



NOTES:

1. THIS IS A UHV ASSEMBLY. KEEP THE UHV PARTS CLEAN DURING ASSEMBLY AND WRAP UP FOR UHV PACKING WITH ALUMINUM FOIL.
2. A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOW DOWN IS NEEDED BEFORE WELDING.
3. DEVICE SHALL BE LEAK TESTED USING A MASS SPECTROMETER WITH MINIMUM 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 24-1208
 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 IN MILLIMETERS

7	3/8 PLAIN WASHER	SST	8
6	3/8 LOCK WASHER	SST	8
5	3/8-16 HEX. JAM NUT	SST (SILVER PLATED)	8
4	3/8-16 HEX. NUT	SST (SILVER PLATED)	8
3	P4105090707-800001 V7 BAFFLE SUPPORT PLATE	304 SST	2
2	P4105090707-820000 V7 BAFFLE WELDMENT	304 SST	1
1	P4105090707-810000 V7 VACUUM CHAMBER WELDMENT	304 SST	1

ARGONNE NATIONAL LABORATORY
ADVANCED PHOTON SOURCE
 V7 BM FRONT END
 6" DELAY LINE ASSEMBLY

Part Number: A14940

DATE: 12/3/93

DESIGNED BY: J. CHANG

CHECKED BY: T. M. KUZAY

DATE: 5/16/93

DATE: 12/3/93

SEE PARTS LIST

REV: 1-2

REV: 1-1

P4105090707-800000-00