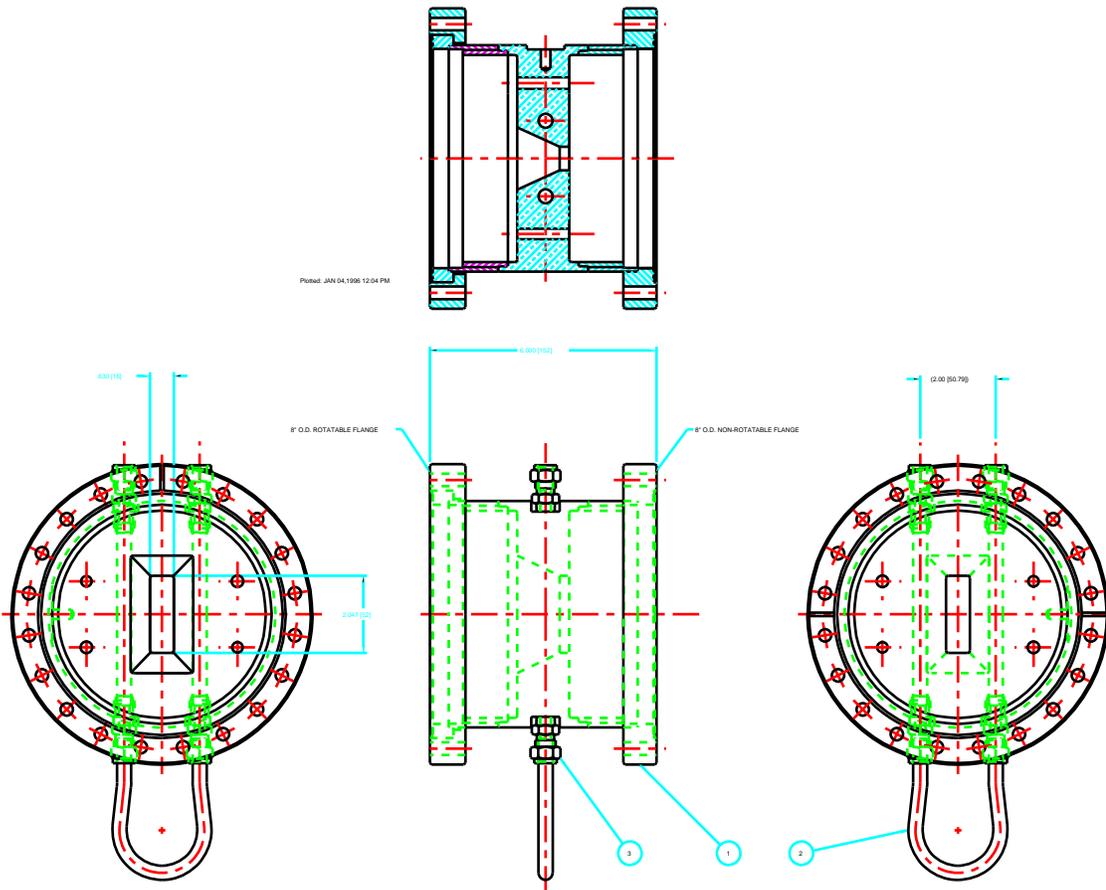


- NOTES:
- THIS IS A UHV ASSEMBLY. KEEP THE UHV PARTS CLEAN DURING ASSEMBLY AND WRAP UP FOR PACKING WITH ALUMINUM FOIL.
 - DEVICE SHALL BE LEAK TESTED USING A MASS SPECTROMETER WITH MINIMUM SENSITIVITY FOR HELIUM OF 2 x 10⁻¹⁰ STANDARD CC/SEC PER LEAK METER DIVISION, SUCH AS:
 - ALCATEL ASM1107DL
 - VARIAN NCR 325 OR 338
 - VEECO MSA 165/90 OR MS-18
 - DUPONT CEC 24-1028
 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.
 - BEFORE ASSEMBLY OF SWAGelok MALE CONNECTORS, USE SILVER COOP THREAD LUBRICANT (FROM SWAGelok CO.) TO ALLOW CONNECTOR TO BE DISASSEMBLED WITHOUT SPECIAL TOOLS.
 - ALL DIMENSIONS WITH () ARE MILLIMETERS.
 - WATER PRESSURE TEST AT 500 PSI AFTER ASSEMBLING.
 - ALL DIMENSIONS IN BRACKETS, EITHER () OR (), IN THIS DRAWING AND SUB-TIER DRAWINGS ARE FOR REFERENCE ONLY.

- INSTRUCTIONS FOR INSTALLATION OF TUBING
- INSTALL THE TUBE INTO THE FITTING UNTIL IT IS BOTTOM AGAINST THE SHOULDER OF THE BODY.
 - THE NUT OF SWAGelok TUBE FITTING SHALL BE TIGHTEN 3/4 TURN FOR FULL PULL-UP. THE SWAGelok GAP GAP INSPECTION GAGE SHALL BE USED TO CHECK FOR SUFFICIENT PULL-UP.



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SOURCE

(SWAGelok)
 DEARBORN VALVE & FITTING CO.
 1540 N. OLD BRAND ROAD
 P.O. BOX 841
 WILCOXVILLE, IL 62094-0847
 708-526-6900
 FAX: 708-526-1221

ITEM	DESCRIPTION	QUANTITY	UNIT	REVISION
3	SS-800-1-4	CONNECTOR, MALE TUBE FITTING	STAINLESS STEEL	6
2	P4105090909-530001	PS-50 COOLING TUBE	SST 316	2
1	P4105090909-530100	PS-50 CHAMBER WELDMENT		1

DATE	BY	CHKD	ENGR

APPROVED FOR PURCHASE J. GOODOL 10/17/95 B.H.	APPROVED FOR PURCHASE J. CHANG 12/22/95	APPROVED FOR PURCHASE J. GOODOL (CHANG) 12/22/95
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APPROVED FOR PURCHASE J. CHANG 12/22/95	APPROVED FOR PURCHASE J. CHANG 12/22/95	APPROVED FOR PURCHASE J. CHANG 12/22/95
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