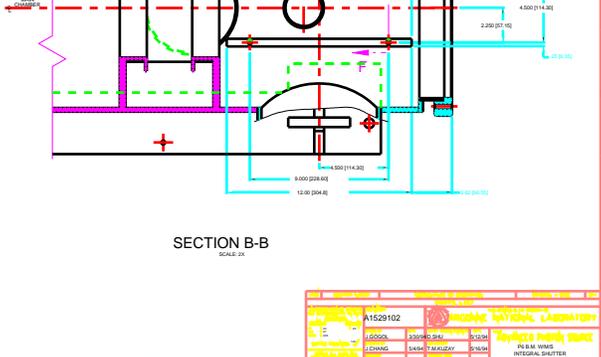
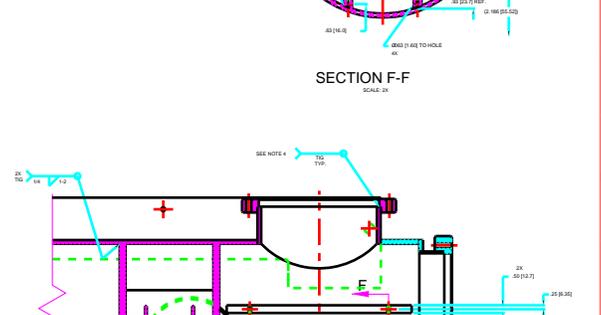
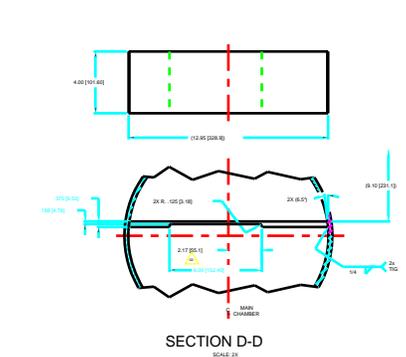
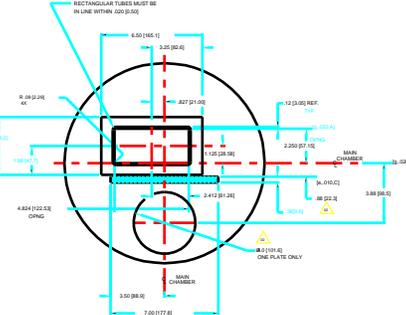
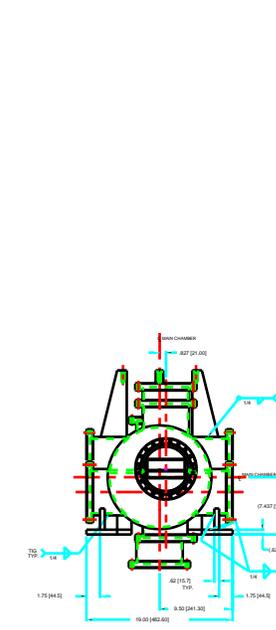


- NOTE:
- THIS IS A ULTRA-HIGH VACUUM CHAMBER (UHV).
 - WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:
 - ALCOBOND 5 STAR 49
 - TRIM SOL
 - ELECTROPOISHING IS NEEDED BEFORE WELDING. PRIOR TO ELECTROPOISHING, THE CHAMBER NEEDS TO GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOW DOWN. THE CHAMBER VACUUM SIDE SURFACE ROUGHNESS SHALL BE BETTER THAN 63 MICROMETER RMS AFTER ELECTROPOISHING.
 - WELD SHALL BE GAS TUNGSTEN ARC (GTAW) OR TUNGSTEN NERT GAS (TIG) ON VACUUM SIDE OF JOINTS.

ALCATEL ASMA HOTEL
VARANACI SEC 06-08
VELOCRES 65-02 OR 65-19
DUPONT CEC 24-028
 - VACUUM CHAMBER SHALL BE LEAK TESTED USING A MASS SPECTROMETER WITH MINIMUM SENSITIVITY FOR HELIUM OF 2.1E-10 STANDARD CCSE/PER LEAK METER DIVISION SLASH 40.
 - ALL FLANGES ARE TO BE PERPENDICULAR TO TANK AXIS (Z).
 - ALL DIMENSIONS IN [] ARE MILLIMETERS AND ARE FOR REFERENCE ONLY.
 - MACHINE \overline{R} FOR ALL VACUUM SURFACE BEFORE ELECTROPOISHING.
 - ALL MATERIAL IS 304 SST UNLESS OTHERWISE SPECIFIED.

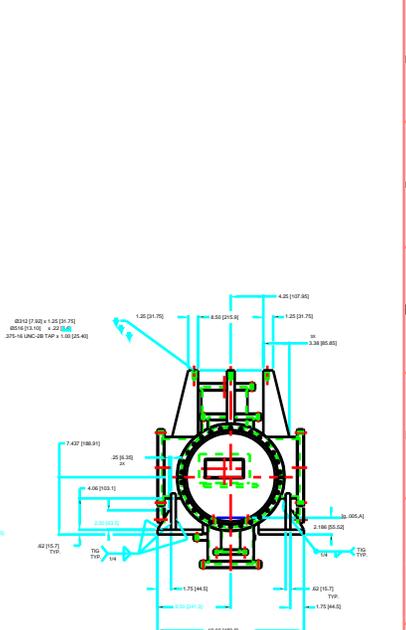
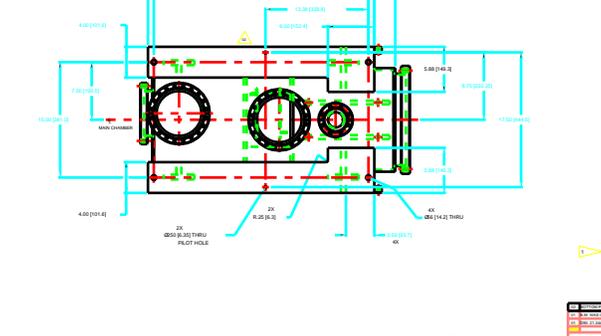
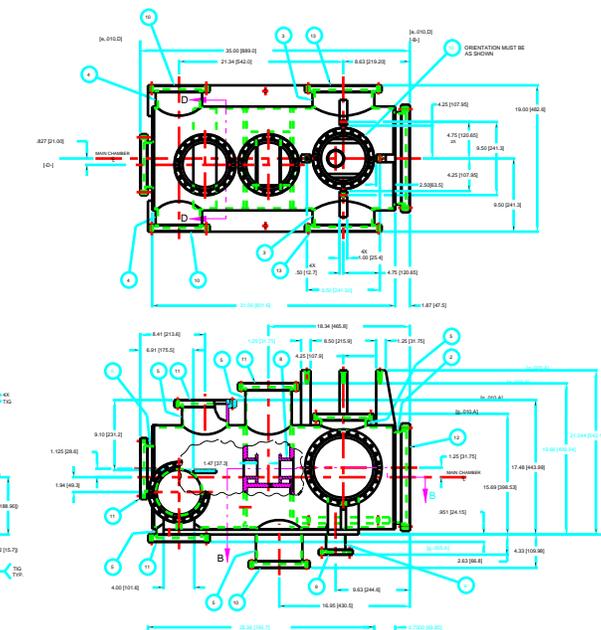


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SOURCE

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