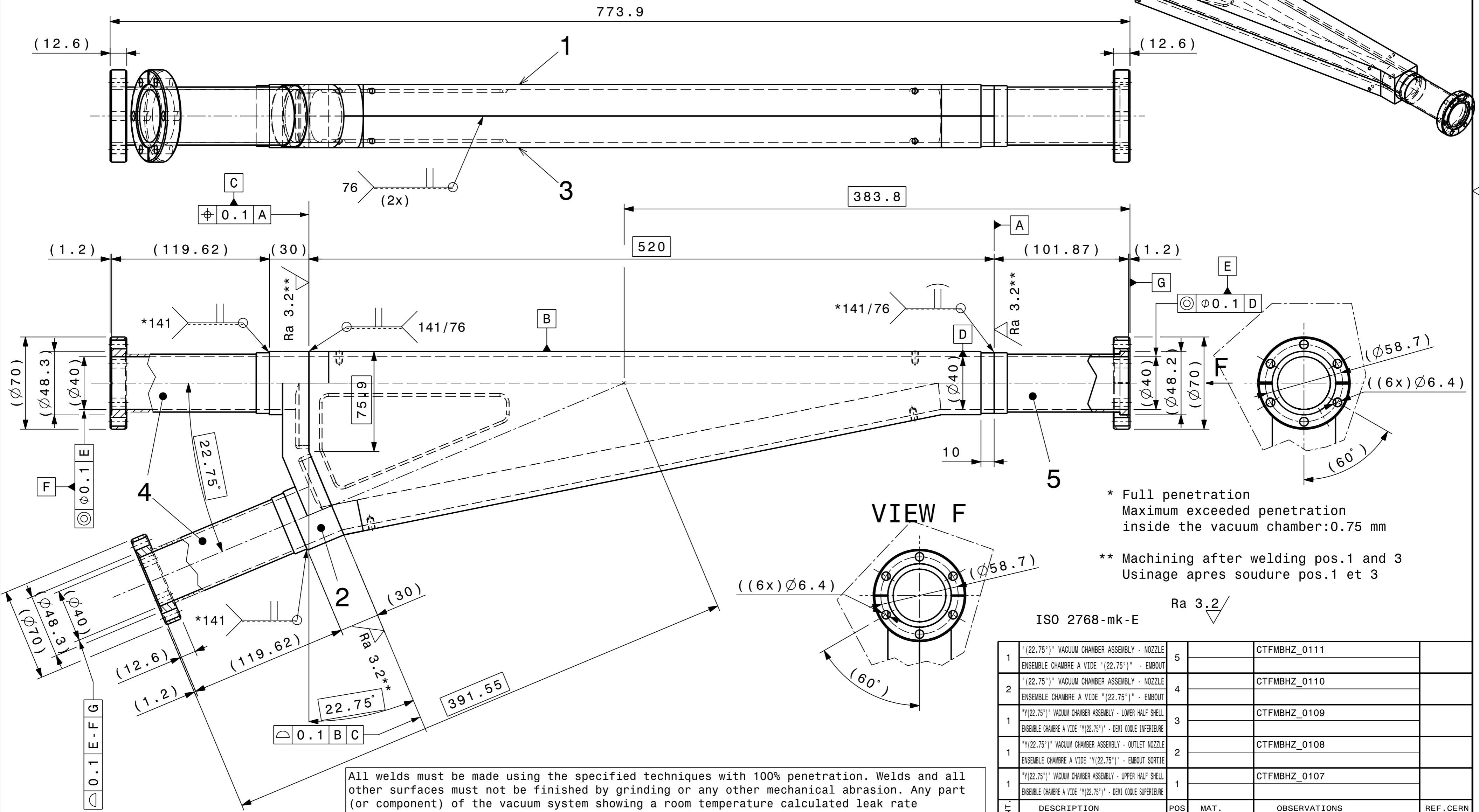


Approximative mass : 3.229 kg
Masse approximative



* Full penetration
Maximum exceeded penetration
inside the vacuum chamber: 0.75 mm

** Machining after welding pos.1 and 3
Usinage apres soudure pos.1 et 3

ISO 2768-mk-E

All welds must be made using the specified techniques with 100% penetration. Welds and all other surfaces must not be finished by grinding or any other mechanical abrasion. Any part (or component) of the vacuum system showing a room temperature calculated leak rate (localized or global), when measured with a calibrated UHV leak detector, in excess of 1.0₁₀-11 Pa.m3.s-1 (1.0₁₀-10 mbar.l.s-1) will be considered as unacceptable.

1. Component fabrication (degreasing and welding).
2. Inscribe drawing number on shaded area with an electrical pen.
3. Leak detection, the test report has to be supplied to the AT Vacuum Group.
4. UHV cleaning according to CERN report "procédure qualité": 867.11 (for Stainless steel) or 867.12 (for aluminium and copper). EDMS reference number 798034.

QUANT.	DESCRIPTION	POS	MAT.	OBSERVATIONS	REF. CERN
1	"Y(22.75°)" VACUUM CHAMBER ASSEMBLY - NOZZLE ENSEMBLE CHAMBRE A VIDE "Y(22.75°)" - EMBOUT	5			CTFMBHZ_0111
2	"Y(22.75°)" VACUUM CHAMBER ASSEMBLY - NOZZLE ENSEMBLE CHAMBRE A VIDE "Y(22.75°)" - EMBOUT	4			CTFMBHZ_0110
1	"Y(22.75°)" VACUUM CHAMBER ASSEMBLY - LOWER HALF SHELL ENSEMBLE CHAMBRE A VIDE "Y(22.75°)" - DEMI COQUE INFÉRIEURE	3			CTFMBHZ_0109
1	"Y(22.75°)" VACUUM CHAMBER ASSEMBLY - OUTLET NOZZLE ENSEMBLE CHAMBRE A VIDE "Y(22.75°)" - EMBOUT SORTIE	2			CTFMBHZ_0108
1	"Y(22.75°)" VACUUM CHAMBER ASSEMBLY - UPPER HALF SHELL ENSEMBLE CHAMBRE A VIDE "Y(22.75°)" - DEMI COQUE SUPÉRIEURE	1			CTFMBHZ_0107

CTF3 MAGNET BENDING HORIZONTAL		ECHELLE SCALE 1:2	DES/DRA.	B. FAVRAT	2007-08-16
BHB MAGNET "Y(22.75°)" VACUUM CHAMBER ASSEMBLY DIPOLE BHB ENSEMBLE CHAMBRE A VIDE "Y(22.75°)"			CONTROLLED		
		RELEASED			
		APPROVED			
		CTF\MBHZ_0\CTFMBHZ_0106			
		REPLACE/REPLACES			
NON VALABLE POUR EXECUTION NOT VALID FOR EXECUTION		QAC	CTFMBHZ_0106		SIZE IND. 2

ISO 2768-mk-E
ISO 13715
Tolerances géométriques, linéaires et angulaires
Aretes de forme non définie
TOLERANCES GÉNÉRALES "MOYENNE"
DESSIN, RUGOSITÉ, TOLERANCES SELON NORMES ISO
DRAWING, RUGOSITY, TOLERANCES ACCORDING TO ISO STANDARDS
PROJECTION
ORGANISATION EUROPÉENNE POUR LA RECHERCHE NUCLÉAIRE
EUROPEAN ORGANIZATION FOR NUCLEAR RESEARCH
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