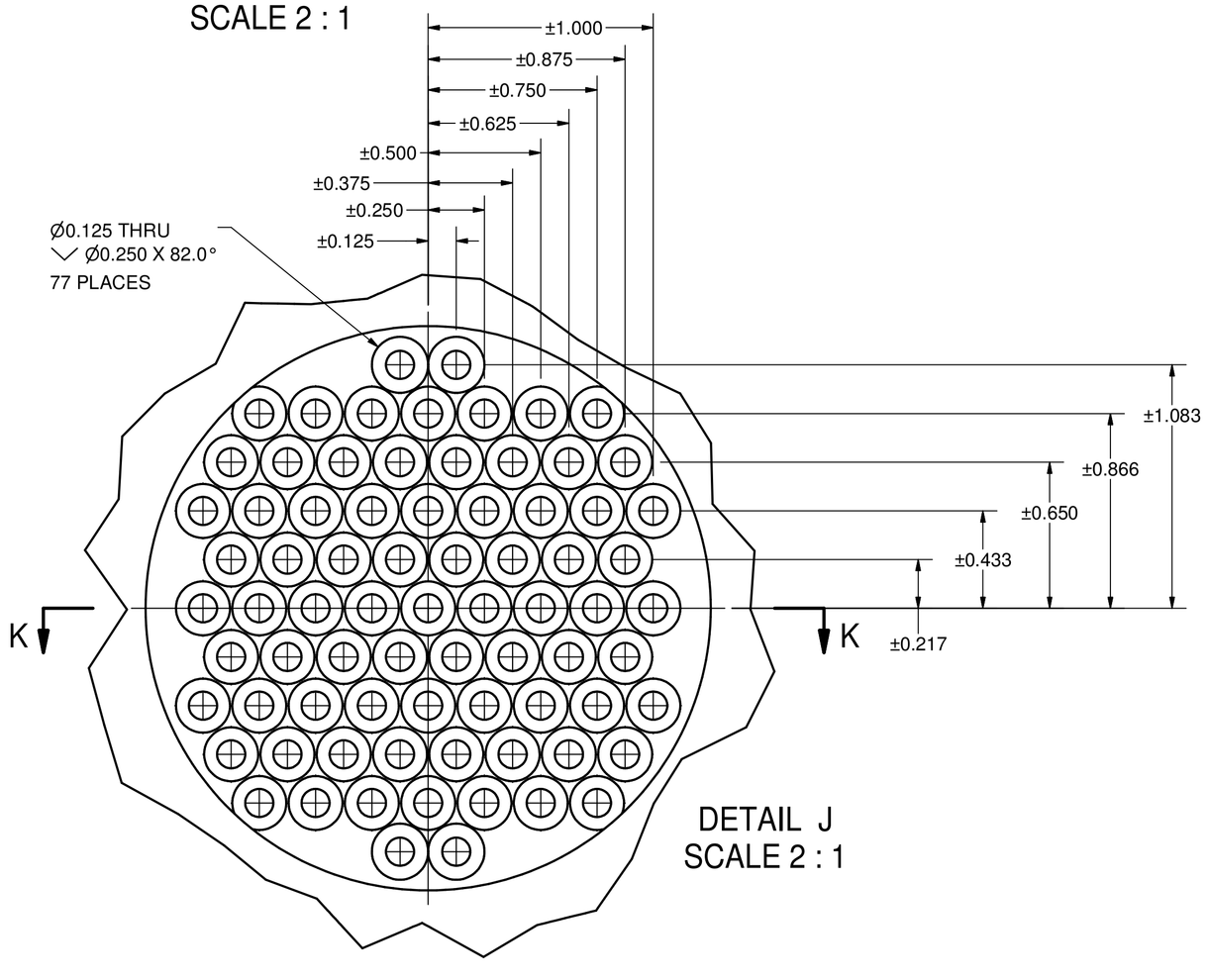
DETAIL HH
SCALE 3:1







SECTION K-K
SCALE 2 : 1



DETAIL J
SCALE 2 : 1

(2) Beam Pipe -- Bottom Half

FILE NAME: 6085-003
SHEET NO.: 6
DFT. SCALE: 1 : 1
MATERIAL: Copper, See Sheet 2
QTY: 1
NOTES:

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ALKALINE DETERGENT LUBRICANT CIMSTAR 40
OR EQUIVALENT APPROVED BY CORNELL LEPP

TECHNICAL RESOURCE APPROVALS REQUIRED BEFORE FABRICATION			
	OK	DATE	N/A
DRAFTING (O'Connel):			
MACHINE SHOP (Kaminski):			
CHEMISTRY (Conklin):			
ELECTRONICS SHOP (Barley):			
FURNACE BRAZING (Sherwood):			
BEAM WELDING (Sears):			
WELDING OTHER (Gallagher):			
UTILITIES INTEGRATION (Gallagher):			
STOCKROOMS (Lockwood):			

ITEM	DWG. NO.	DESCRIPTION	G1	G2	G3	REMARKS	REV.
			QUANTITY				

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PLOT DATE: 2/4/2008
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SH. NO. 6 | 6085-003 | OF 22 | REV.

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FRACTIONS ± 1/64
ANGLES ± 0.5°
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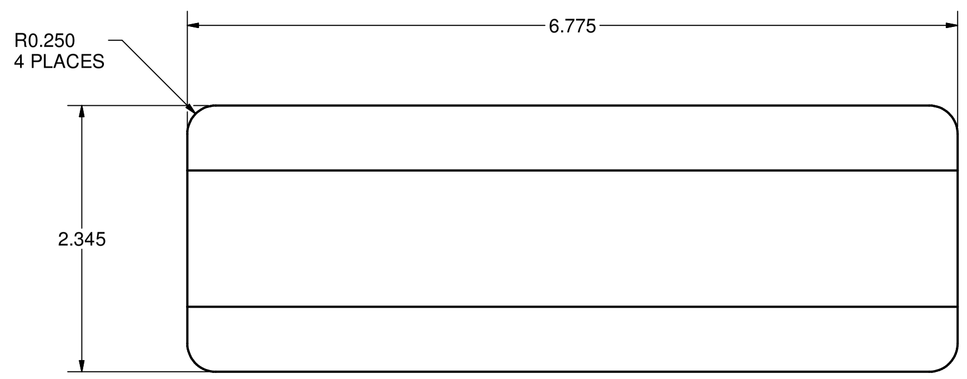
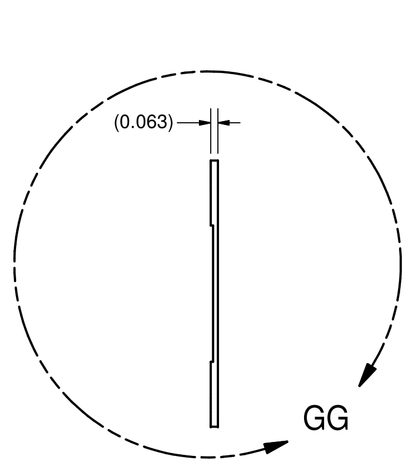
Ithaca, NY 14853

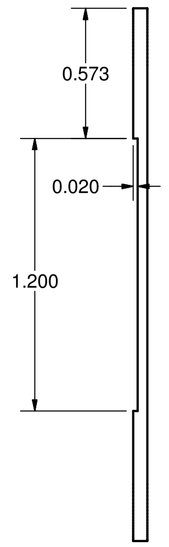
CESR Wiggler Chamber with Thin RFA
Beam Pipe Bottom Half, Detail

DRAWN BY	DRAWN FOR	DATE	SCALE			REV.
Yulin Li	Yulin Li	1/29/2008		D	6085-003 SH. NO. 6 OF 22	

REVISIONS				
SYM.	ZONE	DESCRIPTION	DATE	APP.



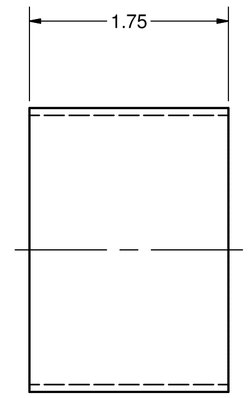


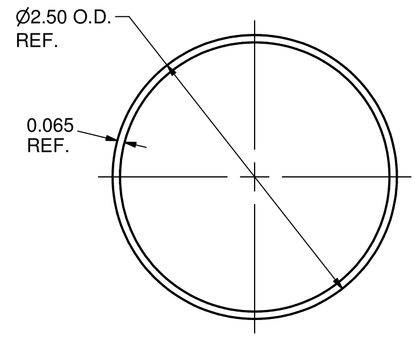


DETAIL GG
SCALE 2 : 1

3 Flex-Circuit Tunnel Cover

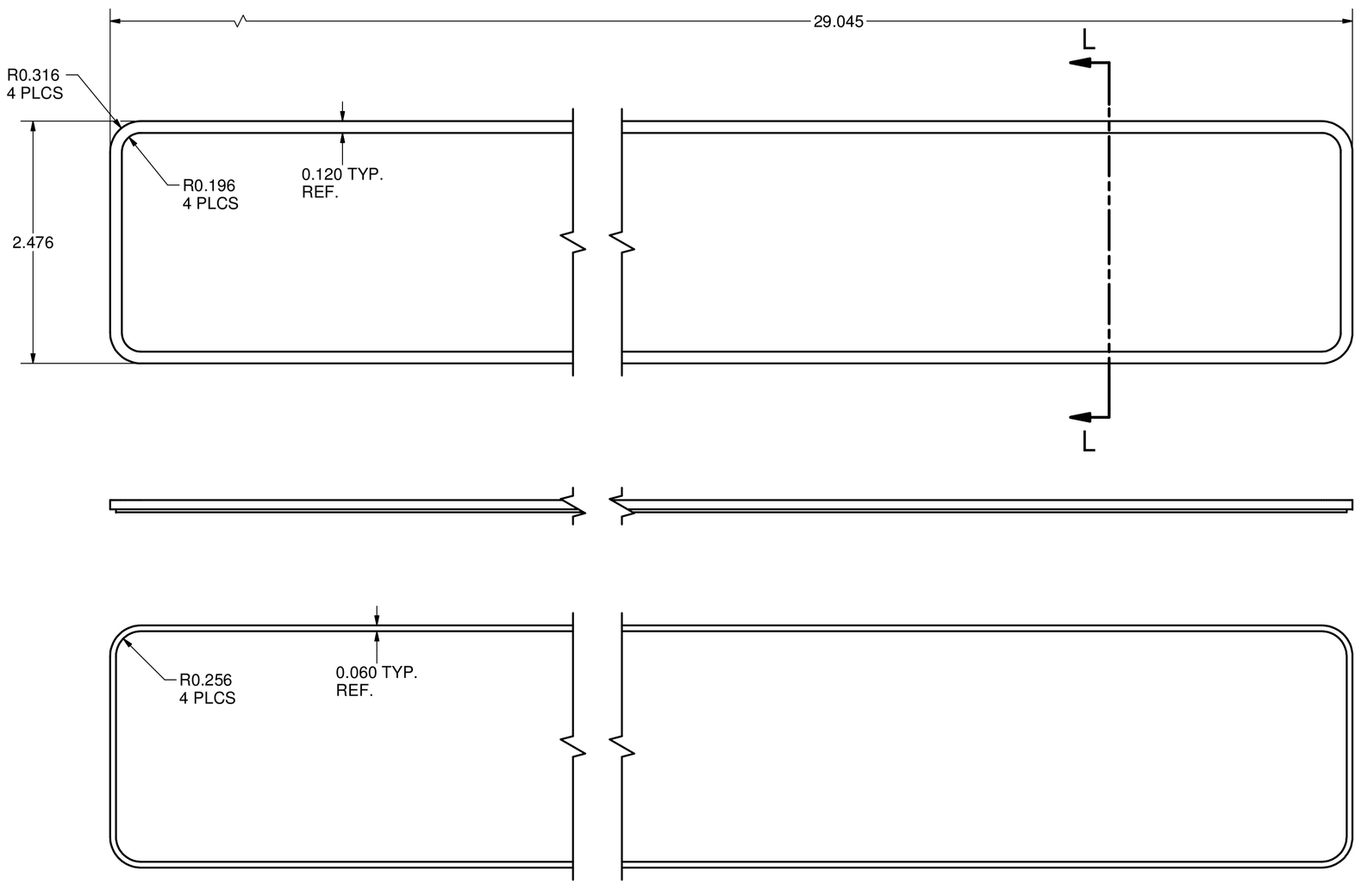
FILE NAME: 6085-003
SHEET NO.: 7
DFT. SCALE: 1 : 1
MATERIAL: OFHC Copper, 0.063" THK
QTY: 1
NOTES:

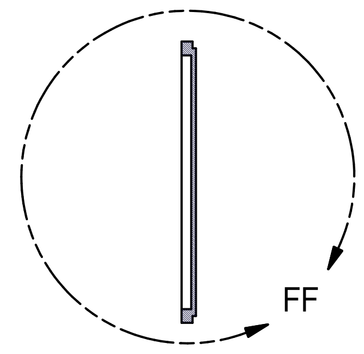




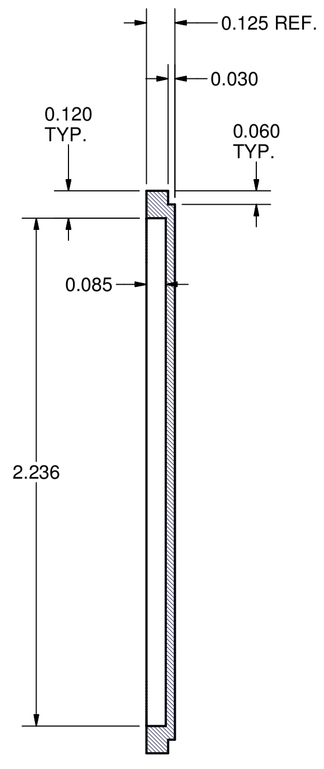
4 2.50" Port Tube

FILE NAME: 6085-003
SHEET NO.: 7
DFT. SCALE: 1 : 1
MATERIAL: 304L SST Tube, 2.50" OD, 0.065" Wall
QTY: 2
NOTES: UHV Grade





SECTION L-L
SCALE 1 : 1



DETAIL FF
SCALE 2 : 1

8 RFA Vacuum Cover

FILE NAME: 6085-003
SHEET NO.: 7
DFT. SCALE: 1 : 1
MATERIAL: OFHC Copper, 0.125" THK
QTY: 1
NOTES:

FOR MACHINING LUBRICANT USE ONLY
ALKALINE DETERGENT LUBRICANT CIMSTAR 40
OR EQUIVALENT APPROVED BY CORNELL LEPP

TECHNICAL RESOURCE APPROVALS REQUIRED BEFORE FABRICATION	OK	DATE	N/A
DRAFTING (O'Connel):			
MACHINE SHOP (Kaminski):			
CHEMISTRY (Conklin):			
ELECTRONICS SHOP (Barley):			
FURNACE BRAZING (Sherwood):			
BEAM WELDING (Sears):			
WELDING OTHER (Gallagher):			
UTILITIES INTEGRATION (Gallagher):			
STOCKROOMS (Lockwood):			

ITEM	DWG. NO.	DESCRIPTION	G1	G2	G3	REMARKS	REV.
			QUANTITY				

PRINT DISTR. CR-1

PLOT DATE: 2/4/2008
CAD FILE NAME: 6085-003.idw

SH. NO. 7 OF 22 — 6085-003 — REV.

UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN INCHES;
TOLERANCES ON:
.00 ± .010
.000 ± .005
FRACTIONS ± 1/64
ANGLES ± 0.5°
ALL SURFACES 32

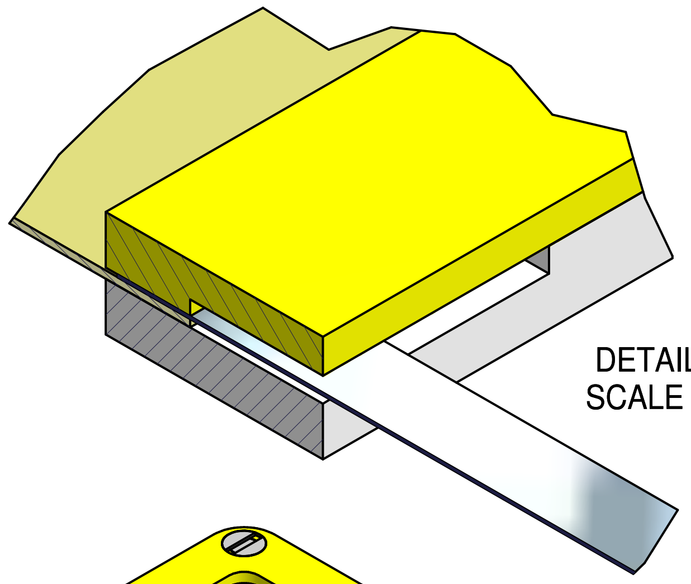
CHECKED BY:
APPROVED BY:

CORNELL UNIVERSITY LEPP
LABORATORY FOR ELEMENTARY-PARTICLE PHYSICS

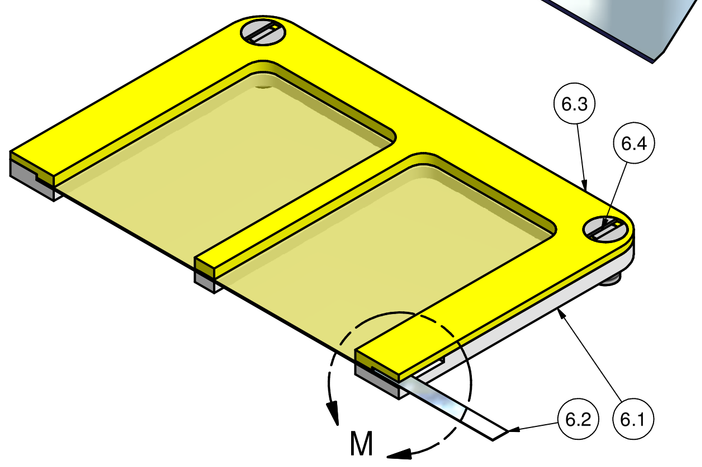
CORNELL UNIVERSITY
Floyd R. Newman Laboratory
Ithaca, NY 14853

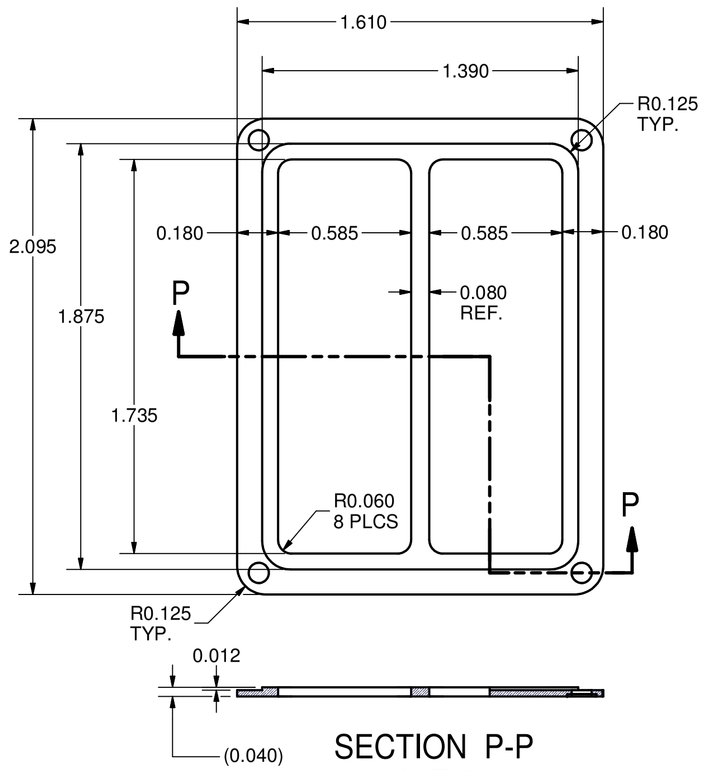
CESR Wiggler Chamber with Thin RFA
Cover Plates, Details

DRAWN BY	DRAWN FOR	DATE	SCALE			REV.
Yulin Li	Yulin Li	1/29/2008		D	6085-003 SH. NO. 7 OF 22	

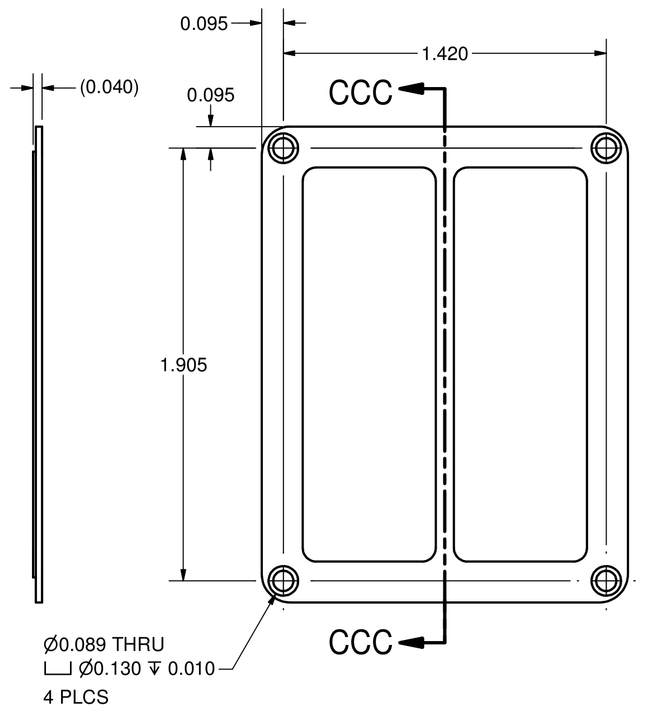


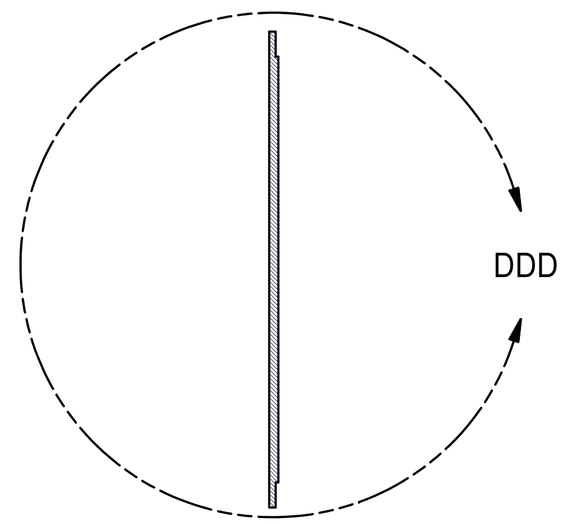
DETAIL M
SCALE 15:1



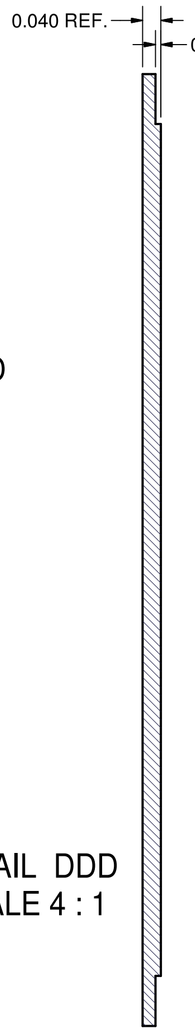


SECTION P-P
SCALE 2 : 1

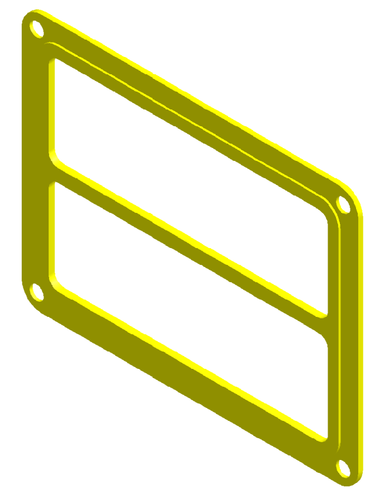




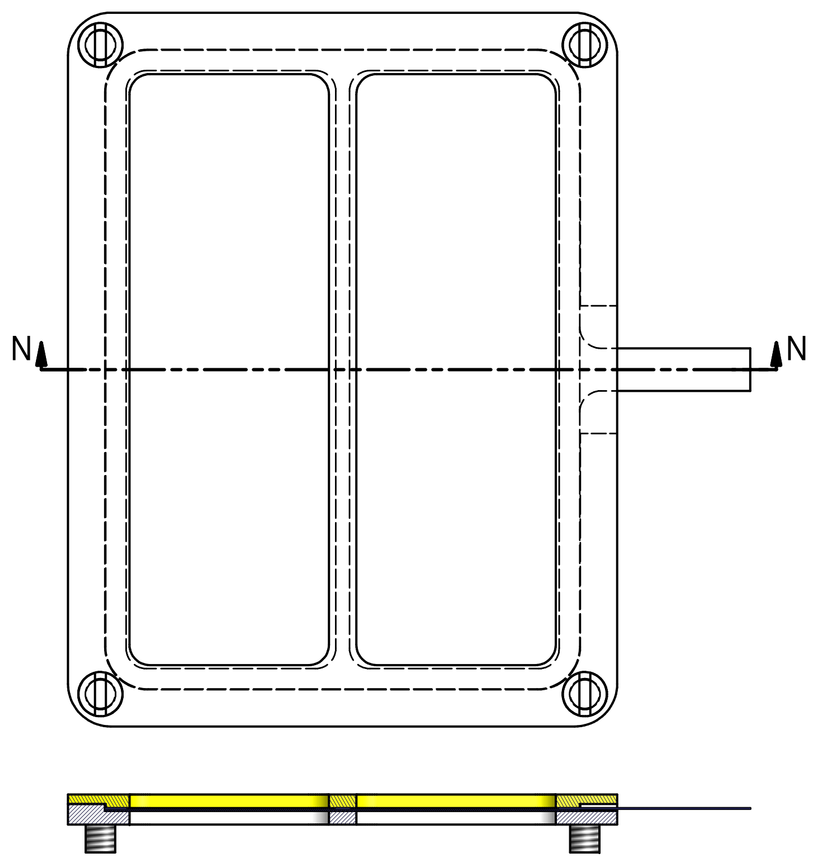
SECTION CCC-CCC
SCALE 2 : 1



DETAIL DDD
SCALE 4 : 1



SCALE 2:1

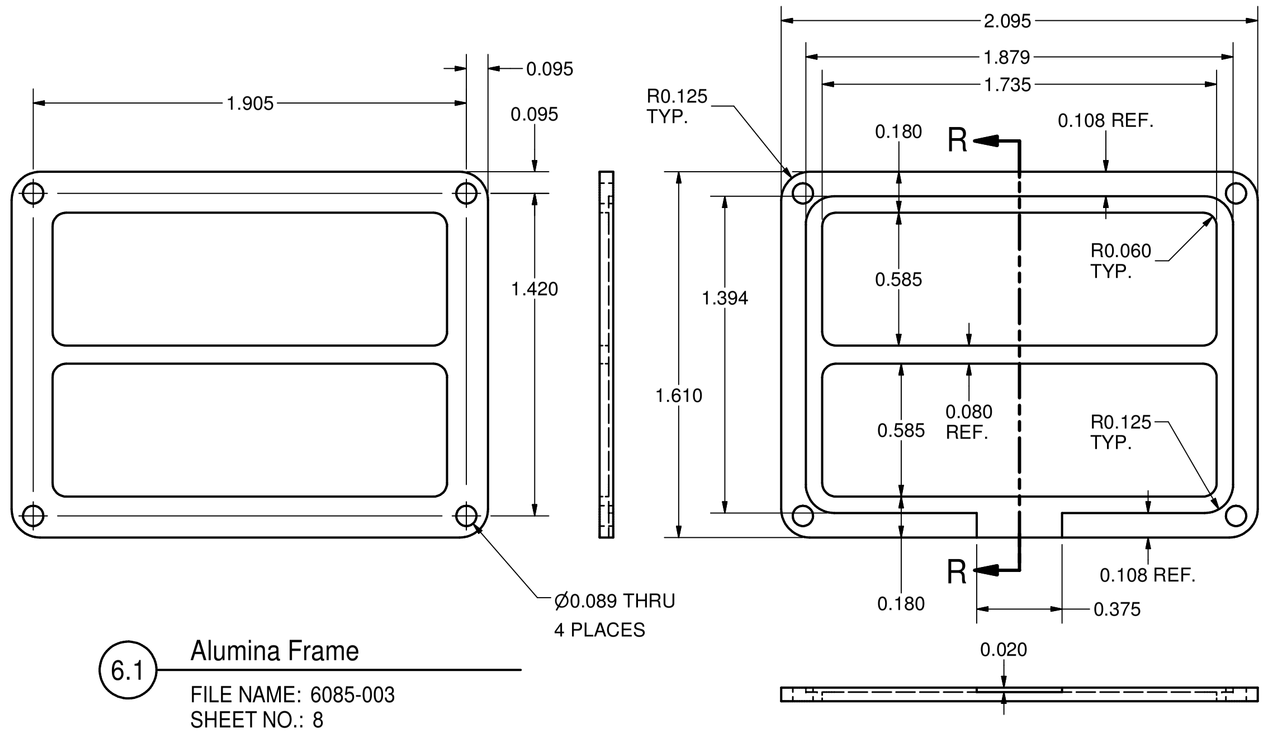


SECTION N-N
SCALE 3 : 1

6 Sandwiched Grid, Sub-Asm

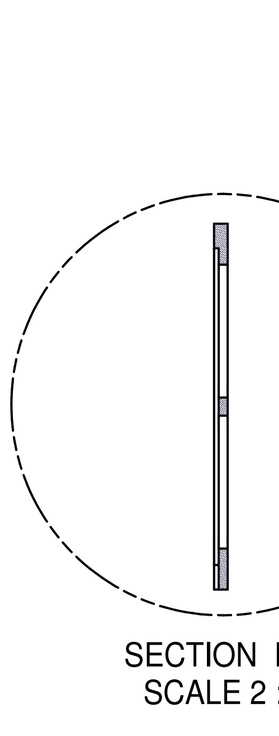
FILE NAME: 6085-003
SHEET NO.: 8
DFT. SCALE: 2 : 1
MATERIAL: As Noted
QTY: 3
NOTES:

6.4	Sheet 9	Special Screw 2-56	4				
6.3	Sheet 8	Alumina Cap	1				
6.2	Sheet 9	Reinforced Grid	1				
6.1	Sheet 8	Alumina Frame	1				



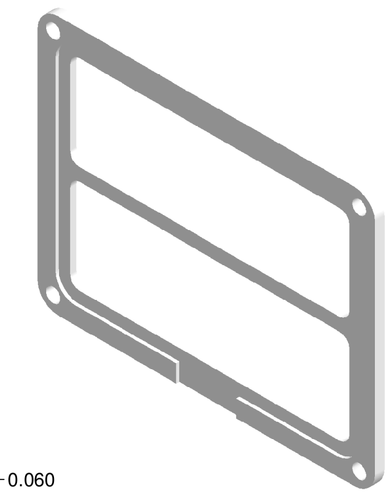
6.1 Alumina Frame

FILE NAME: 6085-003
SHEET NO.: 8
DFT. SCALE: 2 : 1
MATERIAL: Alumina Sheet, 0.060 THK
QTY: 3
NOTES:



SECTION R-R
SCALE 2 : 1

DETAIL BBB
SCALE 4 : 1



SCALE 2 : 1

FOR MACHINING LUBRICANT USE ONLY
ALKALINE DETERGENT LUBRICANT CIMSTAR 40
OR EQUIVALENT APPROVED BY CORNELL LEPP

TECHNICAL RESOURCE APPROVALS REQUIRED BEFORE FABRICATION	OK	DATE	N/A
DRAFTING (O'Connel):			
MACHINE SHOP (Kaminski):			
CHEMISTRY (Conklin):			
ELECTRONICS SHOP (Barley):			
FURNACE BRAZING (Sherwood):			
BEAM WELDING (Sears):			
WELDING OTHER (Gallagher):			
UTILITIES INTEGRATION (Gallagher):			
STOCKROOMS (Lockwood):			

REVISIONS				
SYM.	ZONE	DESCRIPTION	DATE	APP.

ITEM	DWG. NO.	DESCRIPTION	QUANTITY G1	QUANTITY G2	QUANTITY G3	REMARKS	REV.

PRINT DISTR.
PLOT DATE: 2/4/2008
CAD FILE NAME: 6085-003.idw

CR-1

UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN INCHES;
TOLERANCES ON:
.00 ± .010
.000 ± .005
FRACTIONS ± 1/64
ANGLES ± 0.5°
ALL SURFACES

CHECKED BY:
APPROVED BY:

CORNELL UNIVERSITY LEPP
LABORATORY FOR ELEMENTARY-PARTICLE PHYSICS

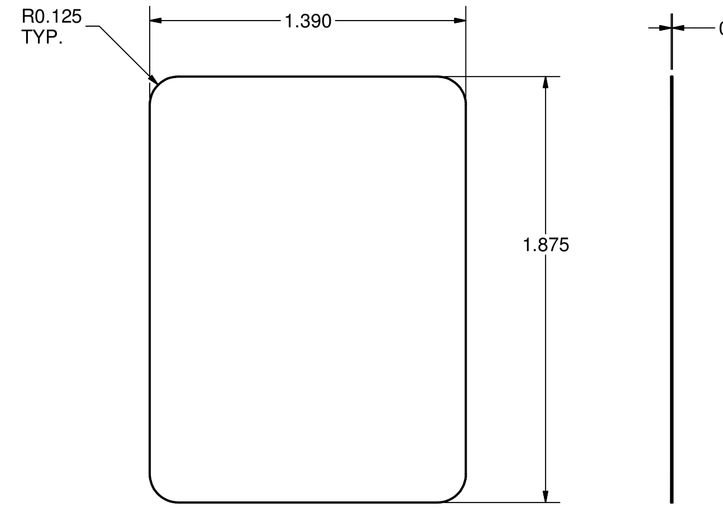
CORNELL UNIVERSITY
Floyd R. Newman Laboratory
Ithaca, NY 14853

CESR Wiggler Chamber with Thin RFA
Sandwich Grid, Sub-Asm

DRAWN BY	DRAWN FOR	DATE	SCALE	SIZE	6085-003 SH. NO. 8 OF 22	REV.
Yulin Li	Yulin Li	1/29/2008		D		

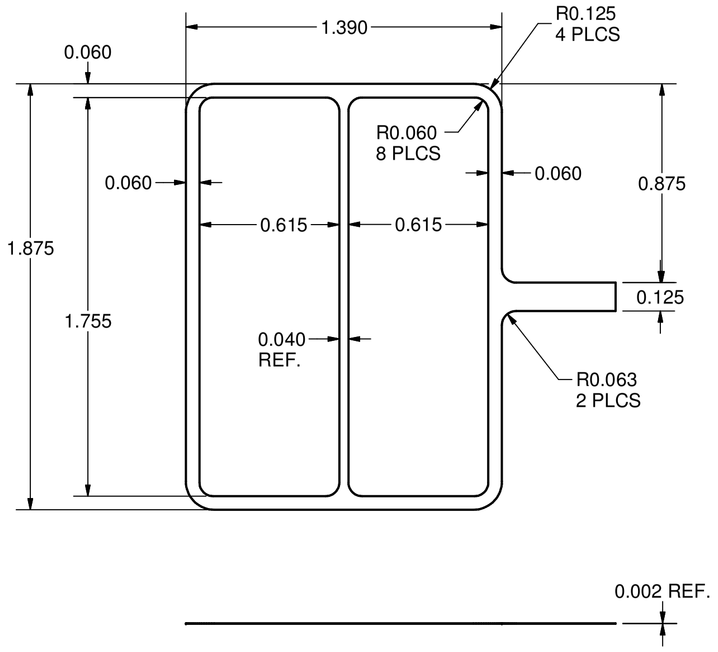
6085-003 SH. NO. 8 OF 22 REV:

REVISIONS				
SYM.	ZONE	DESCRIPTION	DATE	APP.



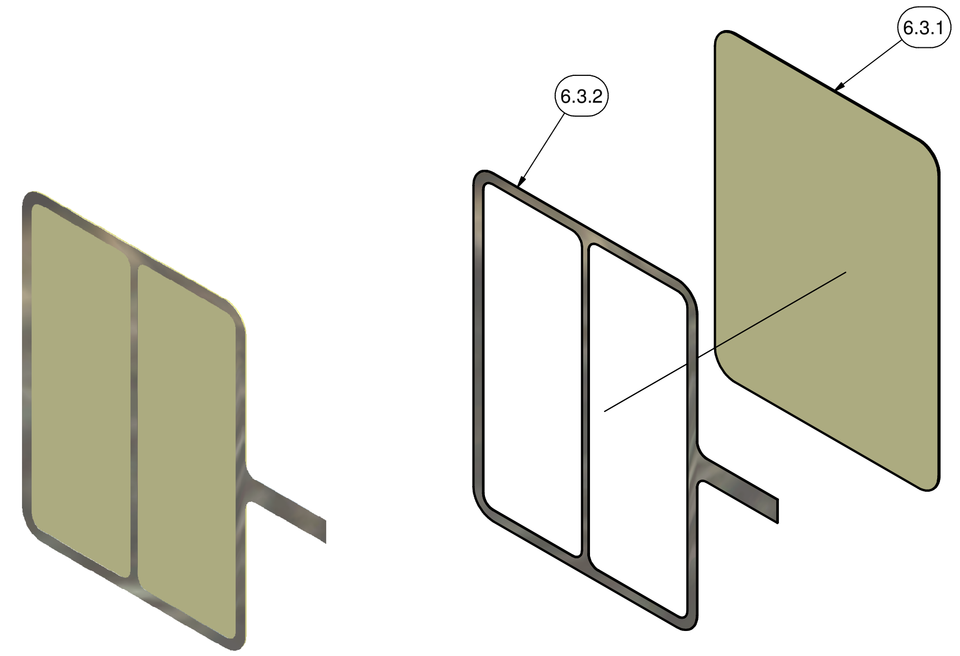
6.3.1 Stainless Steel Mesh

FILE NAME: 6085-003
SHEET NO.: 9
DFT. SCALE: 2 : 1
MATERIAL: Make from P/N BE0600 SST Mesh
QTY: 3
NOTES: Purchase the mesh from InterNet Netting for Industry



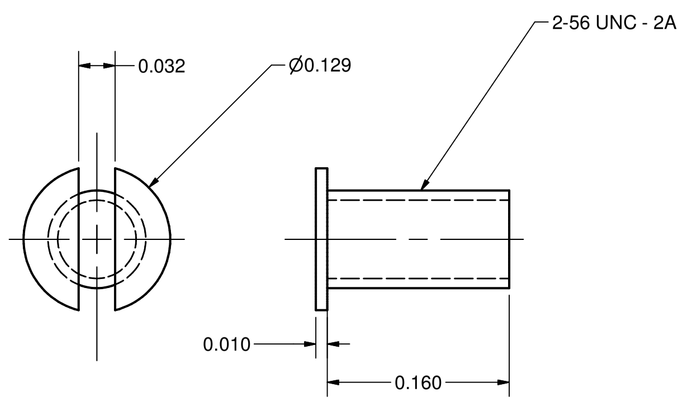
6.3.2 Shim Frame

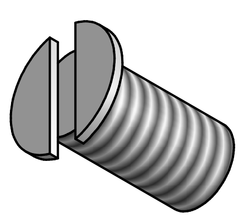
FILE NAME: 6085-003
SHEET NO.: 9
DFT. SCALE: 2 : 1
MATERIAL: 0.002" SST Shim Stock
QTY: 3
NOTES:



6.2 Reinforced Grid

FILE NAME: 6085-003
SHEET NO.: 9
DFT. SCALE: 2 : 1
MATERIAL: As Noted
QTY: 3
NOTES:





6.4 Special #2-56 SST Screws

FILE NAME: 6085-003
SHEET NO.: 9
DFT. SCALE: 10 : 1
MATERIAL: Make from SST Fillister Head #2-56 Screw
QTY: 12
NOTES:

FOR MACHINING LUBRICANT USE ONLY
ALKALINE DETERGENT LUBRICANT CIMSTAR 40
OR EQUIVALENT APPROVED BY CORNELL LEPP

TECHNICAL RESOURCE APPROVALS REQUIRED BEFORE FABRICATION	OK	DATE	N/A
DRAFTING (O'Connel):			
MACHINE SHOP (Kaminski):			
CHEMISTRY (Conklin):			
ELECTRONICS SHOP (Barley):			
FURNACE BRAZING (Sherwood):			
BEAM WELDING (Sears):			
WELDING OTHER (Gallagher):			
UTILITIES INTEGRATION (Gallagher):			
STOCKROOMS (Lockwood):			

ITEM	DWG. NO.	DESCRIPTION	QUANTITY G1	G2	G3	REMARKS	REV.
6.3.2	Sheet 9	SST Shim Frame	1				
6.3.1	Sheet 9	SST Mesh	1				

D | PRINT DISTR. | CR-1

PLOT DATE: 2/4/2008
CAD FILE NAME: 6085-003.idw

UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN INCHES;
TOLERANCES ON:
.00 ± .010
.000 ± .005
FRACTIONS ± 1/64
ANGLES ± 0.5°
ALL SURFACES 63

CHECKED BY:
APPROVED BY:

CORNELL UNIVERSITY LEPP
LABORATORY FOR ELEMENTARY-PARTICLE PHYSICS

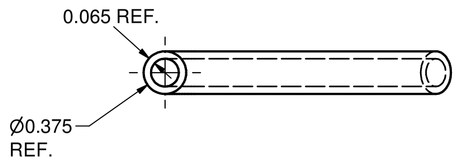
CORNELL UNIVERSITY
Floyd R. Newman Laboratory
Ithaca, NY 14853

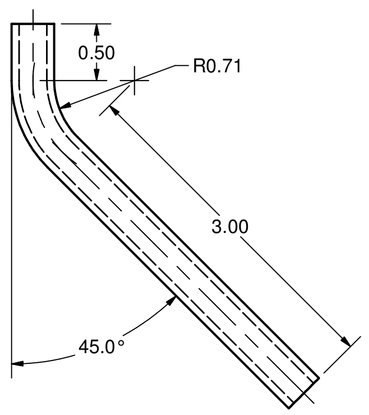
CESR Wiggler Chamber with Thin RFA
Reinforced Grid, Sub-Asm

DRAWN BY	DRAWN FOR	DATE	SCALE			REV.
Yulin Li	Yulin Li	1/29/2008		D	6085-003 SH. NO. 9 OF 22	

6085-003 SH. NO. 9 OF 22 REV.

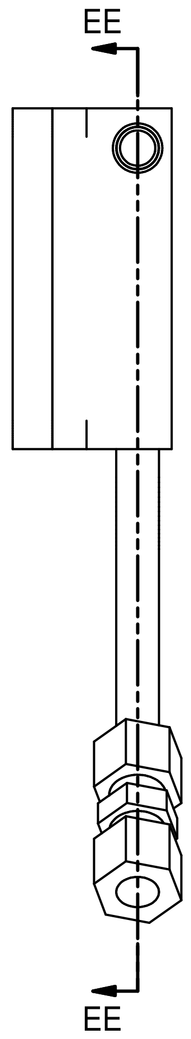
REVISIONS				
SYM.	ZONE	DESCRIPTION	DATE	APP.

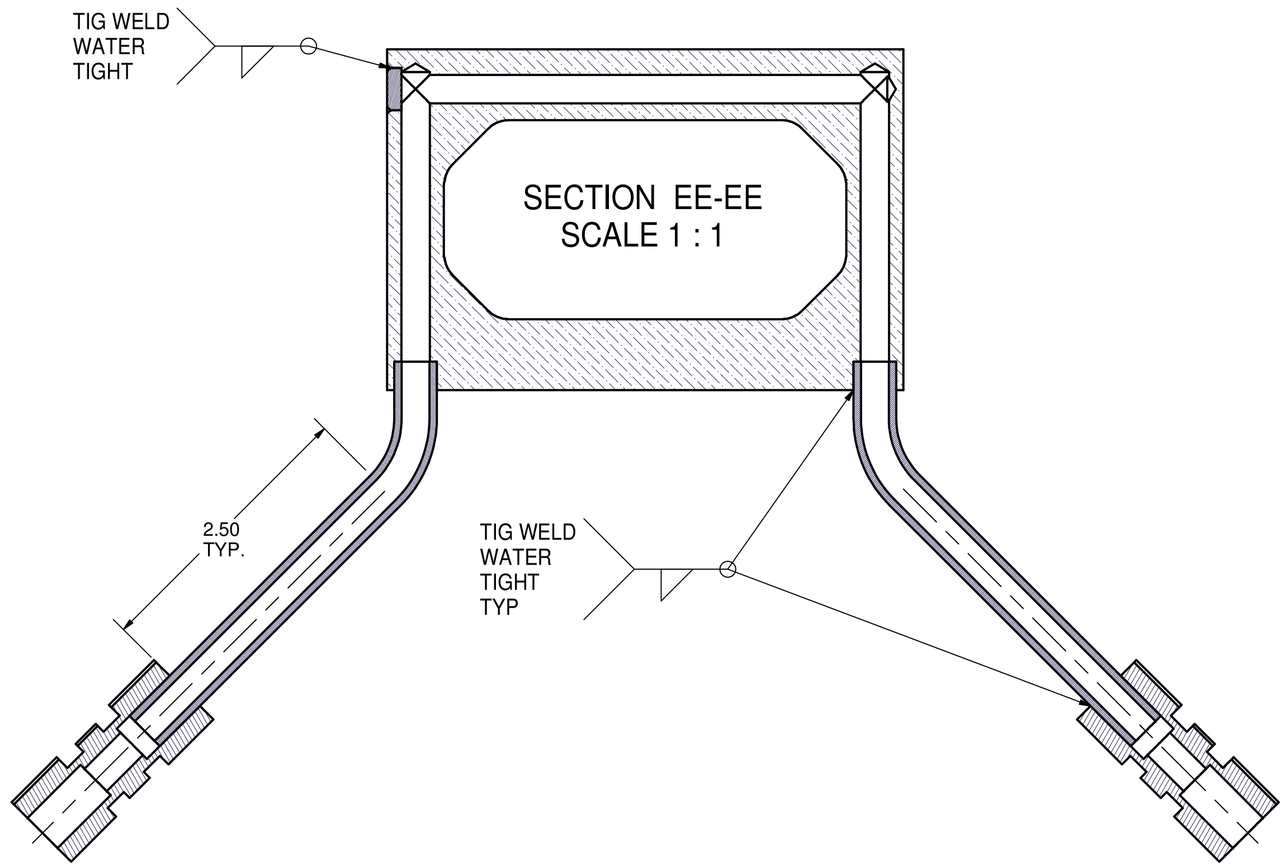


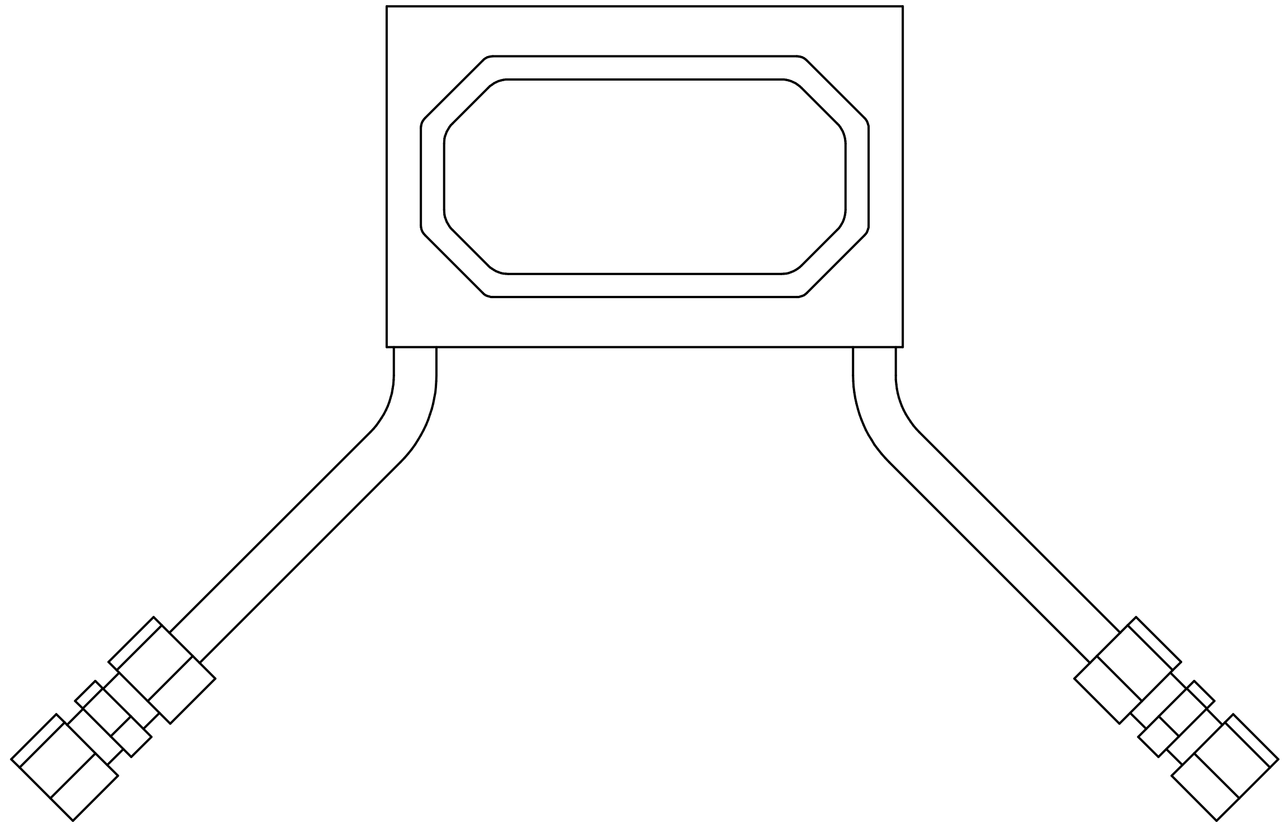


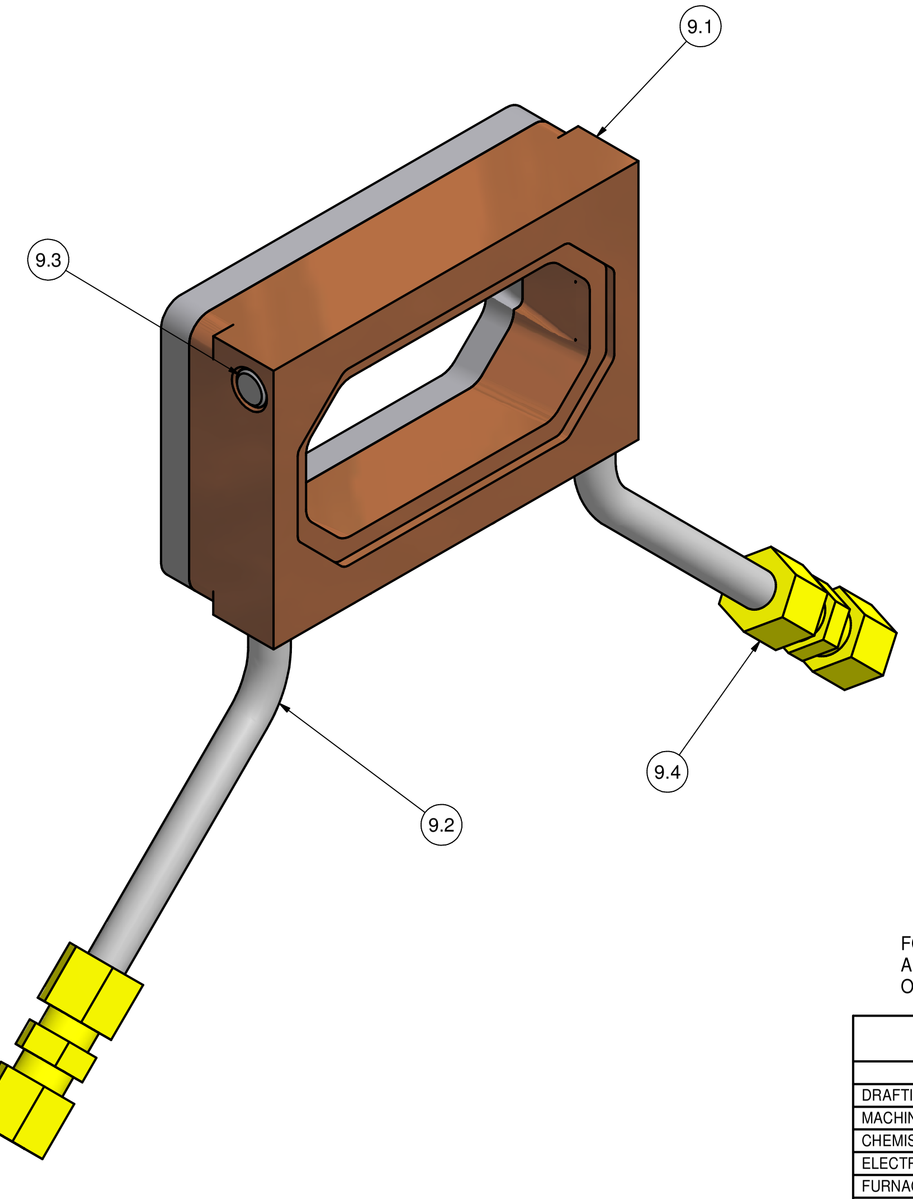
9.2 Cooling Tube

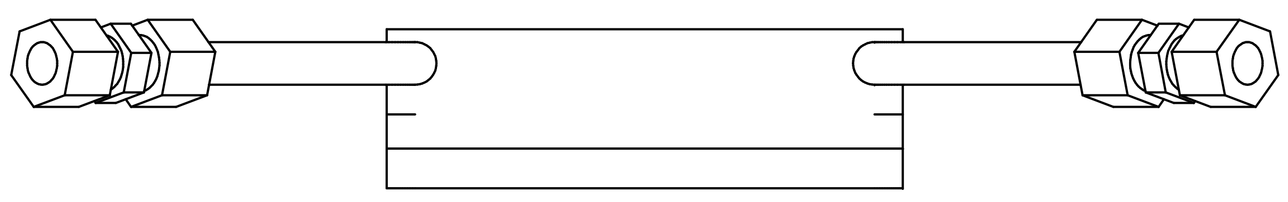
FILE NAME: 6085-003
SHEET NO.: 10
DFT. SCALE: 1 : 1
MATERIAL: 3/8" SST Tube, 0.065" Wall
QTY: 2 PER SUB-ASM (4 TOTAL)
NOTES:





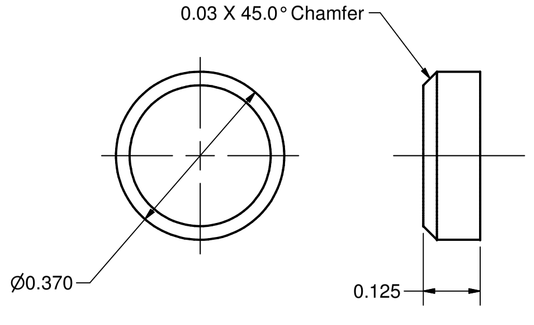






9 SST-Cu Transition, Sub-Asm

FILE NAME: 6085-003
SHEET NO.: 10
DFT. SCALE: 1 : 1
MATERIAL: As Noted
QTY: 2
NOTES: Only one transition will be used in this assembly
The second will be used in final assembly at Cornell



9.3 Plug

FILE NAME: 6085-003
SHEET NO.: 10
DFT. SCALE: 4 : 1
MATERIAL: 304L SST
QTY: 1
NOTES:

FOR MACHINING LUBRICANT USE ONLY
ALKALINE DETERGENT LUBRICANT CIMSTAR 40
OR EQUIVALENT APPROVED BY CORNELL LEPP

TECHNICAL RESOURCE APPROVALS REQUIRED BEFORE FABRICATION	OK	DATE	N/A
DRAFTING (O'Connel):			
MACHINE SHOP (Kaminski):			
CHEMISTRY (Conklin):			
ELECTRONICS SHOP (Barley):			
FURNACE BRAZING (Sherwood):			
BEAM WELDING (Sears):			
WELDING OTHER (Gallagher):			
UTILITIES INTEGRATION (Gallagher):			
STOCKROOMS (Lockwood):			

ITEM	DWG. NO.	DESCRIPTION	QUANTITY G1	G2	G3	REMARKS	REV.
9.4	LEPP Stock	0375 Swage	2			Purchase	
9.3	Shee 10	SST Plug	1				
9.2	Sheet 10	3/8" SST Tube	2				
9.1	Sheet 11	SST-Cu Transition	1				

D

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PLOT DATE: 2/4/2008
CAD FILE NAME: 6085-003.idw

CR-1

6085-003 SH. NO. 10 OF 22

REV.

UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN INCHES;
TOLERANCES ON:
.00 ± .010
.000 ± .005
FRACTIONS ± 1/64
ANGLES ± 0.5°
ALL SURFACES 63

CHECKED BY:
APPROVED BY:

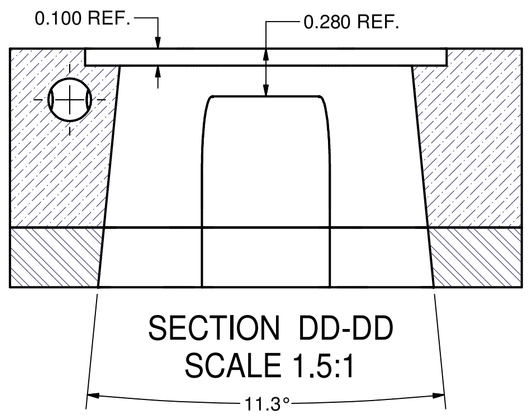
CORNELL UNIVERSITY LEPP
LABORATORY FOR ELEMENTARY-PARTICLE PHYSICS

CORNELL UNIVERSITY
Floyd R. Newman Laboratory
Ithaca, NY 14853

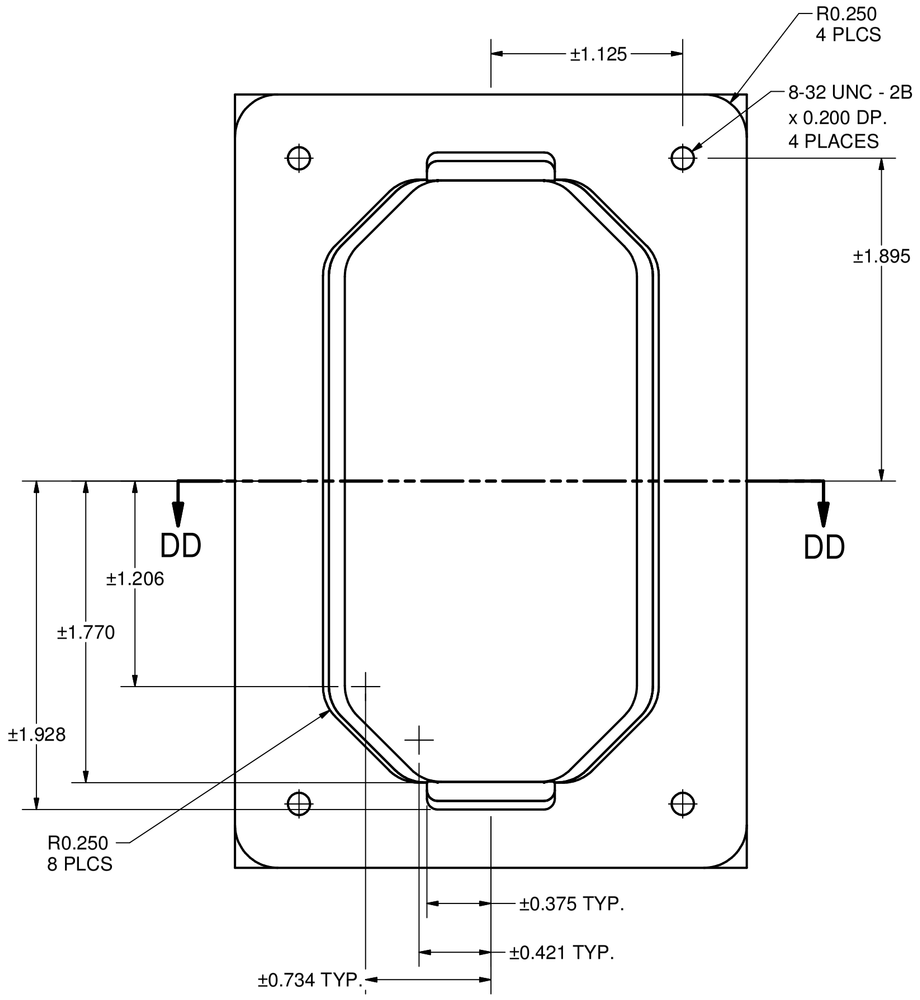
CESR Wiggler Chamber with Thin RFA
SST-Cu Transition, Sub-Asm

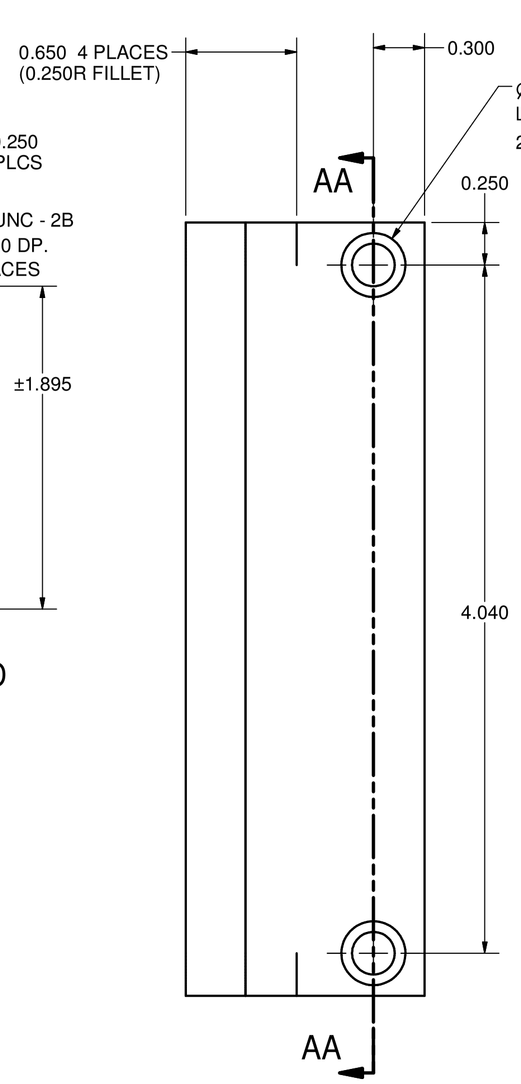
DRAWN BY	DRAWN FOR	DATE	SCALE			REV.
Yulin Li	Yulin Li	1/29/2008		D	6085-003 SH. NO. 10 OF 22	

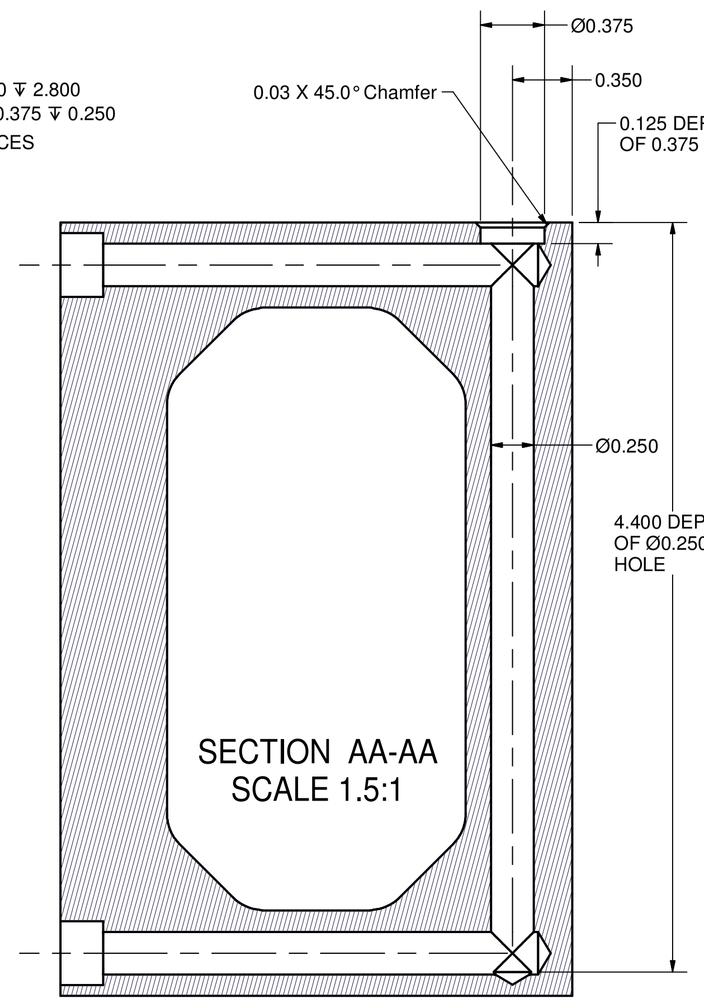
REVISIONS				
SYM.	ZONE	DESCRIPTION	DATE	APP.



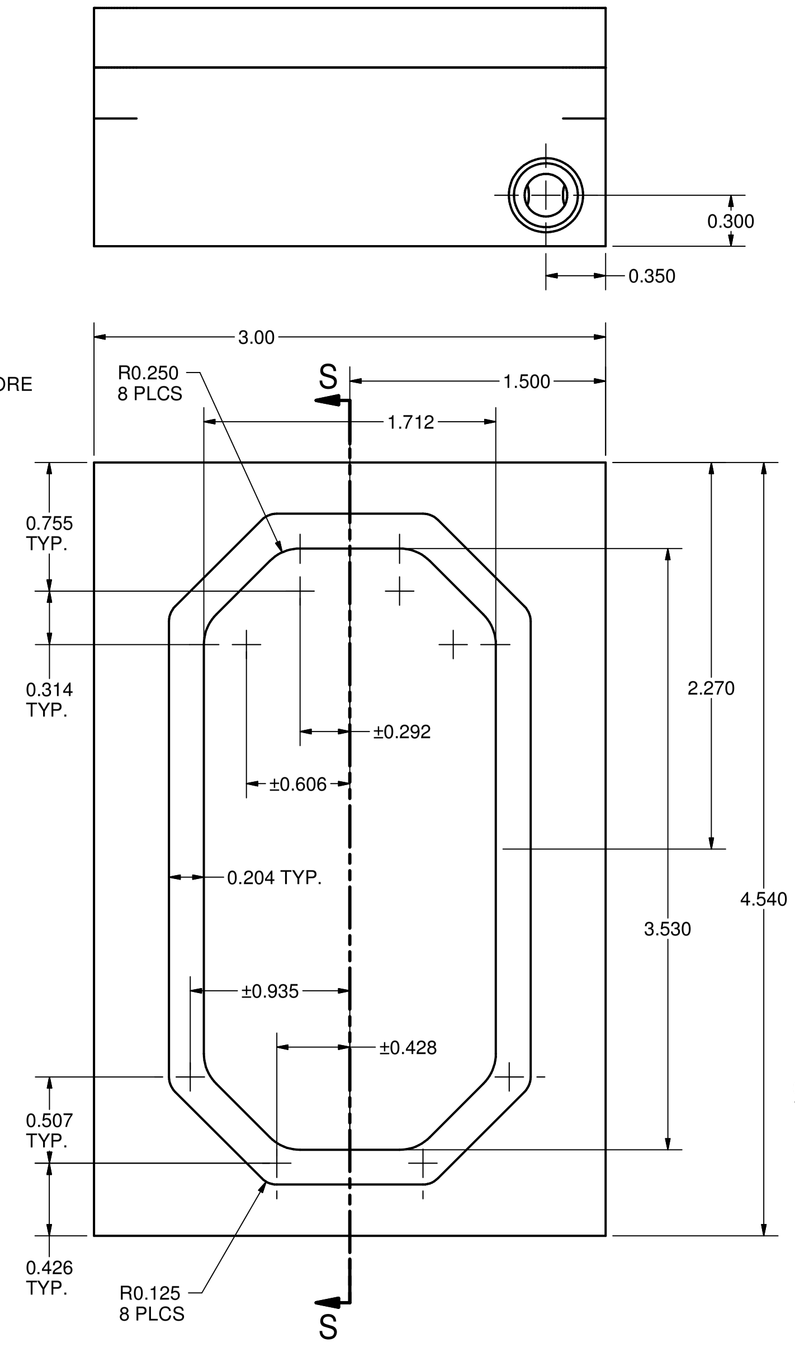
SECTION DD-DD
SCALE 1.5:1

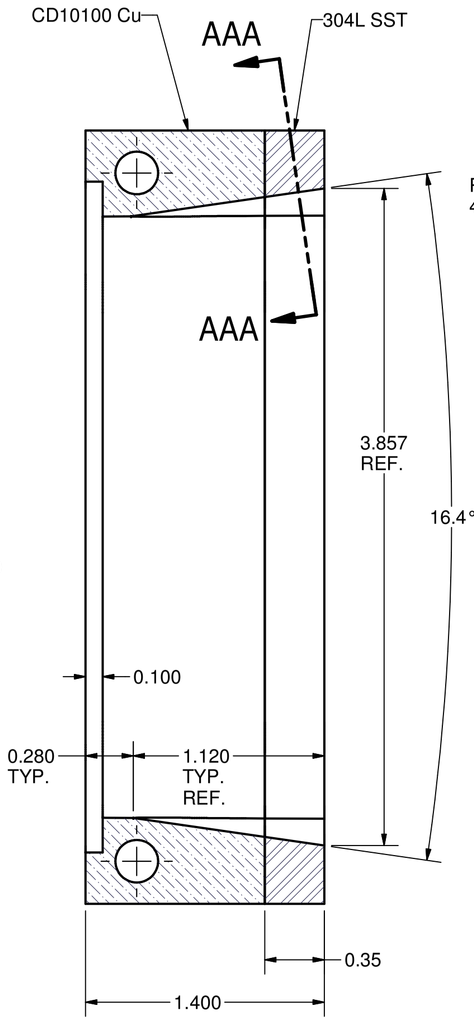






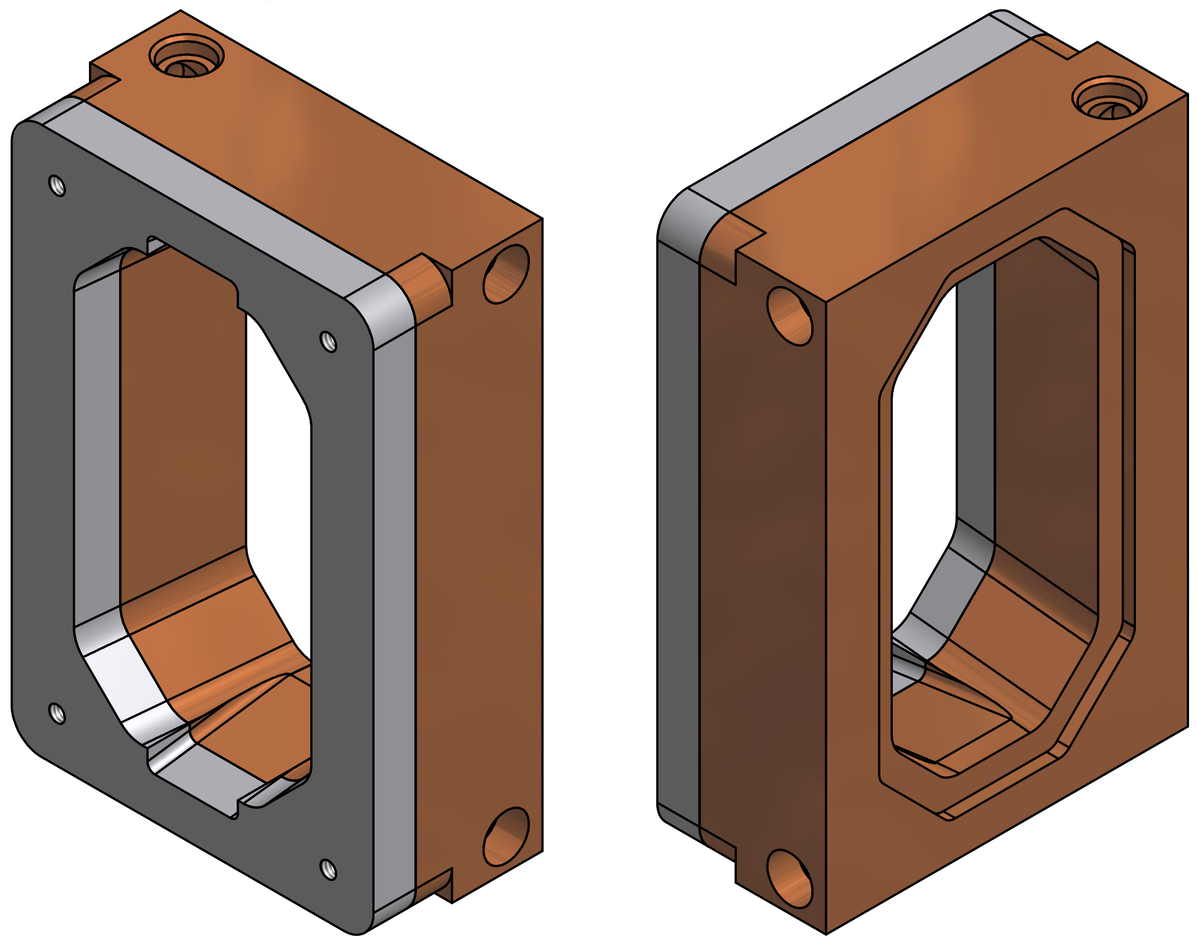
SECTION AA-AA
SCALE 1.5:1





SECTION AAA-AAA
SCALE 1.5:1

SECTION S-S
SCALE 1.5:1



9.1 SST/Cu Transition

FILE NAME: 6085-003
SHEET NO.: 11
DFT. SCALE: 1.5:1
MATERIAL: Explosion Bonded SST-Cu Plate
QTY: 2
NOTES:

FOR MACHINING LUBRICANT USE ONLY
ALKALINE DETERGENT LUBRICANT CIMSTAR 40
OR EQUIVALENT APPROVED BY CORNELL LEPP

TECHNICAL RESOURCE APPROVALS REQUIRED BEFORE FABRICATION			
	OK	DATE	N/A
DRAFTING (O'Connel):			
MACHINE SHOP (Kaminski):			
CHEMISTRY (Conklin):			
ELECTRONICS SHOP (Barley):			
FURNACE BRAZING (Sherwood):			
BEAM WELDING (Sears):			
WELDING OTHER (Gallagher):			
UTILITIES INTEGRATION (Gallagher):			
STOCKROOMS (Lockwood):			

ITEM	DWG. NO.	DESCRIPTION	QUANTITY G1	G2	G3	REMARKS	REV.

PRINT DISTR. CR-1

PLOT DATE: 2/4/2008
CAD FILE NAME: 6085-003.idw

UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN INCHES;
TOLERANCES ON:
.00 ±.010
.000 ±.005
FRACTIONS ±1/64
ANGLES ±0.5°
ALL SURFACES

CHECKED BY:
APPROVED BY:

CORNELL UNIVERSITY LEPP
LABORATORY FOR ELEMENTARY-PARTICLE PHYSICS

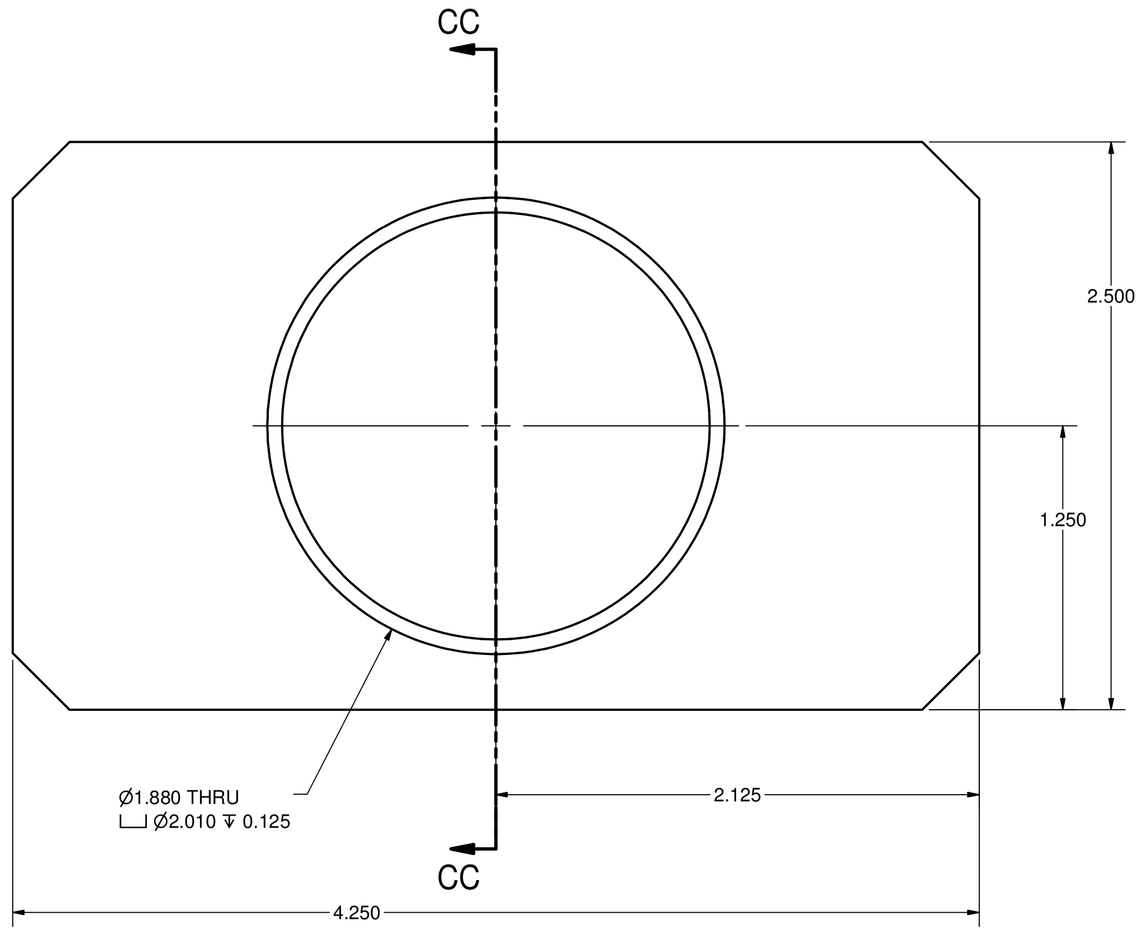
CORNELL UNIVERSITY
Floyd R. Newman Laboratory
Ithaca, NY 14853

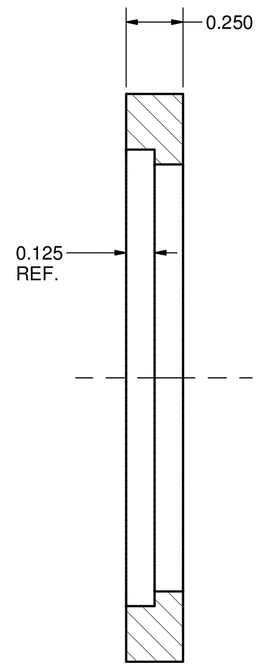
CESR Wiggler Chamber with Thin RFA
SST/Cu Transition, Detail

DRAWN BY	DRAWN FOR	DATE	SCALE			REV.
Yulin Li	Yulin Li	1/29/2008		D	6085-003 SH. NO. 11 OF 22	

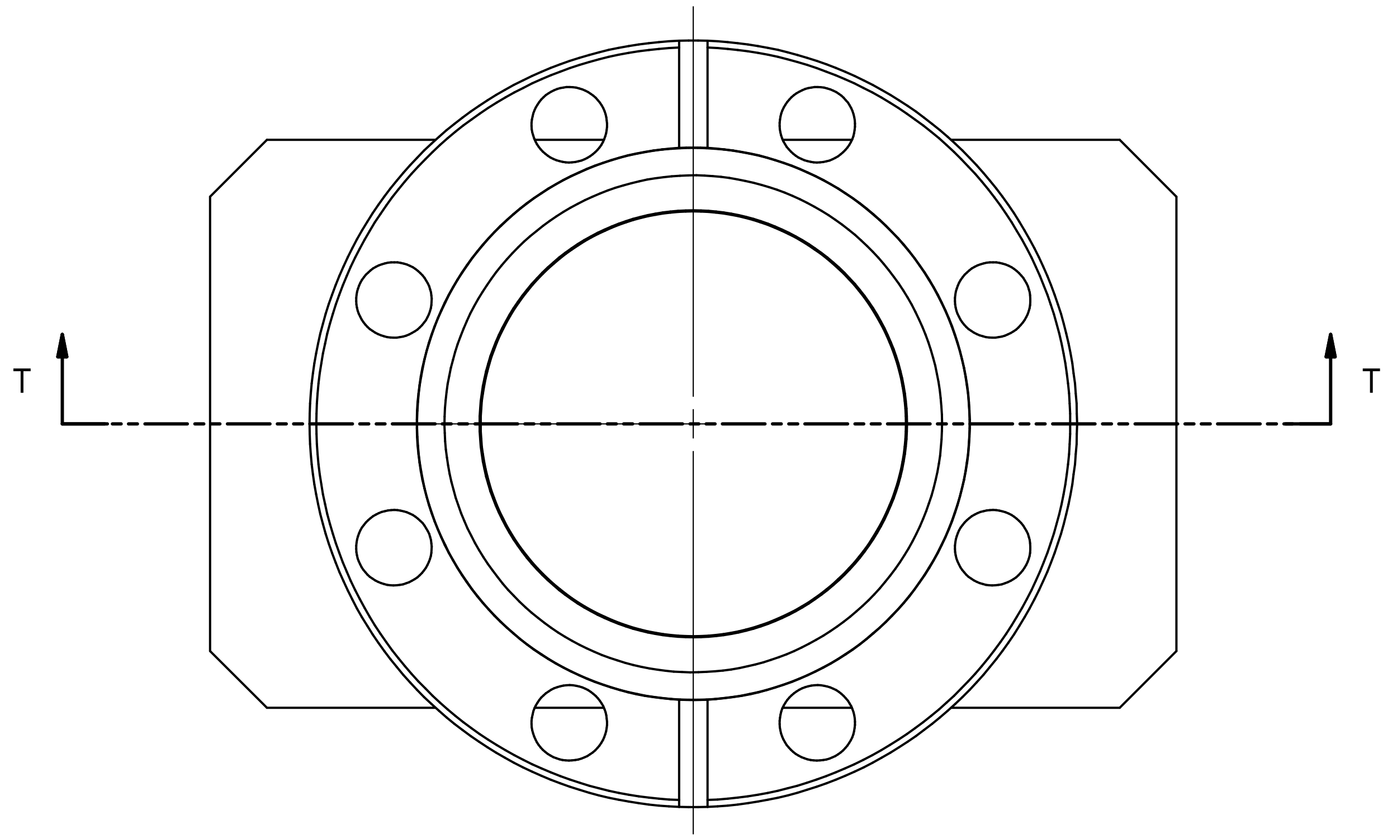
6085-003 SH. NO. 11 OF 22 REV.

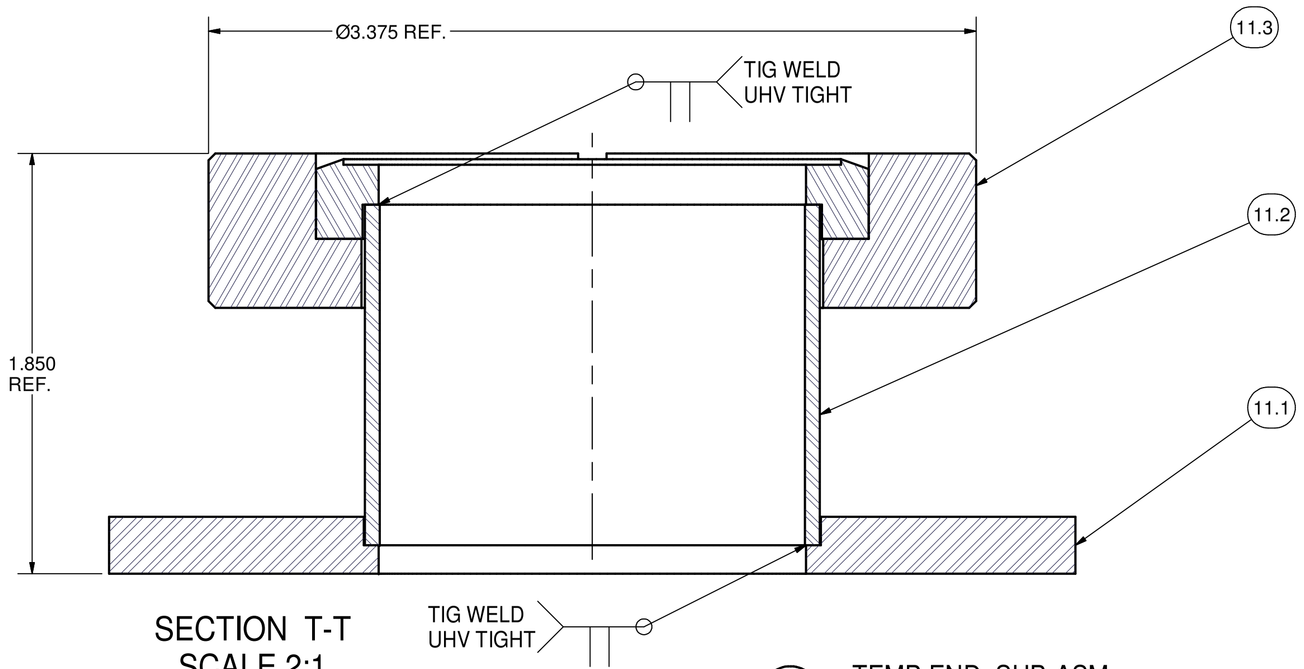
REVISIONS				
SYM.	ZONE	DESCRIPTION	DATE	APP.





SECTION CC-CC
SCALE 2:1

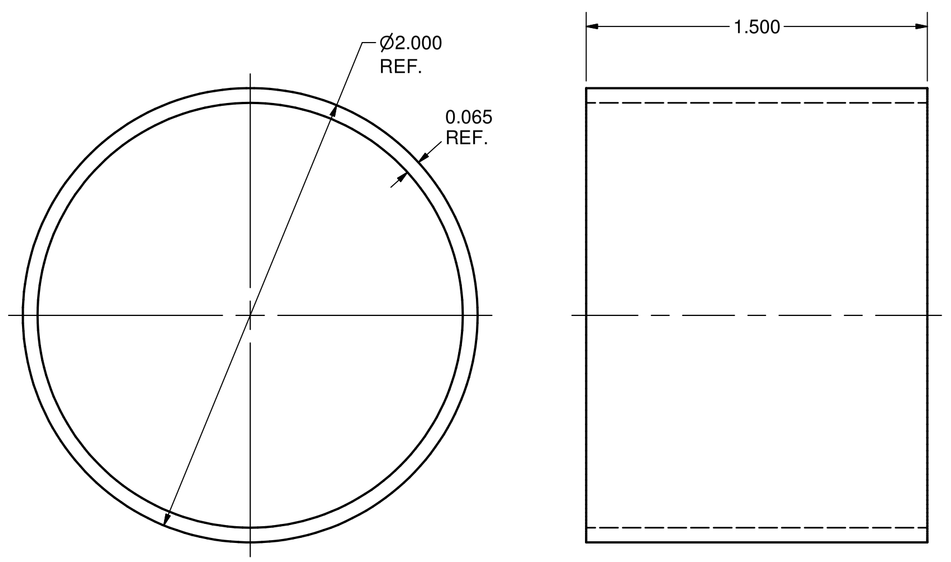




SECTION T-T
SCALE 2:1

11.1 TEMP END PLATE

FILE NAME: 6085-003
SHEET NO.: 12
DFT. SCALE: 2:1
MATERIAL: 304L STN STL
QTY: 1 PER SUB-ASM
NOTES:



11.2 2.00" O.D. TUBE

FILE NAME: 6085-003
SHEET NO.: 12
DFT. SCALE: 2:1
MATERIAL: 2.00 O.D. x 0.065" WALL STN STL TUBE
QTY: 1 PER SUB-ASM
NOTES: UHV GRADE

11 TEMP END, SUB-ASM

FILE NAME: 6085-003
SHEET NO.: 12
DFT. SCALE: 2:1
MATERIAL: AS NOTED
QTY: 1 PER ASM
NOTES:

ITEM	DWG. NO.	DESCRIPTION	QUANTITY G1	G2	G3	REMARKS	REV.
11.3	Sheet 12	F0338X200RCE	1			Purchase	
11.2	Sheet 12	2.00"O.D. Tube	1				
11.1	Sheet 12	Temp End Plate	1				

FOR MACHINING LUBRICANT USE ONLY
ALKALINE DETERGENT LUBRICANT CIMSTAR 40
OR EQUIVALENT APPROVED BY CORNELL LEPP

TECHNICAL RESOURCE APPROVALS REQUIRED BEFORE FABRICATION	OK	DATE	N/A
DRAFTING (O'Connel):			
MACHINE SHOP (Kaminski):			
CHEMISTRY (Conklin):			
ELECTRONICS SHOP (Barley):			
FURNACE BRAZING (Sherwood):			
BEAM WELDING (Sears):			
WELDING OTHER (Gallagher):			
UTILITIES INTEGRATION (Gallagher):			
STOCKROOMS (Lockwood):			

D

PRINT DISTR. CR-1

PLOT DATE: 2/4/2008
CAD FILE NAME: 6085-003.idw

UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN INCHES;
TOLERANCES ON:
.00 ± .010
.000 ± .005
FRACTIONS ± 1/64
ANGLES ± 0.5°
ALL SURFACES 63

CHECKED BY:
APPROVED BY:

CORNELL UNIVERSITY LEPP
LABORATORY FOR ELEMENTARY-PARTICLE PHYSICS

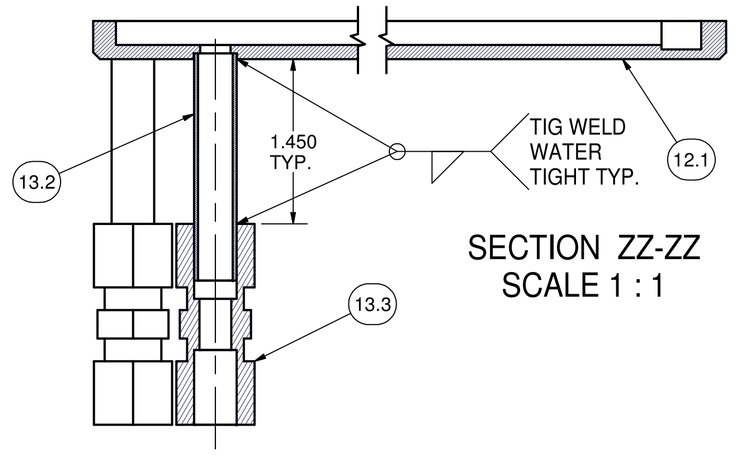
CORNELL UNIVERSITY
Floyd R. Newman Laboratory
Ithaca, NY 14853

CESR Wiggler Chamber with Thin RFA
Temp End, Sub-Asm

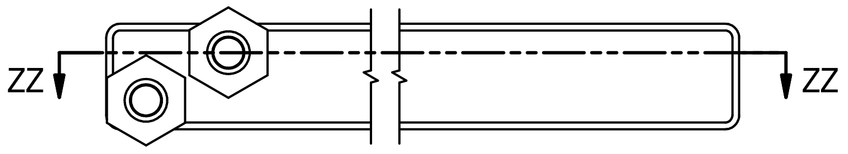
DRAWN BY	DRAWN FOR	DATE	SCALE			REV.
Yulin Li	Yulin Li	1/29/2008		D	6085-003 SH. NO. 12 OF 22	

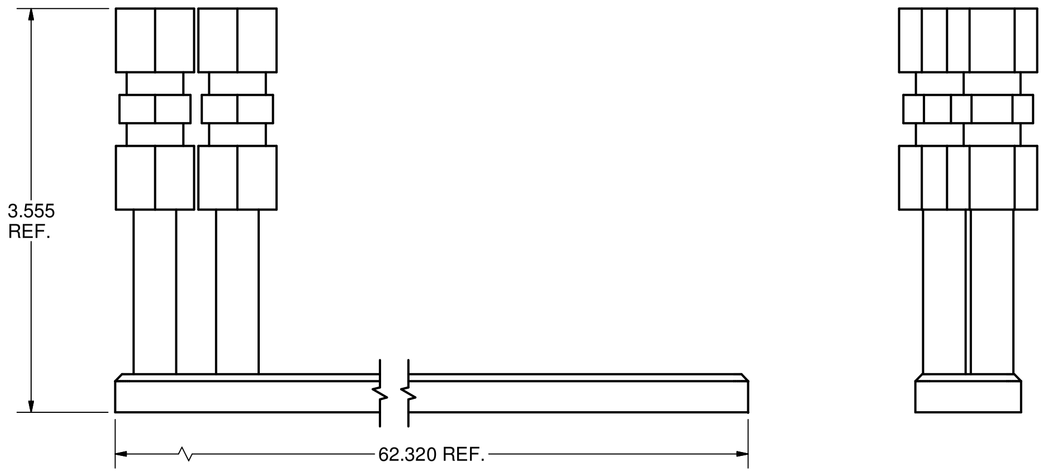
6085-003 SH. NO. 12 OF 22 REV.

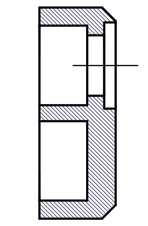
REVISIONS				
SYM.	ZONE	DESCRIPTION	DATE	APP.



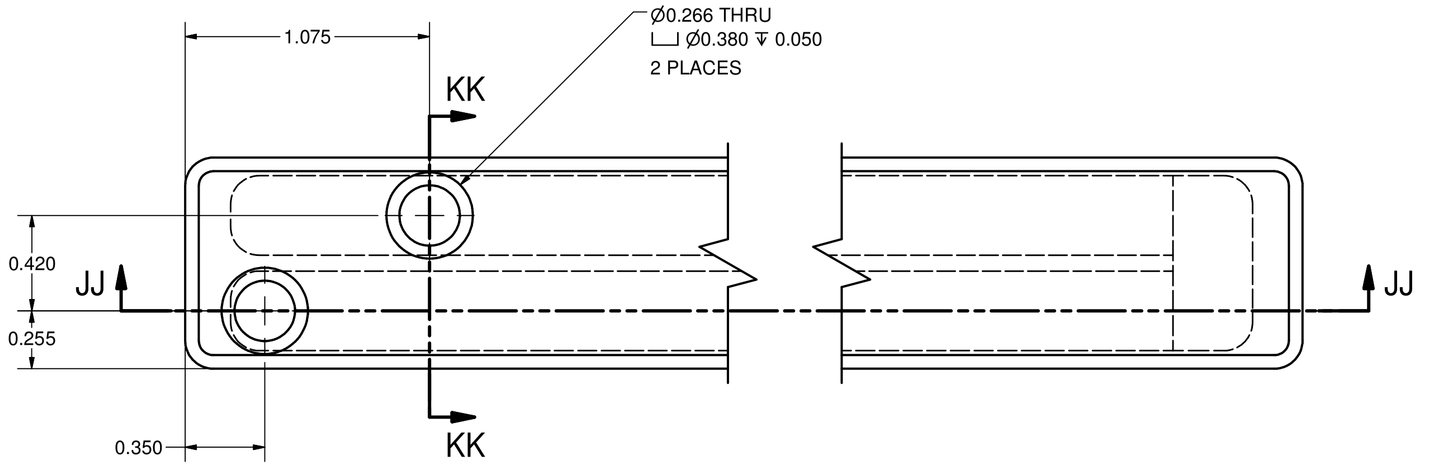
SECTION ZZ-ZZ
SCALE 1 : 1

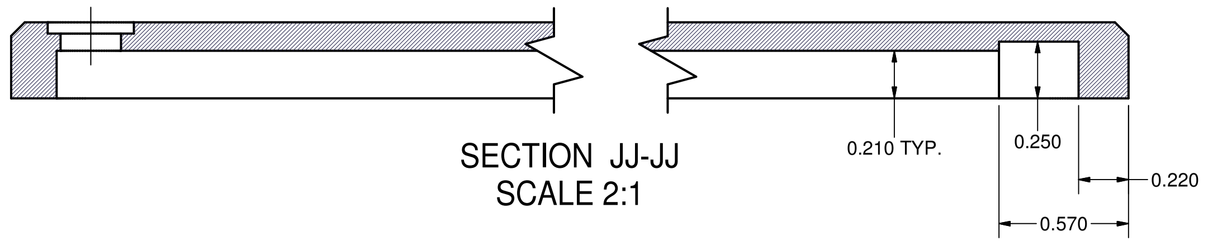




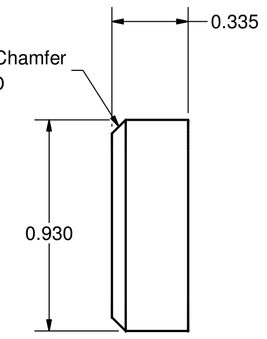


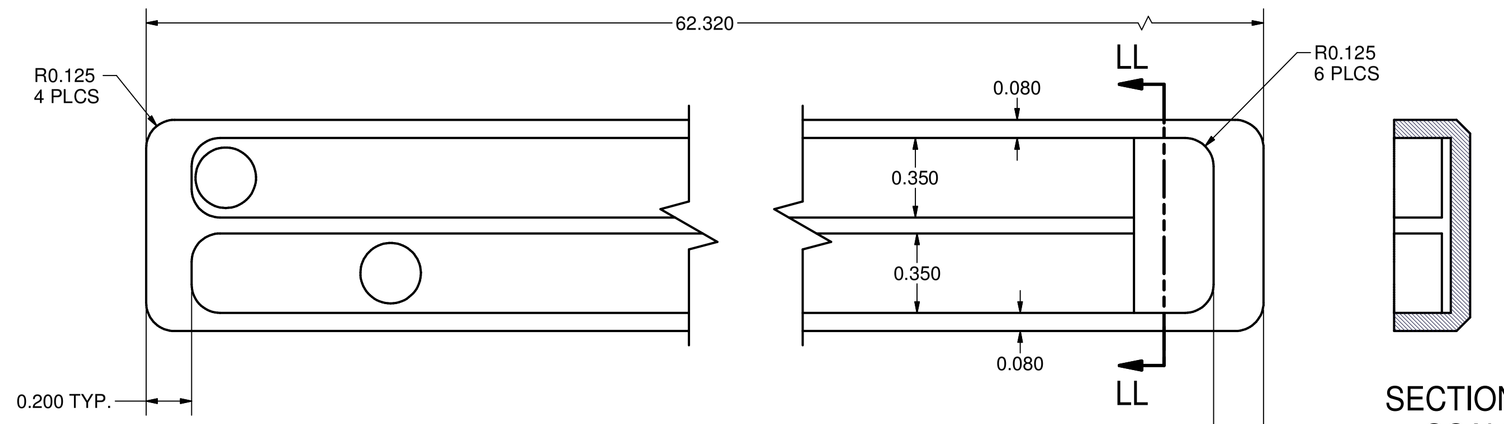
SECTION KK-KK
SCALE 2:1





SECTION JJ-JJ
SCALE 2:1





SECTION LL-LL
SCALE 2:1

12 COOLING CHANNEL BAR #1, SUB-ASM

FILE NAME: 6085-003
SHEET NO.: 13
DFT. SCALE: 1:1
MATERIAL: AS NOTED
QTY: 1 PER SUB-ASM
NOTES:

13.3	LEPP STock	3/8" Swage-Lok Fitting	2				
13.2	Sheet 14	0.375 O.D. x 2.00 Lg. Tube	2				
12.1	Sheet 13	Cooling Channel Bar #1	1				

12.1 COOLING CHANNEL BAR #1

FILE NAME: 6085-003
SHEET NO.: 13
DFT. SCALE: 1:1
MATERIAL: 304L STN STL
QTY: 1 PER SUB-ASM
NOTES:

FOR MACHINING LUBRICANT USE ONLY
ALKALINE DETERGENT LUBRICANT CIMSTAR 40
OR EQUIVALENT APPROVED BY CORNELL LEPP

TECHNICAL RESOURCE APPROVALS REQUIRED BEFORE FABRICATION	OK	DATE	N/A
DRAFTING (O'Connel):			
MACHINE SHOP (Kaminski):			
CHEMISTRY (Conklin):			
ELECTRONICS SHOP (Barley):			
FURNACE BRAZING (Sherwood):			
BEAM WELDING (Sears):			
WELDING OTHER (Gallagher):			
UTILITIES INTEGRATION (Gallagher):			
STOCKROOMS (Lockwood):			

ITEM	DWG. NO.	DESCRIPTION	QUANTITY G1	G2	G3	REMARKS	REV.

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PLOT DATE: 2/4/2008
CAD FILE NAME: 6085-003.idw

UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN INCHES;
TOLERANCES ON:
.00 ± .010
.000 ± .005
FRACTIONS ± 1/64
ANGLES ± 0.5°
ALL SURFACES 63

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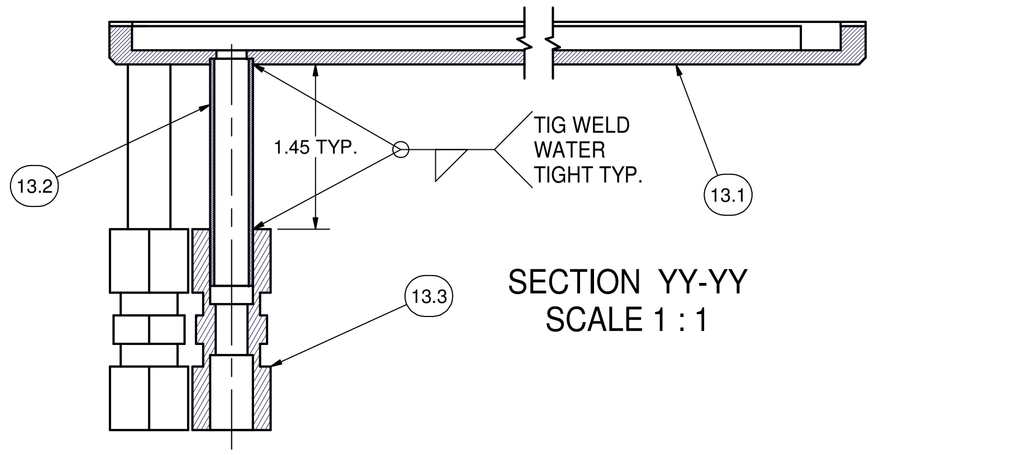
CORNELL UNIVERSITY
Floyd R. Newman Laboratory
Ithaca, NY 14853

CESR Wiggler Chamber with Thin RFA
Cooling Channel Bar, Sub-Asm

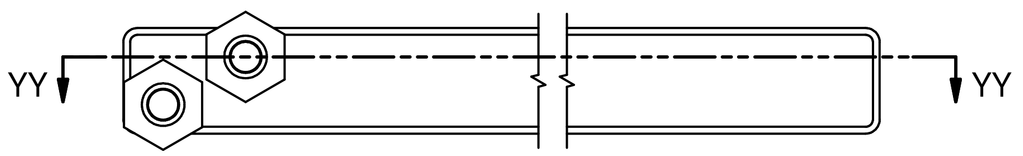
DRAWN BY	DRAWN FOR	DATE	SCALE		REV.
Yulin Li	Yulin Li	1/29/2008		D 6085-003 SH. NO. 13 OF 22	

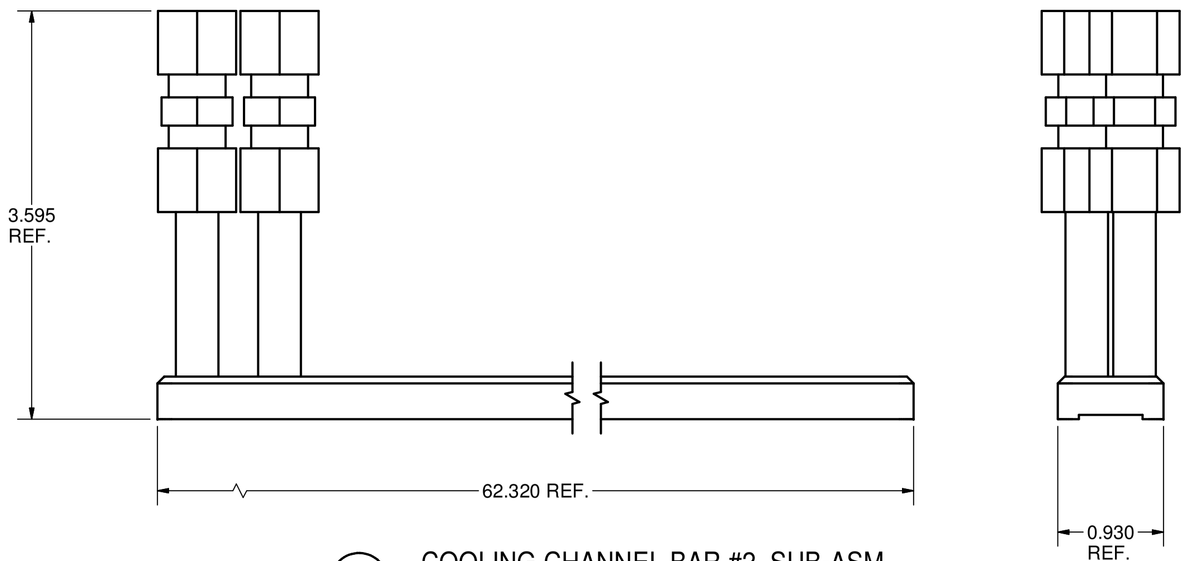
6085-003 SH. NO. 13 OF 22 REV.

REVISIONS				
SYM.	ZONE	DESCRIPTION	DATE	APP.



SECTION YY-YY
SCALE 1 : 1

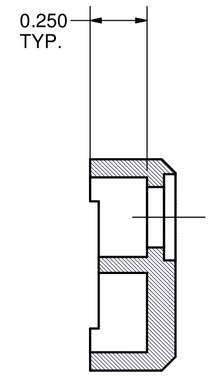




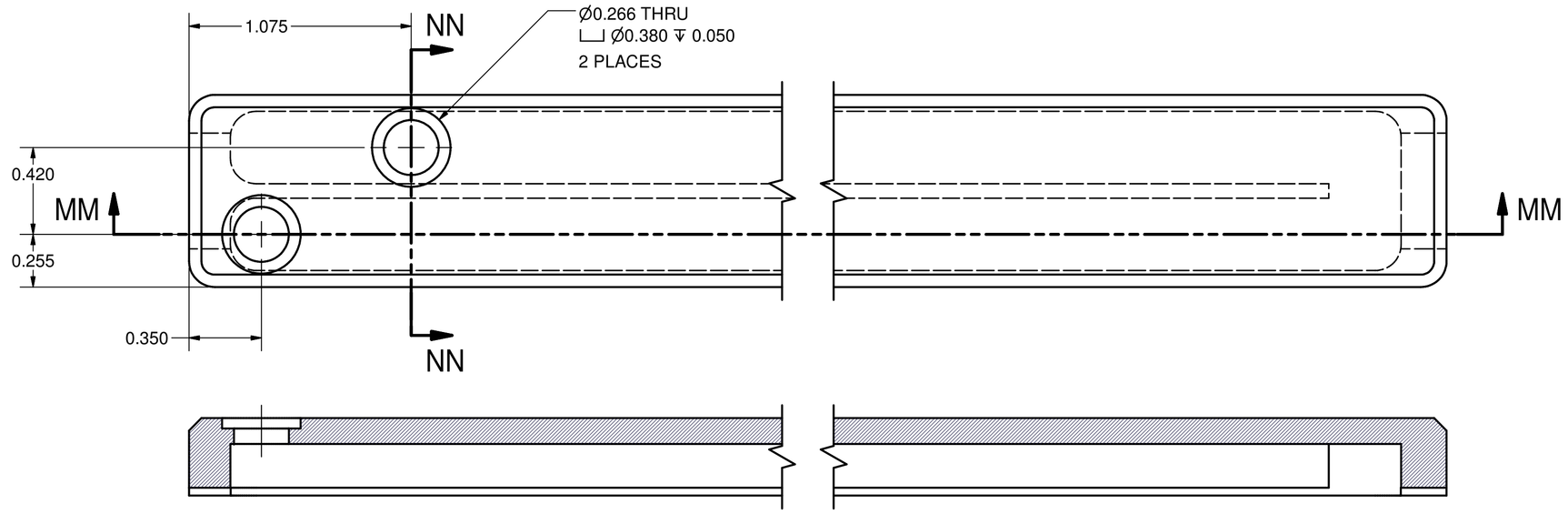
13 COOLING CHANNEL BAR #2, SUB-ASM

FILE NAME: 6085-003
SHEET NO.: 14
DFT. SCALE: 1:1
MATERIAL: AS NOTED
QTY: 1 PER SUB-ASM
NOTES:

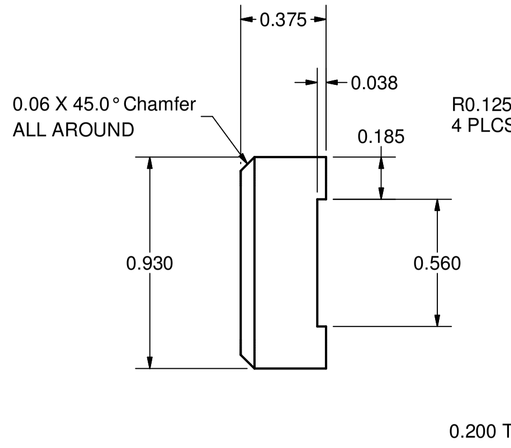
13.3	LEPP Stock	3/8" Swag-Lok Fitting	2				
13.2	Sheet 14	0.375 O.D. x 2.00 Lg. Tube	2				
13.1	Sheet 14	Cooling Channel Bar #2	1				

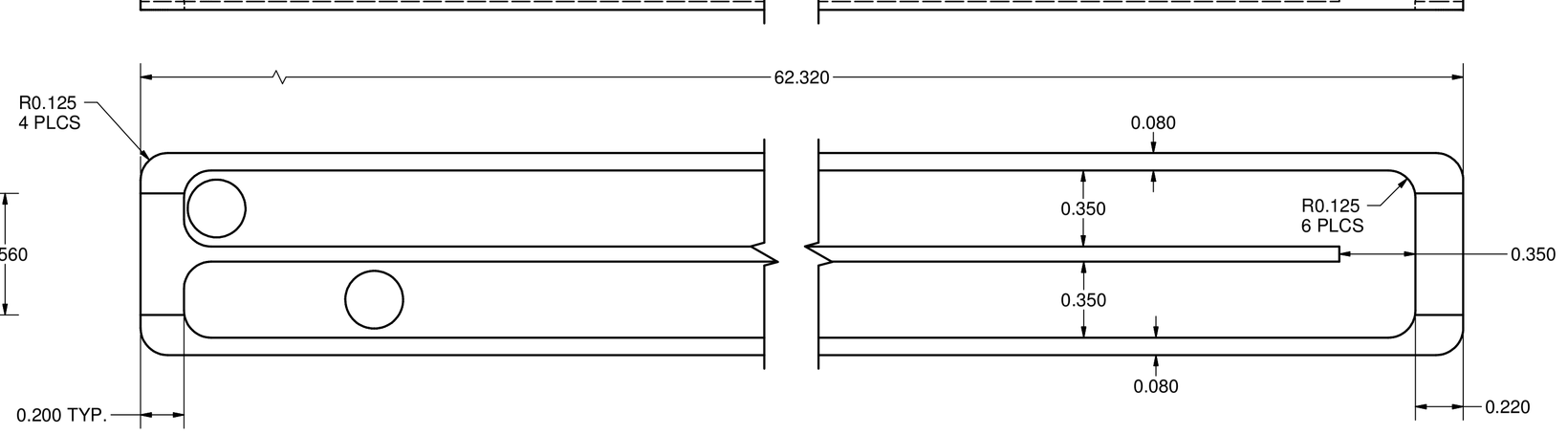


SECTION NN-NN
SCALE 2:1



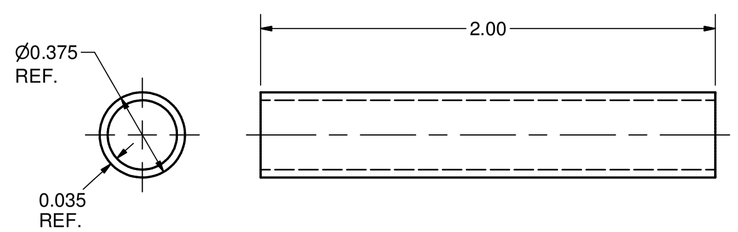
SECTION MM-MM
SCALE 2:1





13.1 COOLING CHANNEL BAR #2

FILE NAME: 6085-003
SHEET NO.: 14
DFT. SCALE: 1:1
MATERIAL: 304L STN STL
QTY: 1 PER SUB-ASM
NOTES:



13.2 0.375 O.D. x 2.00 LG TUBE

FILE NAME: 6085-003
SHEET NO.: 14
DFT. SCALE: 2:1
MATERIAL: 0.375 O.D. x 0.035 WALL STN STL TUBE
QTY: 2 PER SUB-ASM
NOTES:

FOR MACHINING LUBRICANT USE ONLY
ALKALINE DETERGENT LUBRICANT CIMSTAR 40
OR EQUIVALENT APPROVED BY CORNELL LEPP

TECHNICAL RESOURCE APPROVALS REQUIRED BEFORE FABRICATION			
	OK	DATE	N/A
DRAFTING (O'Connel):			
MACHINE SHOP (Kaminski):			
CHEMISTRY (Conklin):			
ELECTRONICS SHOP (Barley):			
FURNACE BRAZING (Sherwood):			
BEAM WELDING (Sears):			
WELDING OTHER (Gallagher):			
UTILITIES INTEGRATION (Gallagher):			
STOCKROOMS (Lockwood):			

ITEM	DWG. NO.	DESCRIPTION	QUANTITY G1	G2	G3	REMARKS	REV.

D | PRINT DISTR. | PLOT DATE: 2/4/2008 | CAD FILE NAME: 6085-003.idw

CR-1

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DIMENSIONS ARE IN INCHES;
TOLERANCES ON:
.00 ± .010
.000 ± .005
FRACTIONS ± 1/64
ANGLES ± 0.5°
ALL SURFACES 63

CHECKED BY:
APPROVED BY:

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LEPP
LABORATORY FOR ELEMENTARY-PARTICLE PHYSICS

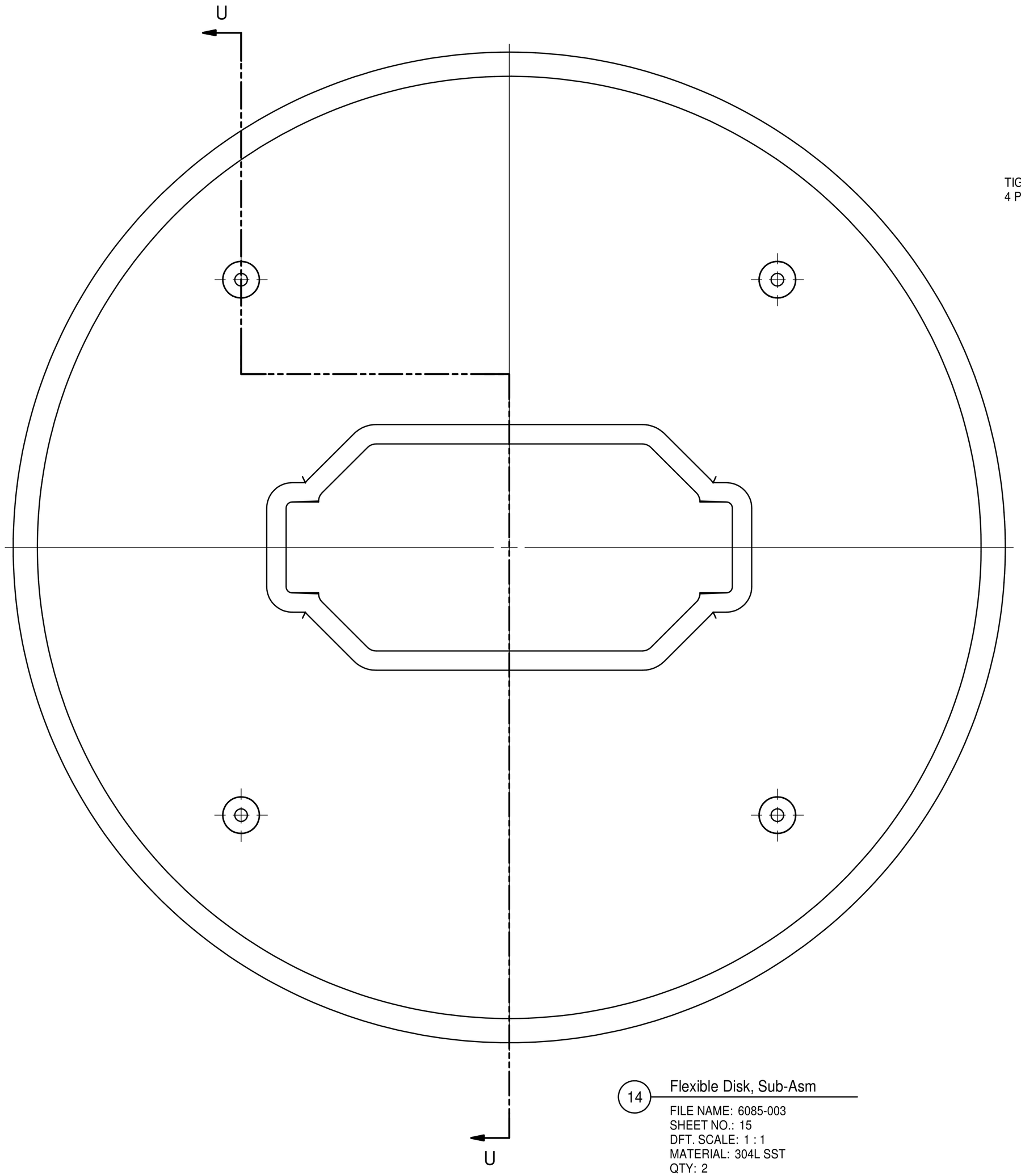
CORNELL UNIVERSITY
Floyd R. Newman Laboratory
Ithaca, NY 14853

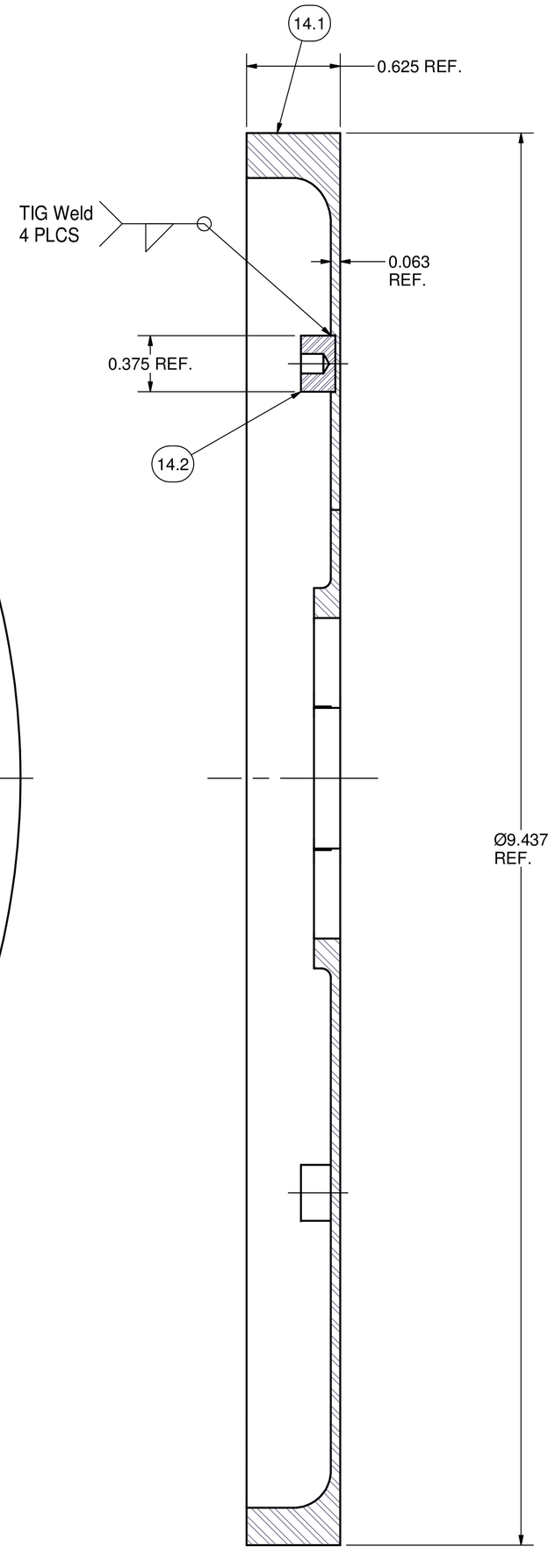
CESR Wiggler Chamber with Thin RFA
Cooling Channel Bar #2, Sub-Asm

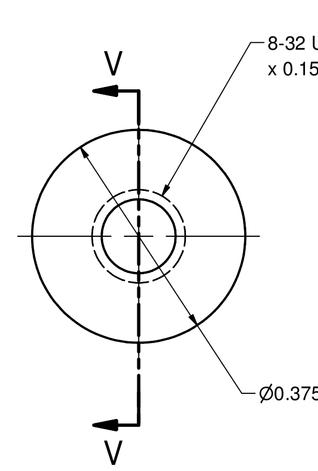
DRAWN BY	DRAWN FOR	DATE	SCALE			REV.
Yulin Li	Yulin Li	1/29/2008		D	6085-003 SH. NO. 14 OF 22	

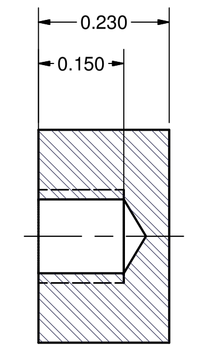
6085-003 SH. NO. 14 OF 22 REV.

REVISIONS				
SYM.	ZONE	DESCRIPTION	DATE	APP.









SECTION V-V
SCALE 5 : 1

14.2 Flex Disk Standoff

FILE NAME: 6085-003
SHEET NO.: 15
DFT. SCALE: 5 : 1
MATERIAL: 304L SST
QTY: 8
NOTES:

14 Flexible Disk, Sub-Asm

FILE NAME: 6085-003
SHEET NO.: 15
DFT. SCALE: 1 : 1
MATERIAL: 304L SST
QTY: 2
NOTES: Only one is used in the assembly
The second asm will be used in the final assembly at Cornell

SECTION U-U
SCALE 1.5:1

14.2	Sheet 15	Flex Disk Standoff	8				
14.1	Sheet 16	Flex Disk	2				

FOR MACHINING LUBRICANT USE ONLY
ALKALINE DETERGENT LUBRICANT CIMSTAR 40
OR EQUIVALENT APPROVED BY CORNELL LEPP

TECHNICAL RESOURCE APPROVALS REQUIRED BEFORE FABRICATION			
	OK	DATE	N/A
DRAFTING (O'Connel):			
MACHINE SHOP (Kaminski):			
CHEMISTRY (Conklin):			
ELECTRONICS SHOP (Barley):			
FURNACE BRAZING (Sherwood):			
BEAM WELDING (Sears):			
WELDING OTHER (Gallagher):			
UTILITIES INTEGRATION (Gallagher):			
STOCKROOMS (Lockwood):			

ITEM	DWG. NO.	DESCRIPTION	G1	G2	G3	REMARKS	REV.
			QUANTITY				

D | PRINT DISTR. CR-1 | PLOT DATE: 2/4/2008 | CAD FILE NAME: 6085-003.idw

SH. NO. 15 OF 22 | REV.

UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN INCHES;
TOLERANCES ON:
.00 ± .010
.000 ± .005
FRACTIONS ± 1/64
ANGLES ± 0.5°
ALL SURFACES 63

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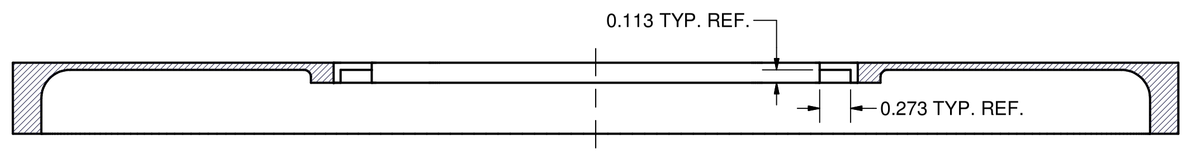
CORNELL UNIVERSITY
Floyd R. Newman Laboratory
Ithaca, NY 14853

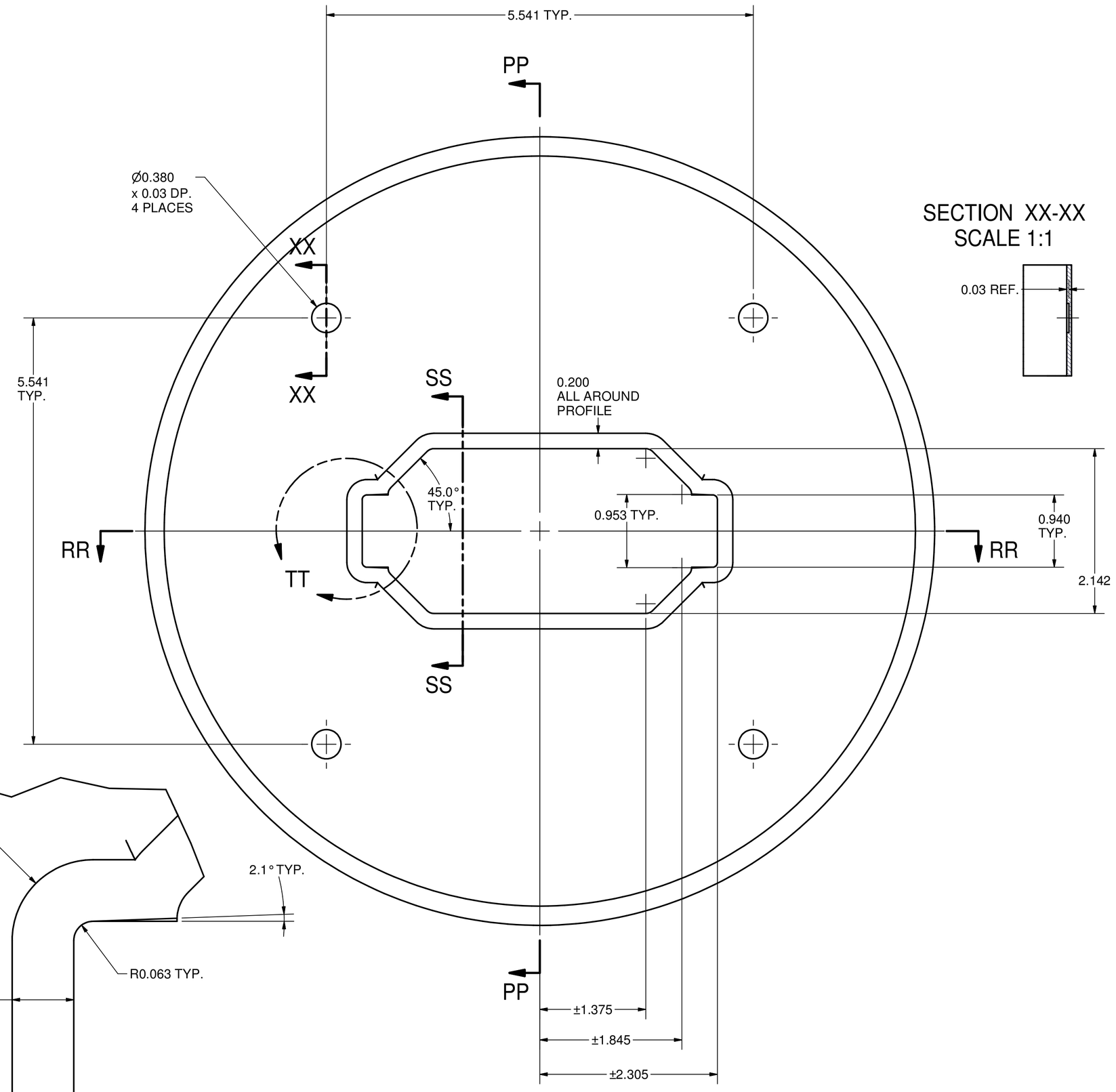
CESR Wiggler Chamber with Thin RFA
Flexible Disk, Sub-Asm

CHECKED BY:	DRAWN BY	DRAWN FOR	DATE	SCALE			REV.
APPROVED BY:	Yulin Li	Yulin Li	1/29/2008		D	6085-003 SH. NO. 15 OF 22	

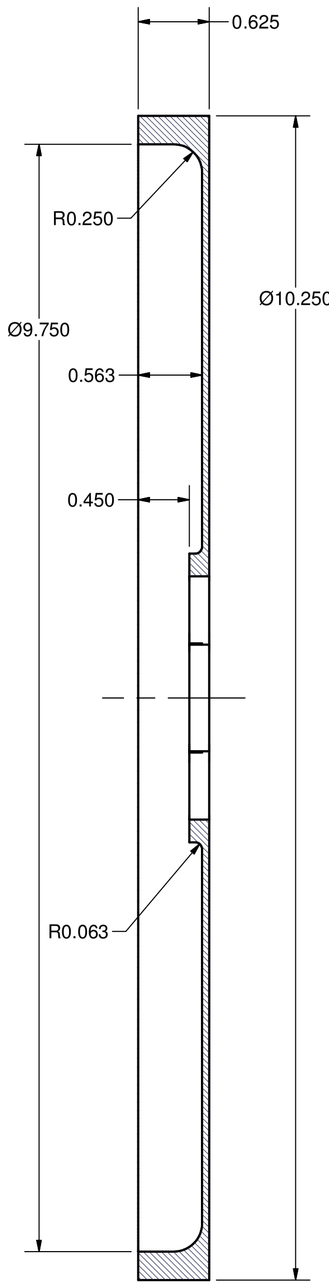
REVISIONS				
SYM.	ZONE	DESCRIPTION	DATE	APP.



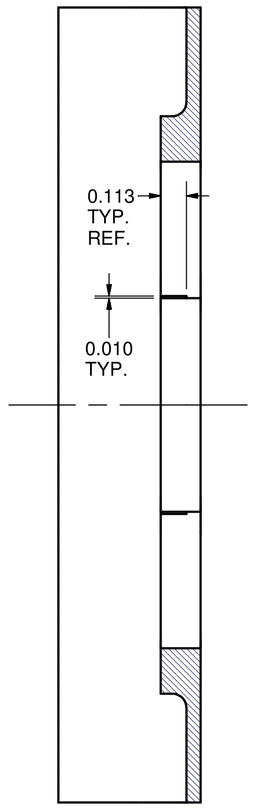
SECTION RR-RR
SCALE 1:1



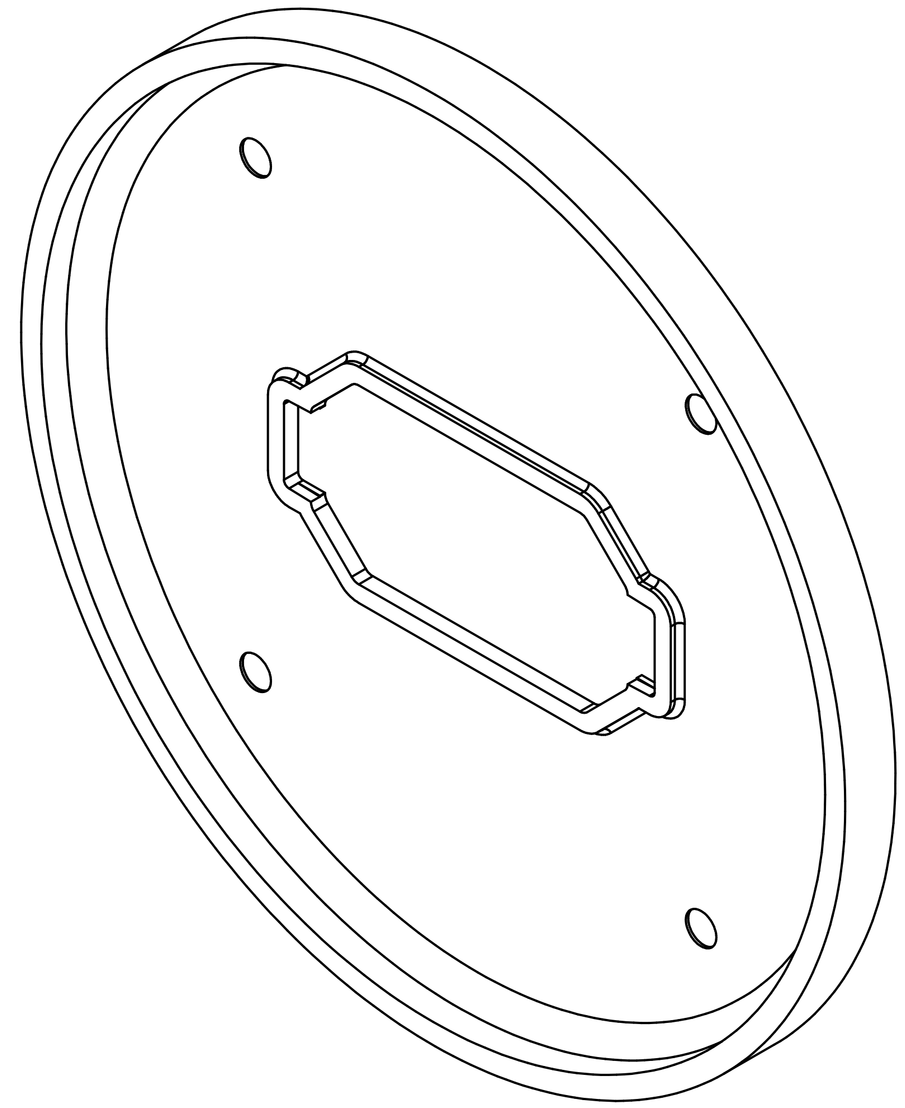
SECTION XX-XX
SCALE 1:1

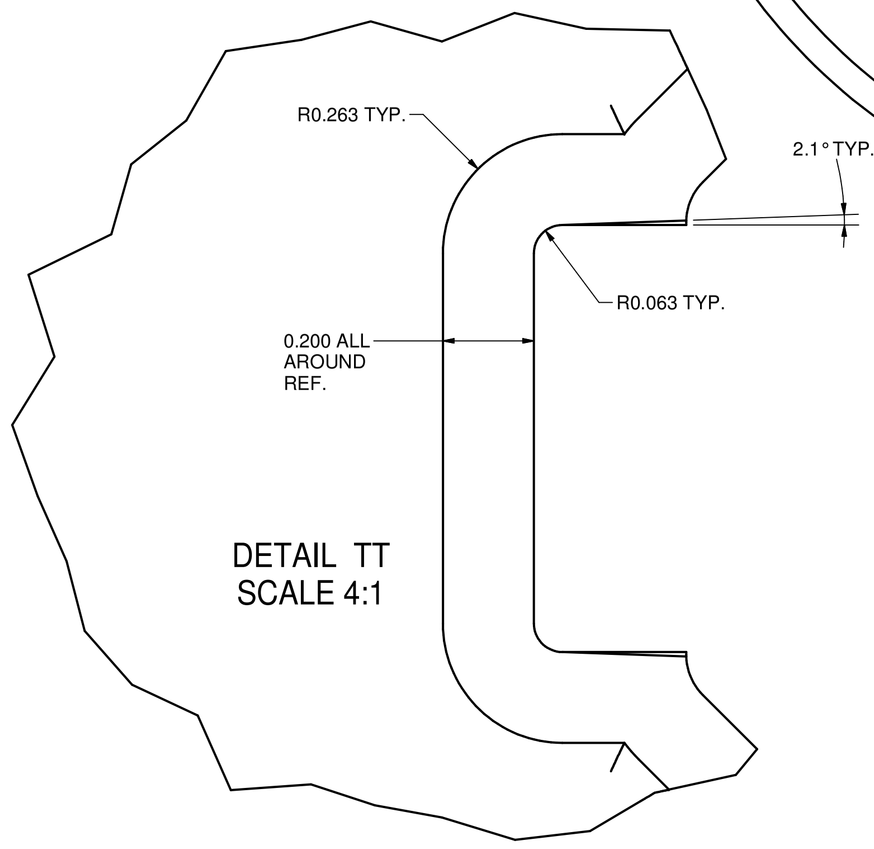


SECTION PP-PP
SCALE 1:1



SECTION SS-SS
SCALE 2:1





DETAIL TT
SCALE 4:1

(14.1) Flexible Disk

FILE NAME: 6085-003
SHEET NO.: 16
DFT. SCALE: 1 : 1
MATERIAL: 304L SST
QTY: 2
NOTES: Only one will be used at this assembly
The second one will be used in the final assembly at Cornell

FOR MACHINING LUBRICANT USE ONLY
ALKALINE DETERGENT LUBRICANT CIMSTAR 40
OR EQUIVALENT APPROVED BY CORNELL LEPP

TECHNICAL RESOURCE APPROVALS REQUIRED BEFORE FABRICATION			
	OK	DATE	N/A
DRAFTING (O'Connel):			
MACHINE SHOP (Kaminski):			
CHEMISTRY (Conklin):			
ELECTRONICS SHOP (Barley):			
FURNACE BRAZING (Sherwood):			
BEAM WELDING (Sears):			
WELDING OTHER (Gallagher):			
UTILITIES INTEGRATION (Gallagher):			
STOCKROOMS (Lockwood):			

ITEM	DWG. NO.	DESCRIPTION	QUANTITY G1	G2	G3	REMARKS	REV.

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PLOT DATE: 2/4/2008
CAD FILE NAME: 6085-003.idw

CR-1

SH. NO. 16 OF 22

6085-003

REV.

UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN INCHES; TOLERANCES ON:
.00 ± .010
.000 ± .005
FRACTIONS ± 1/64
ANGLES ± 0.5°
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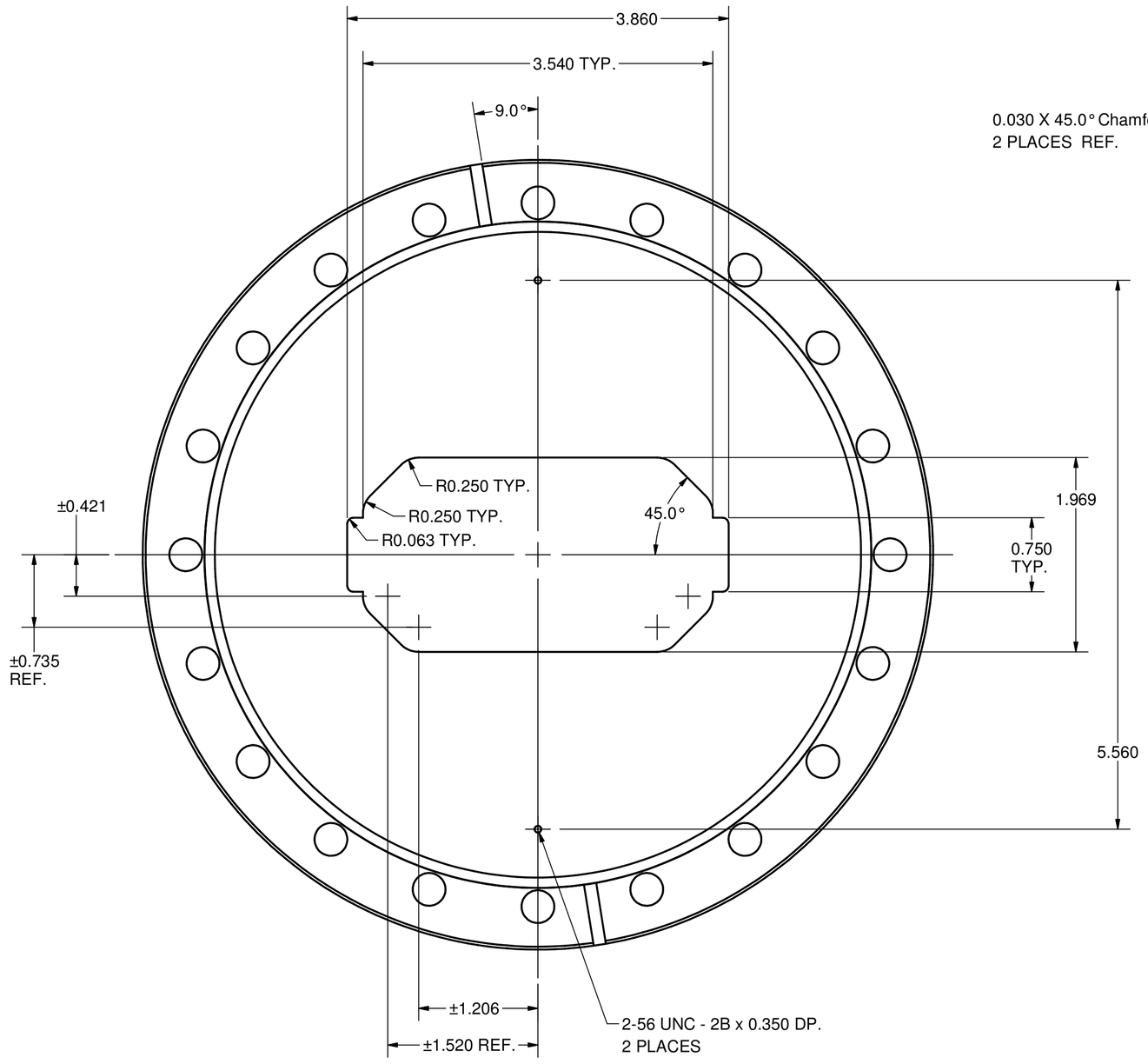
Floyd R. Newman Laboratory
Ithaca, NY 14853

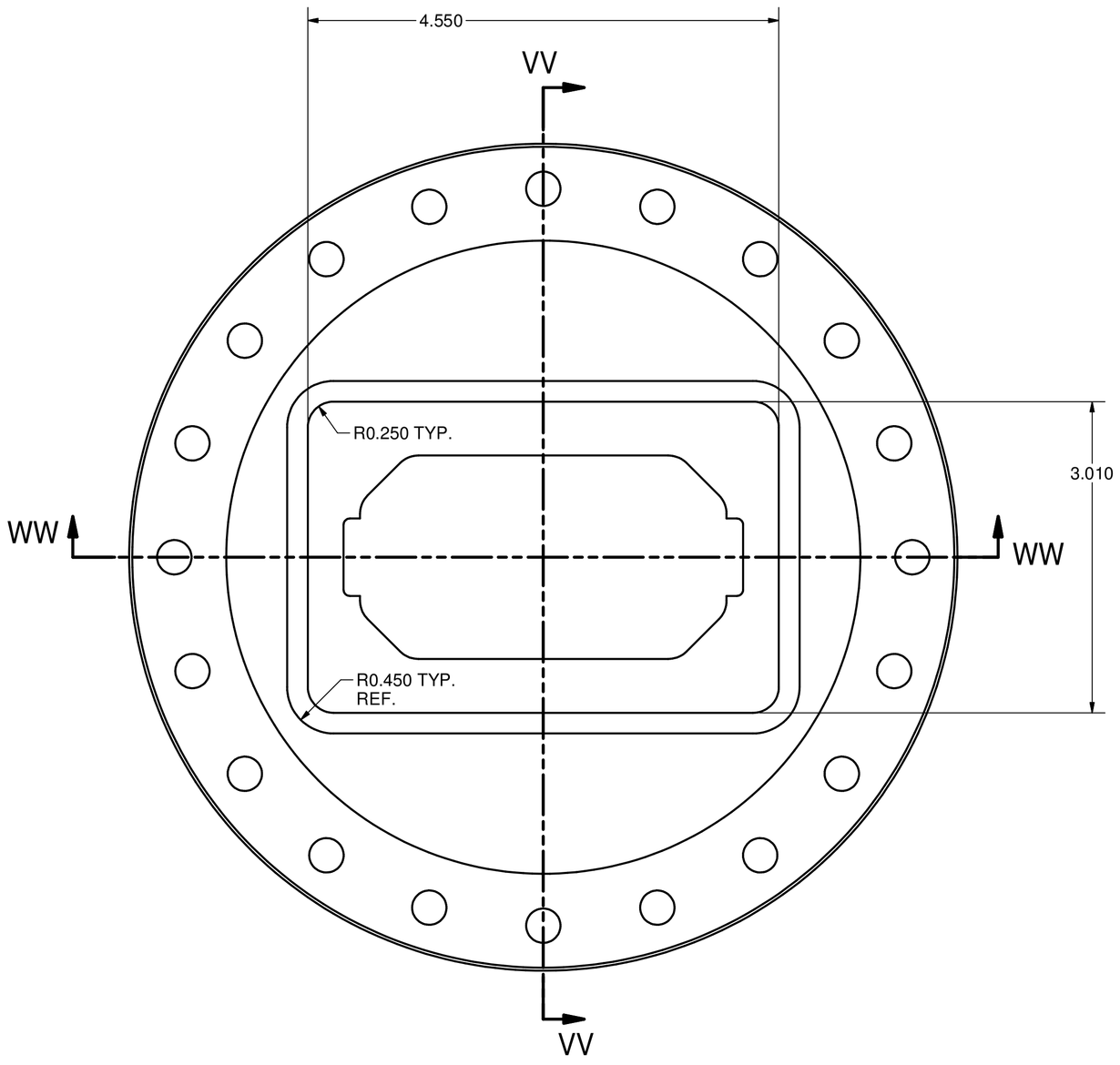
CESR Wiggler Chamber with Thin RFA
Flexible Disk, Detail

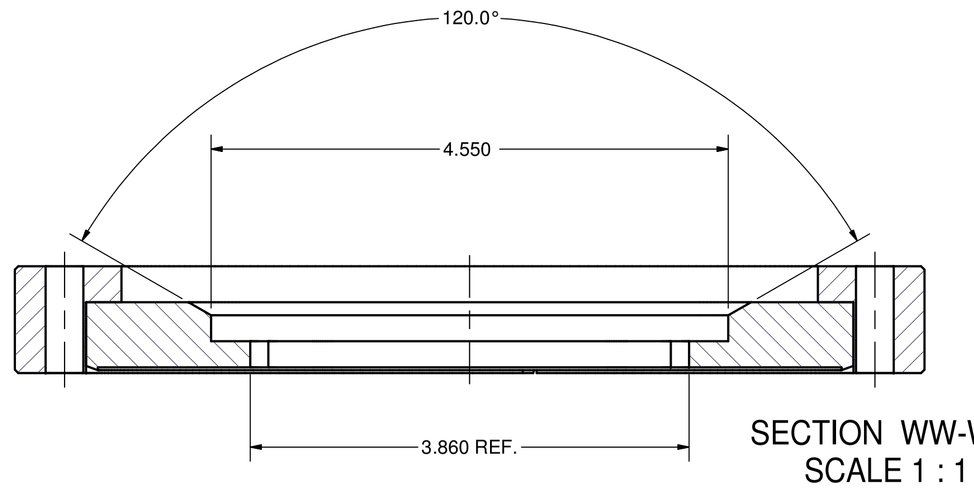
DRAWN BY	DRAWN FOR	DATE	SCALE			REV.
Yulin Li	Yulin Li	1/29/2008		D	6085-003 SH. NO. 16 OF 22	

REVISIONS				
SYM.	ZONE	DESCRIPTION	DATE	APP.



SECTION VV-VV
SCALE 1 : 1





SECTION WW-WW
SCALE 1 : 1

(15) 8" Rotatable Flange

FILE NAME: 6085-003
SHEET NO.: 17
DFT. SCALE: 1 : 1
MATERIAL: Make from F0800X0000RCE
QTY: 2
NOTES:

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ALKALINE DETERGENT LUBRICANT CIMSTAR 40
OR EQUIVALENT APPROVED BY CORNELL LEPP

TECHNICAL RESOURCE APPROVALS REQUIRED BEFORE FABRICATION	OK	DATE	N/A
DRAFTING (O'Connel):			
MACHINE SHOP (Kaminski):			
CHEMISTRY (Conklin):			
ELECTRONICS SHOP (Barley):			
FURNACE BRAZING (Sherwood):			
BEAM WELDING (Sears):			
WELDING OTHER (Gallagher):			
UTILITIES INTEGRATION (Gallagher):			
STOCKROOMS (Lockwood):			

ITEM	DWG. NO.	DESCRIPTION	QUANTITY G1	QUANTITY G2	QUANTITY G3	REMARKS	REV.

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PLOT DATE: 2/4/2008
CAD FILE NAME: 6085-003.idw

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DIMENSIONS ARE IN INCHES;
TOLERANCES ON:
.00 ± .010
.000 ± .005
FRACTIONS ± 1/64
ANGLES ± 0.5°
ALL SURFACES 63

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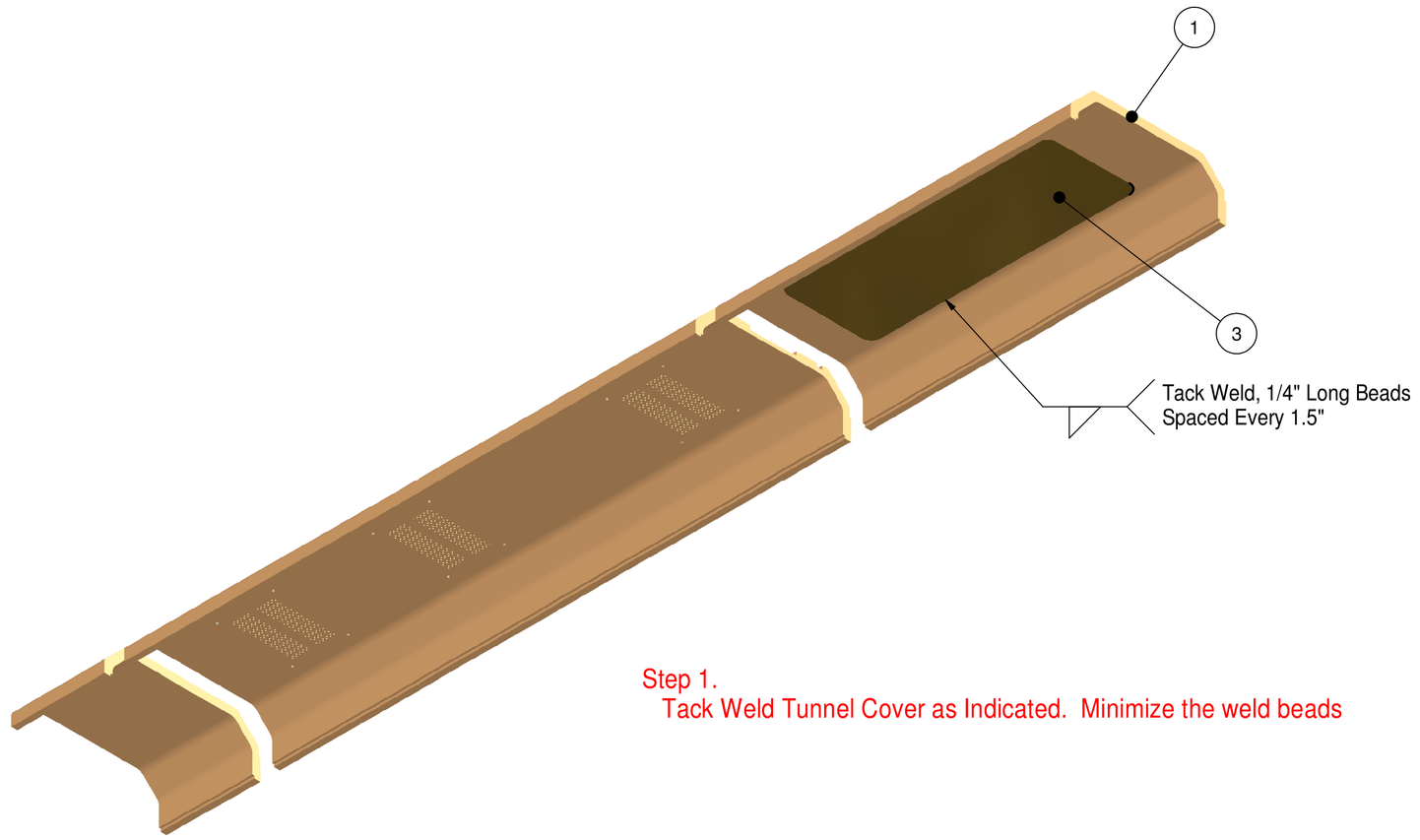
CORNELL UNIVERSITY
Floyd R. Newman Laboratory
Ithaca, NY 14853

CESR Wiggler Chamber with Thin RFA
8.00" Rotatabl Flange Modified

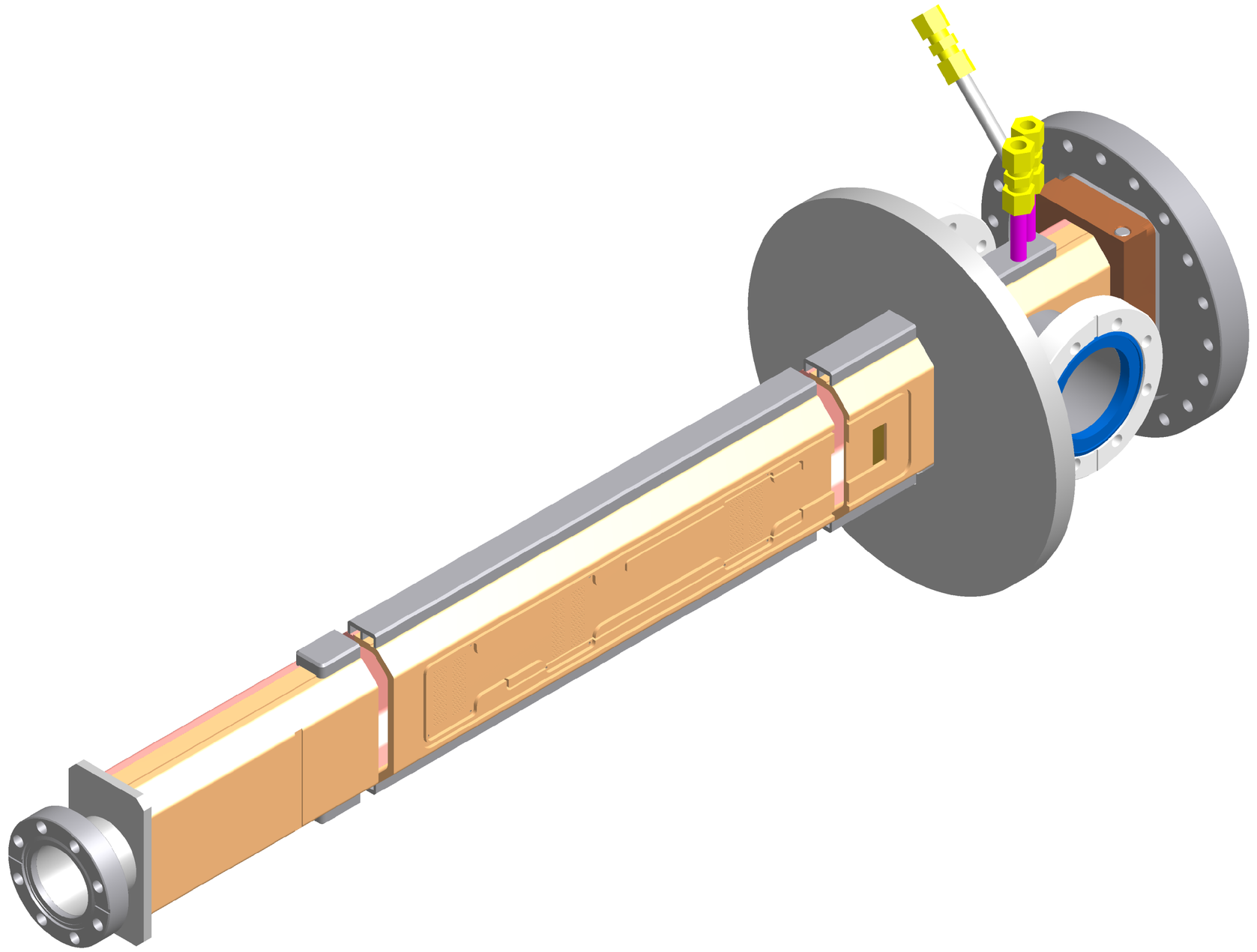
CHECKED BY:							
APPROVED BY:	DRAWN BY	DRAWN FOR	DATE	SCALE	D	6085-003 SH. NO. 17 OF 22	REV.
	Yulin Li	Yulin Li	1/29/2008				

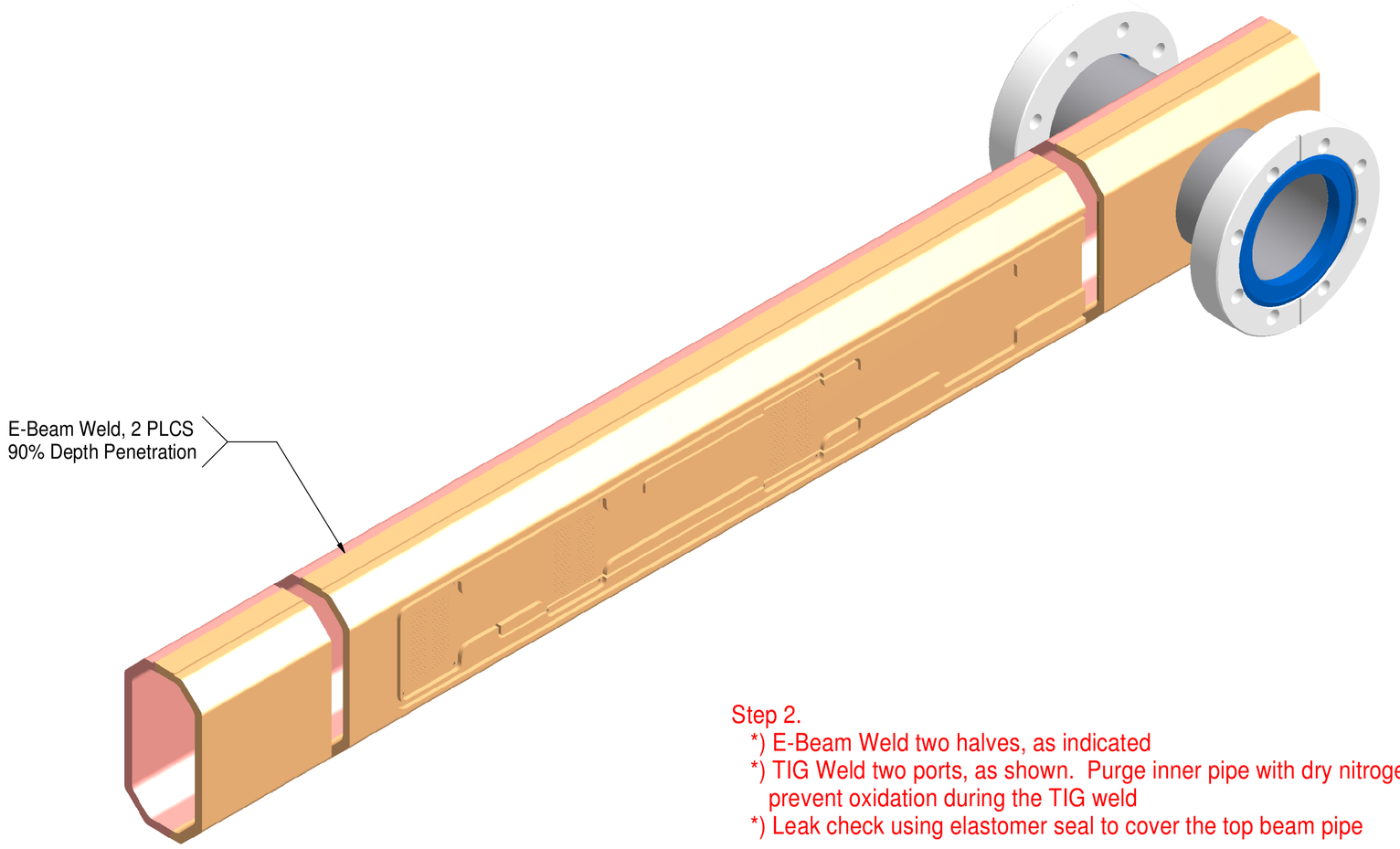
6085-003 SH. NO. 17 OF 22 REV.

REVISIONS				
SYM.	ZONE	DESCRIPTION	DATE	APP.



Step 1.
Tack Weld Tunnel Cover as Indicated. Minimize the weld beads





Step 2.
*) E-Beam Weld two halves, as indicated
*) TIG Weld two ports, as shown. Purge inner pipe with dry nitrogen to prevent oxidation during the TIG weld
*) Leak check using elastomer seal to cover the top beam pipe

Step 3.
*)Ensure to have dry nitrogen purging through the pipe to prevent oxidation of the inner surfaces
*)TIG weld SST/Cu Transition and then the 8" flange
*)TIG weld both cooling bars, and pressure test the cooling bar welds to 90 PSI
*)TIG weld the flexible disk.
*)TIG weld the temporay end flange assembly
*)Leak check the beam pipe vacuum joints
*)Leak check the flexible disk weld joint, with a fixture

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ALKALINE DETERGENT LUBRICANT CIMSTAR 40
OR EQUIVALENT APPROVED BY CORNELL LEPP

TECHNICAL RESOURCE APPROVALS REQUIRED BEFORE FABRICATION	OK	DATE	N/A
DRAFTING (O'Connel):			
MACHINE SHOP (Kaminski):			
CHEMISTRY (Conklin):			
ELECTRONICS SHOP (Barley):			
FURNACE BRAZING (Sherwood):			
BEAM WELDING (Sears):			
WELDING OTHER (Gallagher):			
UTILITIES INTEGRATION (Gallagher):			
STOCKROOMS (Lockwood):			

ITEM	DWG. NO.	DESCRIPTION	QUANTITY G1	QUANTITY G2	QUANTITY G3	REMARKS	REV.

D | PRINT DISTR. CR-1

PLOT DATE: 2/4/2008
CAD FILE NAME: 6085-003.idw

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TOLERANCES ON:
.00 ± .010
.000 ± .005
FRACTIONS ± 1/64
ANGLES ± 0.5°
ALL SURFACES

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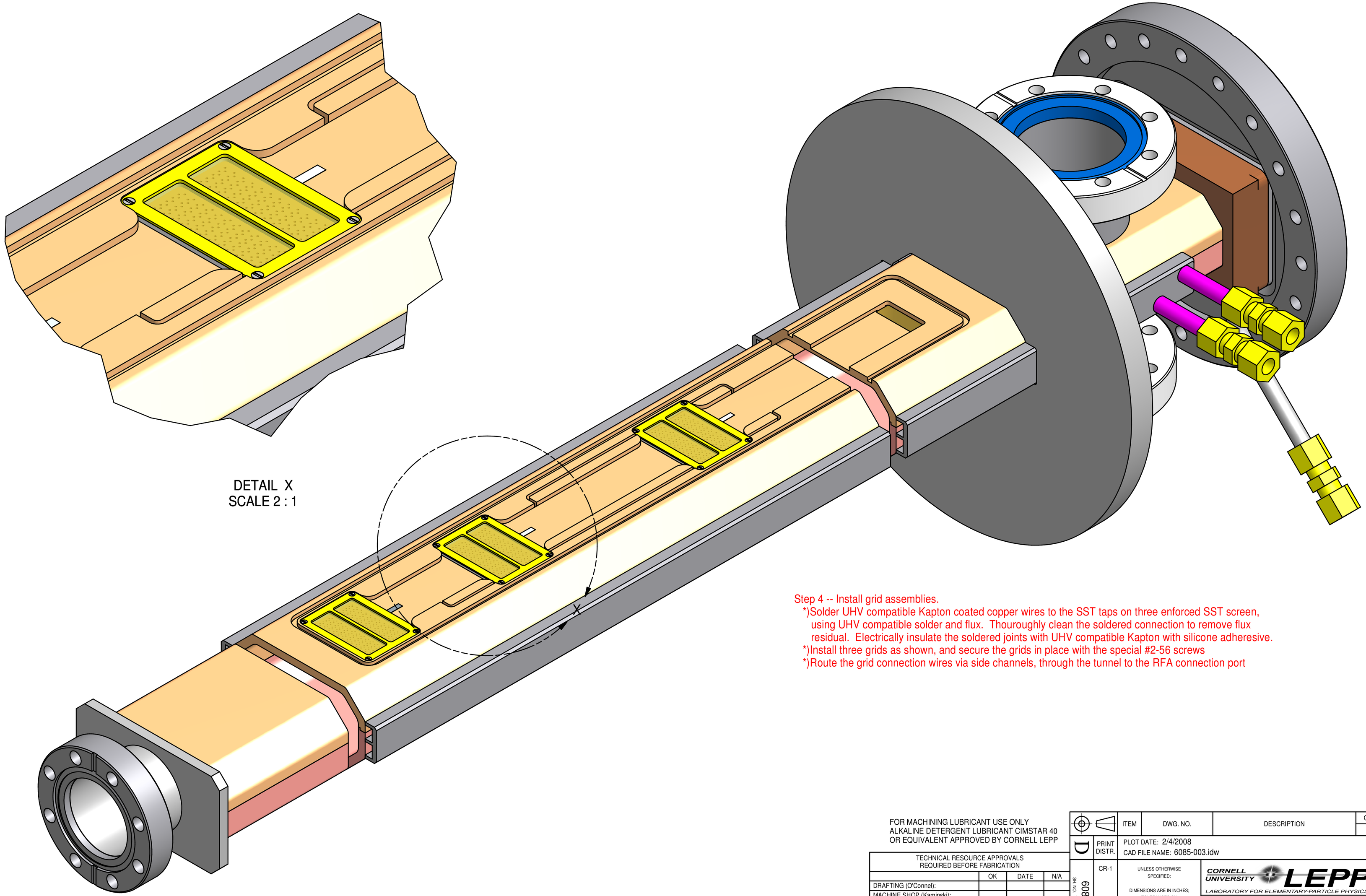
CESR Wiggler Chamber with Thin RFA

CHECKED BY:	DRAWN BY	DRAWN FOR	DATE	SCALE		
APPROVED BY:	Yulin Li	Yulin Li	1/29/2008		D	6085-003 SH. NO. 18 OF 22 REV.

6085-003 SH. NO. 18 OF 22 REV.

REVISIONS				
SYM.	ZONE	DESCRIPTION	DATE	APP.



DETAIL X
SCALE 2 : 1

Step 4 -- Install grid assemblies.
*)Solder UHV compatible Kapton coated copper wires to the SST taps on three enforced SST screen, using UHV compatible solder and flux. Thouroughly clean the soldered connection to remove flux residual. Electrically insulate the soldered joints with UHV compatible Kapton with silicone adheresive.
*)Install three grids as shown, and secure the grids in place with the special #2-56 screws
*)Route the grid connection wires via side channels, through the tunnel to the RFA connection port

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OR EQUIVALENT APPROVED BY CORNELL LEPP

TECHNICAL RESOURCE APPROVALS REQUIRED BEFORE FABRICATION	OK	DATE	N/A
DRAFTING (O'Connel):			
MACHINE SHOP (Kaminski):			
CHEMISTRY (Conklin):			
ELECTRONICS SHOP (Barley):			
FURNACE BRAZING (Sherwood):			
BEAM WELDING (Sears):			
WELDING OTHER (Gallagher):			
UTILITIES INTEGRATION (Gallagher):			
STOCKROOMS (Lockwood):			

ITEM	DWG. NO.	DESCRIPTION	QUANTITY G1	G2	G3	REMARKS	REV.

PRINT DISTR. CR-1

PLOT DATE: 2/4/2008
CAD FILE NAME: 6085-003.idw

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.00 ±.010
.000 ±.005
FRACTIONS ±1/64
ANGLES ±0.5°
ALL SURFACES

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APPROVED BY:

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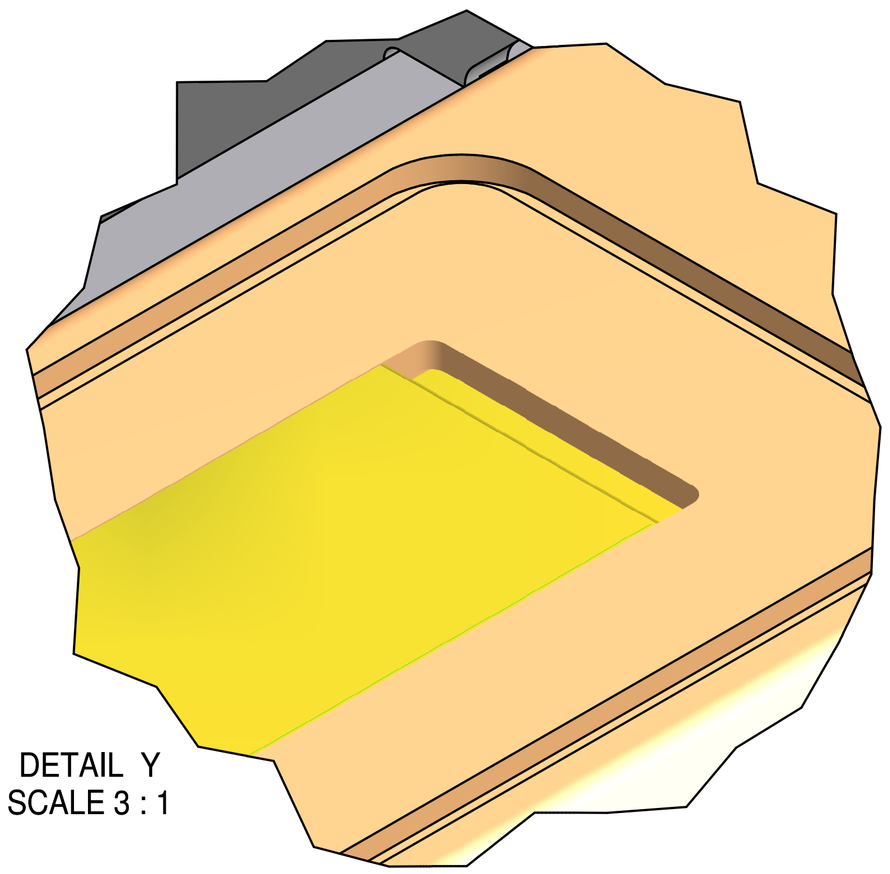
CESR Wiggler Chamber with Thin RFA

DRAWN BY	DRAWN FOR	DATE	SCALE	SIZE	DWG. NO.	REV.
Yulin Li	Yulin Li	1/29/2008		D	6085-003 SH. NO. 19 OF 22	

6085-003 SH. NO. 19 OF 22 REV.

REVISIONS				
SYM.	ZONE	DESCRIPTION	DATE	APP.



Step 5 -- Install Flex-Circuit collector stripe.
*)Feed the flex-circuit stripe through the tunnel to the RFA connection port
*)Make soldering connection of the flex-circuit stripe to the UHV cable assemblies, per Cornell specification
*)Locate the flex-circuit stripe to location as shown, and secure the stripe in location using UHV-compatible Kapton tapes with silicone adheresive

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OR EQUIVALENT APPROVED BY CORNELL LEPP

TECHNICAL RESOURCE APPROVALS REQUIRED BEFORE FABRICATION	OK	DATE	N/A
DRAFTING (O'Connel):			
MACHINE SHOP (Kaminski):			
CHEMISTRY (Conklin):			
ELECTRONICS SHOP (Barley):			
FURNACE BRAZING (Sherwood):			
BEAM WELDING (Sears):			
WELDING OTHER (Gallagher):			
UTILITIES INTEGRATION (Gallagher):			
STOCKROOMS (Lockwood):			

ITEM	DWG. NO.	DESCRIPTION	QUANTITY G1	QUANTITY G2	QUANTITY G3	REMARKS	REV.

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PLOT DATE: 2/4/2008
CAD FILE NAME: 6085-003.idw

SH. NO. 20 OF 22 | 6085-003 | REV.

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FRACTIONS ± 1/64
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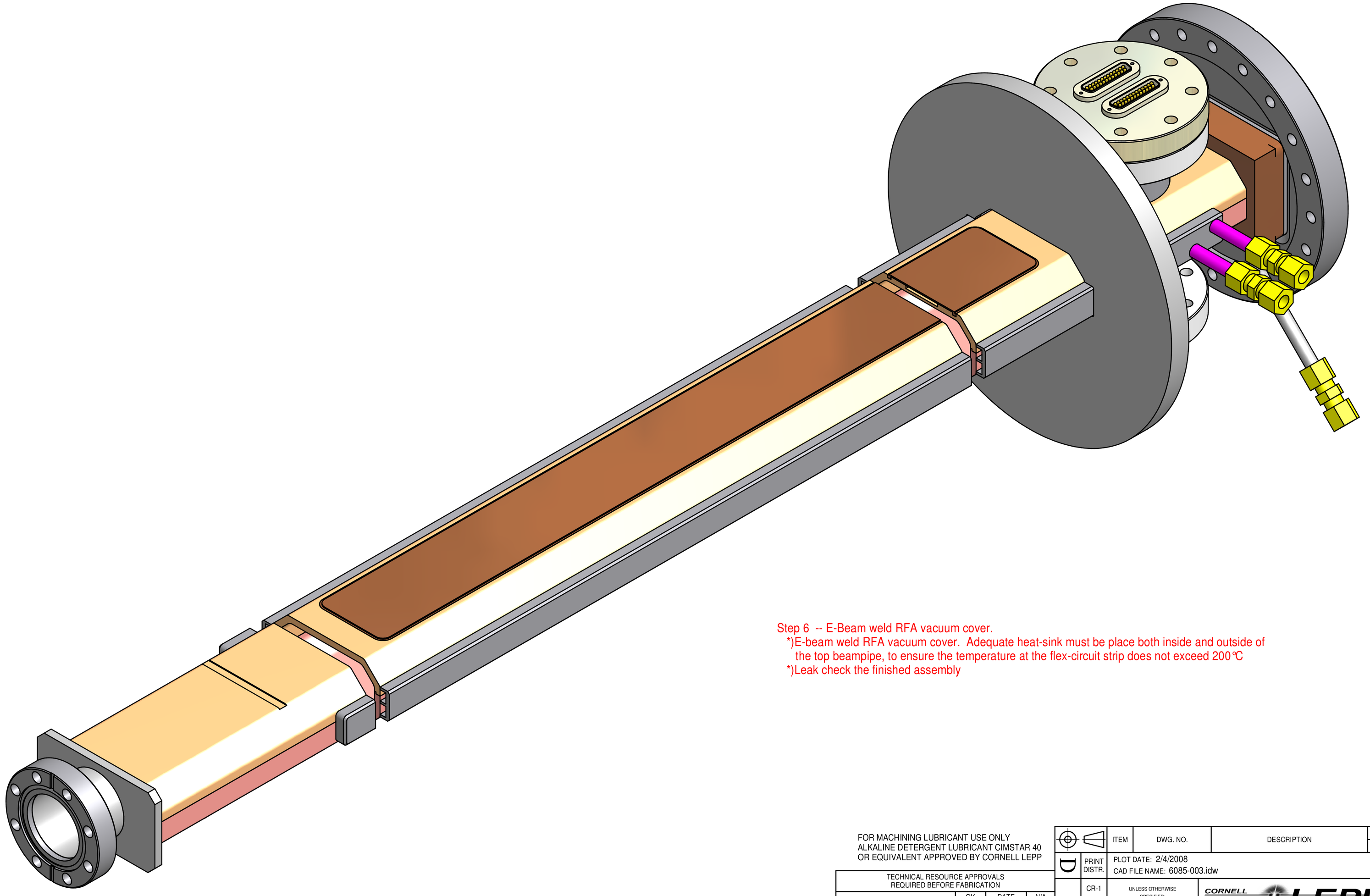
CESR Wiggler Chamber with Thin RFA

DRAWN BY	DRAWN FOR	DATE	SCALE			REV.
Yulin Li	Yulin Li	1/29/2008		D	6085-003 SH. NO. 20 OF 22	

REVISIONS				
SYM.	ZONE	DESCRIPTION	DATE	APP.



Step 6 -- E-Beam weld RFA vacuum cover.
*)E-beam weld RFA vacuum cover. Adequate heat-sink must be place both inside and outside of the top beampipe, to ensure the temperature at the flex-circuit strip does not exceed 200℃
*)Leak check the finished assembly

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TECHNICAL RESOURCE APPROVALS REQUIRED BEFORE FABRICATION	OK	DATE	N/A
DRAFTING (O'Connel):			
MACHINE SHOP (Kaminski):			
CHEMISTRY (Conklin):			
ELECTRONICS SHOP (Barley):			
FURNACE BRAZING (Sherwood):			
BEAM WELDING (Sears):			
WELDING OTHER (Gallagher):			
UTILITIES INTEGRATION (Gallagher):			
STOCKROOMS (Lockwood):			

ITEM	DWG. NO.	DESCRIPTION	QUANTITY G1	QUANTITY G2	QUANTITY G3	REMARKS	REV.

PRINT DISTR. D

PLOT DATE: 2/4/2008
CAD FILE NAME: 6085-003.idw

CR-1

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.000 ± .005
FRACTIONS ± 1/64
ANGLES ± 0.5°
ALL SURFACES

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APPROVED BY:

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CESR Wiggler Chamber with Thin RFA

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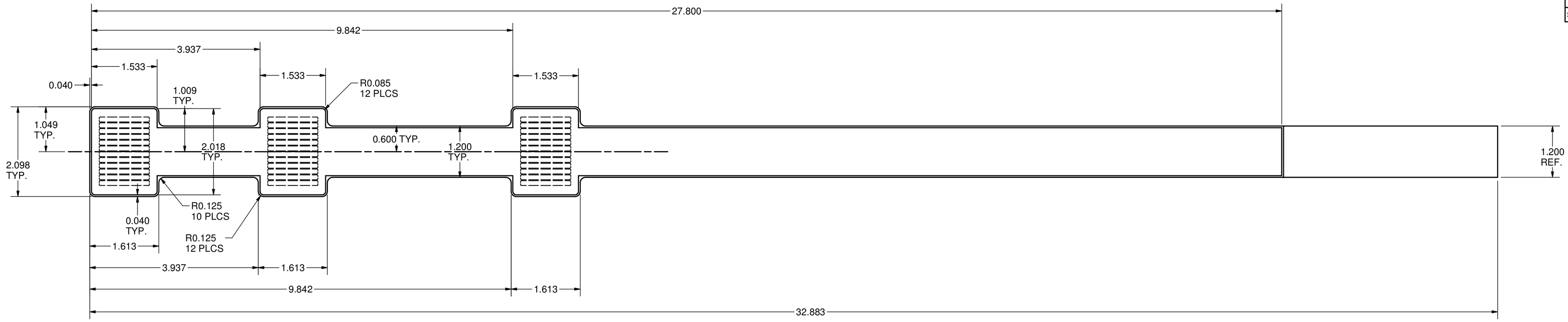
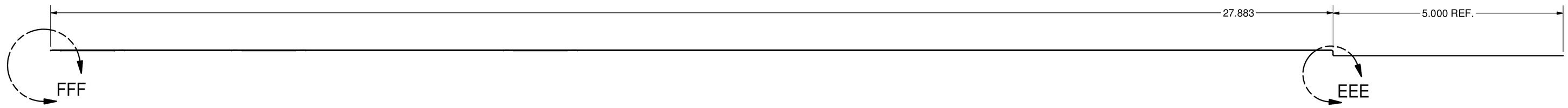
Yulin Li	Yulin Li	1/29/2008		D	6085-003 SH. NO. 21 OF 22	

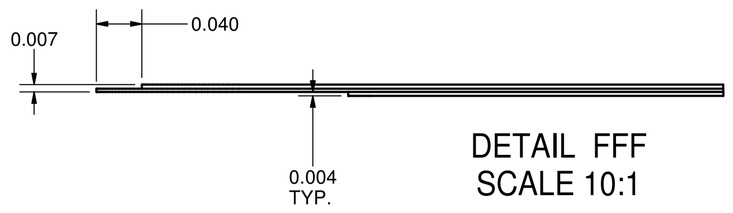
6085-003 SH. NO. 21 OF 22

REV.

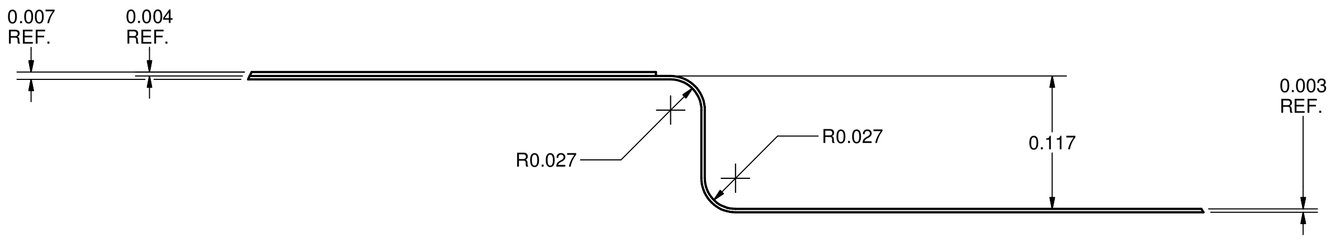
REVISIONS				
SYM.	ZONE	DESCRIPTION	DATE	APP.



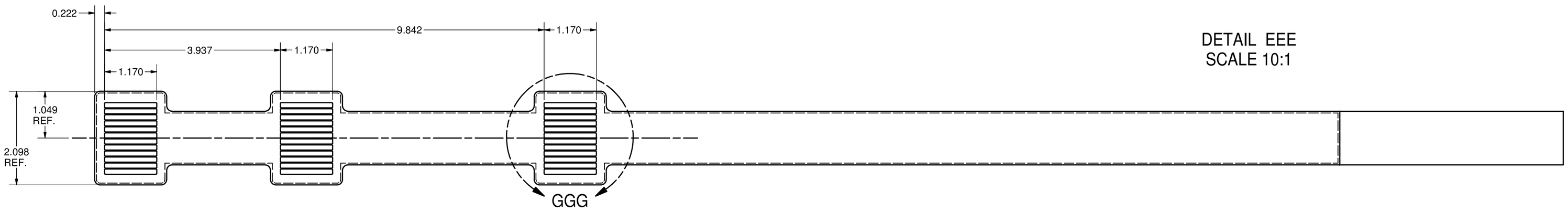


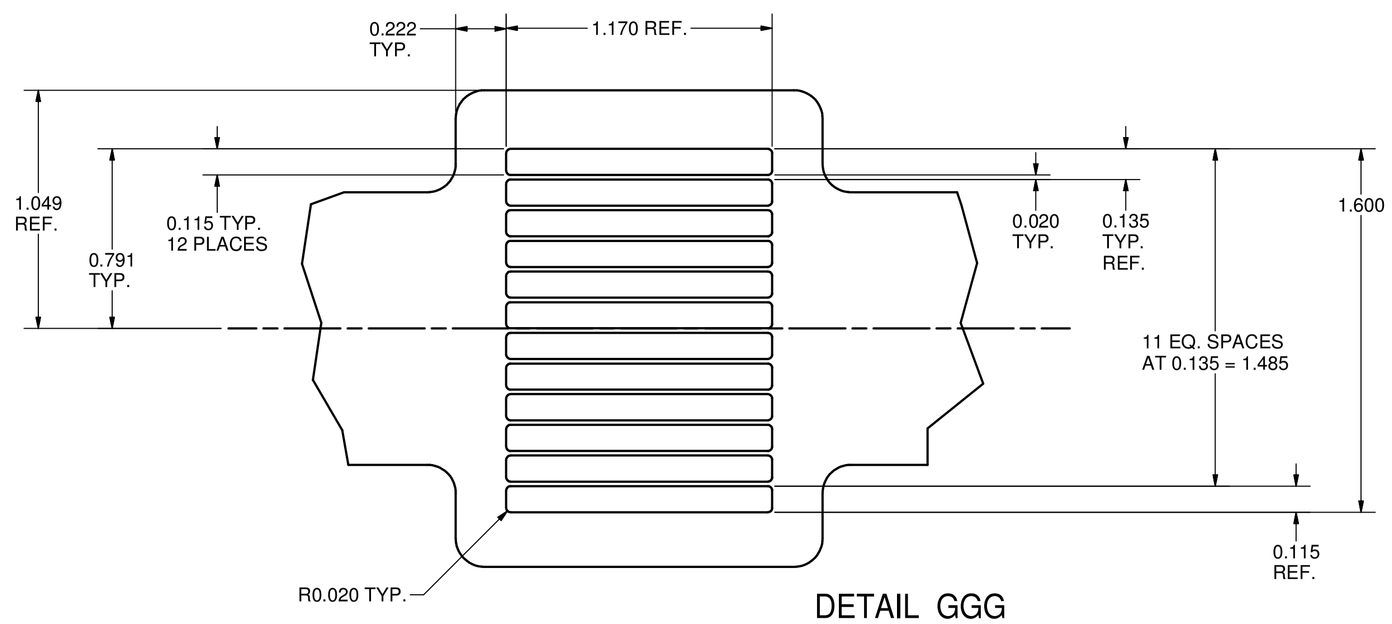


DETAIL FFF
SCALE 10:1



DETAIL EEE
SCALE 10:1





DETAIL GGG
SCALE 2:1

7 RFA FLEX CIRCUIT STRIP

FILE NAME: 6085-003
SHEET NO.: 22
DFT. SCALE: 1:1
MATERIAL: CONTACT YULIN LI - LEPP
QTY: 1 PER ASM
NOTES:

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TECHNICAL RESOURCE APPROVALS REQUIRED BEFORE FABRICATION			
	OK	DATE	N/A
DRAFTING (O'Connel):			
MACHINE SHOP (Kaminski):			
CHEMISTRY (Conklin):			
ELECTRONICS SHOP (Barley):			
FURNACE BRAZING (Sherwood):			
BEAM WELDING (Sears):			
WELDING OTHER (Gallagher):			
UTILITIES INTEGRATION (Gallagher):			
STOCKROOMS (Lockwood):			

ITEM	DWG. NO.	DESCRIPTION	G1	G2	G3	REMARKS	REV.
			QUANTITY				

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PLOT DATE: 2/4/2008
CAD FILE NAME: 6085-003.idw

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ALL SURFACES

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CESR Wiggler Chamber with Thin RFA
RFA Flex Circuit Strip, Detail

CHECKED BY:
APPROVED BY:

DRAWN BY	DRAWN FOR	DATE	SCALE			REV.
Yulin Li	Yulin Li	1/29/2008		D	6085-003 SH. NO. 22 OF 22	

6085-003 SH. NO. 22 OF 22 REV.