

(∅) PLOT SCALE: 1=1 DWG. SCALE: 1

8 7 6 5 4 3 2 1

D

D

C

C

B

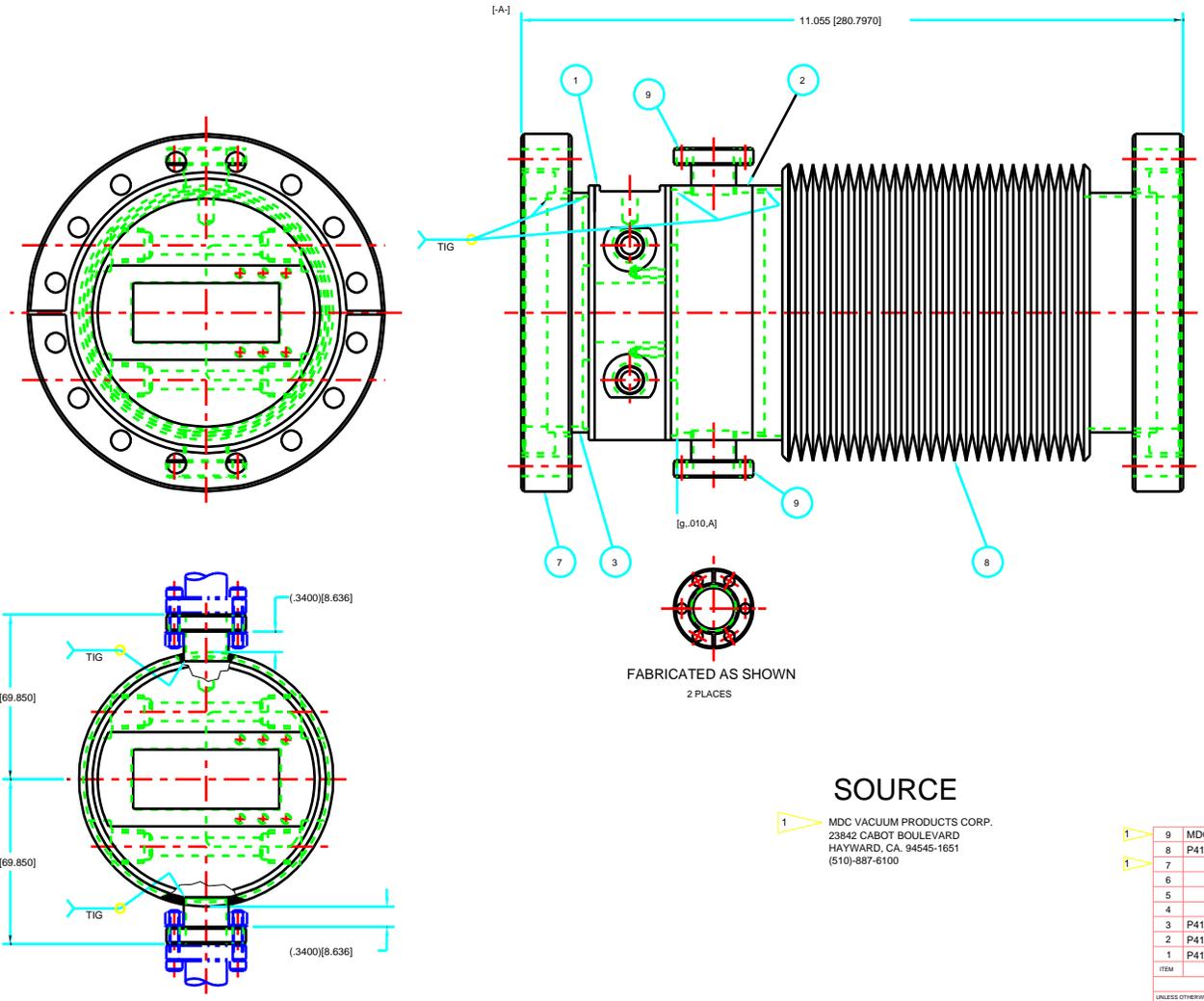
B

A

A

NOTES:

1. THIS IS A UHV ASSEMBLY. KEEP THE UHV PARTS CLEAN DURING ASSEMBLY AND WRAP UP FOR PACKING WITH ALUMINUM FOIL.
2. THE ASSEMBLY SHALL BE LEAK TESTED USING A MASS SPECTROMETER WITH MINIMUM SENSITIVITY FOR HELIUM OF 2 x 10<sup>-10</sup> STANDARD CC/SEC PER LEAK METER DIVISION, SUCH AS:  
ALCATEL ASM-11OTCL  
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.
3. WELDS SHALL BE GAS TUNGSTEN ARC (GTAW) OR TUNGSTEN INERT GAS (TIG) ON VACUUM SIDE OF JOINTS.
4. ALL DIMENSIONS IN [ ] ARE MILLIMETERS AND ARE FOR REFERENCE ONLY.
5. TOLERANCE SPECIFICATIONS TO CONFORM TO TOLERANCE BLOCK.



FABRICATED AS SHOWN  
2 PLACES

SOURCE

MDC VACUUM PRODUCTS CORP.  
23842 CABOT BOULEVARD  
HAYWARD, CA. 94545-1651  
(510)-887-6100

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
9	MDC #401000 (MOD.)	1.33" ∅ HALF NIPPLE (CUT TO .78" O.A. LG.)	SST 304	2
8	P4105091407-510002-00	BELLOWS AND FLANGE	SST347 & SST 304	1
7	MDC #100026	6" ∅ NOM. ROTATABLE FLANGE	SST 304	1
6				
5				
4				
3	P4105091407-210003-00	SHORT TUBE	SST 304	1
2	P4105091407-210002-01	FEED-THROUGH TUBE	SST 304	1
1	P4105091407-510001-00	COOLING BLOCK	SST 304 / GLID-COP	1

UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES TOLERANCES: DECIMAL: .01 ANGULAR: .25 SURFACE ROUGHNESS: 125 REMOVE ALL BURRS AND BREAK SHARP EDGES TO R10. SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST AND 98.1 DIMENSIONS & TOLERANCES IN ACCORDANCE WITH LATEST AND 114.5

LOG NUMBER: **A2572700**

THIS DRAWING IS THE PROPERTY OF: **ARGONNE NATIONAL LABORATORY**

ADVANCED PHOTON SOURCE  
B7 - 50 ID MASK  
WITH BM BPM  
CHAMBER WELDMENT

DRAWN BY: corcuera	DATE: 11/18/99	CHIEF DESIGN ENGINEER: SHU	DATE: 11/18/99
CHECKED BY: J. CHANG	DATE: 2/18/97	DESIGNER: CHANG/ CORCUERA	DATE: 2/20/97
RESPONSIBLE ENGINEER: J. CHANG	DATE: 2/18/97	APPROVED/RELEASED:	

SCALE: 1:1 SHEET: 1 of 1 DRAWING NUMBER: P4105091407-510000-00

8 7 6 5 4 3 2 1