



NOTES:

1. THIS IS A UHV ASSEMBLY. KEEP THE UHV PARTS CLEAN DURING ASSEMBLY AND WRAP UP FOR UHV PACKING WITH ALUMINUM FOIL.
2. 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-1107C/L
 - VARIAN NCR-925 OR 926
 - VEECO HS-9, HS-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.

3. ALL DIMENSIONS WITH [] ARE MILLIMETERS
4. ALL DIMENSIONS IN BRACKETS, EITHER () OR [], IN THIS DRAWING AND SUBV-DRAWINGS ARE FOR REFERENCE ONLY.

| 3 | SOCKET HEAD CAP SCREW 250-20 UNC-3A x .63 LG. | SST 304 SILVER PLATED | 4 | | | | | | | | | | | | | | | | | | | | |
|---|--|--------------------------|----------|------------|-------------|------|----|------|----|----------------|---------|----------|------------|----|---------------|---------|----------|------------|----|---------------|---------|----------|------------|
| 2 | P4105090904-210100 P4 CHAMBER WELLMENT | SST 304 | 1 | | | | | | | | | | | | | | | | | | | | |
| 1 | P4105090904-210001 P4 ALIGNMENT PLATE | SST 304 | 1 | | | | | | | | | | | | | | | | | | | | |
| <p>REVISIONS</p> <table border="1"> <tr> <th>NO.</th> <th>DESCRIPTION</th> <th>DATE</th> <th>BY</th> <th>CHKD</th> </tr> <tr> <td>01</td> <td>ISSUED FOR FAB</td> <td>3/29/94</td> <td>J. CHANG</td> <td>R. KRAKORA</td> </tr> <tr> <td>02</td> <td>REVISION 2015</td> <td>3/29/94</td> <td>J. CHANG</td> <td>R. KRAKORA</td> </tr> <tr> <td>03</td> <td>REVISION 2016</td> <td>3/29/94</td> <td>J. CHANG</td> <td>R. KRAKORA</td> </tr> </table> | | | | NO. | DESCRIPTION | DATE | BY | CHKD | 01 | ISSUED FOR FAB | 3/29/94 | J. CHANG | R. KRAKORA | 02 | REVISION 2015 | 3/29/94 | J. CHANG | R. KRAKORA | 03 | REVISION 2016 | 3/29/94 | J. CHANG | R. KRAKORA |
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| <p>ARGONNE NATIONAL LABORATORY</p> <p>ADVANCED PHOTON SOURCE</p> <p>P4 I.D. W/M/S INTEGRAL SHUTTER CHAMBER ASSEMBLY</p> | | | | | | | | | | | | | | | | | | | | | | | |
| SEE B.O.M. | | E P4105090904-210000 02 | | | | | | | | | | | | | | | | | | | | | |