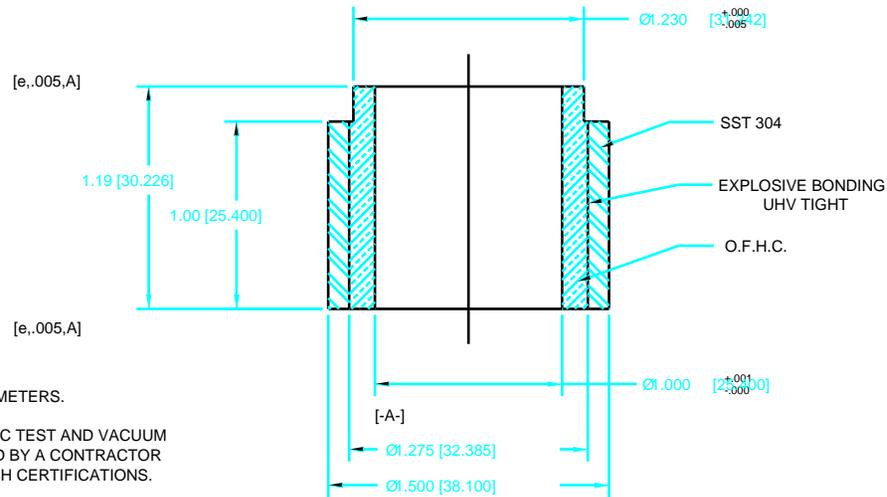
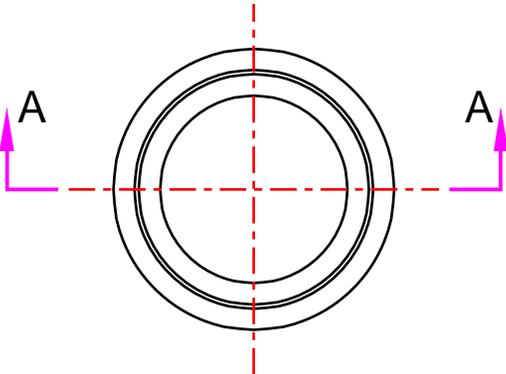


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SECTION A-A

NOTES:

- 1. THIS IS ULTRA-HIGH WELDMENT ASSEMBLY (UHV).
- 2. 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) TRIM SOL
- 3. WELDMENT ASSEMBLY SHALL BE LEAK TESTED USING A MASS SPECTROMETER WITH MINIMUM SENSITIVITY FOR HELIUM OF 2×10^{-10} STD. 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
- 4. DIMENSIONS IN [] ARE IN MILLIMETERS.
- 5. CERTIFICATION ON ULTRASONIC TEST AND VACUUM EXAMINATION SHALL BE SIGNED BY A CONTRACTOR REPRESENTATIVE TO SIGN SUCH CERTIFICATIONS.

CALIBRATION OF THE LEAK DETECTOR SENSITIVITY SHALL PERFORMED JUST PRIOR TO TESTING.

FINAL TEST WILL CONSIST OF SURROUNDING THE ASSEMBLY (BAGGING) WITH HELIUM. THE ASSEMBLY WILL BE REJECTED IF A 2% DEFLECTION IN THE MOST SENSITIVE RANGE OF THE LEAK DETECTOR IS SENSED WITHIN 1 MIN.

SYN	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				

ITEM	BYG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN INCHES		THIS DRAWING IS THE PROPERTY OF		
DECIMALS ANGLES .X .015 .25 .XX .010 .XXX .005		ARGONNE NATIONAL LABORATORY		
SURFACE ROUGHNESS R_a 32 ✓ REMOVE ALL BURRS AND BREAK SHARP EDGES TO MAX. SURFACE FINISH TO BE IN ACCORDANCE WITH LATEST ASST 044. DIMENSIONS & TOLERANCES TO ACCORD WITH LATEST ASST 044. DO NOT SCALE DRAWING		LOG NUMBER A15565		ADVANCED PHOTON SOURCE L5 APS UNDULATOR WHITE BEAM H & V SLITS UPPER COOLING EXPLOSIVE BONDING TUBE
DRAWN BY R. KRAKORA	DATE 11/93	CHIEF DESIGN ENGINEER D. SHU	DATE 2/94	PROJECT MGR. T.M. KUZAY
CHECKED BY J. WOTHE	DATE 11/93	RESPONSIBLE ENGINEER R. KRAKORA	APPROVE/RELEASED D. SHU	DATE 2/94
MATERIAL SEE ABOVE SECTION			SCALE 2:1	SHEET 1 of 1
			DRAWING NUMBER P4105091505-210104-00	

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