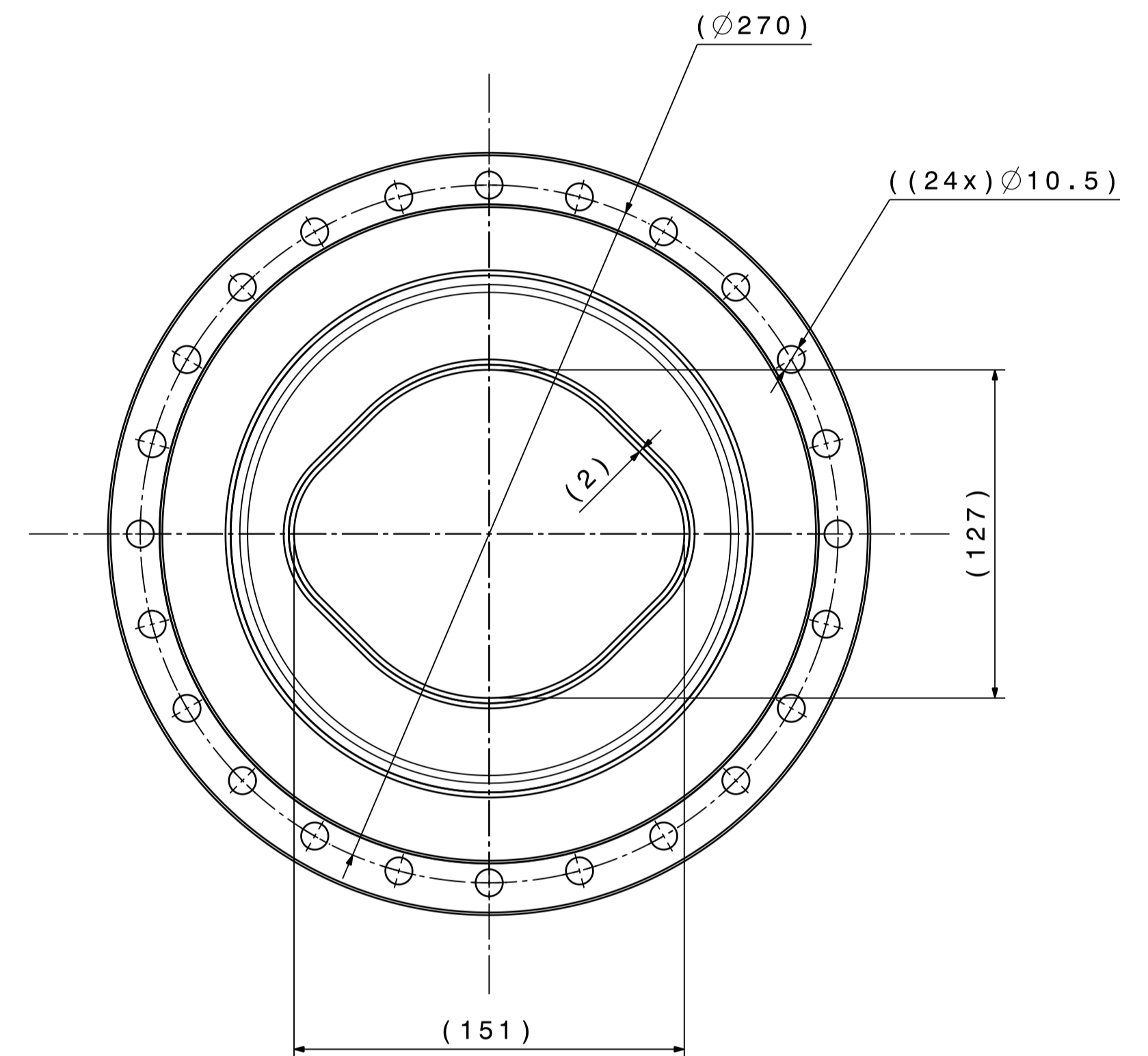


Approximative mass :26.5 Kg  
Masse approximative



To weld during assembling after mounting vacuum chamber into quadrupoles.  
See drawing LEILMQFB0001.

A souder au montage apres introduction de la chambre dans les quadrupoles.  
Voir plan LEILMQFB0001.

**Cleaning / Nettoyage**  
According procedure / Suivant procedures de L. Ferreira, CERN Reports : Procedure Qualite 867.11, 867.15, 876.16 (2003)

**Vacuum firing / Traitement Thermique**  
600°C for 24H / 600°C pendant 24H

**NEG coating / Depot NEG**  
Coating with 2 µm Ti-Zr-V / Dépôt de 2 µm de Ti-Zr-V

**Information**  
Inscribe drawing number on shades area with an electrical pen  
Inscrire le numero de detail sur une zone predefini avec un stylo electrique

TOLERANCES DIMENSIONNELLES GÉOMÉTRIQUES	Tolerances geometriques, lineaires et angulaires	ISO 2768-mK-E
	Arêtes de forme non définies	ISO 13715 $\pm 0.3$ $\pm 0.3$

This drawing represents a part (or a component) of the vacuum system for LEIR with will operate at 10-10 Pa (10-12Torr).All welds must be made using the specified technics with 100% penetration.Welds and all other surfaces must not be finished by grinding or any other mechanical abrasion.Any part (or component) of the vacuum system showing a room temperature leak rate (localized or global),when measured with a calibrated UHV leak detector, in excess of 1x10<sup>-11</sup> Pa m3 s<sup>-1</sup> (7.5x10<sup>-11</sup> Torr ls-1) will be considered as unacceptable.

Ce dessin represente une partie (ou composant) du systeme a vide LEIR qui fonctionnera a 10-10 Pa (10-12 Torr). Toutes les soudures seront realisees selon le procede specifique avec penetration de 100%.Ces soudures ne doivent etre ni meulees ni abrasees. Toute partie (ou composant) du systeme a vide ayant un taux de fuite (local ou global), qui est mesure a l'aide d'un detecteur de fuite UHV, superieur a 1x10<sup>-11</sup> Pa m3 s<sup>-1</sup> (7.5x10<sup>-11</sup> Torr ls-1) sera considere comme inacceptable.

2	BELLOWS / FLANGE ASS.	2	ST. STEEL	E43.1045	
	ENS. SOUFFLET / BRIDE		AC. INOX		
1	VACUUM TUBE	1	ST. STEEL	LEIVCQLA0002	
	TUBE A VIDE		316LN		
QUANT.	DESCRIPTION	POS.	MAT.	OBSERVATIONS	REF.CERN
	ENS/ASS		S.ENS/S.ASS	LEILMQFB0001	
LEIR Vacuum Chamber for Quadrupoles Loose-shaped (Variant A)				ECHELLE SCALE	DES/DRA. ACROTECNA 2006-06-15
QUADRUPOLES STACK VACUUM CHAMBER STACK DE QUADRUPOLES CHAMBRE A VIDE				1:2	CONTROLLED
				APPROVED	RELEASED
				LEIVCQLA0001	REPLACE/REPLACES
NON VALABLE POUR EXECUTION NOT VALID FOR EXECUTION				QAC	SIZE IND.
				LEIVCQLA0001	1