



- NOTES:
- THIS IS A ULTRA - HIGH - VACUUM ASSEMBLY (UHV) KEEP THE UHV PARTS CLEAN DURING ASSEMBLY, AND AND WRAP UP FOR PACKING WITH ALUMINUM FOIL
 - WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:
 - CIMCOOL 5 STAR 49
 - TRIM SOL
 - THIS IS A UHV PART, ELECTROPOLISHING IS NEEDED BEFORE WELDING. PRIOR TO ELECTROPOLISHING, THE PART MUST GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOW DOWN.
 - THE 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
 - DJ 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.
 - DIMENSIONS IN [] ARE MILLIMETERS AND FOR REF. ONLY

REF. SOURCE
 MCD VACUUM PRODUCTS CORP.
 23842 CABOT BLVD.
 HAYWARD, CA 94545-1651
 1-800-443-8817
 FAX: 510-887-0626

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
3	#110015	3.38 O.D. FLANGE (NONROTATABLE BLANK)	SST	1
2		1.75 O.D. X .12 WALL X 1.71 LG.	SST	1
1	#110025	6.00 O.D. FLANGE (NONROTATABLE BLANK)	SST	1

UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN INCHES		TOLERANCES:		SURFACE FINISH:	
DECIMALS	ANGULAR	DECIMALS	ANGULAR	RA	SPR
.125	.005	.010	.005	125	125
.001	.001	.001	.001		

LOG NUMBER		DATE		DATE		DATE	
A2188700		12/15/95	D. SHU	3/5/95			
DRAWN BY	DATE	DESIGNED BY	DATE	CHECKED BY	DATE	APPROVED BY	DATE
W. YUN	2/23/95	T.M. KUZAY	3/6/95				
DESIGNER	DATE	PROJECT MGR.	DATE	APPROVED/RELEASED	DATE		
D. SHU/FUHRMANN							
RESPONSIBLE ENGINEER	DATE						
D. SHU	3/5/95						

REV	CHANGE DESCRIPTION	BY	CHKD	DATE

SCALE	SHEET	SIZE	DRAWING NUMBER
1:1	1 of 1	D	P4105091202-300201-00