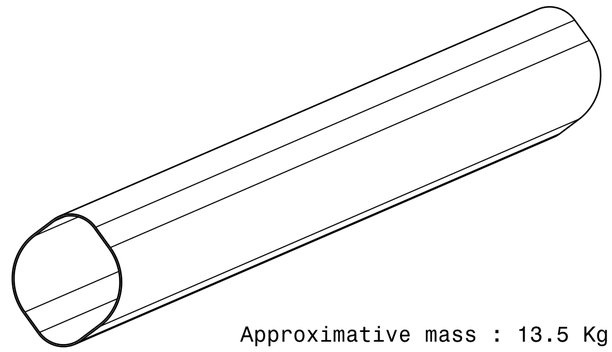
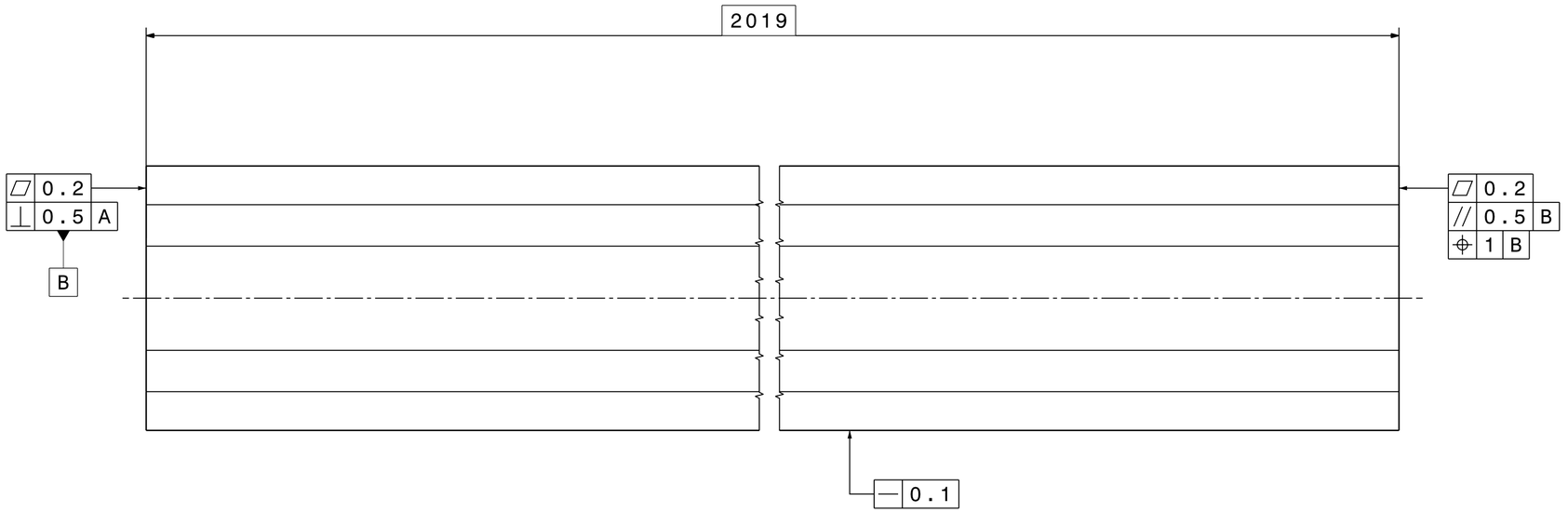
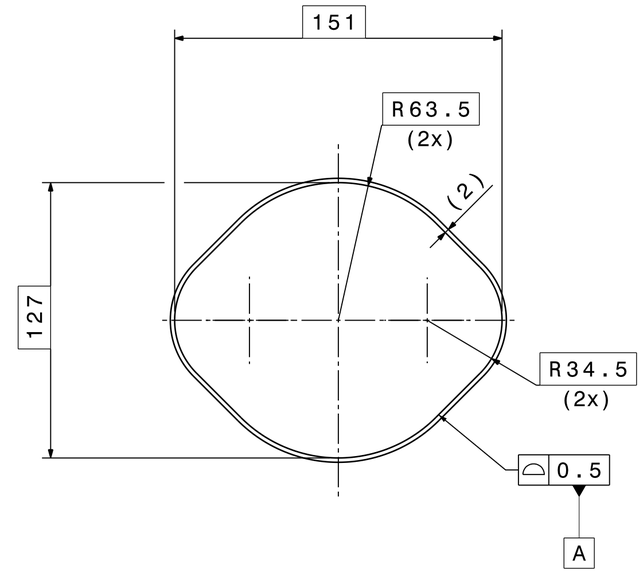


Approximative mass : 13.5 Kg
Masse approximative





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 1x10-11 Pa m3 s-1 (7.5x10-11 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 1x10-11 Pa m3 s-1 (7.5x10-11 Torr ls-1) sera considere comme inacceptable.

Cutting of the material : Ra 1.6
Decoupes des matieres

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

TOLERANCES GENERALES "MOYENNE"		
	Tolerances geometriques, lineaires et angulaires	ISO 2768-mK-E
	Aretes de forme non definies	ISO 13715 +0.3 -0.3

Ra 1.6 ( )

QUANT.	DESCRIPTION	POS	MAT.	OBSERVATIONS	REF.CERN
1	SHEET TH. 2mm	1	ST. STEEL	2025x450x2	44.59.32
	TOLE EP. 2mm		316LN		520.1
	ENS/ASS LEILMQFB0001		S.ENS/S.ASS	LEIVCQLA0001	

LEIR Vacuum Chamber for Quadrupoles Lozenge-shaped (Variant A)

VACUUM CHAMBER
VACUUM TUBE
CHAMBRE A VIDE
TUBE A VIDE

ECHELLE SCALE 1:2

DES/DRA.	ACROTECNA	2006-07-07
CONTROLLED		
RELEASED		
APPROVED		

LEI\VCQLA0\LEIVCQLA0002
REMPLACE/REPLACES

NON VALABLE POUR EXECUTION
NOT VALID FOR EXECUTION

QAC -

LEIVCQLA0002

SIZE 2 IND.

DESSIN, RUGOSITE, TOLERANCES SELON NORMES ISO
DRAWING, RUGOSITY, TOLERANCES ACCORDING TO ISO STANDARDS

PROJECTION