

P4105090804-400100-00/A19141	P4105090804-400103-00/A19140
P4105090804-200106-00/A20899	
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P4105090804-200103-00/A20897	
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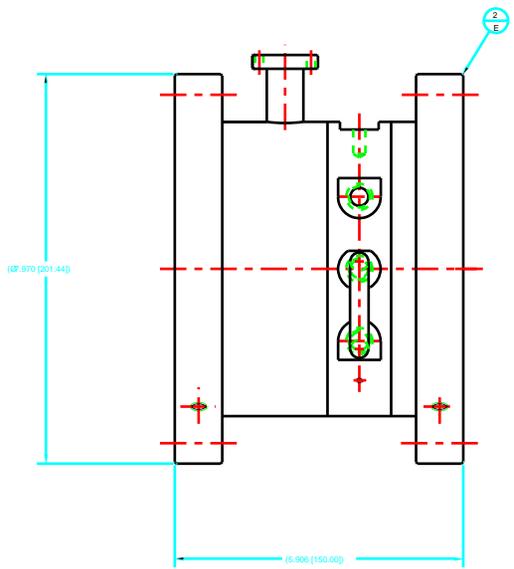
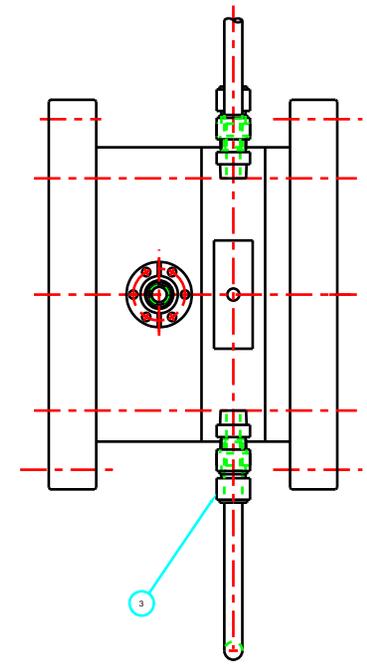
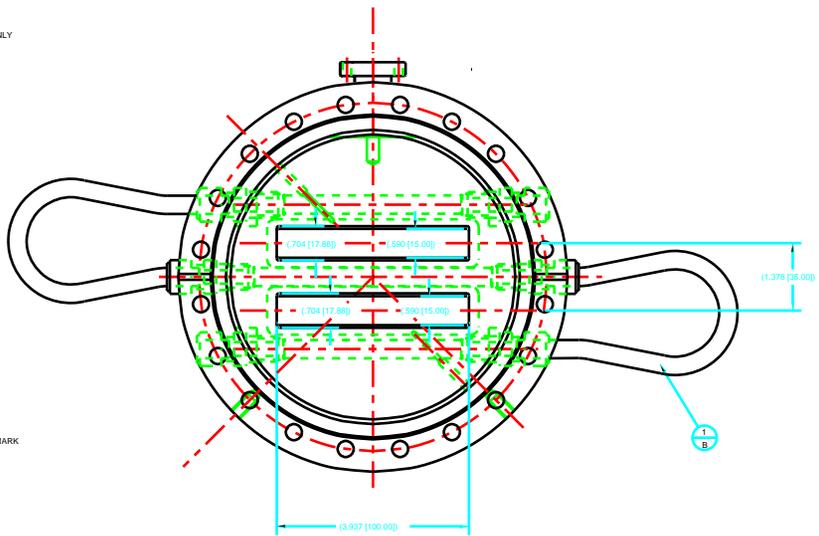
NOTES:

- THIS IS A UHV ASSEMBLY. KEEP THE UHV PARTS CLEAN DURING ASSEMBLY AND WRAP UP FOR PACKING WITH ALUMINUM FOIL.
- DEVICE SHALL BE LEAK TESTED USING A MASS SPECTROMETER WITH MINIMUM SENSITIVITY FOR HELIUM OF 2×10^{-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
DUPONT 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.

- BEFORE ASSEMBLY OF SWAGELOK MALE CONNECTORS, USE SILVER COOP THREAD LUBRICANT (FROM SWAGelok CO.) TO ALLOW CONNECTION TO BE DISASSEMBLED WITHOUT SPECIAL TOOLS.
- ALL DIMENSIONS WITH [] ARE MILLIMETERS AND FOR REF. ONLY
- WATER PRESSURE TEST AT 500 PSI AFTER ASSEMBLING.

INSTRUCTIONS FOR INSTALLATION OF TUBING

- INSTALL THE TUBE INTO THE FITTING UNTIL IT IS BOTTOMED AGAINST THE SHOULDER OF THE BODY.
- TIGHTEN NUT TO APPR. 1/8 TURN PAST FINGER TIGHT.
- SCRIBE A LINE ON NUT AT 6 O'CLOCK.
- 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)
- SUFFICIENT PULL-UP IS REACHED WHEN SWAGELOK GAP INSPECTION GAGE (MS-IG-468) DOES NOT FIT INTO GAP BETWEEN NUT AND BODY.



SOURCE

(SWAGelok)
DEARBORN VALVE & FITTING CO.
1540 N. OLD RAND ROAD
P.O. BOX 847
WAUCONDA, IL 60084-0847
708-526-8900
FAX: 708-526-1221

3	SS-600-1-4	CONNECTOR MALE TUBE FITTING	SST	6
2	P4105090804-400100	8" O.D. BEAMLINE DUAL WINDOW WELDMENT ASSEMBLY	SST	1
1	P4105090804-400001	8" O.D. BEAMLINE DUAL WINDOW TUBING	SST	2

REV	DESCRIPTION	DATE	BY	CHKD	DATE
1	ISSUED FOR FABRICATION	10/13/94	D. SHU		

PARTS LIST		ARGONNE NATIONAL LABORATORY	
DESIGNED BY	D. SHU	DATE	10/13/94
CHECKED BY	J. WOTHE	DATE	10/13/94
APPROVED BY	D. SHU	DATE	10/13/94

ADVANCED PHOTON SOURCE
W-40 BEAMLINE WINDOW
8" O.D. (15 X 100 X Z)
ASSEMBLY

SCALE: 1:1
SHEET: 1 of 4
PARTS LIST