



NOTES:

- THIS IS A ULTRA - HIGH VACUUM WELDMENT ASSEMBLY (UHV)
- ALL MATERIALS ARE 304L STAINLESS STEEL UNLESS OTHERWISE SPECIFIED
- WELD ASSEMBLY SHALL BE LEAK TESTED USING A MASS SPECTROMETER WITH MINIMUM SENSITIVITY FOR HELIUM OF 2X 10⁻¹⁰ STANDARD CC/SEC PER LEAK METER DIVISIONS.
- CLEANING: THE COMPONENT MUST BE CLEANED SUCH THAT A UHV PRESSURE OF 1 X 10⁻⁹ TORR CAN BE ACHIEVED
- HANDLING: THE COMPONENTS SHALL BE HANDLED WITH WHITE SILK GLOVES AND WRAPPED WITH ALUMINUM FOIL TYPE DRY ANNEAL AND UNDER CLEAN ROOM CONDITIONS
- DIMENSIONS IN [] ARE MILLIMETERS AND FOR REF. ONLY

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 ASSEMBLY (BAGGING) WITH HELIUM. THE ASSEMBLY WILL BE REJECTED IF A 2% DEFLECTION IN THE MOST SENSITIVE RANGE OF THE LEAK DETECTOR IS SENSED WITHIN 1 MIN.

REF. SOURCE

MDC VACUUM PRODUCTS CORP.
 23042 CABOT BLVD
 HAYWARD, CA 94545-1691
 TEL: 1-800-443-8817
 FAX: 1-510-887-0626

16	#191004	2 3/4" O.D. CONFORM COPPER GASKET	OFHC COPPER	4
15	#191009	4 1/2" O.D. CONFORM COPPER GASKET	OFHC COPPER	8
14	#191017	8" O.D. CONFORM COPPER GASKET	OFHC COPPER	4
13	#191025	14" O.D. CONFORM COPPER GASKET	OFHC COPPER	1
12		1/4 - 248 UNF 2B NUT	SST	24
11		1/4 - 28 X 1 1/4" LG. 12 POINT BOLT	SST/SILVER PLATE	24
10	#453001	2 3/4" O.D. ZERO PROFILE SAPPHIRE VIEWPORT	SST	4
9		5/16 - 24 X 2" LG. 12 POINT BOLT	SST/SILVER PLATE	64
8	#453002	4 1/2" O.D. ZERO PROFILE SAPPHIRE VIEWPORT	SST	8
7		5/16 - 24 UNF 2B NUT	SST	144
6		5/16 - 24 X 2 1/4" LG. 12 POINT BOLT	SST/SILVER PLATE	80
5	#450026	8" O.D. ZERO PROFILE QUARTZ VIEWPORT	SST	4
4		3/8 - 24 UNF 2B NUT	SST	30
3		3/8 - 24 X 3" LG. 12 PT. BOLT	SST/SILVER PLATE	30
2	V3-310002-01	V3 VACUUM TANK COVER	SST	1
1	V3-310001-01	V3 VACUUM TANK BODY	SST	1

ARGONNE NATIONAL LABORATORY
 ADVANCED PHOTON SOURCE
 V3 SRI CAT
 4-ID BEAMLINE COMPONENT
 TEST FACILITY
 VACUUM TANK ASSEMBLY

V3310000-02

MUSCIA 8/5/98 D. SHU 8/7/98
 F. CARRERA 8/6/98 T.M. KUZAY 8/10/98
 CARRERA/MUSCIA 8/11/98
 F. CARRERA 8/6/98

SEE PARTS LIST

1/4 1/8
 1/2 1/8

V3-310000-02

2	V3-310001-01 WAS V3-310001-00			
	(1.13 [28.58]) WAS 1.50 [38.10]			
	(29.68 [754.06]) WAS 29.955 [760.86]			
	(31.19 [792.15]) WAS (31.46 [798.96])			
	6X			
	4X Ø11 [10.41] THRU	M.J.M		
1	V3-310002-01 WAS V3-310002-00	M.J.M		