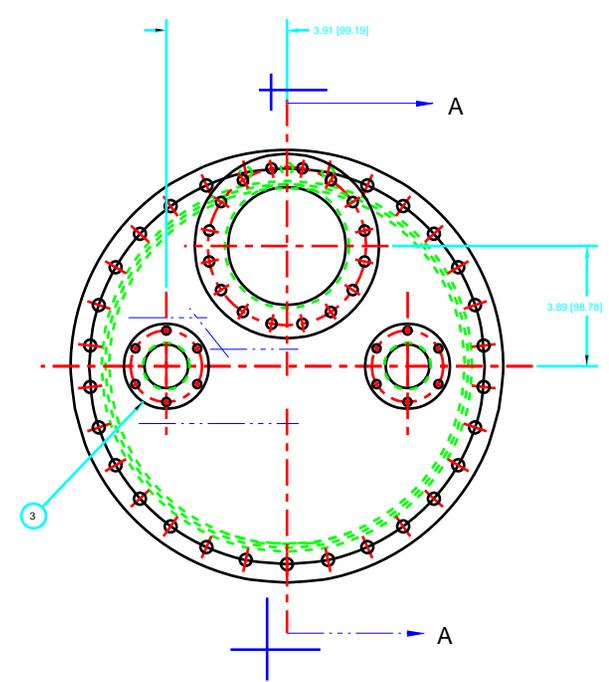


SECTION A-A



- 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
 - ALL WELDING FOR VACUUM SEALS ARE TUNGSTEN INERT GAS (TIG) WELDS, VACUUM SIDE. STRESS RELIEF AFTER WELDING.
 - THIS IS A UHV ASSEMBLY, ELECTROPOLISHING IS NEEDED BEFORE WELDING. PRIOR TO ELECTROPOLISHING, THE ASSEMBLY MUST GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOW DOWN.
 - ASSEMBLY SHALL BE LEAK TESTED USING A MASS SPECTROMETER WITH MINIMUM SENSITIVITY FOR HELIUM OF 2 X 10⁻¹⁰ STANDARD CC/SEC PER LEAK METER DIVISION, SUCH AS
ALCATEL SAM-110TCL
DU PONT 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 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.
 - KEEP THE ASSEMBLY CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
 - DIMENSIONS IN [] ARE MILLIMETERS AND FOR REF. ONLY

MDC VACUUM PRODUCTS CORP.
23842 CABOT BLVD.
HAYWARD, CA 94545-1651
1-800-443-8817
FAX: 1-501-887-0626

REV	DESCRIPTION	DATE	BY	CHKD	DATE	MATERIAL	QTY
5	#480010	4.00 O.D. X .083 WALL TUBING				SST	1
4	#480006	1.50 O.D. X .065 WALL TUBING				SST	2
3	#110014	2 3/4 O.D. NONROTATABLE VACUUM FLANGE				SST	2
2	#110037	14" O.D. NR VACUUM FLANGE BLANK				SST	1
1	#110026	6" O.D. NONROTATABLE VACUUM FLANGE				SST	1

REV	DESCRIPTION	DATE	BY	CHKD	DATE	MATERIAL	QTY
1	STAINLESS STEEL 304 OR 304L						

A2469300 5/22/96 FUHRMANN 7/96 C.BENSON 7/96 FUHRMANN 7/96 C.BENSON 7/96		ARGONNE NATIONAL LABORATORY 5/22/96 D.SHU 7/96 T.M.KUZAY 7/96 MULLICK 7/96 MULLICK 7/96		Y5-20 MIRROR TANK ASSEMBLY FOR 1-BM-A RIGHT END FLANGE ASSEMBLY
--	--	---	--	---