



NOTES:

- WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:
A) CIMCOOL 5 STAR 49
B) TRIM SOL
- BONDING ASSEMBLY SHALL BE LEAK TESTED USING A MASS SPECTROMETER WITH MINIMUM SENSITIVITY FOR HELIUM OF 2X 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
 Du PONT CEC 24-120B

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

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

- CERTIFICATION OF ULTRA SONIC TEST AND VACUUM EXAMINATION SHALL BE SIGNED BY A CONTRACTOR REPRESENTATIVE TO SIGN SUCH CERTIFICATION
- KEEP THE ASSEMBLY CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
- ALL SURFACE FINISHES TO BE ✓ 63
- DIMENSIONS IN [] ARE MILLIMETERS

SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES		LOG NUMBER A10417		
TOLERANCES		THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY		
DECIMALS	ANGULAR	DRAWN BY MUSCIA		
.X - .03 [0.7620]	- .25	DATE	CHIEF DESIGN ENGINEER	DATE
.XX - .01 [0.25]		3/17/93		
.XXX - .005 [0.127]		CHECKED BY	GP LEADER	
SURFACE ROUGHNESS	63 ✓	DESIGNER	PROJECT MGR.	
REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX.		MUSCIA	4/27/93	
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1		RESPONSIBLE ENGINEER	APPROVED/RELEASED	
DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5		MATERIAL	SEE ABOVE	
SCALE 1:1		SIZE	DRAWING NUMBER	
SHEET 1 of 1		C	P4102010101-210008-00	