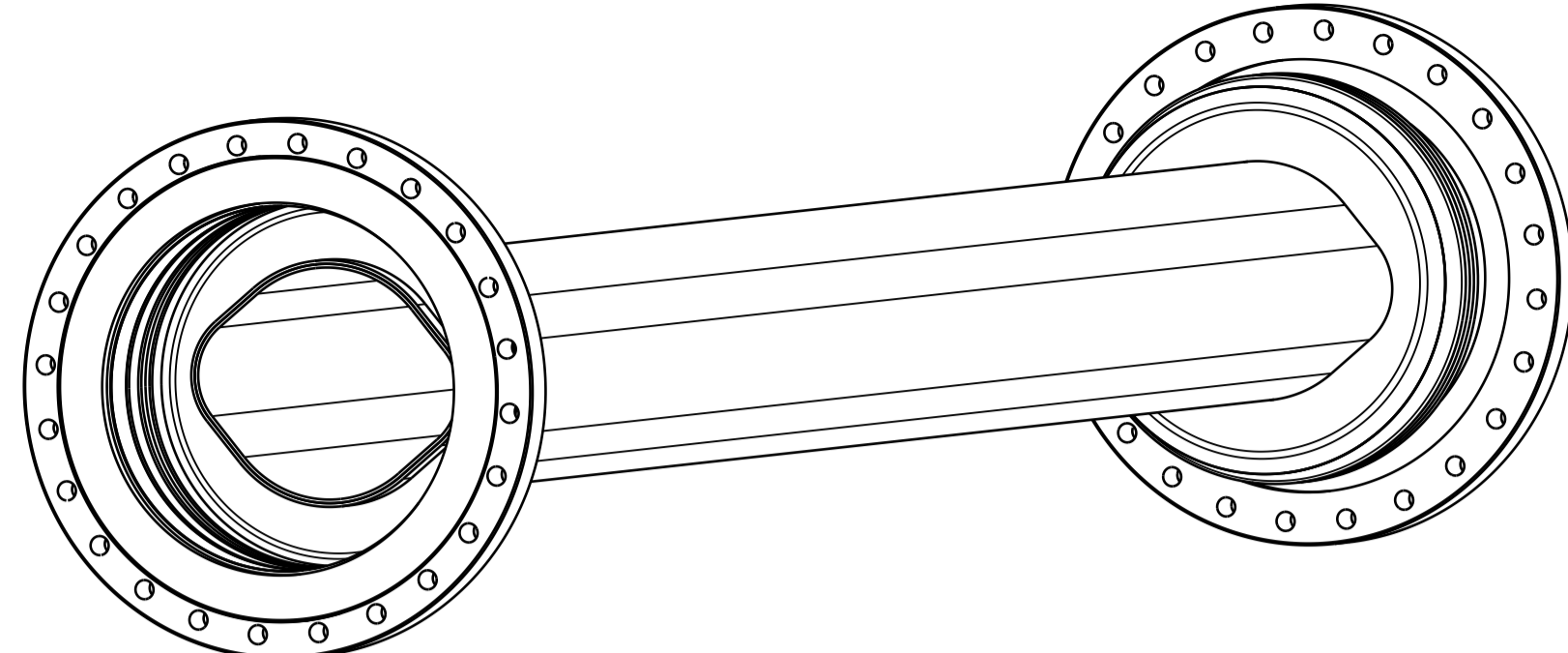
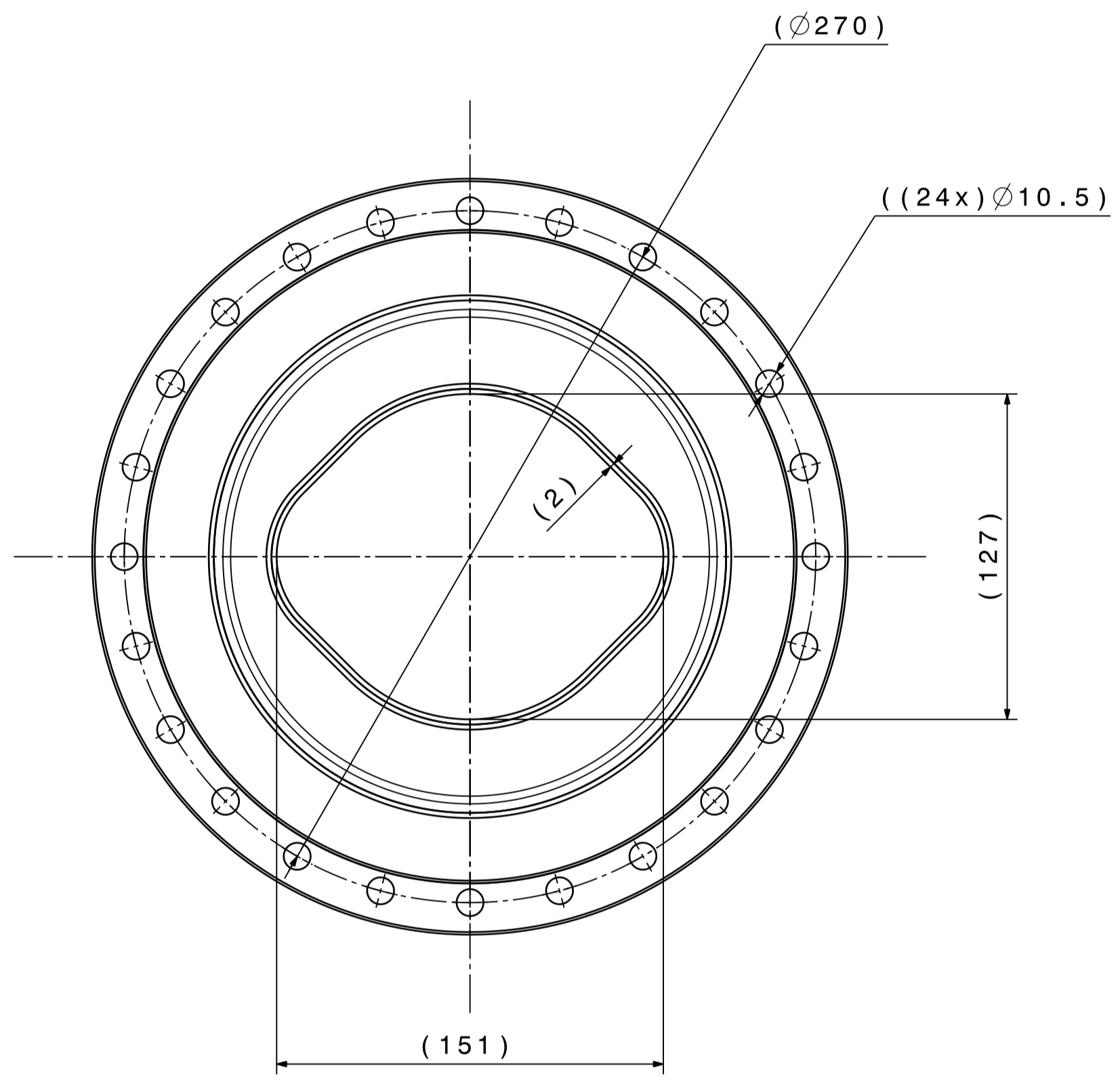


To weld during assembling after mounting vacuum chamber into quadrupoles.
See drawing LEILMQFB0003.

A souder au montage apres introduction de la chambre dans les quadrupoles.
Voir plan LEILMQFB0003.



Approximative mass : 23.2 Kg
Masse approximative



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 électrique

DIMENSIONS DIMENSIONS DIMENSIONS	Tolerances geometriques, lineaires et angulaires	ISO 2768-mK-E
	Arêtes de forme non definies	ISO 13715 $\sqrt{r0.3}$ $\sqrt{r0.3}$

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 TUBE TUBE A VIDE	1	ST. STEEL 316LN	LEIVCQLC0002	
QUANT.	DESCRIPTION	POS.	MAT.	OBSERVATIONS	REF.CERN
	ENS/ASS		S.ENS/S.ASS	LEILMQFB0003	
LEIR Vacuum Chamber for Quadrupoles Lorange-shaped (Variant C)				SCALE	DES/DRA. ACROTECNA 2006-07-25
QUADRUPOLES STACK VACUUM CHAMBER STACK DE QUADRUPOLES CHAMBRE A VIDE				1:2	CONTROLLED
					APPROVED
				LEIVCQLC0001	
				REPLACE/REPLACES	
NON VALABLE POUR EXECUTION NOT VALID FOR EXECUTION				QAC	SIZE IND.
				LEIVCQLC0001	1

ORGANIZATION EUROPEENNE POUR LA RECHERCHE NUCLEAIRE
 EUROPEAN ORGANIZATION FOR NUCLEAR RESEARCH
 LEIR Vacuum Chamber for Quadrupoles Lorange-shaped (Variant C)
 LEIR Vacuum Chamber for Quadrupoles Lorange-shaped (Variant C)
 LEIR Vacuum Chamber for Quadrupoles Lorange-shaped (Variant C)