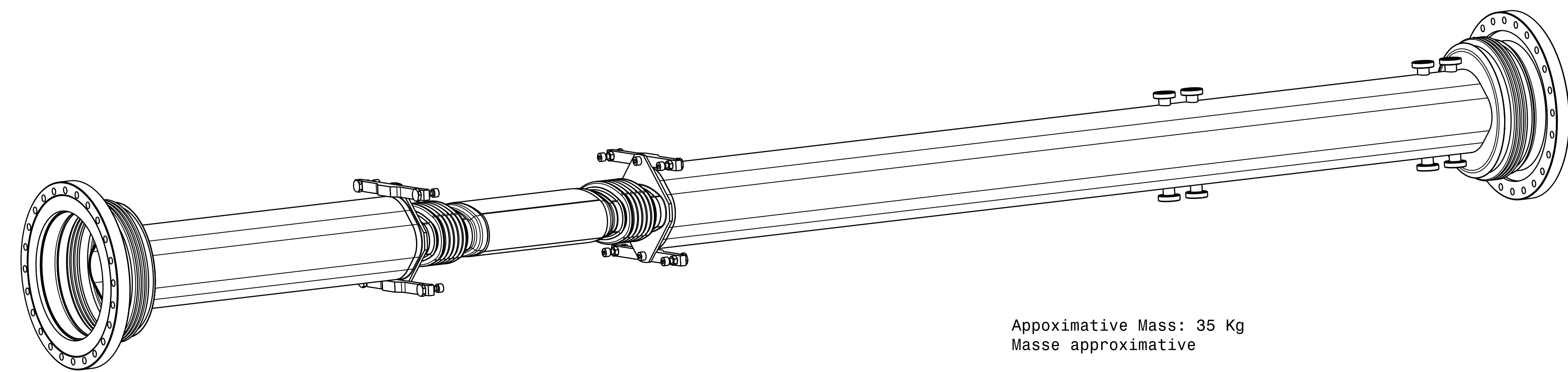
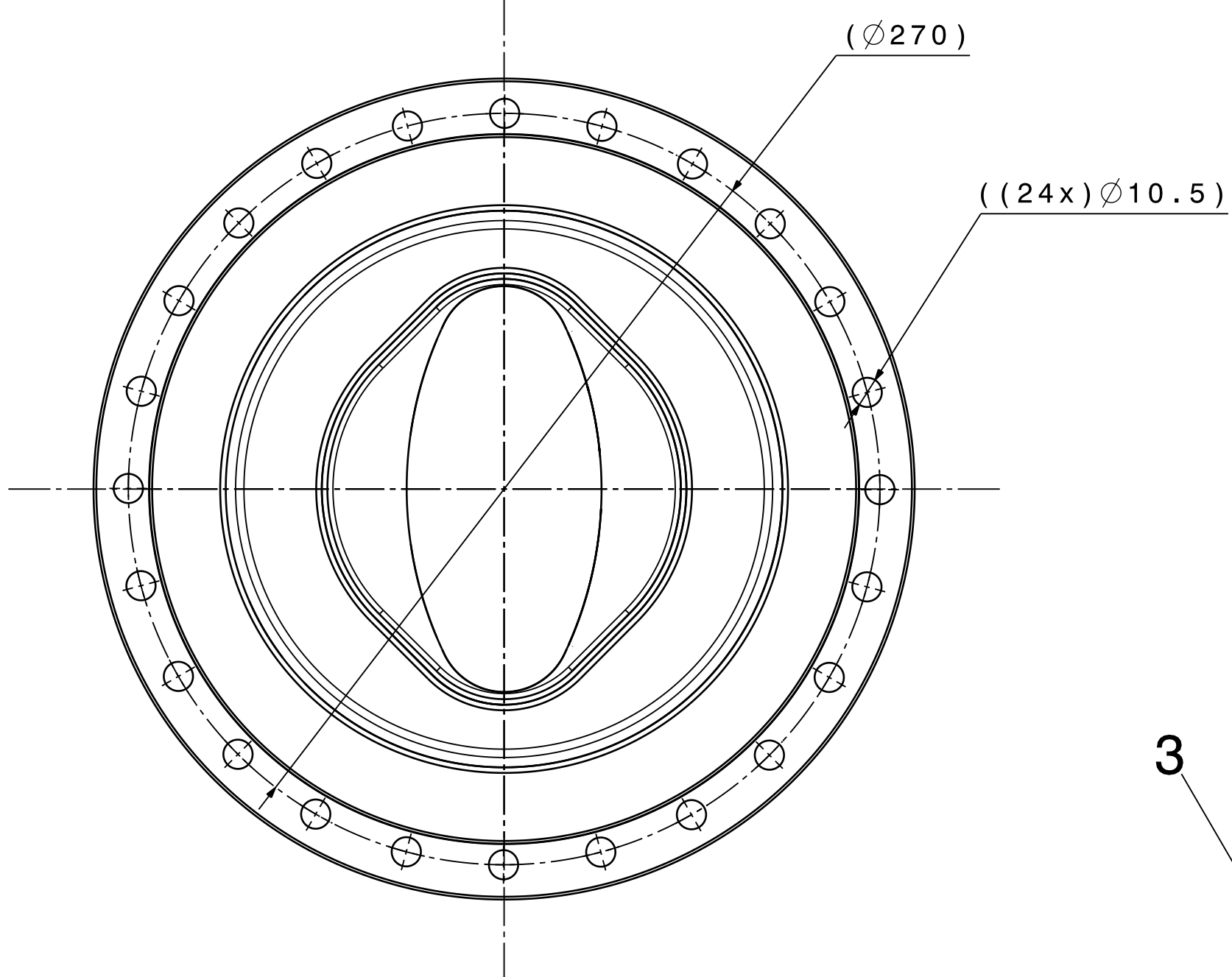
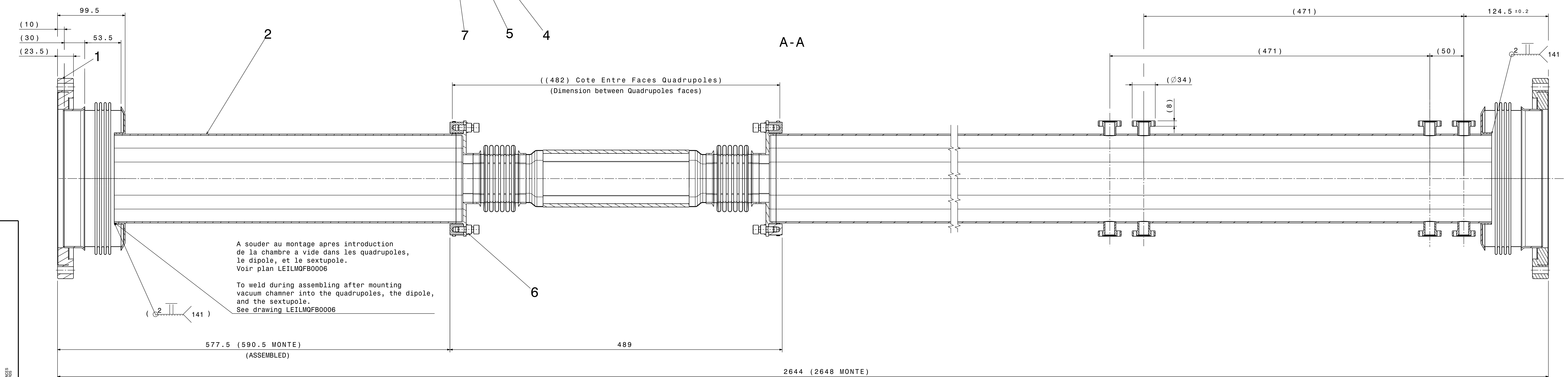
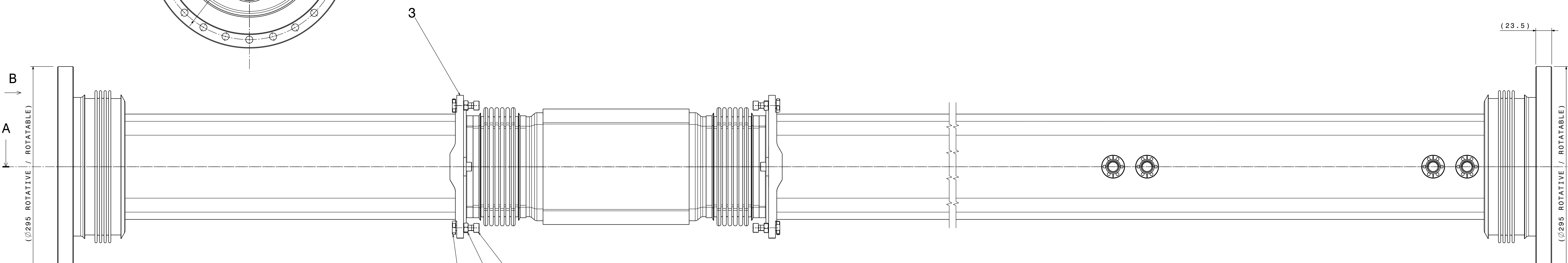


Vue B  
View



Approximative Mass: 35 Kg  
Masse approximative



A souder au montage apres introduction de la chambre a vide dans les quadrupoles, le dipole, et le sextupole. Voir plan LE1LMQFB0006  
To weld during assembling after mounting vacuum chamber into the quadrupoles, the dipole, and the sextupole. See drawing LE1LMQFB0006

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

**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

**Note / Nota :**  
Protect the ceramic during the removal of the NEG  
Protéger la céramique lors de la dépose du NEG

This drawing represents a part (or a component) of the vacuum system for LEIR with will operate at 10-10 Pa (10-12 Torr). 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.

TOLERANCES GEOMETRIQUES, LINEAIRES ET ANGULAIRES	ISO 2768-mK-E
Aretes de forme non definies	ISO 13715 $\sqrt{0.3}$ $\sqrt{0.3}$

QTY	DESCRIPTION	POS	MAT.	OBSERVATIONS	REF. CERN
8	ISOLATING CONTACT	7	SILK TIBRE	LE1VCLB0007	
	CONTACT ISOLANT		FIBRE DE SOIE		
4	SOCKET HEAD SCREW M8x12	6	ST. STEEL	BOSSARD 1127047	
	VIS CHC M8x12		AC. INOX		
4	HEXAGONAL NUT M8	5	ST. STEEL		47.43.77
	ECROU HEXAGONAL M8		AC. INOX		080.3
8	SOCKET HEAD SCREW M8x30	4	ST. STEEL		47.62.71
	VIS CHC M8x30		AC. INOX		311.3
4	CONTACT BAR	3	ST. STEEL	LE1VCLB0006	
	BARRE DE CONTACT				
1	VACUUM CHAMBER	2	ST. STEEL	LE1VCLB0002	
	CHAMBRE A VIDE		316LN		
2	EXTREMITY OF QUADRUPOLES	1		E43.1045	
	EXTREMITE DE QUADRUPOLES				

QUADRUPOLES STACK		SCALE		ACROTECHA 2006-07-06	
VACUUM CHAMBER ASSEMBLY		1:2		APPROVED	
STACK DE QUADRUPOLES				REPLACEMENT	
ENSEMBLE CHAMBRE A VIDE				REPLACE/REPLACES	
NON VALABLE POUR EXECUTION				LE1VCLB0001	
NOT VALID FOR EXECUTION				0	