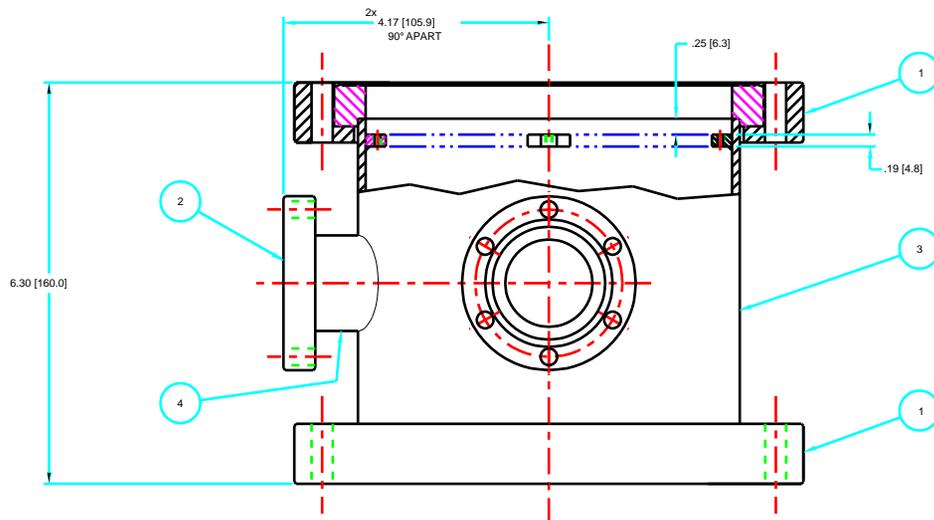


SCALE 3:1

NOTES:

- THIS IS A UHV CHAMBER. ELECTROPOLISHING IS NEEDED BEFORE WELDING. PRIOR TO ELECTROPOLISHING, THE PART NEEDS TO GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOW DOWN.
- KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
- CHAMBER 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.
- ALL DIMENSIONS WITH ∅ ARE MILLIMETERS



5	#7GA (.187) SHEET STL OR 3/16" PLATE	SS 304	3
4	∅.5" x .065 WALL TUBING	SS 304	1
3	∅" x .120 WALL TUBING	SS 304	1
2	P/N 110014 2-3/4" NONROTATABLE FLANGE (MDC)	SS 304	2
1	P/N 100031 8" ROTATABLE FLANGE (MDC)	SS 304	2

UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES		LOG NUMBER: A11812		THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY	
TOLERANCES: DECIMALS ANGULAR		DATE: 6/17/93		DATE: 8/31/93	
DRAWN BY: J.G.		DATE: 6/17/93		DATE: 8/31/93	
CHECKED BY: J.CHANG		DATE: 8/31/93		DATE: 8/31/93	
DESIGNER: J.G.		DATE: 6/7/93		DATE: 8/31/93	
APPROVED/RELEASED: J.CHANG		DATE: 8/31/93		DATE: 8/31/93	
MATERIAL: SEE PARTS LIST		SCALE: 1:1		DRAWING NUMBER: D	
BYM		SHEET: 1 of 1		P4105090703-820100-00	

REV	CHANGE DESCRIPTION	BY	CHKD	DATE