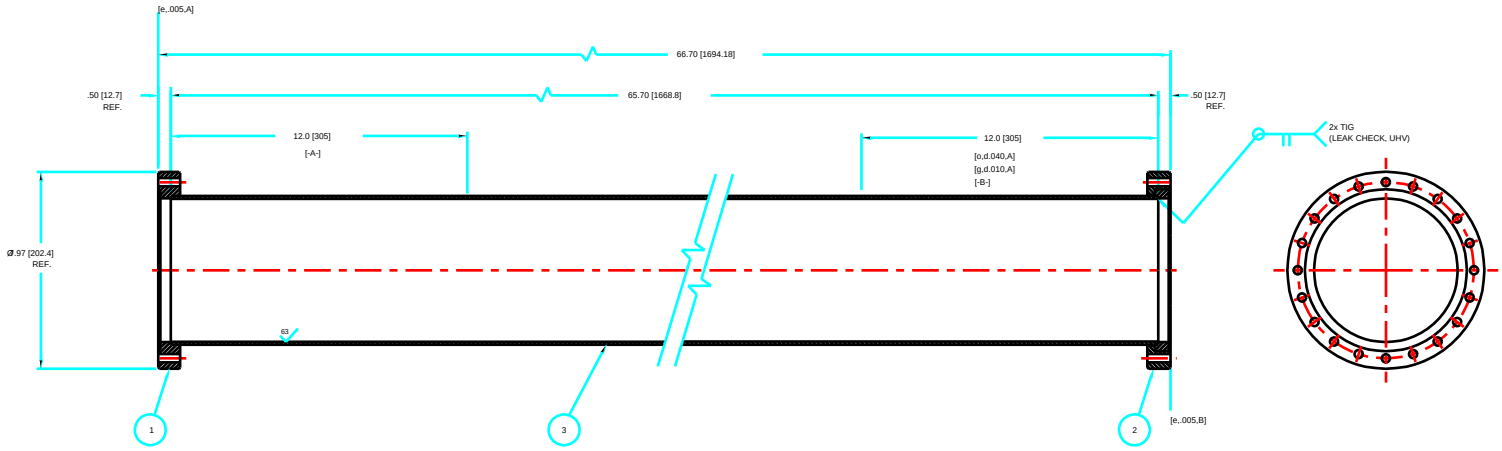
(D)	PLOT SCALE: 1=1	DWG. SCALE: .5	Axxxxx



NOTES:

1. 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.

2. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.

3. CHAMBER SHALL BE LEAK TESTED USING A MASS SPECTROMETER WITH MINIMUN 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.

4. ALL DIMENSIONS WITH ARE MILLIMETERS

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

ITEM	PART NUMBER	DESCRIPTION	MATERIAL / SPEC	QTY
3		6" O.D. x .120 WALL TUBING	SST 304	1
2	100031	8" ROTATABLE FLANGE (MDC)	SST 304	1
1	110031	8" NONROTATABLE FLANGE (MDC)	SST 304	1

PARTS LIST

DWG NO	A14942		
DRAWN BY	J.G.	5/16/93	D. SHU 12/3/93
CHECKED BY	J. CHANG	12/3/93	T. M. KUZAY 12/3/93
ENGINEER	J.G.	5/16/93	
PROJECT ENGINEER	J. CHANG	12/3/93	
SCALE	SEE PARTS LIST		

ARGONNE NATIONAL LABORATORY

ADVANCED PHOTON SOURCE

V7 BM FRONT END
6" DELAY LINE
VACUUM CHAMBER WELDMENT

SCALE 1:2 | SHEET 1 OF 1 | D | P4105090707-810000-00