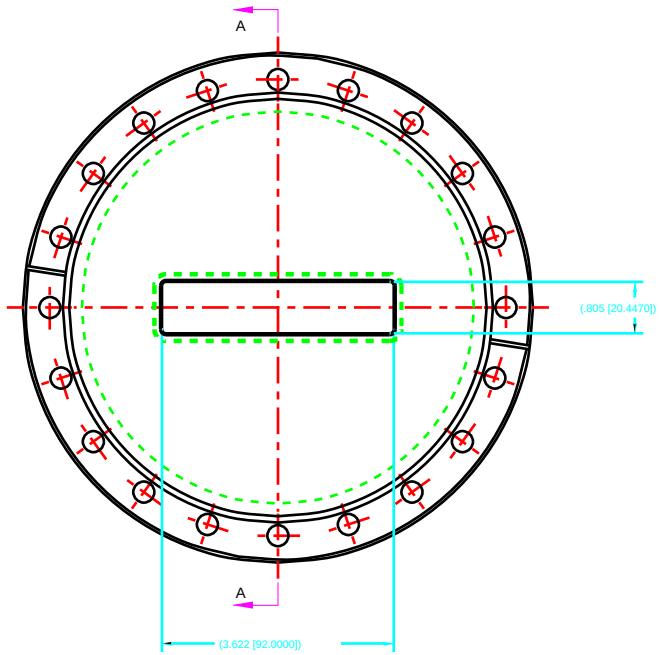

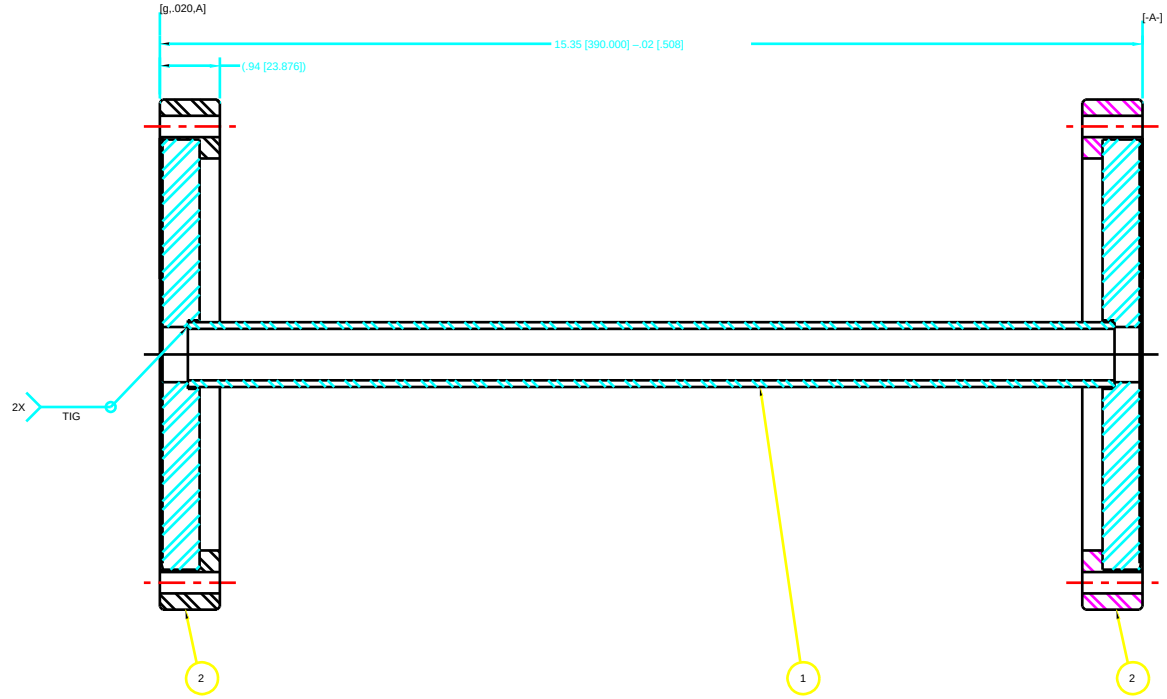

SECTION A-A

NOTES:

1. MODIFY FROM PURCHASED PART:
ROTATABLE FLANGE; MDC #100030

2. CHAMBER ASSEMBLY SHALL BE LEAK TESTED USING A MASS SPECTROMETER WITH MINIMUM SENSITIVITY FOR HELIUM OF 2 x 10 STANDARD CC/SEC PER LEAK METER DIVISION, SUCH AS:
ALCATEL SAM-11OTCL
DuPONT CEC 24-120B
VARIAN MS-9, MS-90 OR MS-18

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

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

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

4. DIMENSIONS IN [ ] ARE MILLIMETERS AND FOR REFERENCE ONLY.

PARTS LIST

ITEM	DWG. & ELECTRONIC FILE No.	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
2	P4102020102-210102-00	K2 END FLANGE	SST	2
1	P4102020102-210101-00	K2 RECTANGULAR TUBING	SST	1

SYM	CHANGE DESCRIPTION	BY	CHKD	DATE

REVISIONS

UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES
TOLERANCES
DECIMALS: .X ± .015; .XX ± .010; .XXX ± .005
ANGULAR ± 2s
SURFACE ROUGHNESS 125
REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX.
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1
DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5
DO NOT SCALE DRAWING

ELECTRONIC FILE NUMBER: A09901

THIS DRAWING IS THE PROPERTY OF
ARGONNE NATIONAL LABORATORY

DRAWN BY: RICK KRAKORA	DATE: 4/93	CHIEF DESIGN ENGINEER	DATE
CHECKED BY	DATE	GP LEADER	DATE
DESIGNER: RICK KRAKORA	DATE: 4/93	PROJECT MGR	DATE
RESPONSIBLE ENGINEER	DATE	APPROVED/RELEASED	DATE

TITLE
ADVANCED PHOTON SOURCE
K2 BM FIRST COLLIMATOR
VACUUM CHAMBER
WELDMENT ASSEMBLY

MATERIAL: SEE B.O.M.
SCALE: 1=1
SHEET: 1 OF 1
SIZE: D
DRAWING NUMBER: P4102020102-210100-00

PLOT SCALE: 1=1