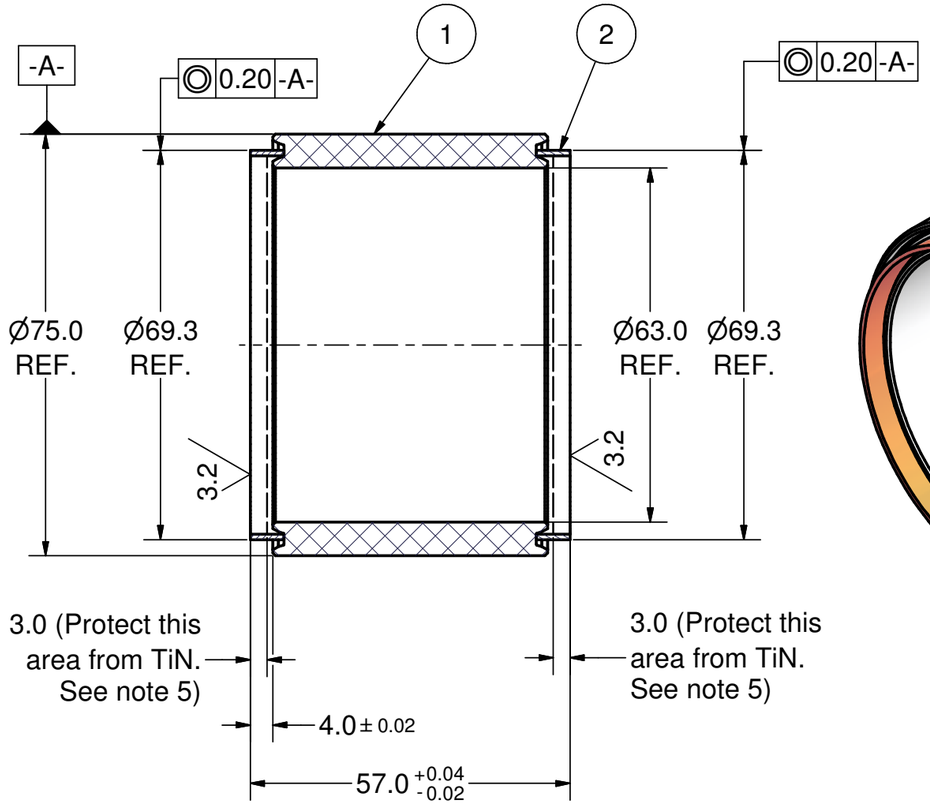

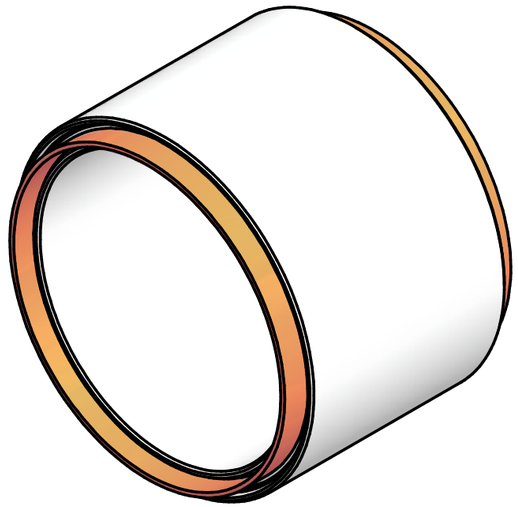

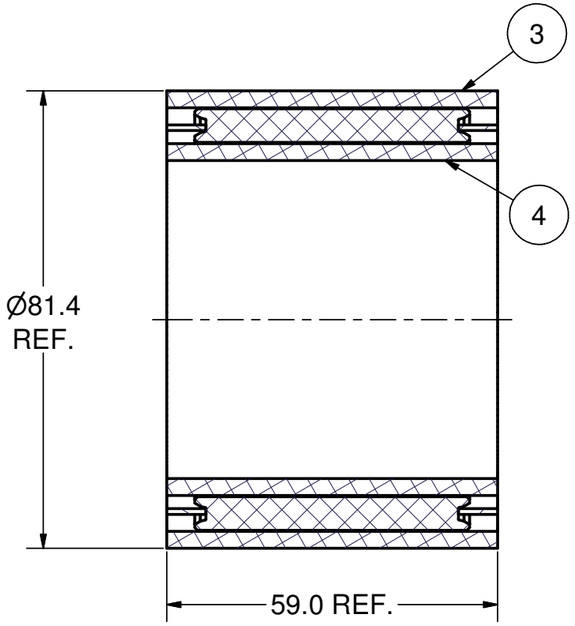

ASSEMBLY FOR BRAZING

NOTES:

1. Ceramics item 1 delivered with metallized ends.
2. Degas ceramics for 1 hour at 800˚C in clean vacuum ($P < 10^{-5}$ mbar). After that, handle only with gloves and pack in lint-free paper bag.
3. Braze copper sleeves item 2 to ceramics item 1 with Cu-Ag solder at 780˚C in clean vacuum oven.
4. Cut copper sleeves after brazing.
5. Deposit TiN layer of 10 nm thickness inside.
6. Pack the assembly in lint-free paper or non-polymeric plastic bag.

Issued all design changes as Rev C (TIO) - 4/19/07 - SAB

Parts List

ITEM	PART NUMBER	DESCRIPTION	MATERIAL	QTY
1	100.124.001	WARM CERAMICS	Ceramics, Alumina, Al-300	1
2	100.124.002	COPPER SLEEVE	Copper, OFHC	2
3	100.124.003	EXTERNAL COVER TUBE FOR WARM WINDOW	Ceramics, Alumina, Al-300	1
4	100.124.004	INTERNAL COVER TUBE FOR WARM WINDOW	Ceramics, Alumina, Al-300	1

State	Changes	Date	Name

	Date	Name
Drawn	10/5/04	Churanov
Checked	01-03-07	VM
Standard		

Rev. C

Scale : 1:1 | mat:

ASSEMBLY : *75 kW CW Input Coupler*

DESIGNATION :

WARM CERAMIC WINDOW

100.124.000 AS | 1 | A3