



1. THIS IS A ULTRA - HIGH - VACUUM CHAMBER (UHV)

SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:

IS NEEDED BEFORE WELDING. PRIOR TO THROUGH A INVOLVING DEGREASING, NITROGEN BLOW DOWN. THE VACUUM SIDE SURFACE ROUGHNESS, OF THE CHAMBER, SHALL BE BETTER THAN 63 MICROINCHES RMS AFTER ELECTROPOLISHING.

4. WELDS SHALL BE GAS TUNGSTEN ARC (GTAW) OR

5. VACUUM CHAMBER SHALL BE LEAK TESTED

OF 2 X 10⁻¹⁰ STANDARD CC/SEC PER

SENSITIVITY SHALL BE PERFORMED JUST

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

6. KEEP THE ASSEMBLY CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.

7. DIMENSIONS IN [] ARE MILLIMETERS AND FOR REF. ONLY

8. MACHINE FINISH FOR ALL VACUUM SURFACES BEFORE ELECTROPOLISHING

9. ALL MATERIAL IS 304 STAINLESS STEEL UNLESS OTHERWISE SPECIFIED

MAKE FROM MDC'S 6" O.D. ROTATABLE FLANGE
CAT. # 100025

NO.	DATE	BY	CHKD	DATE	DESCRIPTION
1	11/95	RAF		11/95	DIM. 1.017 WAS .886 INSIDE
1	11/95	RAF		11/95	DIM. 780 WAS .652 INSIDE

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES TOLERANCES: DECIMALS .015 (+/-) XX .005 (+/-) XXX .010 (+/-)		LOG NUMBER A2360201	PARTS LIST THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY	
SURFACE ROUGHNESS REMOVE ALL BURRS AND BREAK SHARP EDGES TO MAX. SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ARG/MS-1 DIMENSIONS & TOLERANCING IN ACCORDANCE WITH LATEST ARG/MS-1		DESIGNER BARRAZA/FUHRMANN	DATE 10/31/95	PROJECT MGR. M. KUZAY
DO NOT SCALE DRAWING		SCALE 1:1	SHEET 1 of 1	DRAWING NUMBER P4105090403-210101-01

ADVANCED PHOTON SOURCE
K3-21
2-ID-A
1ST COLLIMATOR ASSEMBLY
VACUUM CHAMBER
FLANGE