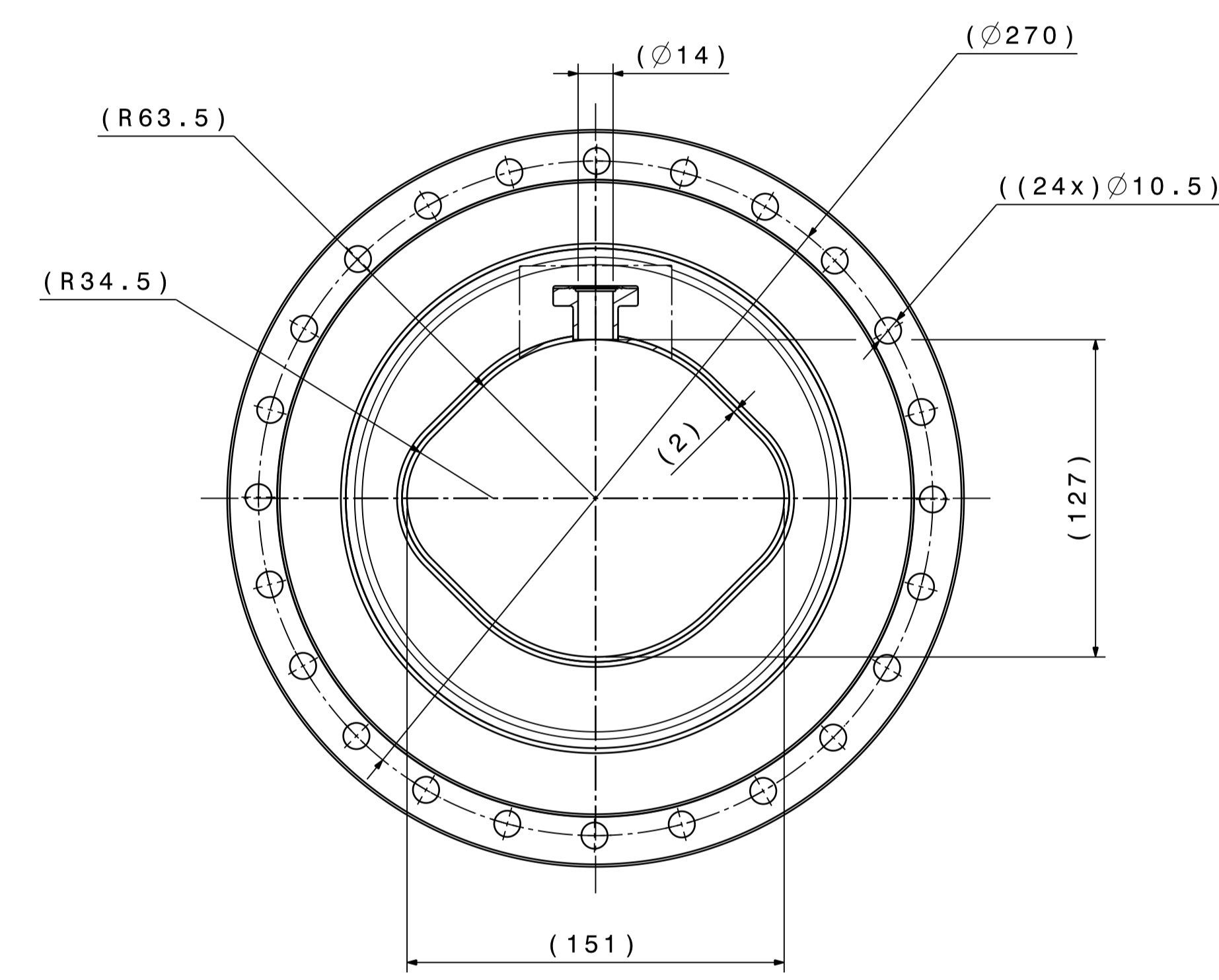
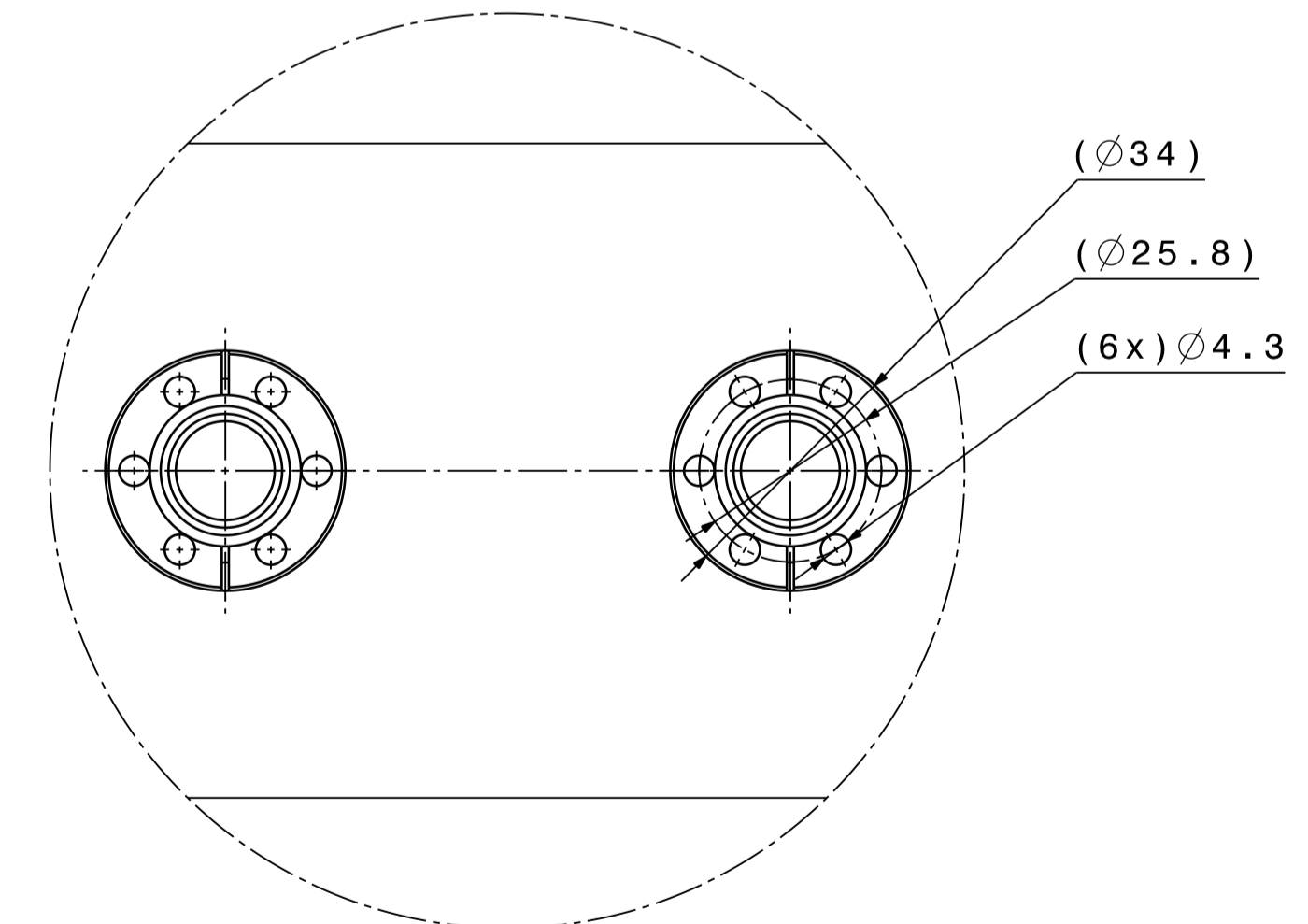


Approximative mass : 26.8 kg
Masse approximative



Vue A
View
Echelle: 1:1
Scale



To weld during assembling after mounting vacuum chamber into quadrupoles and sextupoles. See drawing LEILMQFB0004.

A souder au montage apres introduction de la chambre dans les quadrupoles et les sextupoles. Voir plan LEILMQFB0004.

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 GENERALES "NON ENUNCIÉ"	Tolerances geometriques, lineaires et angulaires	ISO 2768-mK-E
	Arêtes de forme non définies	ISO 13715 $\sqrt{0.3}$ $\sqrt{0.3}$

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 1x10⁻¹¹ 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.

2	BELLOWS / FLANGE ASS. ENS. SOUFFLET / BRIDE	2	ST. STEEL AC. INOX	E43.1045	
1	VACUUM CHAMBER WITH PICK UP CHAMBRE A VIDE AVEC PIQUAGES	1	ST. STEEL 316LN	LEIVCQLE0002	
QUANT.		POS.		MAT.	
ENS/ASS		S.ENS/S.ASS		OBSERVATIONS	
				LEILMQFB0004	
LEIR Vacuum Chamber for Quadrupoles Large-sized (Variant E)				E/CHELLE SCALE	
QUADRUPOLES STACK VACUUM CHAMBER ASSEMBLY STACK DE QUADRUPOLES ENSEMBLE CHAMBRE A VIDE				DES/DRA. ACROTECNA 2006-07-06	
				CONTROLLED	
				RELEASED	
				APPROVED	
				LEIVCQLE0001	
				REPLACE/REPLACES	
NON VALABLE POUR EXECUTION NOT VALID FOR EXECUTION				GAC	
				SIZE IND.	
				LEIVCQLE0001 1	

ORGANIZATION RESPONSIBLE FOR DESIGN, DRAWING, TOLERANCES ACCORDING TO ISO STANDARDS
DESIGN, DRAWING, TOLERANCES ACCORDING TO ISO STANDARDS
PROJECTION