



- NOTES:
1. THIS IS A UHV PART. 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.
 2. CHAMBER 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 SAM-110TCL Du PONT CEC 24-120B VARIAN MS-9, MS-90 OR MS-18 CALIBRATION OF THE LEAK DETECTOR SENSITIVITY SHALL BE PERFORMED JUST PRIOR TO TRESTING. FINAL TEST WILL CONSIST OF SURROUNDING THE CHAMBER (BAGGING) WITH HELIUM. THE CHAMBER WILL BE REJECTED IF A 2% DEFLECTION ON THE MOST SENSITIVE RANGE OF THE LEAK DETECTOR IS SENSED WITHIN 1 MIN.
 3. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
 4. DIMENSIONS IN [] ARE MILLIMETERS
 5. STRUCTURAL WELD

REV	LOG NUMBER	ITEM	DISP/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL SPEC	QTY
2	A18051	2	P4102020102-230302-0K2	Ø2 3/4 NON ROTABLE FLANGE	MDC # 100014	1
1	A18052	1	P4102020102-230301-0K2	RECTANGULAR CHAMBER		1

LOG NUMBER LIST				PARTS LIST			
01	REVISED WELD & UPDATED B.O.M.	DRN	DATE	ARGONNE NATIONAL LABORATORY			
01	CHANGE DESCRIPTION	BY	CHGD. DATE	PROJECT NUMBER	DATE	DATE	DATE
				A18053	10/17/93	10/27/93	10/27/93
				K2 BM RATCHET WALL COLLIMATOR CHAMBER WELDMENT ASSEMBLY			
				SEE PARTS LIST			