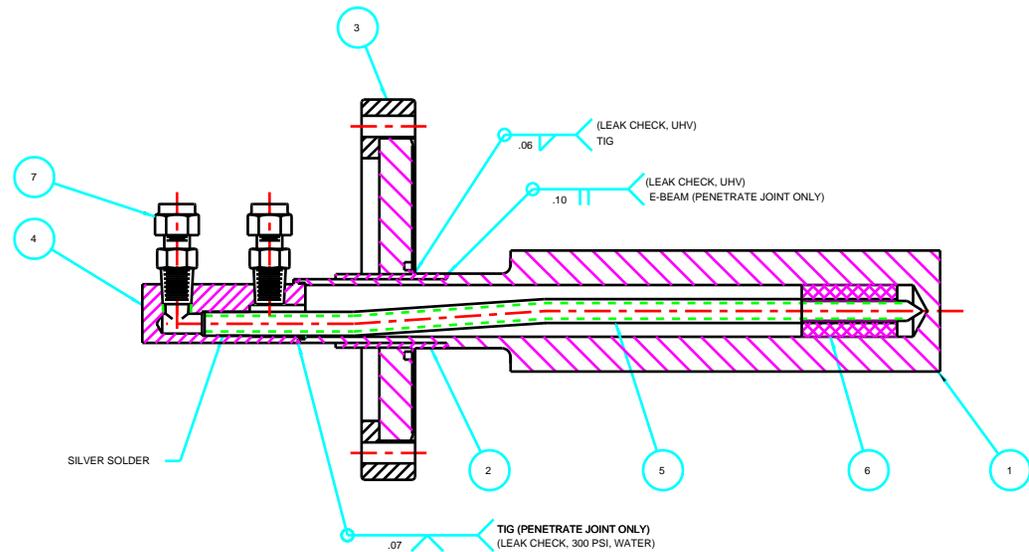
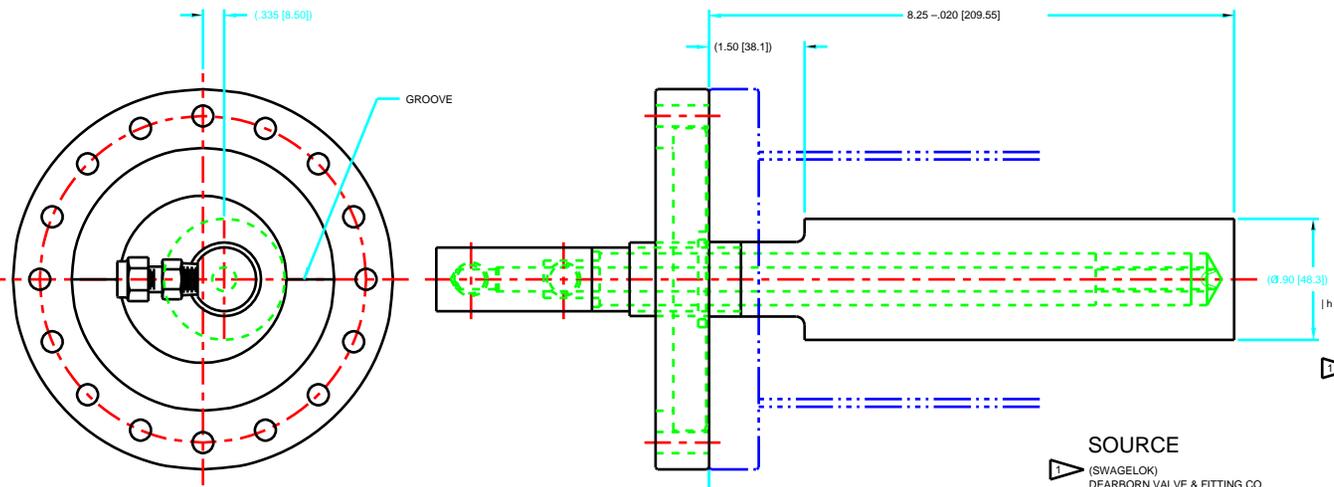


(P) PLOT SCALE: 1=1 DWG. SCALE: 1



- NOTES:
- THIS IS USED FOR AN ULTRA - HIGH VACUUM CHAMBER (UHV).
 - THIS IS A UHV PART, ELECTROPOLISHING IS NEEDED BEFORE WELDING. PRIOR TO ELECTROPOLISHING, THE PART NEEDS TO GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOW DOWN.
 - KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
 - DEVICE 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 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.
 - ALL DIMENSIONS WITH ARE MILLIMETERS
 - BEFORE ASSEMBLE SWAGelok MALE CONNECTORS, USE SILVER GOOP TREAD LUBRICANT FROM SWAGelok CO. TO ALLOW CONNECTORS TO BE DISASSEMBLED WITHOUT SPECIAL TOOLS.



SOURCE
 (SWAGelok)
 DEARBORN VALVE & FITTING CO.
 1540 N. OLD RAND ROAD
 P.O. BOX 847
 WAUCONDA, IL, 60084-0847
 708-526-6900
 FAX: 708-526-1221

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
7	SS-600-1-4	MALE CONNECTOR (SWAGelok)	SST 316	2
6	P4102020103-210008	P3-20 COPPER MESH	COPPER, 75% Ø	1
5	P4105091009-400004	M9-40 INNER TUBE	OFHC COPPER	1
4	P4102020103-210009	P3-20 ENTRANCE & EXIT PORTS	MONEL 400	1
3	P4105091009-400003	M9-40 6" ROTATABLE FLANGE (MDC)	S.S. 304	1
2	P4105091009-400002	M9-40 INTERFACE SST TUBE	S.S. 304	1
1	P4105091009-400001	M9-40 COOLING BLOCK & TUBE	OFHC COPPER	1

UNLESS OTHERWISE SPECIFIED:
 ALL DIMENSIONS ARE IN INCHES
 DECIMALS ANGULAR
 SURFACE ROUGHNESS 125

REWORK ALL SURFS AND BREAK SHARP EDGES (R 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

LOG NUMBER: **A2458000**

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ADVANCED PHOTON SOURCE

M9-40
 FIXED MASK ASSEMBLY
 FOR SRICAT 2-ID

SCALE: 1:1
 SHEET: 1 of 1
 DRAWING NUMBER: P4105091009-400000-00

BY	CHKD	DATE	REVISIONS