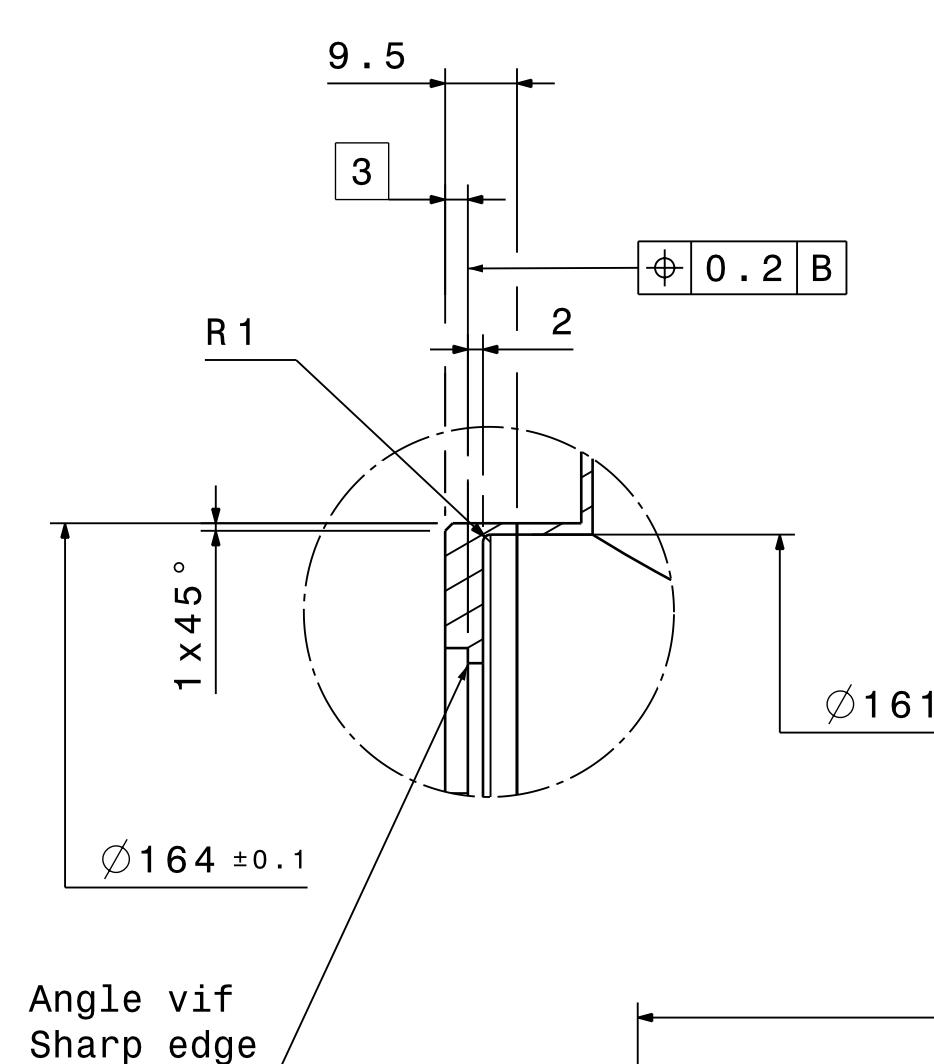
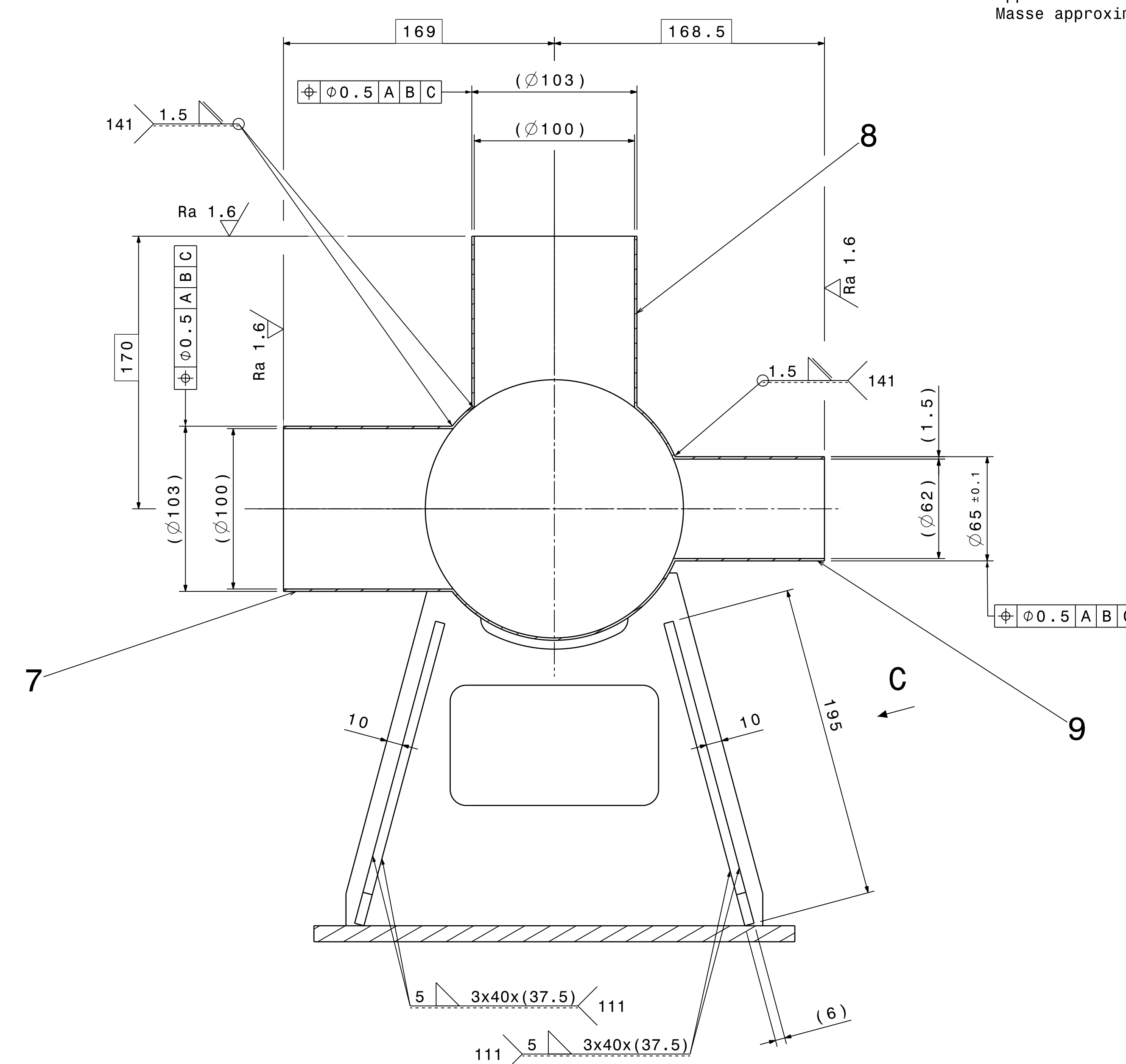


Approximative mass : 10 kg
Masse approximative

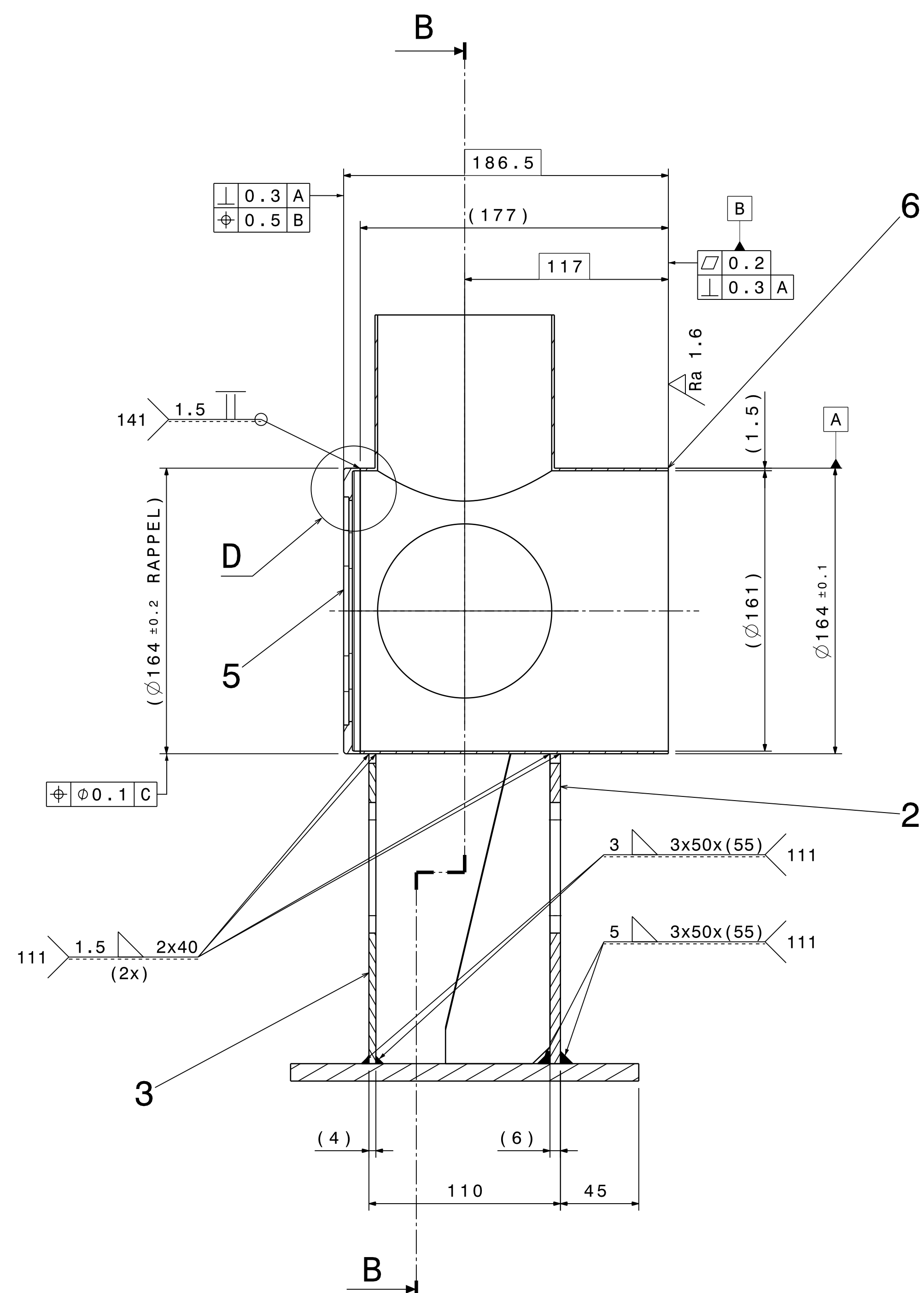
Détail D
Echelle : 1:1
Scale



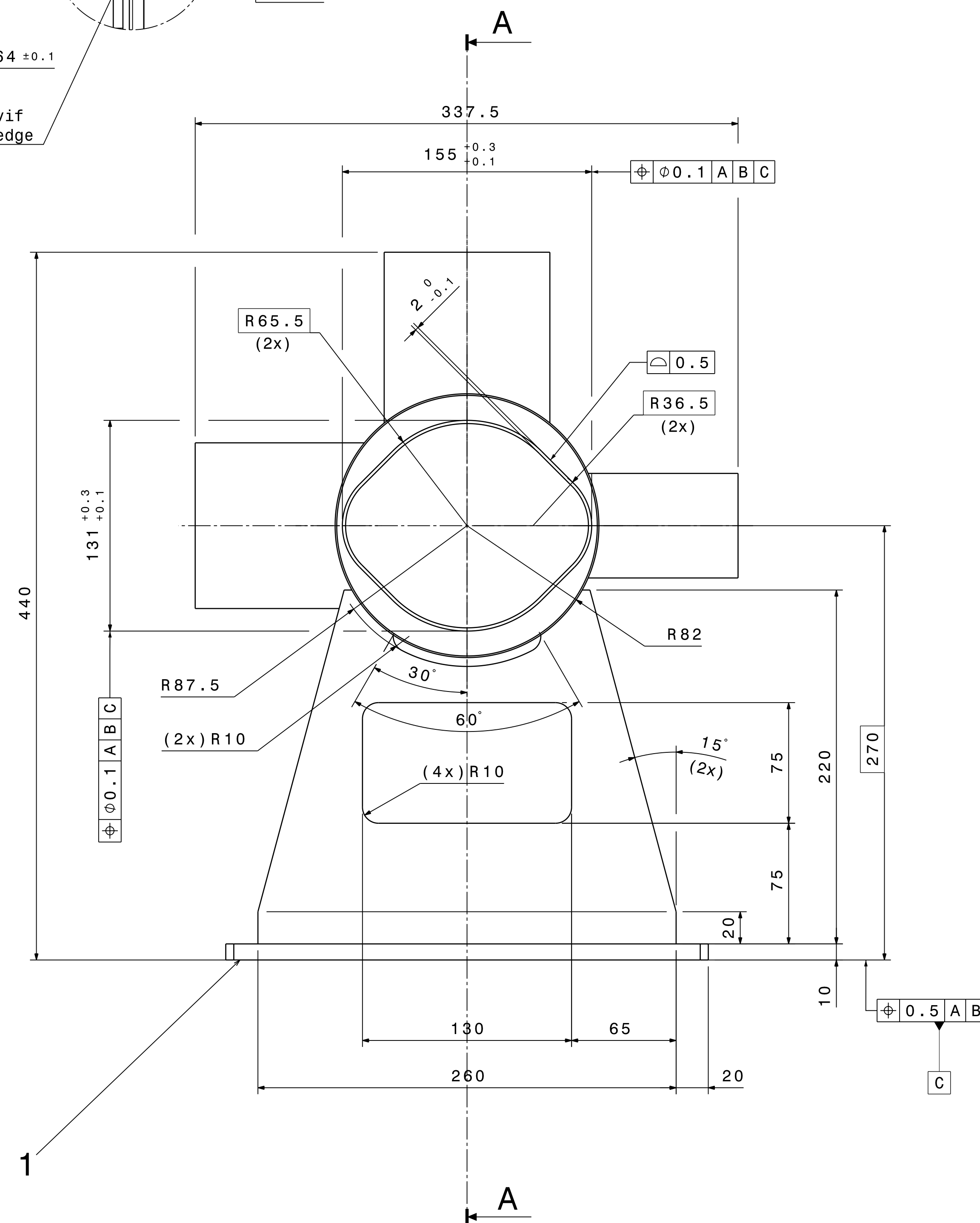
B-B



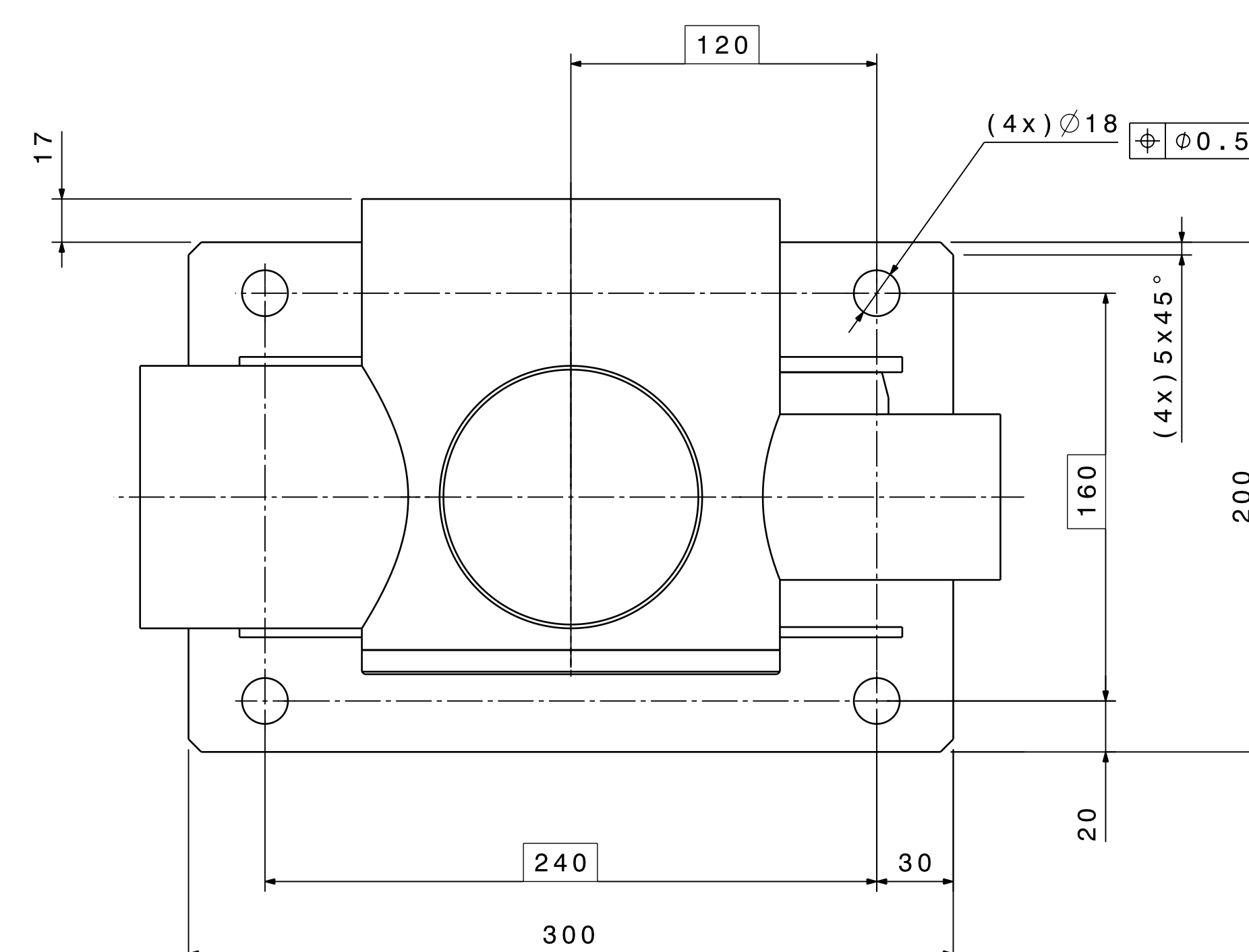
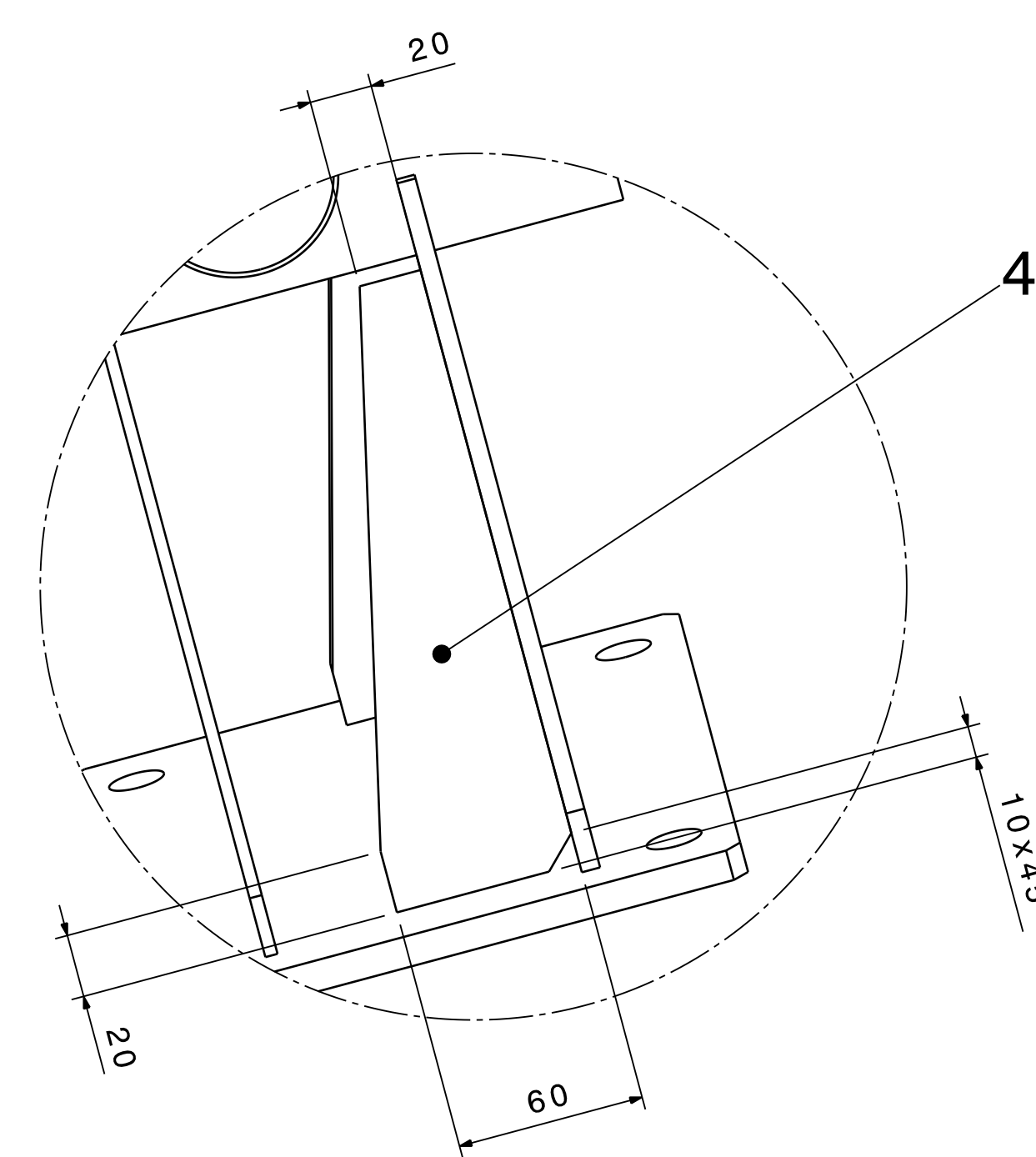
A-A



A



Vue C
View



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.

Cutting of the material : Ra 3.2
Decoupes des matieres

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

Tolerances geometriques, lineaires et angulaires	ISO 2768-mK-E	Ra 3.2	(Ra 1.6)
Arêtes de forme non définies	ISO 13715	0.3	0.3

QTY	DESCRIPTION	POS	MAT.	OBSERVATIONS	REF. CERN
1	SHEET TH. 1.5mm	9	ST. STEEL	205 (ØDEV.)x100x1.5	44.59.32
1	TUBE Ø103/Ø100	8	ST. STEEL	LONGEUR 115mm	515.8
1	TUBE Ø103/Ø100	8	ST. STEEL	LONGEUR 115mm	39.36.05
1	TUBE Ø103/Ø100	7	ST. STEEL	LONGEUR 115mm	800.0
1	SHEET TH. 1.5mm	6	ST. STEEL	515 (ØDEV.)x185x1.5	39.36.05
1	TUBE Ø103/Ø100	6	ST. STEEL	LONGEUR 115mm	800.0
1	TUBE Ø103/Ø100	6	ST. STEEL	LONGEUR 115mm	515.8
1	ROUND BAR Ø201	5	ST. STEEL	LENGTH 12mm	44.57.10
1	ROUND Ø201	5	ST. STEEL	LONGUEUR 12mm	368.1
2	SHEET TH. 6mm	4	ST. STEEL	200x85x6	44.59.32
2	TOLE EP. 6mm	4	304L		060.8
1	SHEET TH. 4mm	3	ST. STEEL	270x230x4	44.59.32
1	TOLE EP. 4mm	3	304L		040.2
1	SHEET TH. 6mm	2	ST. STEEL	270x230x6	44.59.32
1	TOLE EP. 6mm	2	304L		060.8
1	SHEET TH. 12mm	1	ST. STEEL	310x210x12	44.59.32
1	TOLE EP. 12mm	1	304L		112.3

DRYANT	LEIIMF0003	S. ENS/S. ASS	LEIVCQLD001
SCALE	1:2	ACROTECHNA	2006-07-11
CONTROLLED	1:1		
RELEASED			
APPROVED			
REPLACE/REPLACES			
NON VALABLE POUR EXECUTION			
NOT VALID FOR EXECUTION			
REF. CERN	LEIVCQLD003		