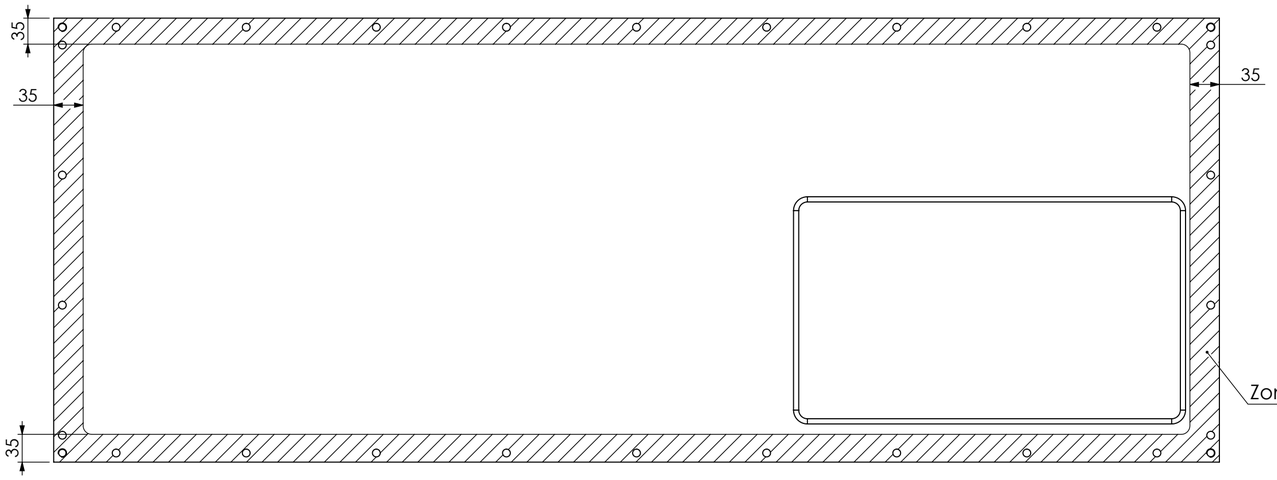
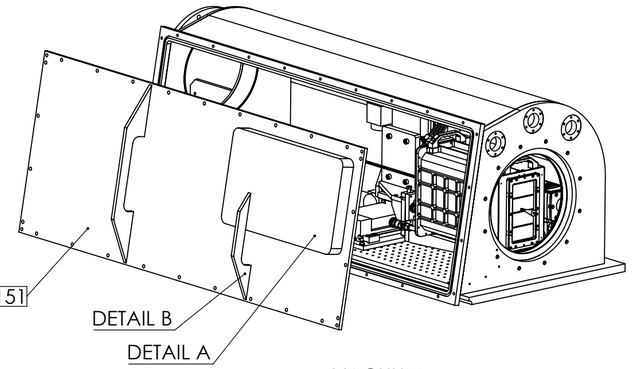
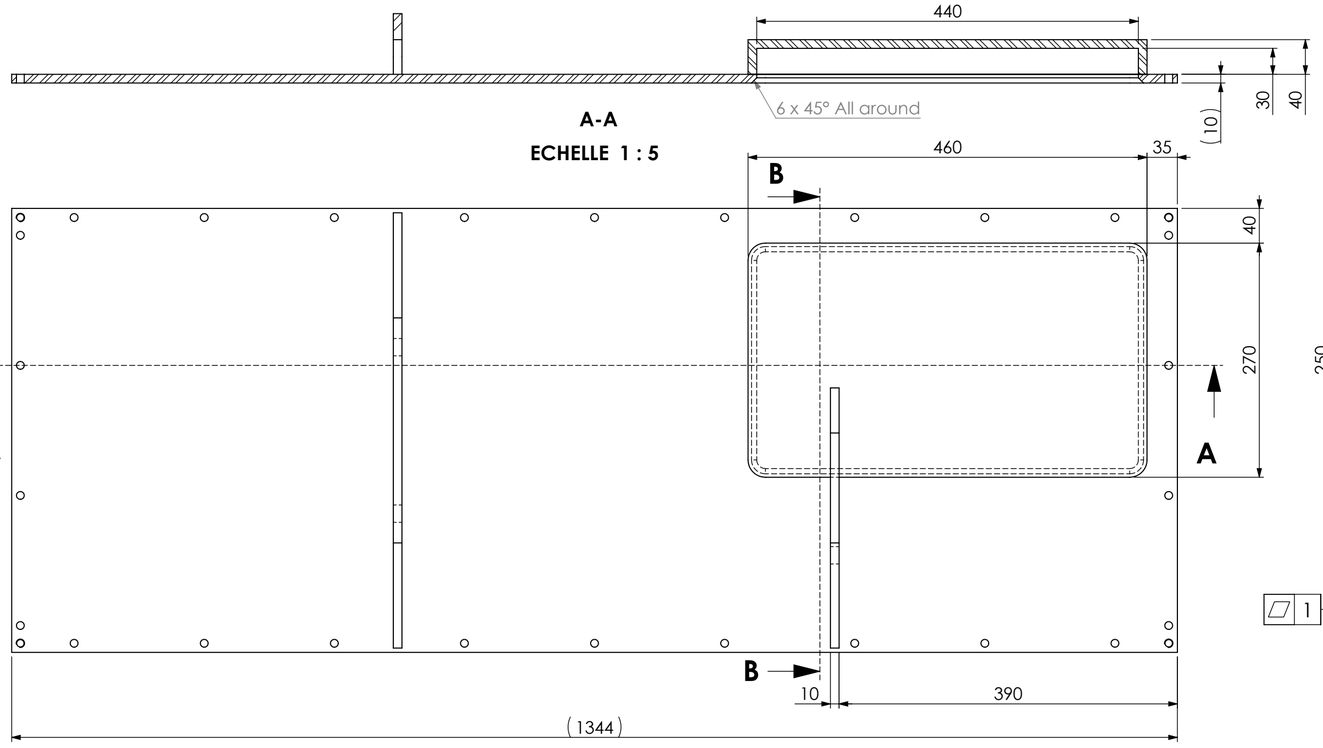


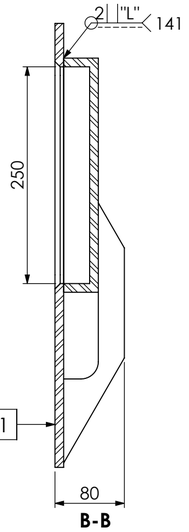
- REMOVE ALL BURRS AND SHARP EDGES
- GENERAL LINEAR TOLERANCE, UNLESS OTHERWISE STATED.
  MACHINED DIMENSIONS: Js12
  BETWEEN WELDED PART: Js14
- ALL VACUUM SURFACES TO BE FREE FROM VISIBLE DEFECTS SUCH AS PITTING CRACKS AND INDENTATIONS
- VACUUM SEALING FACES TO BE FREE FROM RADIAL SCRATCHES AND TO BE PROTECTED DURING TRANSIT AND STORAGE.
- VACUUM VESSEL TO BE TESTED TO A LEAK RATE BETTER THAN 10 MBAR LITRES / SEC. IN ACCORDANCE WITH SPECIFICATION SpLine-ENG 99.09/CMN
- ITEM TO BE CLEANED IN ACCORDANCE WITH SPECIFICATION SpLine-VAC 99.09/CMN

NOTES: 1. CUTTING OF MATERIAL : Ra 6.3
2. GENERAL SURFACES FINISH:
3. REMOVE ALL BURRS AND SHARP EDGES
4. WELDING: 5 EXCEPT INDICATIONS.
5. STABILISATION: HEAT TREATMENT AFTER WELDING BEFORE FINAL MACHINING

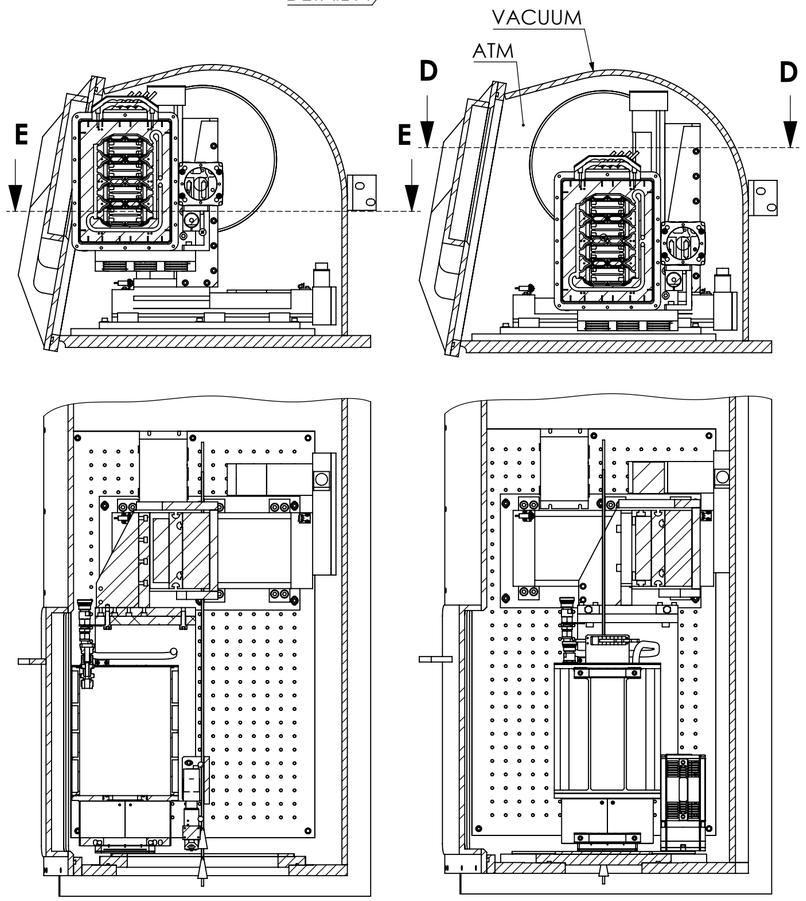




A-A
ECHELLE 1 : 5

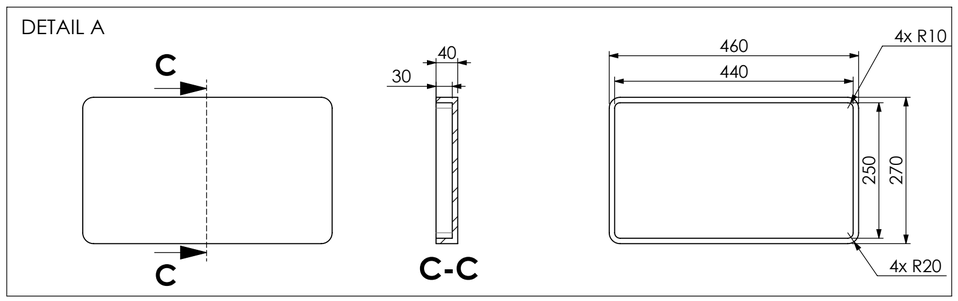


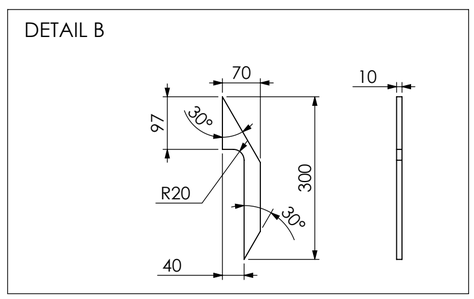
B-B
ECHELLE 1 : 5



E-E

D-D





MOD	DATE	DRND.	APPD.	DESCRIPTION

	NAME	DATE
DRN.	HEYMAN	11/11/2019
CKD.		
APPD.		

SCALE: 0mm — 100

GEN. TOL. :

GEN. SURFACE FINISH :

ID01 - DIFF IMAGING NANO WAGON ASSY DOOR MODIFICATION

A2

EUROPEAN SYNCHROTRON RADIATION FACILITY
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TEL. 04-76-88-20-00 WWW.ESRF.FR

ASSY. 01.57.1320

00.56.3151

SolidWorks