



NOTES:

- THIS IS A UHV CHAMBER. ELECTROPOLISHING IS NEEDED BEFORE WELDING. PRIOR TO ELECTRO-POLISHING, THE PART NEEDS TO GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOW DOWN.
- KEEP THE VACUUM CHAMBER CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
- WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:
 - A) CIMCOOL 5 STAR 49
 - B) TRM SOL
- VACUUM 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 IN MILLIMETERS
- FINISH FOR ALL VACUUM SURFACE

REFERENCE SOURCE:
 MDC VACUUM PRODUCTS CORP.
 23842 CABOT BLVD.
 HAYWARD, CA 94545
 PHONE: 1-800-443-8817

2	P/N 110031	Ø I.D. NOM. NONROTATABLE FLANGE (MDC)	304 SST	1															
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<p>ARGONNE NATIONAL LABORATORY ADVANCED PHOTON SOURCE SLOW & FAST VALVES VACUUM CHAMBER WELDMENT</p>																			
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