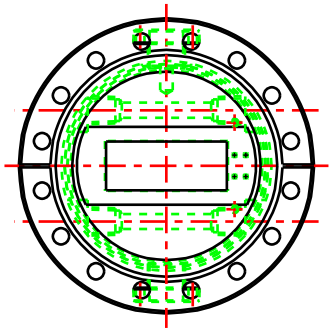
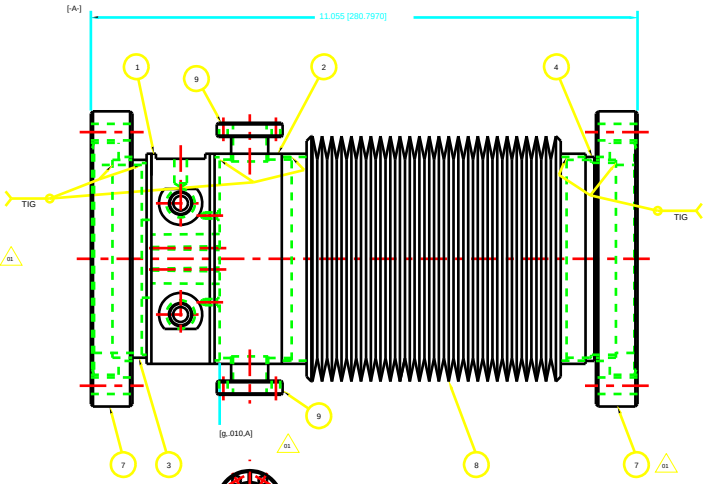
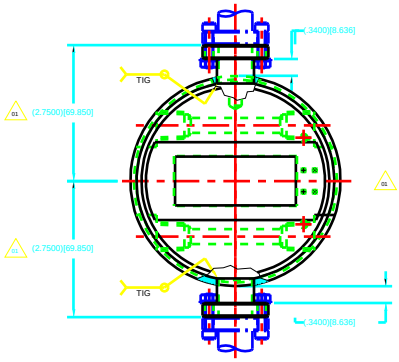
(D)	PLOT SCALE: 1=1	DWG. SCALE: 1	A1657501





FABRICATED AS SHOWN
2 PLACES



SHOWN WITHOUT FLANGE

NOTES:

1. THIS IS A UHV ASSEMBLY. KEEP THE UHV PARTS CLEAN DURING ASSEMBLY AND WRAP UP FOR PACKING WITH ALUMINUM FOIL.

2. THE ASSEMBLY SHALL BE LEAK TESTED USING A MASS SPECTROMETER WITH MINIMUM SENSITIVITY FOR HELIUM OF 2 x 10 -10 STANDARD CC/SEC PER LEAK METER DIVISION, SUCH AS:

   ALCATEL ASM-11OTCL
   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.

3. WELDS SHALL BE GAS TUNGSTEN ARC (GTAW) OR TUNGSTEN INERT GAS (TIG) ON VACUUM SIDE OF JOINTS.

4. ALL DIMENSIONS IN [ ] ARE MILLIMETERS AND ARE FOR REFERENCE ONLY.

5. TOLERANCE SPECIFICATIONS TO CONFORM TO TOLERANCE BLOCK.

SOURCE

1. MDC VACUUM PRODUCTS CORP.
   23842 CABOT BOULEVARD
   HAYWARD, CA. 94545-1651
   (510)-887-6100

2. STANDARD BELLOWS COMPANY
   375 ELLA T. GRASSO TURNPIKE
   WINDSOR LOCKS, CT. 06096
   (203)-623-2307

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
9		1.33" ØHALF NIPPLE (CUT TO .78" O.A. LG.)	MDC #401000 (MOD.)	2
8		BELLOWS WITH EXTENDED ENDS	#497-400-7-EE	1
7		6" ØNOM. ROTATABLE FLANGE	MDC #100026	2
6				
5				
4	P4105091407-210004-01	LONG TUBE	SST 304	1
3	P4105091407-210003-00	SHORT TUBE	SST 304	1
2	P4105091407-210002-01	FEED-THROUGH TUBE	SST 304	1
1	P4105091407-210001-01	COOLING BLOCK SUB-ASSEMBLY	SST 304 / GUID-COP	1

PARTS LIST

UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN INCHES
TOLERANCES
DECIMALS: X ± .03, XX ± .01, XXX ± .005
ANGULAR ± .05°
SURFACE ROUGHNESS 125
REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX.
SURFACE TEXTURE TO BE 64 ACCORDANCE WITH LATEST ANSI B46.1
DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5
DO NOT SCALE DRAWING

LOG NUMBER: A1657501

THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY

		DATE
DRAWN BY	R.KRAKORA	2/94
CHIEF DESIGN ENGINEER	D.SHU	5/17/94
CHECKED BY	J.CHANG	5/16/94
CAD LEADER	T.M.KUZAY	5/18/94
DESIGNER	R.KRAKORA/J.CHANG	5/16/94
PROJECT MGR.		
RESPONSIBLE ENGINEER	J.CHANG	5/16/94
APPROVED/RELEASED		

TITLE: ADVANCED PHOTON SOURCE
B7 ID BEAM MIS-STEERING
SAFETY MONITOR
CHAMBER WELDMENT

MATERIAL
SCALE 1:1
SHEET 1 of 1
SIZE D
DRAWING NUMBER P4105091407-210000-01

SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
01	UPDATED DRAWING & BOM	RK	JC	1/29/96
01	ADDED GEOMETRIC TOLERANCES	RK	JC	1/29/96

REVISIONS