

NOTES:

1. THIS IS A UHV PART. A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOWDOWN IS NEEDED BEFORE WELDING. ELECTROPOLISHING FOR ROD IS NEEDED AFTER CLEANING AND BEFORE WELDING.

2. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.

3. DEVICE SHALL BE LEAK TESTED USING A MASS SPECTROMETER WITH MINIMUM SENSITIVITY FOR HELIUM OF 2X 10⁻¹⁰ STANDARD CC/SEC PER LEAK METER DIVISION, SUCH AS:

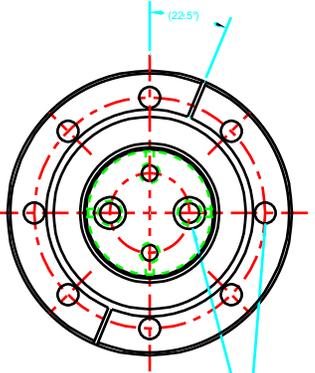
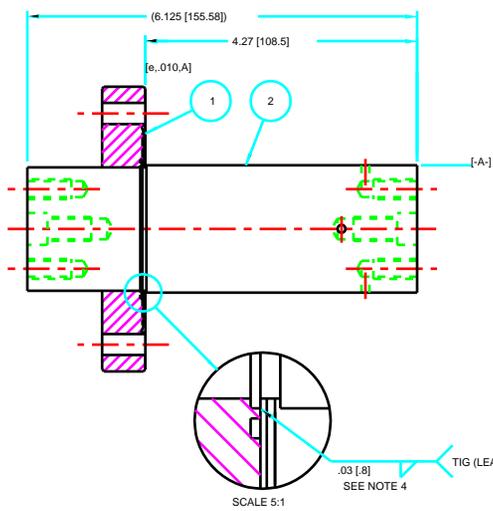
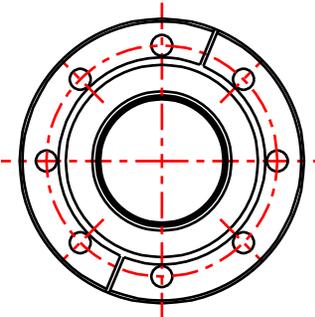
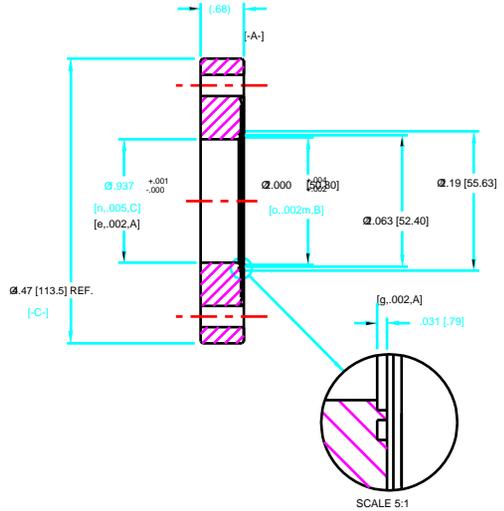
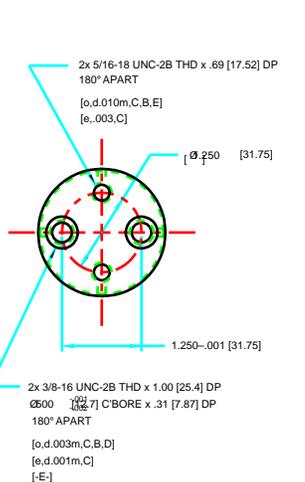
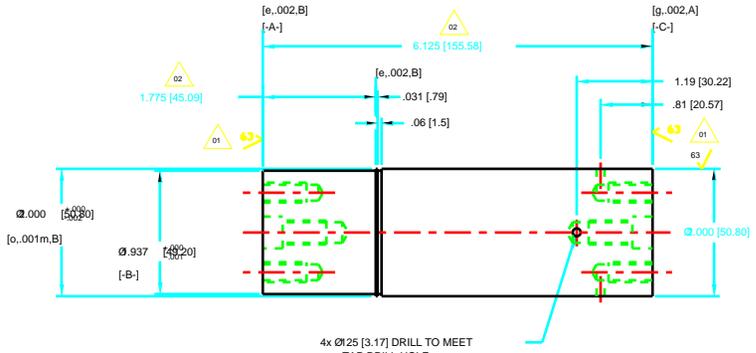
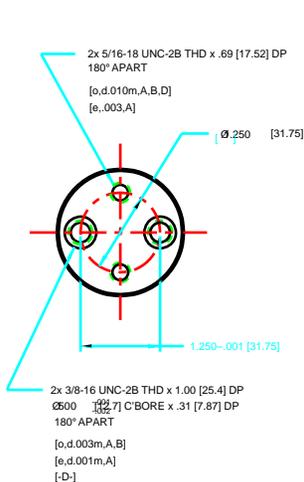
ALCATEL ASM-110TCL
 VARIAN NCR 925 OR 936
 VEECO MS-9, MS-90 OR MS-18
 DU PONT CEC 24-120B

CALIBRATION OF THE LEAK DETECTOR SENSITIVITY SHALL BE PERFORMED JUST PRIOR TO TESTING.

FINAL TEST WILL CONSIST OF SURROUNDING THE CHAMBER (BAGGING) WITH HELIUM. THE CHAMBER WILL BE REJECTED IF A 2% DEFLECTION IN THE MOST SENSITIVE RANGE OF THE LEAK DETECTOR IS SENSED WITHIN 1 MIN.

4. FLANGE HOLE HAS TO LINE UP WITH SHOULDER SCREW HOLES ON BOTH SIDES WITHIN -5°

5. ALL DIMENSIONS WITH \square ARE MILLIMETERS



DETAIL 1

REWORK EXISTING FLANGE P.N.130018 (MDC)
 NOM. O.D. 4-1/2, NOM. I.D. BLANK
 AS SHOWN ABOVE.

DETAIL 2

2	DETAIL 2	ROD	SST 304	1
1	DETAIL 1	4-1/2" NOM. O.D. FLANGE (MDC)	SST 304	1
ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY

UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES		LOG NUMBER A18169		THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY	
TOLERANCES		DRAWN BY J. G.		DATE 1/14/93	
ANGULAR		DATE 2/15/93		TITLE ADVANCED PHOTON SOURCE	
X - .03		DATE 2/15/93		DATE 2/15/93	
XXX - .01		DATE 1/6/93		DATE 1/6/93	
XXX - .005		DATE 2/10/93		DATE 2/10/93	
SURFACE ROUGHNESS		DATE 2/10/93		DATE 2/10/93	
REMOVE ALL BURRS AND BREAK SHARP EDGES TO MAX.		DATE 2/10/93		DATE 2/10/93	
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST AND B6.1		DATE 2/10/93		DATE 2/10/93	
OMBODING A TOLERANCING IN ACCORDANCE WITH LATEST AND P14.		DATE 2/10/93		DATE 2/10/93	
DO NOT SCALE DRAWING		DATE 2/10/93		DATE 2/10/93	

02	DIM. 6.125 WAS 5.000	RK			
02	DIM. 1.775 WAS 1.400	RK			
01	ADDED FINISH SYMBOL	RAF	JC	7/8/93	
01	TITLE CHANGE	RAF	JC	7/8/93	
01M		BY	CHD	DATE	