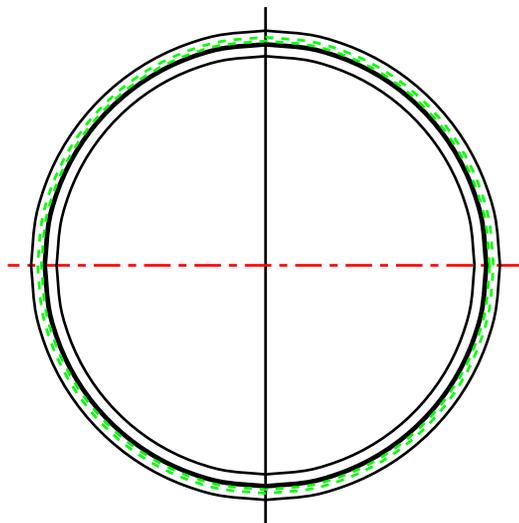


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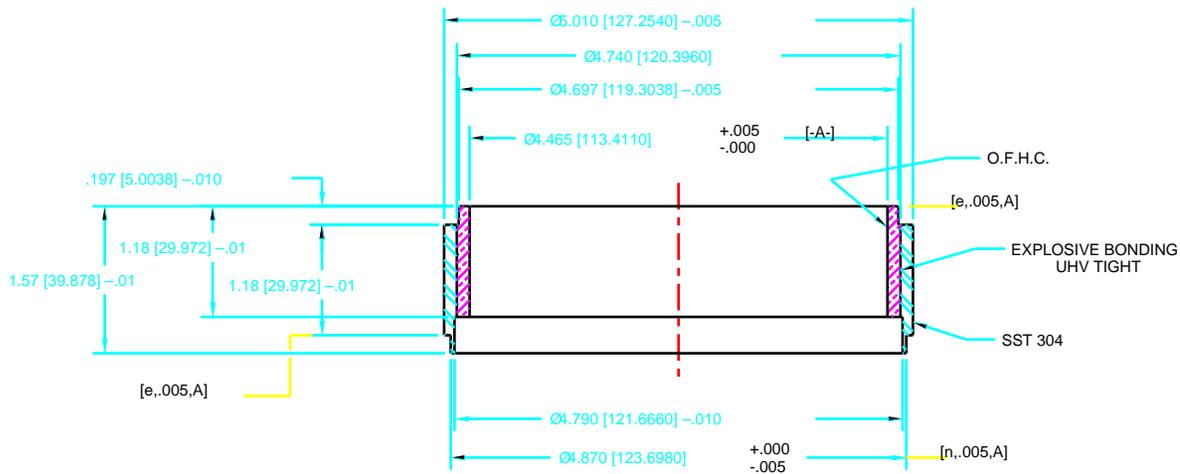
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NOTES:

- THIS IS A ULTRA-HIGH VACUUM WELDMENT ASSEMBLY (UHV).
- WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:
 - CIMCOOL 5 STAR 49
 - TRIM SOL
- WELDMENT ASSEMBLY SHALL BE LEAK TESTED USING A MASS SPECTROMETER WITH MINIMUM SENSITIVITY FOR HELIUM OF 2×10^{-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
 - DUPONT 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.
- ALL DIMENSIONS WITH [] ARE IN MILLIMETERS.
- CERTIFICATION OF ULTRASONIC TEST AND VACUUM EXAMINATION SHALL BE SIGNED BY A CONTRACTOR REPRESENTATIVE AUTHORIZED TO SIGN SUCH CERTIFICATIONS.



ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN INCHES		LOG NUMBER A11199	THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY	
DECIMALS X 0.015 XX 0.010 XXX 0.005		ANGLE 0.25		
SURFACE ROUGHNESS R_a 63		DESIGNER D. SHU	CHECKED BY T. KUZAY	DATE 8/31/93
REMOVE ALL BURRS AND BREAK SHARP EDGES TO MAX.		DESIGNER D. SHU	CHECKED BY T. KUZAY	DATE 8/31/93
SURFACE FINISH TO BE IN ACCORDANCE WITH LATEST ASH		RESPONSIBLE ENGINEER D. SHU	PROJECT MGR. T. KUZAY	DATE 8/31/93
MATERIAL O.F.H.C. / 304 SST		APPROVED/RELEASED		
DO NOT SCALE DRAWING		SCALE 1:1	SIZE C	DRAWING NUMBER P4102010104-220005-00

SYN	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				

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