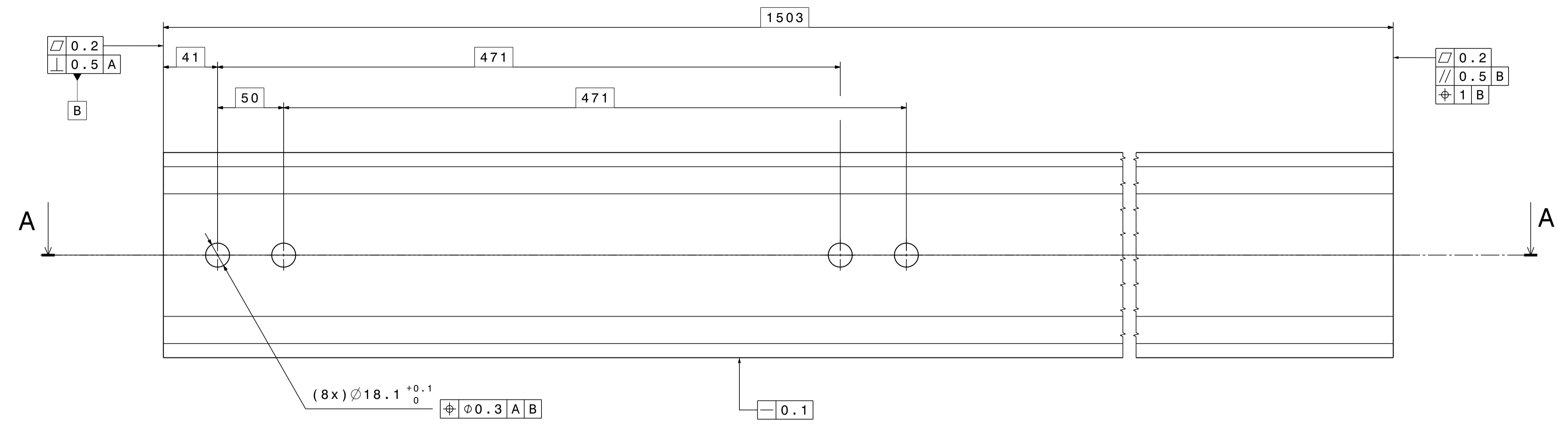
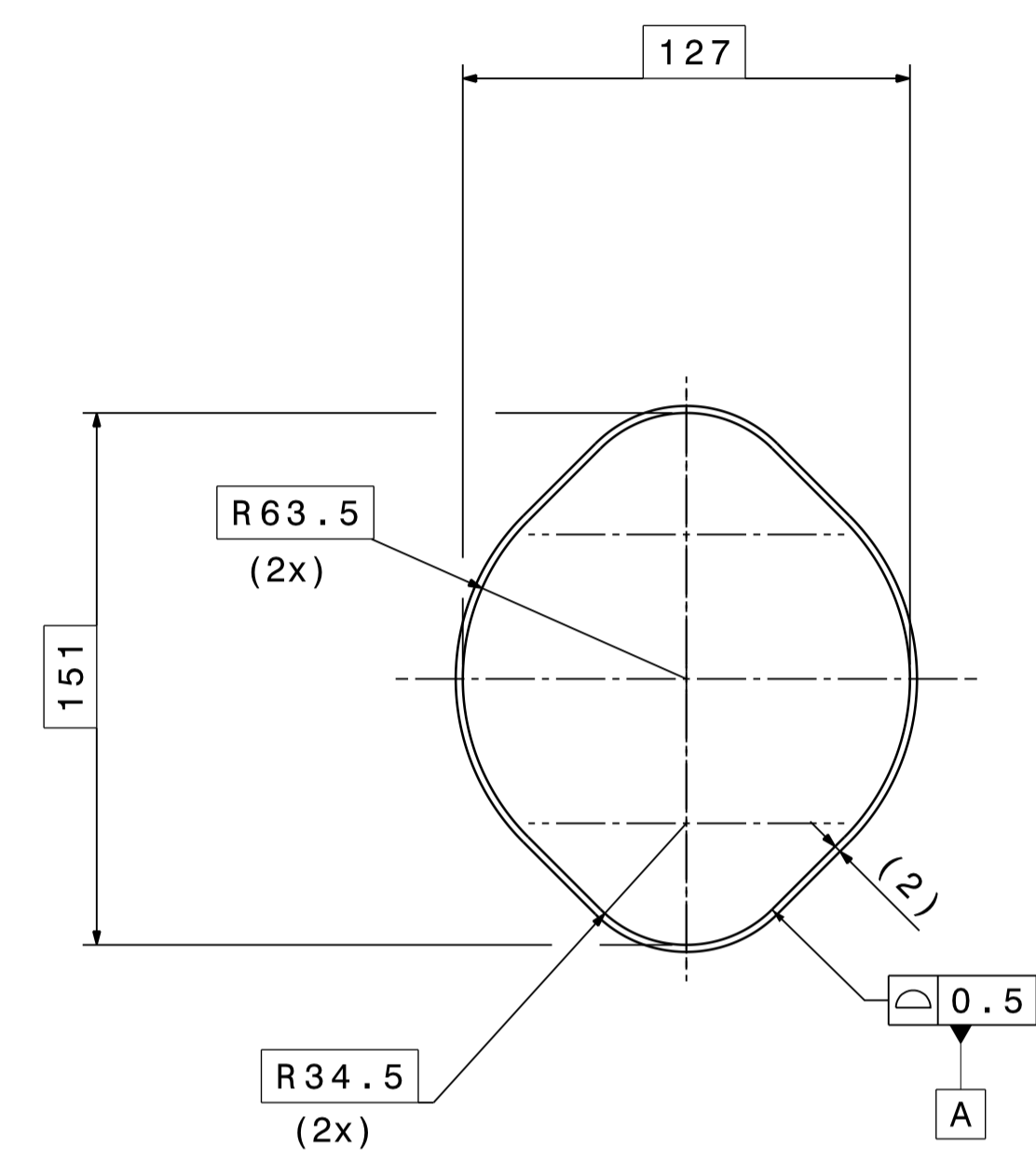
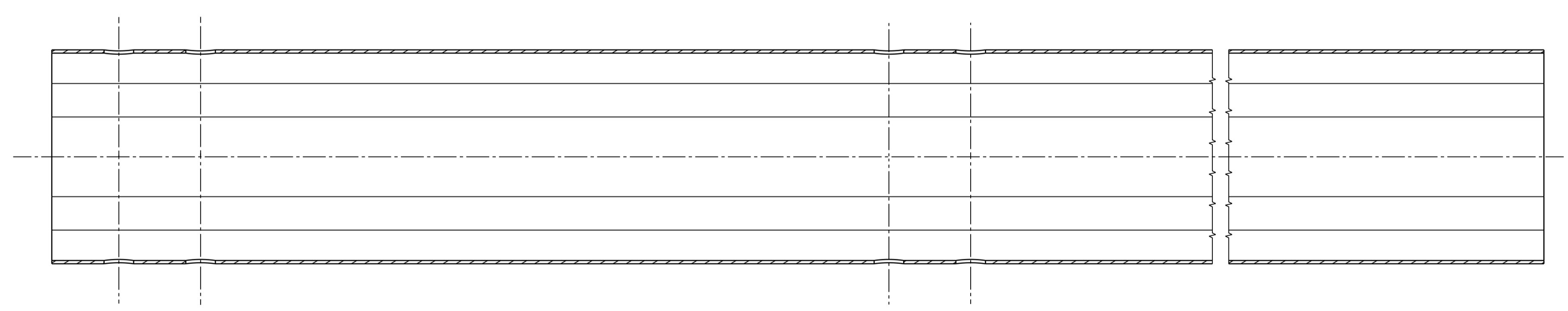


Approximative mass : 10 kg  
Masse approximative



A-A



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 geometriques, lineaires et angulaires	ISO 2768-mK-E
Aretes de forme non definies	ISO 13715 $\sqrt{0.3}$ $\sqrt{0.3}$

✓ Ra 1.6/ (✓)

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  $1 \times 10^{-11}$  Pa m3 s-1 ( $7.5 \times 10^{-11}$  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  $1 \times 10^{-11}$  Pa m3 s-1 ( $7.5 \times 10^{-11}$  Torr ls-1) sera considere comme inacceptable.

1	SHEET TH. 2mm	1	ST. STEEL	1515x450x2	44.59.32
	TOLE EP. 2mm		316LN		520.1
QUANT.	DESCRIPTION	POS.	MAT.	OBSERVATIONS	REF.CERN
	ENS/ASS	LEIVCQLB0001		S.ENS/S.ASS	LEIVCQLB0002
LEIR Vacuum Chamber for Quadrupoles Lozenge-shaped (Variant B)				ECHELLE SCALE	DES/DRA. ACROTECNA 2006-07-07
VACUUM CHAMBER WITH PICK UP				1:2	CONTROLLED
CHAMBRE A VIDE					RELEASED
CHAMBRE A VIDE AVEC PIQUAGES					APPROVED
					LEIVCQLB01   LEIVCQLB0003
					REPLACE/REPLACES
NON VALABLE POUR EXECUTION				GAC	SIZE IND.
NOT VALID FOR EXECUTION				-	LEIVCQLB0003 1

ORGANIZATION RESPONSIBLE FOR THE DESIGN, MANUFACTURE AND DELIVERY OF THE COMPONENTS OF THE VACUUM SYSTEM FOR LEIR  
 ORGANISATION RESPONSIBLE POUR LE DESSIN, LA FABRICATION ET LA DELIVRANCE DES COMPOSANTS DU SYSTEME A VIDE POUR LEIR  
 EUROPEAN ORGANIZATION FOR NUCLEAR RESEARCH  
 ORGANISATION EUROPEENNE POUR LA RECHERCHE NUCLEAIRE  
 CERN