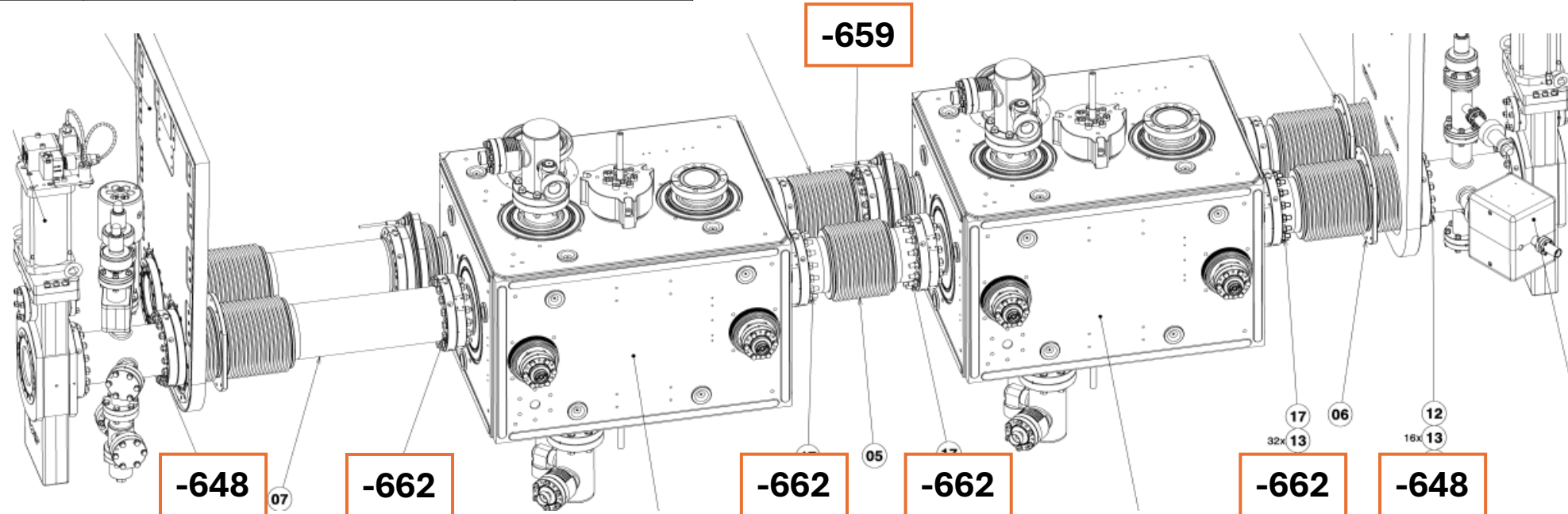


Gaskets for CM2 Step1

DWG	Description	QTY Needed
LHCACFCA0662	DN100 Cu Gasket + 3xM3 + features	4
LHCACFCA0659	DN100 Cu Gasket with Retainer	1
LHCACFCA0648-vAC	DN100 Cu Gasket with External Lip	2
-	DN100 Cu Gasket (Ag Coated)	2
-	DN40 Cu Gasket (Ag Coated)	5
-	DN40 Cu Gasket	11
-	DN16 Cu Gasket	1



DWG	Description	QTY Needed
LHCACFCA0662	DN100 Cu Gasket + 3xM3 + features	4
LHCACFCA0659	DN100 Cu Gasket with Retainer	1
LHCACFCA0648-vAC	DN100 Cu Gasket with External Lip	2

Option A

Use best gaskets received Nov24 (with re-clean)

-663: 7, 8, 14, 17

-662: 6, 3, 2, 5, 4, 7, 16

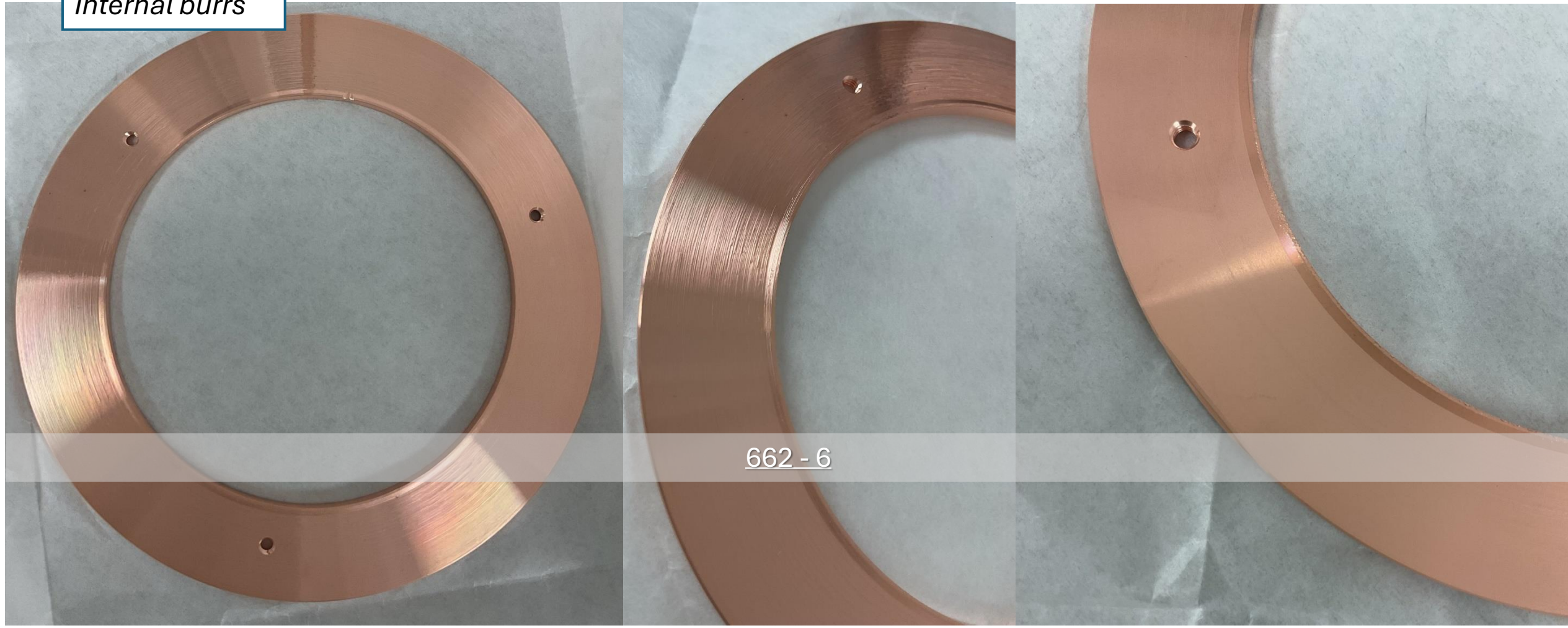
-659: 18, 20, 16, 9, 2

-648: 3, 10, 14, 4, 12, 11, 20, 17

Option A - Use best Gaskets received Nov24

DWG	Description	QTY Needed
LHCACFCA0662	DN100 Cu Gasket + 3xM3 + features	4

Machine marks
Internal burrs

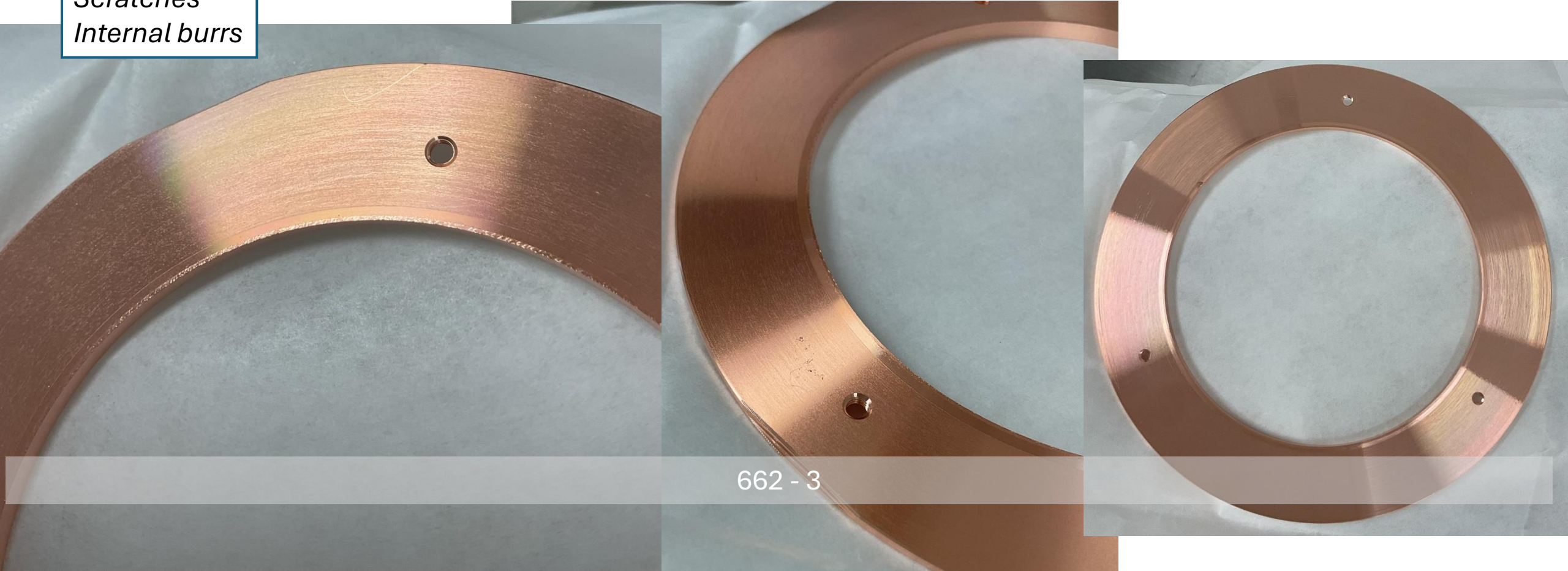


662 - 6

DWG	Description	QTY Needed
LHCACFCA0662	DN100 Cu Gasket + 3xM3 + features	4

Option A - Use best Gaskets received Nov24

Scratches
Internal burrs

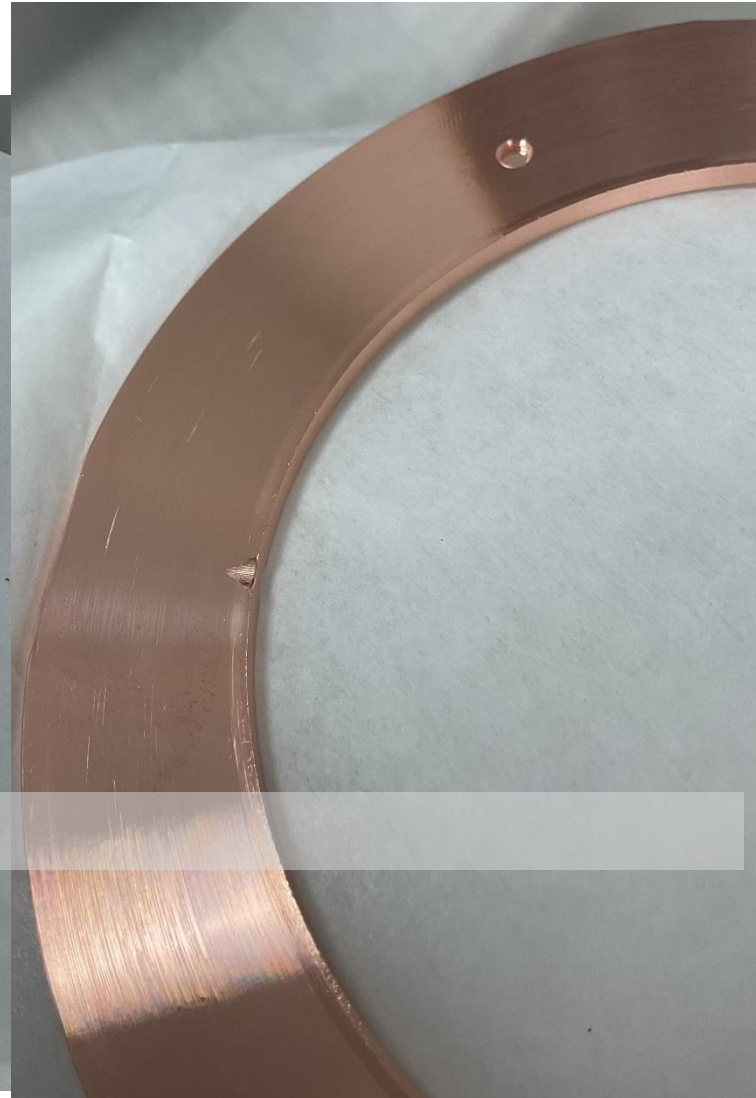
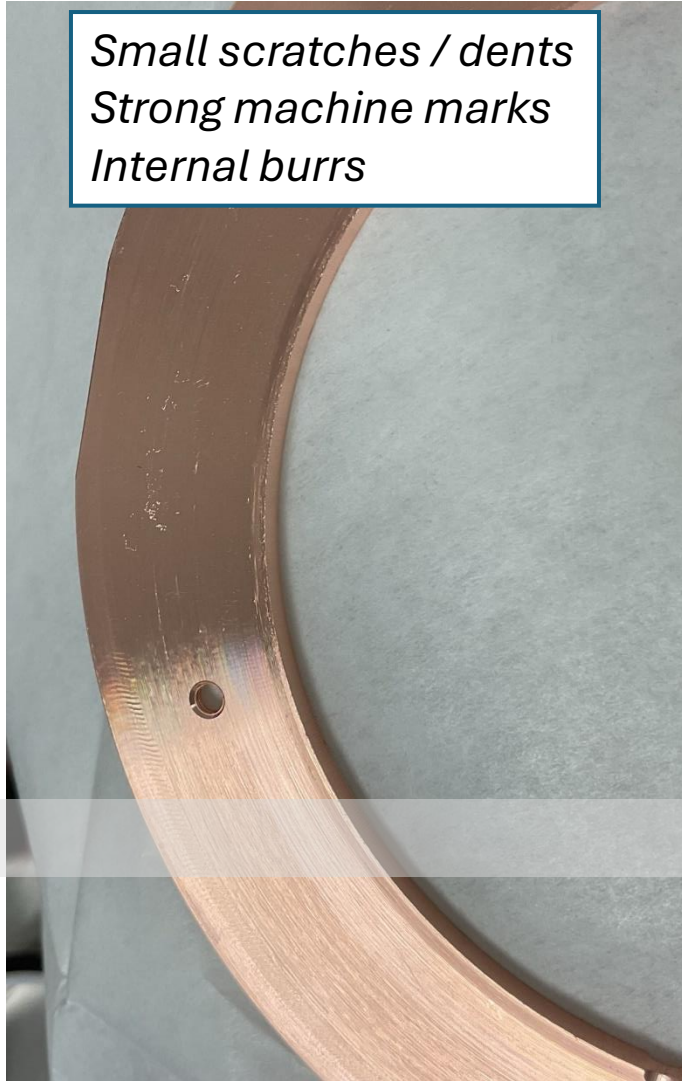


662 - 3

DWG	Description	QTY Needed
LHCACFCA0662	DN100 Cu Gasket + 3xM3 + features	4

Option A - Use best Gaskets received Nov24

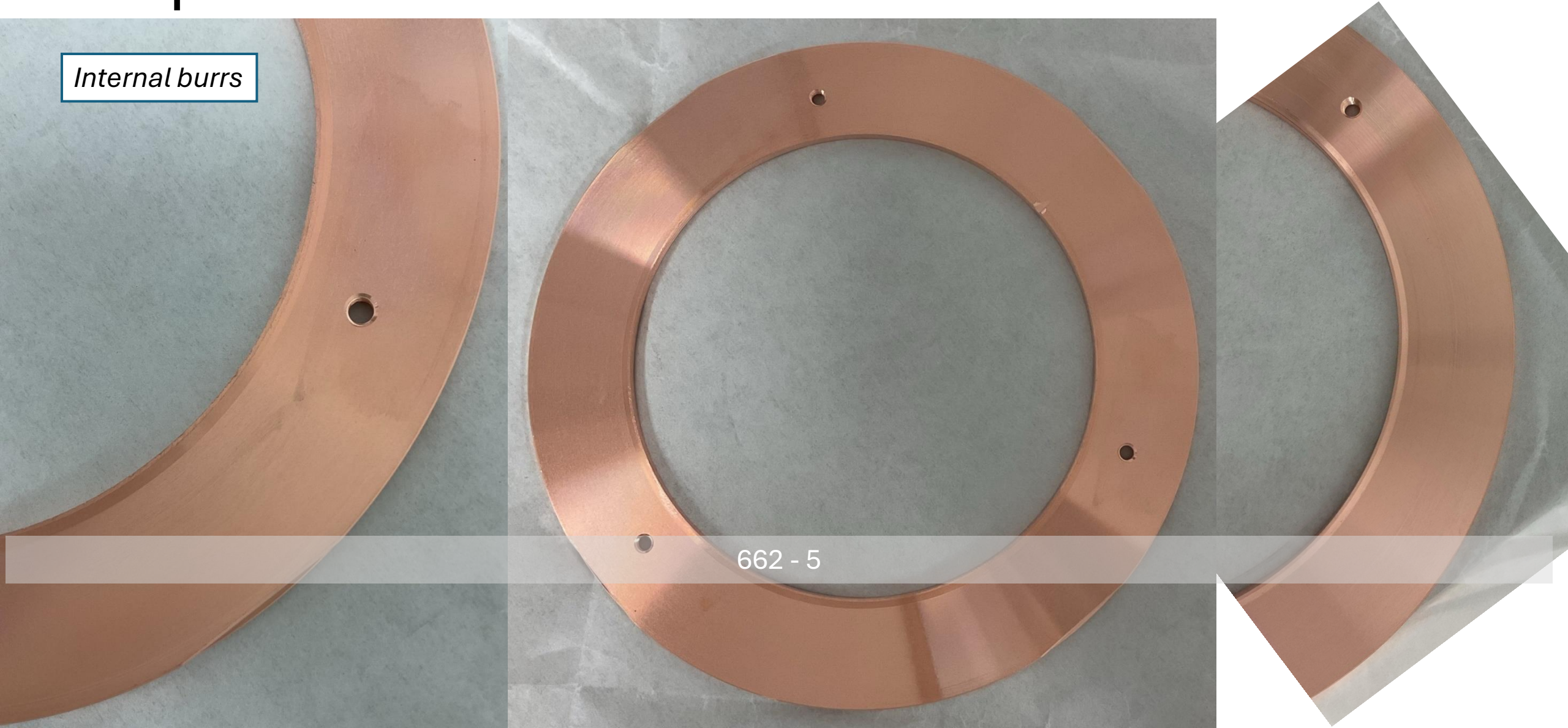
Small scratches / dents
Strong machine marks
Internal burrs



DWG	Description	QTY Needed
LHCACFCA0662	DN100 Cu Gasket + 3xM3 + features	4

Option A - Use best Gaskets received Nov24

Internal burrs

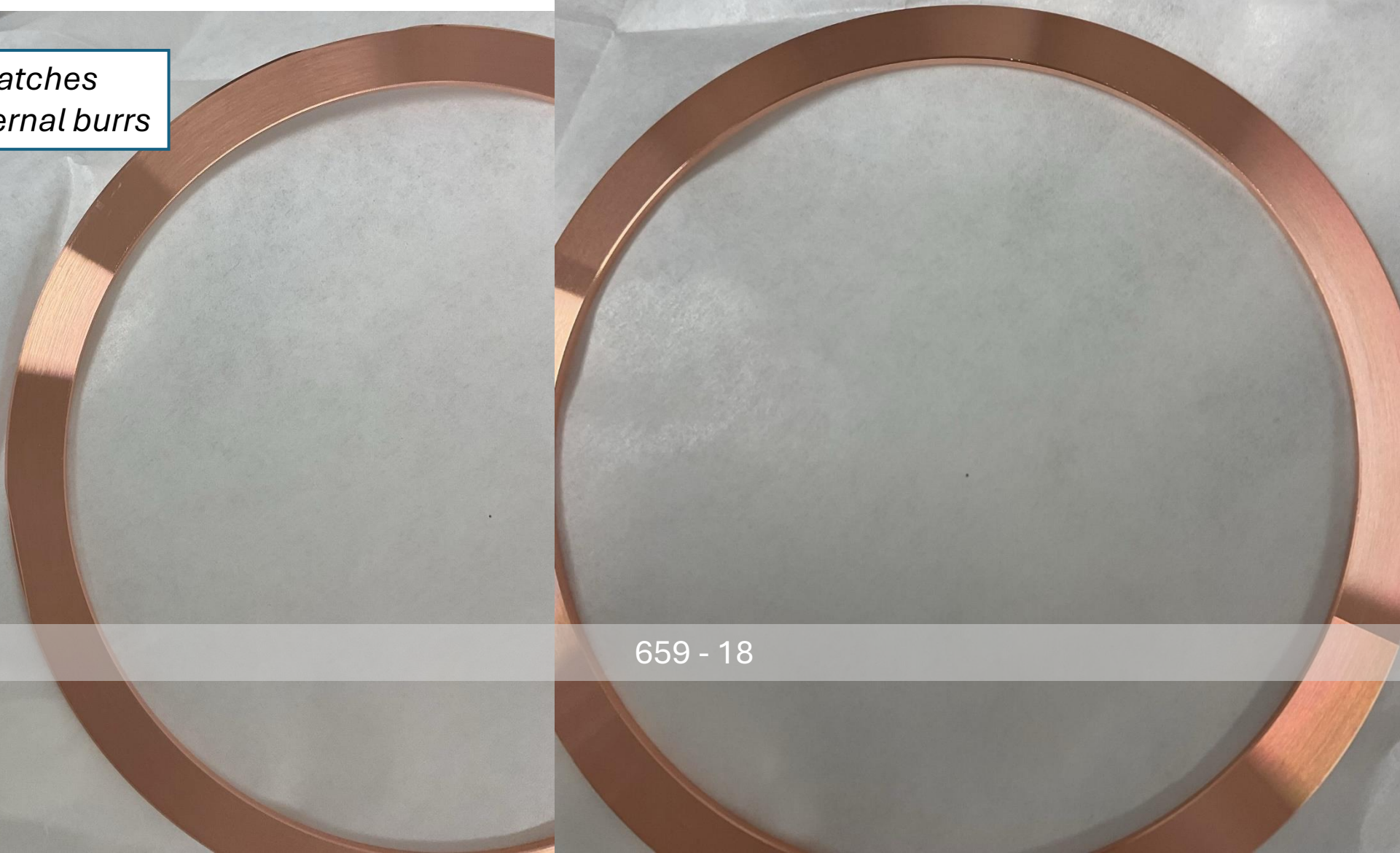


662 - 5

DWG	Description	QTY Needed
LHCACFCA0659	DN100 Cu Gasket with Retainer	1

Option A - Use best Gaskets received Nov24

*Small scratches
Some internal burrs*



659 - 18

DWG	Description	QTY Needed
LHCACFCA0648-vAC	DN100 Cu Gasket with External Lip	2

Option A - Use best Gaskets received Nov24

Small inner & outer scratches

648 - 3



DWG	Description	QTY Needed
LHCACFCA0648-vAC	DN100 Cu Gasket with External Lip	2

Option A - Use best Gaskets received Nov24

Small inner & outer scratches

648 - 10



DWG	Description	QTY Needed	Available Alternates
LHCACFCA0662	DN100 Cu Gasket + 3xM3 + features	4	-353, -651
LHCACFCA0659	DN100 Cu Gasket with Retainer	1	-648-vAB, -649, -647
LHCACFCA0648-vAC	DN100 Cu Gasket with External Lip	2	-648-vAB

Option B

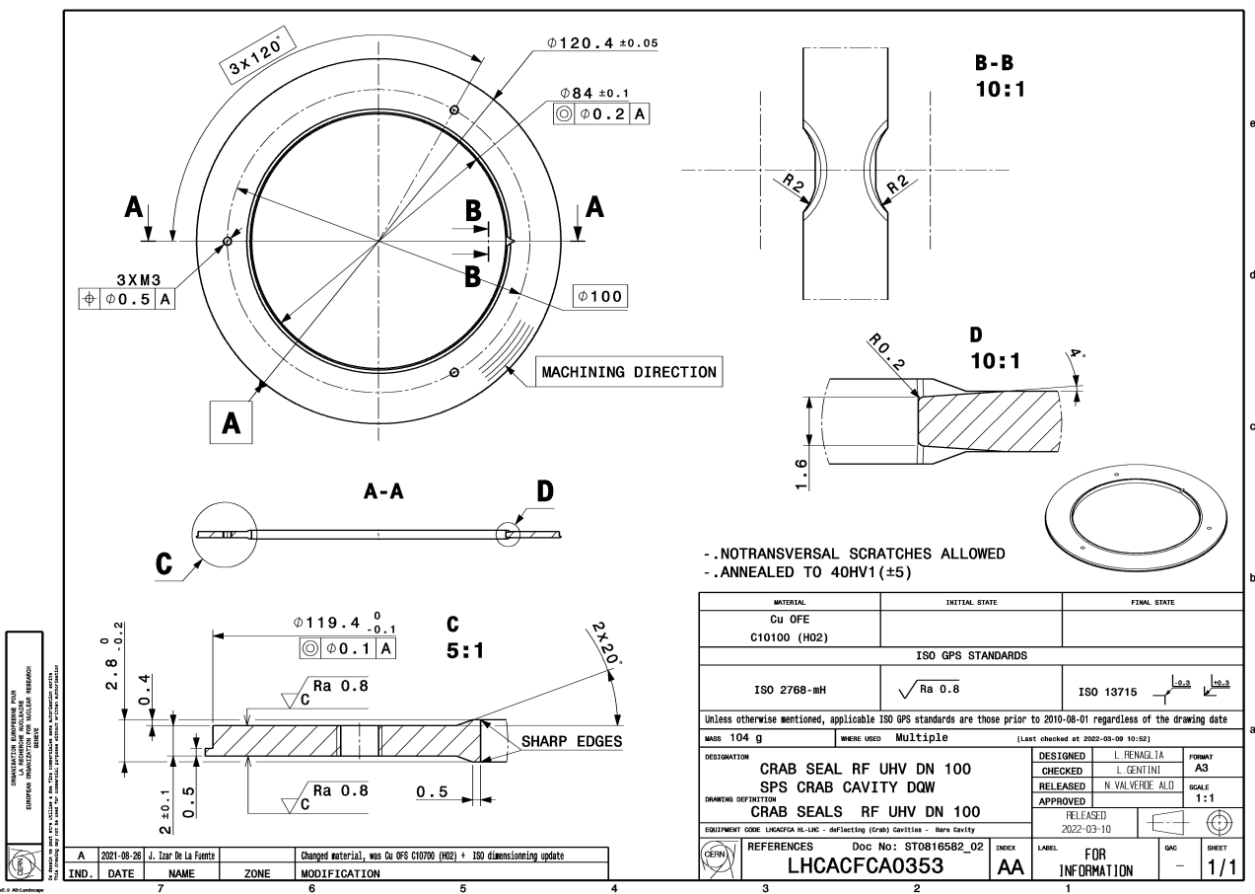
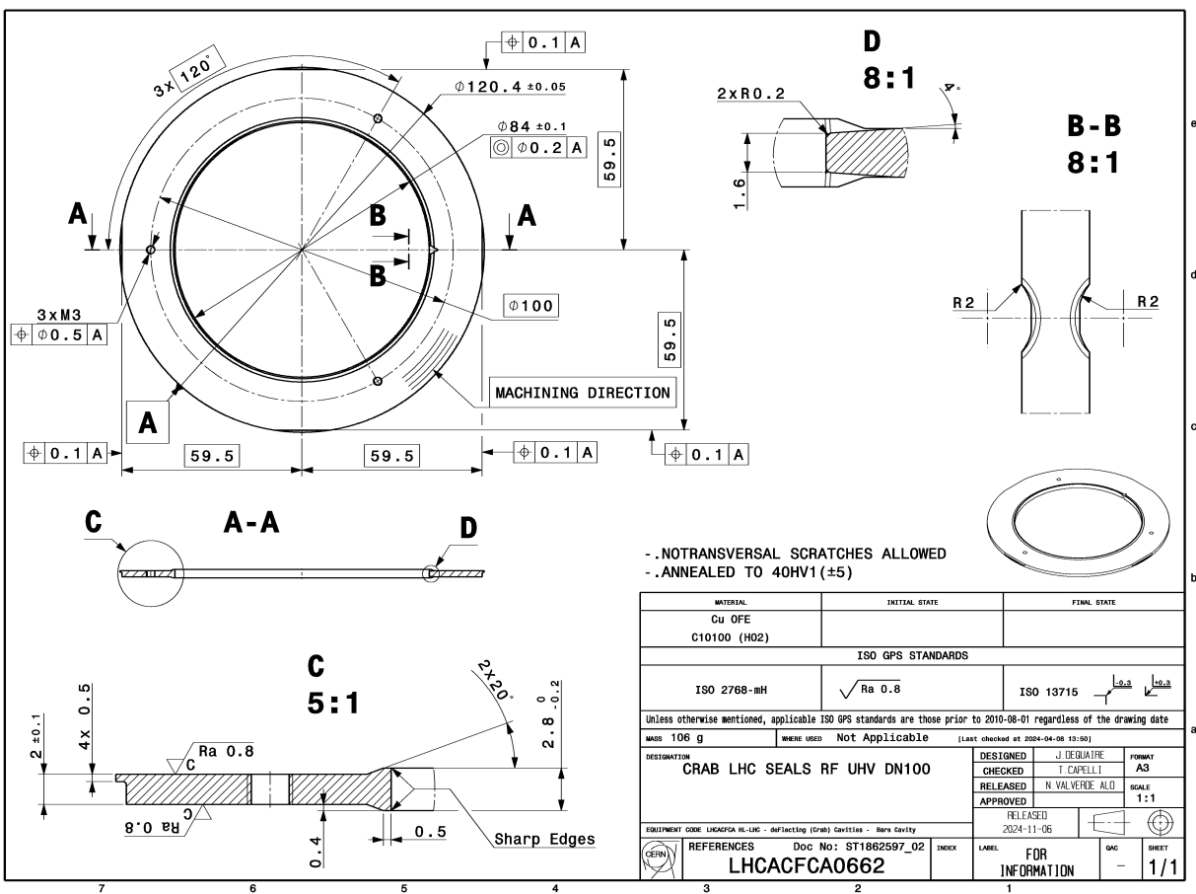
Use alternate RFD spares (with re-clean)

No noticeable NCs but oxidised (some severely)

All step1 gaskets options to be re-cleaned by rinsing using BPS-172 and hang-drying

DWG	Description	QTY Needed	Available Alternates
LHCACFCA0662	DN100 Cu Gasket + 3xM3 + features	4	-353, -651

-662 vs -353



External local lip vs external lip all-round

DWG	Description	QTY Needed	Available Alternates
LHCACFCA0659	DN100 Cu Gasket with Retainer	1	-648-vAB, -649, -647

659 vs 648-vAB

MATERIAL	INITIAL STATE	FINAL STATE
Cu OFE C10100 (H02)		

ISO GPS STANDARDS		
ISO 2768-MH	√ Ra 0.8 (✓)	ISO 13715

NOTE: UNLESS OTHERWISE MENTIONED, APPLICABLE ISO GPS STANDARDS ARE THOSE PRIOR TO 2010-08-01 REGARDLESS OF THE DRAWING DATE

MASS 51.23 g WHERE USED Not Applicable (Last checked at 2024-11-21 00:00)

DESIGNATION METAL SEAL UHV FLANGE DN100-106 WITH RETAINERS

DESIGNED J. Dequaire
CHECKED T. Capelli
VERIFIED N. Valverde Alonso
REVIEWED

Approved 2024-11-20

IND.	DATE	NAME	ZONE	MODIFICATION
A	2024-11-19	J. Dequaire		Annealed treatment removed

IND.	DATE	NAME	ZONE	MODIFICATION

REFERENCES	Doc No:	INDEX	LABEL	QAC	SHEET
LHCACFCA0659	ST1733872_02	A			1/1

MATERIAL	INITIAL STATE	FINAL STATE
Cu OFE C10100 (H02)		

ISO GPS STANDARDS		
ISO 2768-MH	√ Ra 0.8 (✓)	ISO 13715

NOTE: UNLESS OTHERWISE MENTIONED, APPLICABLE ISO GPS STANDARDS ARE THOSE PRIOR TO 2010-08-01 REGARDLESS OF THE DRAWING DATE

MASS 60.6 g WHERE USED Not Applicable (Last checked at 2022-03-08 17:39)

DESIGNATION METAL SEAL UHV FLANGE DN100-100 WITH EXTERNAL LIP

DESIGNED J. DEQUAIRE
CHECKED T. CAPELLI
RELEASED D. CAPATINA
APPROVED

Released 2024-03-11

IND.	DATE	NAME	ZONE	MODIFICATION
B	2022-03-08	J. Dequaire		Material modification to annealed Cu OFE
A	2022-02-14	J. Dequaire		Increase tolerances on Ø100 ; Ø119.4 ; th2

IND.	DATE	NAME	ZONE	MODIFICATION

REFERENCES	Doc No:	INDEX	LABEL	QAC	SHEET
LHCACFCA0648	ST1520543_02	AB	FOR INFORMATION		1/1

External local lip vs external lip all-round
ID 104 vs 100

DWG	Description	QTY Needed	Available Alternates
LHCACFCA0648-vAC	DN100 Cu Gasket with External Lip	2	-648-vAB

648-vAC vs 648-vAB

- DO NOT SCRATCH THE SURFACE
 - ANNEALED

MATERIAL	INITIAL STATE	FINAL STATE
Cu OFE C10100 (H02)		

ISO GPS STANDARDS		
ISO 2768-mH	√ Ra 0.8 (✓)	ISO 13715

Unless otherwise mentioned, applicable ISO GPS standards are those prior to 2010-08-01 regardless of the drawing date
 MASS 42.3 g WERE USED Multiple (Last checked at 2024-07-12 15:53)

DESIGNATION	DESIGNED	FORMAT
METAL SEAL UHV FLANGE DN100-100 WITH EXTERNAL LIP	J. DEQUAIRE	A3
	T. CAPELLI	
	N. VALVERDE ALD	SCALE 1:1
	APPROVED	

EQUIPMENT CODE LHCACFCA HL-LAC - Deflacting (Grab) Cavities - Bare cavity
 RELEASED 2024-11-06

REFERENCES	Doc No:	INDEX	LABEL	FOR INFORMATION	QAC	SHEET
	ST1520543_02	AC				1/1

IND.	DATE	NAME	ZONE	MODIFICATION
C	2024-09-19	J. Dequaire		External Lip replaced by 4 local flat lips
B	2022-09-08	J. Dequaire		Material modification to annealed Cu OFE
A	2022-02-14	J. Dequaire		Increase tolerances on Ø100 ; Ø119.4 ; th2

- DO NOT SCRATCH THE SURFACE
 - ANNEALED

MATERIAL	INITIAL STATE	FINAL STATE
Cu OFE C10100 (H02)		

ISO GPS STANDARDS		
ISO 2768-mH	√ Ra 0.8 (✓)	ISO 13715

Unless otherwise mentioned, applicable ISO GPS standards are those prior to 2010-08-01 regardless of the drawing date
 MASS 60.6 g WERE USED Not Applicable (Last checked at 2022-03-08 17:38)

DESIGNATION	DESIGNED	FORMAT
METAL SEAL UHV FLANGE DN100-100 WITH EXTERNAL LIP	J. DEQUAIRE	A3
	T. CAPELLI	
	D. CAPATINA	SCALE 1:1
	APPROVED	

EQUIPMENT CODE LHCACFCA HL-LAC - Deflacting (Grab) Cavities - Bare cavity
 RELEASED 2024-03-11

REFERENCES	Doc No:	INDEX	LABEL	FOR INFORMATION	QAC	SHEET
	ST1520543_02	AB				1/1

IND.	DATE	NAME	ZONE	MODIFICATION
B	2022-09-08	J. Dequaire		Material modification to annealed Cu OFE
A	2022-02-14	J. Dequaire		Increase tolerances on Ø100 ; Ø119.4 ; th2

External local lip vs external lip all-round
ID 107 vs 100