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NOTES:

1. THIS IS A ULTRA - HIGH - VACUUM ASSEMBLY (UHV) KEEP THE UHV PARTS CLEAN DURING ASSEMBLY, AND AND WRAP UP FOR PACKING WITH ALUMINUM FOIL

2. THE ASSEMBLY 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:

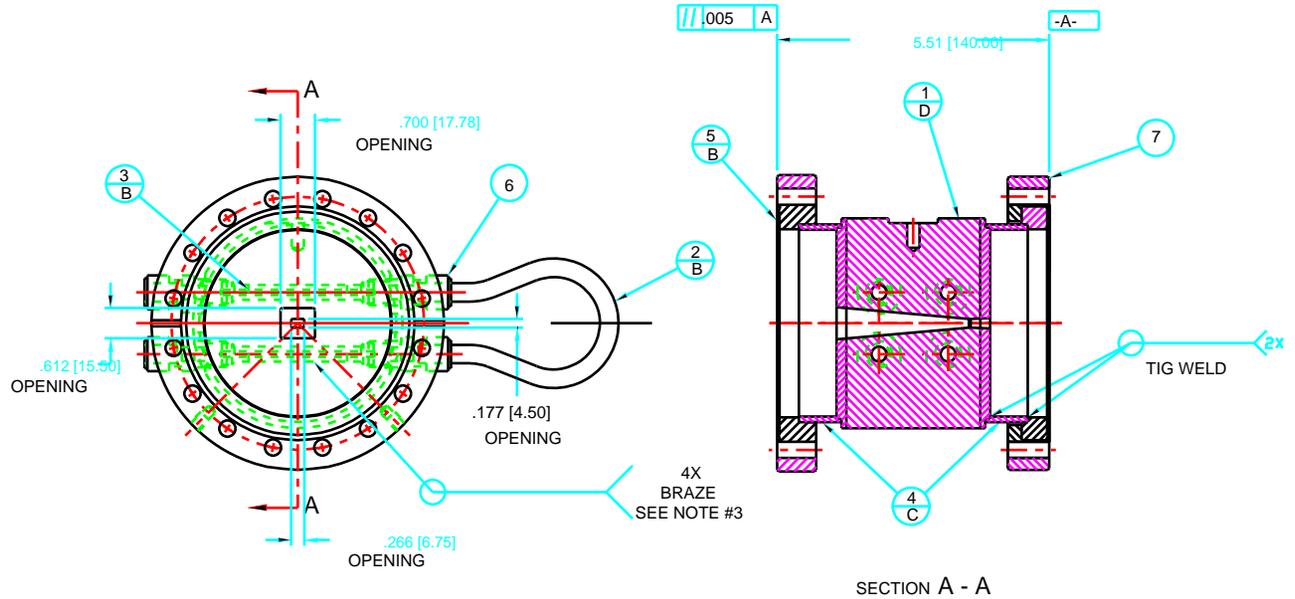
- ALCATEL ASM-110TCL
VARIAN NCR 925 OR 936
VEECO MS-9, MS-90 OR MS-18
Du PONT CEC 24-120B

CALIBRATION OF THE LEAK DETECTOR SENSITIVITY SHALL BE PERFORMED JUST PRIOR TO TESTING.

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. 4X BRAZE ITEM #3 TO ITEM #1 IN PLACE BEFORE TIG WELDING

4. DIMENSIONS IN [] ARE MILLIMETERS AND FOR REF. ONLY



INSTRUCTIONS FOR INSTALLATION OF TUBING

- 1. BEFORE ASSEMBLY OF SWAGELOK MALE CONNECTORS, USE SILVER COOP THREAD LUBRICANT (FROM SWAGELOK CO.) TO ALLOW CONNECTION TO BE DISASSEMBLED WITHOUT SPECIAL TOOLS.
2. INSTALL THE TUBE INTO THE FITTING UNTIL IT IS BOTTOMED AGAINST THE SHOULDER OF THE BODY.
3. TIGHTEN NUT TO APPR. 1/8 TURN PAST FINGER TIGHT.
4. SCRIBE A LINE ON NUT AT 6 O'CLOCK.
5. HOLDING THE FITTING WITH A WRENCH, TIGHTEN NUT PAST ONE COMPLETE TURN AND STOP TURNING WHEN SCRIBE MARK IS AT 9 O'CLOCK. (1-1/4 TURN)
6. SUFFICIENT PULL-UP IS REACHED WHEN SWAGELOK GAP INSPECTION GAGE (MS-IG-468) DOES NOT FIT INTO GAP BETWEEN NUT AND BODY.
7. WATER PRESSURE TEST AT 300 PSI AFTER ASSEMBLING.

REF. SOURCE

1 DEARBORN VALVE & FITTING CO. 1540 N. RAND ROAD P.O. BOX 847 WAUCONDA, IL. 60084-0847 708-526-6900

2 MDC VACUUM PRODUCTS CORP. 23842 CABOT BLVD HAYWARD, CA 94545-1651 TEL: 1-800-443-8817 FAX: 1-510-887-0626

Table with 5 columns: ITEM, DWG/PART NUMBER, NOMENCLATURE OR DESCRIPTION, MATERIAL / SPEC, QTY. Lists parts 1 through 7 including items like 100026, SS-600-1-4, and L5-87 6" O.D. NONROTATABLE VAC. FLG.

Engineering drawing header and title block. Includes 'PARTS LIST' section, 'ARGONNE NATIONAL LABORATORY' logo, drawing title 'ADVANCED PHOTON SOURCE', and drawing number 'L5-880000-00'. Also contains a revision table and scale information.

Revision table with columns: SYM, CHANGE DESCRIPTION, BY, CHG, DATE. Includes a 'REVISIONS' header and a 'DO NOT SCALE DRAWING' warning.

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