



CONNECTOR SIZE  $\triangle A$

ITEM	DIM A	DIM B
30	.613	2.628
3	.613	2.629
15	.613	2.629
17	.613	2.629
19	.613	2.629
16	.613	2.630
27	.613	2.631
12	.613	2.628
14	.613	2.628
20	.613	2.628
1	.613	2.629
2	.613	2.629

SECTION A-A

- 2: VACUUM LEAK TEST  
NO LEAK SHALL BE DETECTABLE ON THE MOST SENSITIVE SCALE OF A HELIUM LEAK DETECTOR WITH A MINIMUM SENSITIVITY OF  $10^{-9}$  ATM CC/SEC
- $\triangle A$  1: BONDING PROCEDURE  
A: CLEAN BRASS PLATE AND SIDES OF CONNECTORS  
B: MIX 2 PART EPOXY THOROUGHLY BY WEIGHT OR VOLUME  
C: PLACE PLATE ON A FLAT SURFACE AND INSERT CONNECTORS. IF NECESSARY, PUT BLOCKS UNDER CONNECTORS TO SUPPORT THEM AT CORRECT HEIGHT  
D: APPLY EPOXY EVENLY TO BOTH SURFACES TO BE JOINED  
E: COAT THE INNER SURFACE AROUND THE PINS WITH KL5 SEALANT. SEALANT SHOULD COAT THE GLASS SLEEVES. DO NOT ALLOW SEALANT TO GET ON PINS

REV.	DESCRIPTION	DRAWN	DATE
A	WAS SOLDER RECTANGLE DIM. #MB-397001	REEDER	8-28-00
B	CONNECTOR CHART ADDED	C. NILA	8-28-00
C	DETAIL #3 WAS #281 SOLDER WIRE	REEDER	9-15-00
		REEDER	11-21-00

3	COML	3M SCOTCH WELD EPOXY ADHESIVE #1838 B/A GREEN 2 PART	AS
2	COML	HERMETIC D-SUB THROUGH BULKHEAD DETRONICS #DR18HS-509-720-LOCKPOST FURNISHED BY FERMLAB	RQ'D
1	MC-384960	CONNECTOR HOLDER	1
ITEM NO.	PART NO.	DESCRIPTION OR SIZE	QTY. REQ.

PARTS LIST

UNLESS OTHERWISE SPECIFIED	ORIGINATOR	R. SCHMITT	6-00
.XX	.XXX	DRAWN	REEDER
± .02	± .005	CHECKED	C. NILA
± .005	±	APPROVED	R. SCHMITT
1. BREAK ALL SHARP EDGES			
2. DO NOT SCALE DRAWG.			
3. DIMENSIONING IN ACCORD WITH ASH-114, 3M-1982			
4. ALL DIMENSIONS ARE IN INCHES.			
MATERIAL			
ME-384956 ITEM 8			
SEE PARTS LIST			

FERMI NATIONAL ACCELERATOR LABORATORY  
 UNITED STATES DEPARTMENT OF ENERGY

PPD/MECHANICAL SUPPORT  
 CDMS BREAKOUT BOX  
 CONNECTOR HOLDER SUB ASSY "A"

SCALE	DRAWING NUMBER	SHEET NO.	REV.
1/2	9213.300-MC-384961	1 OF 1	C