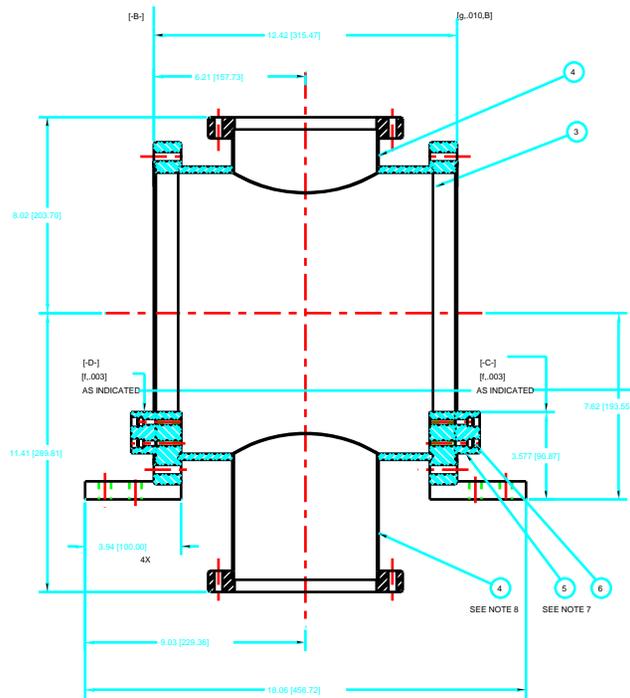
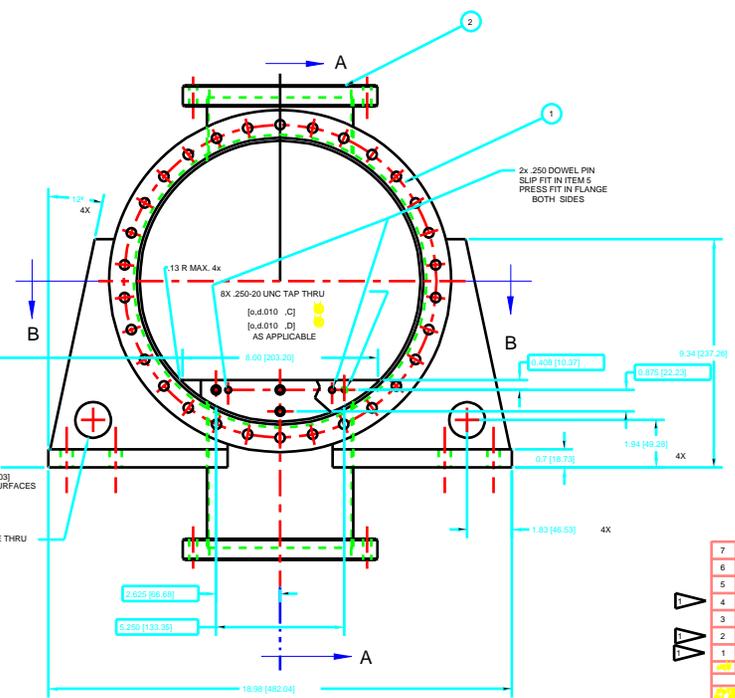


SECTION B-B



SECTION A-A



- NOTES:
1. 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
  2. ALL WELDING FOR VACUUM SEALS ARE TUNGSTEN INERT GAS (TIG) WELDS. VACUUM SIDE. STRESS RELIEF AFTER WELDING.
  3. 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.
  4. ASSEMBLY SHALL BE LEAK TESTED USING A MASS SPECTROMETER WITH MINIMUM SENSITIVITY FOR HELIUM OF  $2 \times 10^{-10}$  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.
  5. KEEP THE ASSEMBLY CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
  6. DIMENSIONS IN [ ] ARE MILLIMETERS AND FOR REF. ONLY
  7. MARK PLATES TO MATCH MOUNTING SIDE.
  8. THIS PORT SUPPORTS 400 LBS VERTICAL LOAD.

MDC VACUUM PRODUCTS CORP.  
28942 CABOT BLVD.  
HAYWARD, CA. 94545-1651  
1-800-443-8817  
FAX: 1-501-887-0626

ITEM	DESCRIPTION	QUANTITY	UNIT	REMARKS
7	Ø50 X .75 LG DOWEL PIN	SST	4	
8	250-20 X 1.00 SOG HD CAP SCR.	SST, SILVER PLATED	8	
5	P4105091207-300101	PLATE BRACKET	SST	2
4	ST600	6" O.D. X .12 WALL TUBING	SST	2
3	#110031	12" O.D. X .25 WALL TUBING	SST	1
2	#110031	8" O.D. NONROTATABLE VACUUM FLANGE	SST	2
1	#110037	14" O.D. NONROTATABLE VACUUM FLANGE	SST	2

PARTS LIST  
 A2418900  
 FURHMANN 38/96  
 BENSON/STURM 400/06  
 D.SHU/FURHMANN 96  
 D. SHU 5/96  
 STAINLESS STEEL 304 OR 304L  
 1.2  
 1.1  
 P4105091207-300001-00