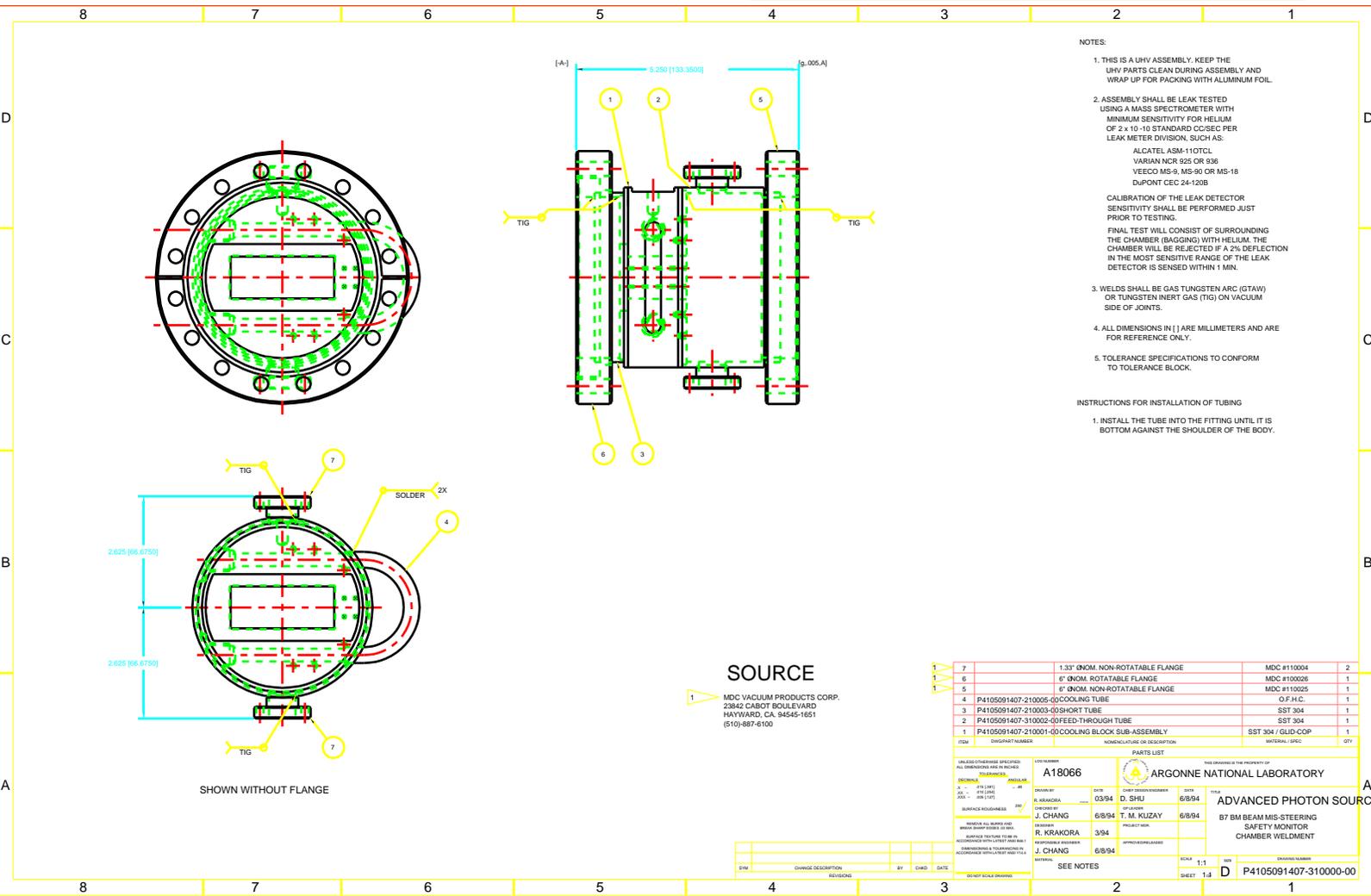


(∅) PLOT SCALE: 1=1 DWG. SCALE: 1



- NOTES:
- THIS IS A UHV ASSEMBLY. KEEP THE UHV PARTS CLEAN DURING ASSEMBLY AND WRAP UP FOR PACKING WITH ALUMINUM FOIL.
 - ASSEMBLY SHALL BE LEAK TESTED USING A MASS SPECTROMETER WITH MINIMUM SENSITIVITY FOR HELIUM OF 2 x 10⁻¹⁰ STANDARD CC/SEC PER LEAK METER DIVISION, SUCH AS:
ALCATEL ASM-110TCL
VARIAN MCR 925 OR 936
VEECO MS-8, MS-90 OR MS-18
DUPOINT 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.
 - WELDS SHALL BE GAS TUNGSTEN ARC (GTAW) OR TUNGSTEN INERT GAS (TIG) ON VACUUM SIDE OF JOINTS.
 - ALL DIMENSIONS IN [] ARE MILLIMETERS AND ARE FOR REFERENCE ONLY.
 - TOLERANCE SPECIFICATIONS TO CONFORM TO TOLERANCE BLOCK.
- INSTRUCTIONS FOR INSTALLATION OF TUBING
- INSTALL THE TUBE INTO THE FITTING UNTIL IT IS BOTTOM AGAINST THE SHOULDER OF THE BODY.

SOURCE
 1 MDC VACUUM PRODUCTS CORP.
 23842 CABOT BOULEVARD
 HAYWARD, CA. 94545-1651
 (510)-887-8100

ITEM	DISPART NUMBER	DESCRIPTION	MATERIAL / SPEC	QTY
7		1.33" ØNOM. NON-ROTATABLE FLANGE	MDC #110004	2
6		6" ØNOM. ROTATABLE FLANGE	MDC #1100026	1
5		6" ØNOM. NON-ROTATABLE FLANGE	MDC #110025	1
4	P4105091407-210005-00	COOLING TUBE	O.F.H.C.	1
3	P4105091407-210003-00	SHORT TUBE	SST 304	1
2	P4105091407-210002-00	FEED-THROUGH TUBE	SST 304	1
1	P4105091407-210001-00	COOLING BLOCK SUB-ASSEMBLY	SST 304 / GLID-COP	1

UNLESS OTHERWISE SPECIFIED:
 ALL DIMENSIONS ARE IN INCHES
 (DIMENSIONS IN MILLIMETERS)

DESIGNED BY: J. CHANG DATE: 03/94
 CHECKED BY: R. KRAKDRA DATE: 6/8/94
 APPROVED BY: J. CHANG DATE: 6/8/94

ARGONNE NATIONAL LABORATORY
 ADVANCED PHOTON SOURCE
 B7 BM BEAM M/S-STEERING
 SAFETY MONITOR
 CHAMBER WELDMENT

SEE NOTES

FORM 1-1
 SHEET 1-1

REVISED BY: D DATE: 6/8/94
 PART NUMBER: P4105091407-310000-00