



ITEM	STOCK OR PART NO	TITLE OR DESCRIPTION	QTY
4	PF-391-542-19	MODIFIED VCR SPLIT NUT	2
3	PF-391-542-18	MODIFIED VCR GLAND	2
2	PF-391-542-03	COLD PLATE FRONT FACE	1
1	PF-391-547-05	COLD PLATE 2	1

- NOTES: UNLESS OTHERWISE SPECIFIED
- OVEN BRAZE ITEMS 2 & 3 TO ITEM 1. USE BRAZE ALLOY 35%Au 65%Cu.
  - VERIFY ITEM 2 IS IN THE CORRECT ORIENTATION AND ALIGNED AS SHOWN.
  - REMOVE ITEM 4 (VCR SPLIT NUTS) PRIOR TO BRAZING.
  - PERFORM MACHINING OPERATIONS AFTER BRAZING.



---	DIMENSIONING AND TOLERANCING IS IN ACCORDANCE WITH ASME Y14.5-2009
---	UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES. TOLERANCES:
---	BREAK EDGES .005-.015
---	INTERNAL CORNERS R0.05 MAX
---	FRACTIONS 1/16
---	DEC .XXX1
---	.XXXX1 .0005
---	.XXXX2
---	.XXXX3
---	ANGLE ±
---	ALL SURF. 63

SCALE: 2:1 (DO NOT SCALE DRAWING)

**SLAC** U.S. DEPARTMENT OF ENERGY  
NATIONAL ACCELERATOR LABORATORY

ENGR M ORLUNNO DATE 2/18/05  
DWN S BOO  
CHR D DOERING

ESTIMATED MASS: 1.449 LB		CAD FILE NAME: sa39154701-0.dft	
LCLS DETECTORS EPIX HR CAMERA COLD PLATE ASSY			
DRAWING NUMBER	REVISION NUMBER		
SA-391-547-01	0	D	