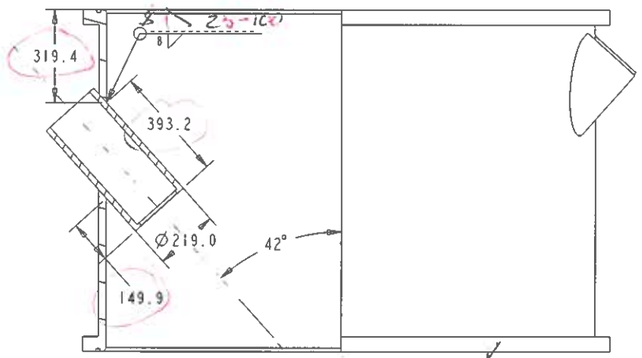
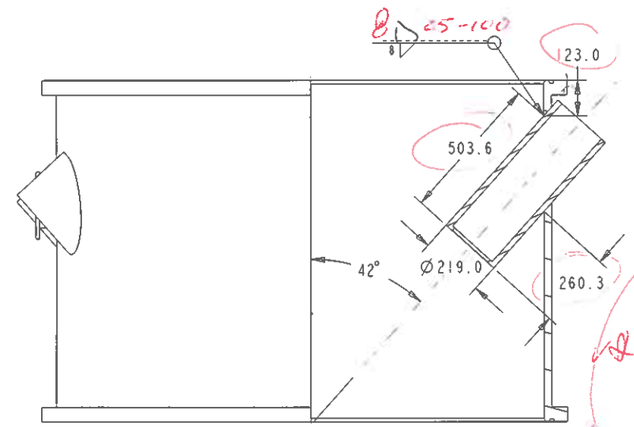
ITEM	DESCRIPTION	MAT'L	QUANTY



SECTION C-C
SCALE 0.100

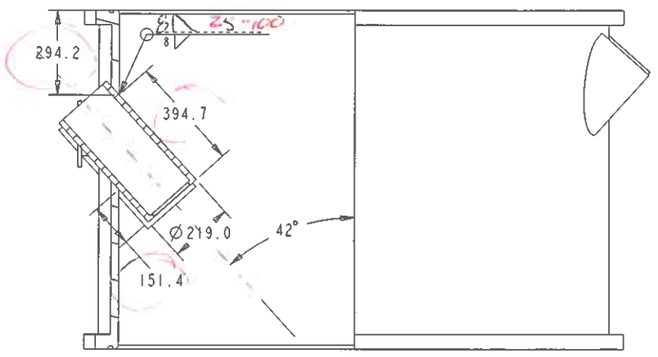


clearance?

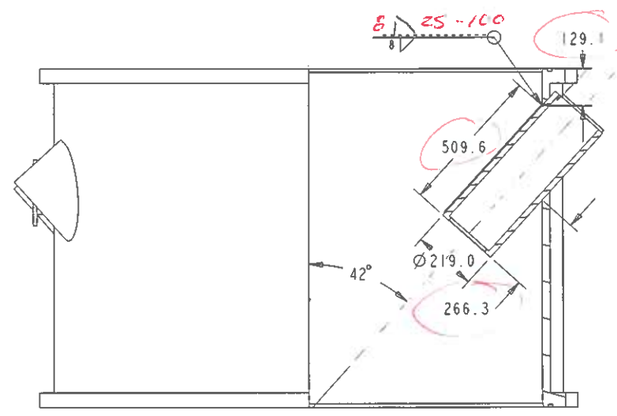
SECTION E-E
SCALE 0.100

?? AWS D1.1 ??

✓ * Welders Qualified to AWS minimum
* Welding Procedures Qualified in Accordance to AWS with Supporting PQR Procedure Qualification Records
✓ * Welds Inspected by AWS CWI minimum



SECTION D-D
SCALE 0.100



SECTION F-F
SCALE 0.100

NOTES:

1. CYLINDRICAL BODY SHALL BE MADE WITH CLEAN ROLLERS TO ELIMINATE ANY POSSIBILITY OF ANY INCLUSIONS BEING INTRODUCED INTO THE MATERIAL
2. WELDS SHALL BE CAREFULLY INSPECTED BEFORE MACHINING
3. ALL SEALING SURFACES MUST BE FREE OF NICKS/DENTS/SCRATCHES
4. DEGREASE ALL PARTS PRIOR TO WELDING
5. CYLINDRICAL BODY WELD SHOULD BE LOCATED APPROX 90 DEGREES FROM GAS PORT WELD
6. SMALL BLIND HOLE SHALL BE LOCATED DIRECTLY ACROSS FROM CYLINDRICAL BODY WELD
7. ALL INSIDE WELDS TO BE VACUUM TIGHT
8. FINISHED VESSEL TO BE VACUUM TIGHT. LEAK RATE MUST NOT EXCEED 2.0x10^-9 SCC PER SECOND OF HELIUM GAS
9. FINISHED VESSEL TO BE DEGREASED & CLEANED FOLLOWED WITH ETHANOL OR METHANOL RINSE
10. PROVIDE BLANK-OFF FLANGES TO MATCH EACH FLANGE — TYPE?
11. SUPPLY BOLTS/WASHERS/NUTS FOR ALL FLANGES CERTIFIED
12. SUPPLY O-RINGS FOR FLANGES — SIZE TYPE?
13. ✓ LEAK TESTING SHALL TAKE PLACE AT VENDOR FACILITY —

* Required Documents ??

CONSIDER ALTERNATIVE DIMENSIONING

REF. DWGS.	REV.	DATE	REVISION	BY	APP'D

ALL DIMENSIONS IN mm UNLESS OTHERWISE SPECIFIED
TOLERANCES UNLESS OTHERWISE SPECIFIED:
FRACTIONAL DIMENSIONS
DECIMAL DIMENSIONS X ± .1 XX ± .05
ANGULAR DIMENSIONS ±0.1°
SURFACE FINISH 32µm

UNIVERSITY OF ALBERTA
EDMONTON ALBERTA CANADA

DESIGNED CHRIS NG
DRAWN CHRIS NG
CHECKED
APPROVED

TELEPHONE: (780) 492 3095
FAX: (780) 492 3408
E-MAIL: cjng@ualberta.ca

CENTER OF PARTICLE PHYSICS

MAIN VESSEL
QUARTZ WINDOW WELDS

SCALE
DATE Jan 9, 2012
APPROVAL CHIEF ENGR.
DWG. NO
REV.