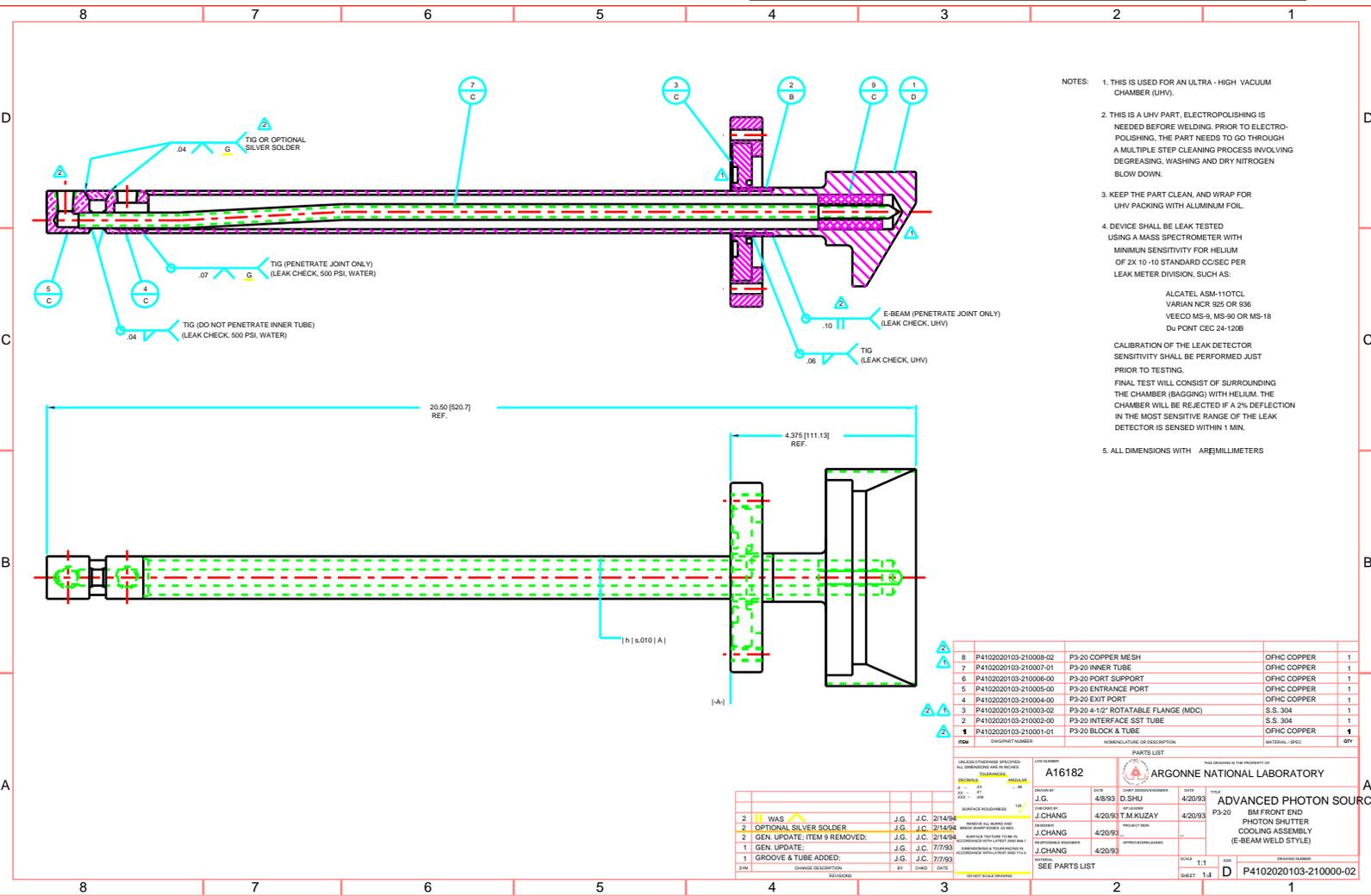


(D) PLOT SCALE: 1=1 DWG. SCALE: 1 A16182



- NOTES:
1. THIS IS USED FOR AN ULTRA - HIGH VACUUM CHAMBER (UHV).
 2. 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.
 3. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
 4. 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-11OTCL
 - 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.
 5. ALL DIMENSIONS WITH ARE[MILLIMETERS]
- 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.

ITEM	DISPART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL - SPEC	QTY
8	P4102020103-210009-02	P3-20 COPPER MESH	OFHC COPPER	1
7	P4102020103-210007-01	P3-20 INNER TUBE	OFHC COPPER	1
6	P4102020103-210006-00	P3-20 PORT SUPPORT	OFHC COPPER	1
5	P4102020103-210005-00	P3-20 ENTRANCE PORT	OFHC COPPER	1
4	P4102020103-210004-00	P3-20 EXIT PORT	OFHC COPPER	1
3	P4102020103-210003-02	P3-20 4-1/2" ROTATABLE FLANGE (MDC)	S.S. 304	1
2	P4102020103-210002-00	P3-20 INTERFACE SST TUBE	S.S. 304	1
1	P4102020103-210001-01	P3-20 BLOCK & TUBE	OFHC COPPER	1

DATE	BY	CHKD	DATE	DESCRIPTION
2/14/94	J.G. J.C.			2 HIAS
2/14/94	J.G. J.C.			2 OPTIONAL SILVER SOLDER
2/14/94	J.G. J.C.			2 GEN. UPDATE: ITEM 9 REMOVED;
7/7/93	J.G. J.C.			1 GEN. UPDATE:
7/7/93	J.G. J.C.			1 GROOVE & TUBE ADDED;

DATE	BY	CHKD	DATE	DESCRIPTION
4/20/93	J.G. J.C.			1 GEN. UPDATE: ITEM 9 REMOVED;
4/20/93	J.G. J.C.			1 GEN. UPDATE:
4/20/93	J.G. J.C.			1 GROOVE & TUBE ADDED;

A

1