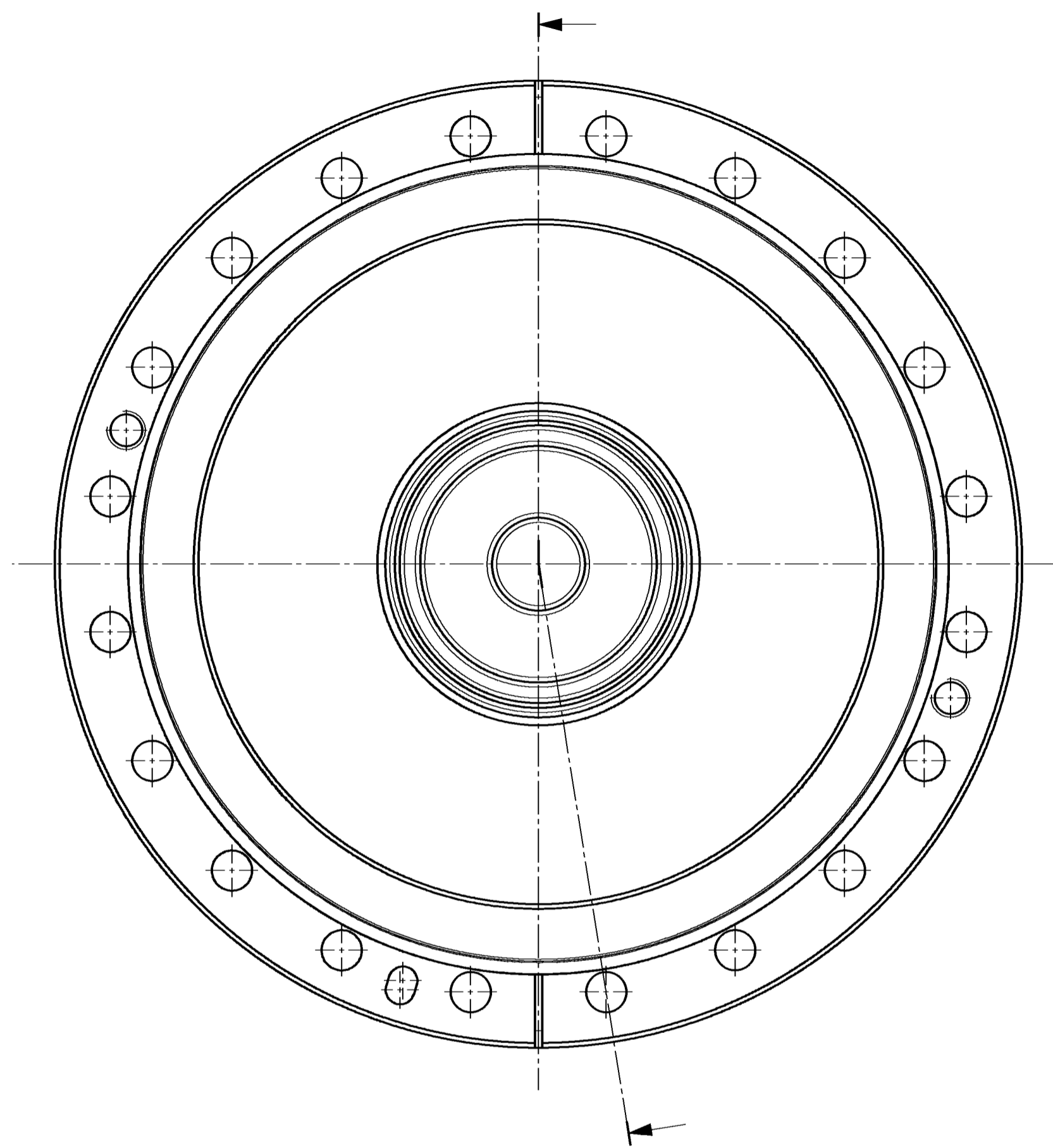
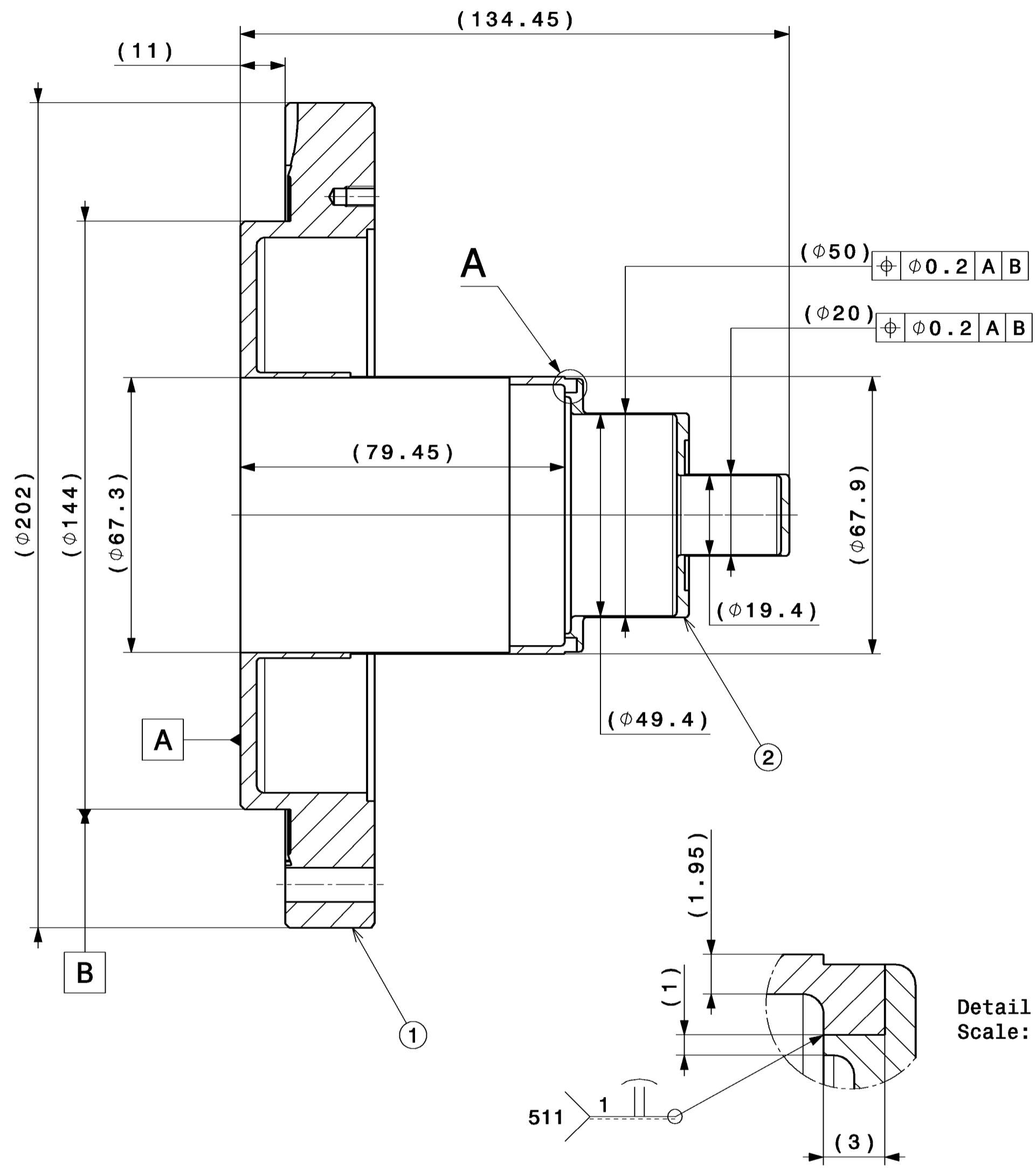


DESSTIN, RUGOSITE, TOLERANCES
 SELON NORMES ISO
 DRAWING, RUGOSITY, TOLERANCES
 ACCORDING TO ISO STANDARDS

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Detail A
Scale: 5:1

Mass 3.5Kg

Materials applied in the construction are submitted to the approval of the vacuum group
 All welds must be made using the specified techniques with 100% penetration.
 All water circuits inside the vacuum vessel with internal welds or brazing and in direct contact
 with the vacuum must be pressure tested with 100% helium at a pressure equivalent to the water pressure or higher.
 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 calculated leak rate (localized or global),
 when measured with a calibrated UHV leak detector according to ASTM E498-95 (2000),
 in excess of 2.0₁₀-11 Pa.m³.s⁻¹ (2.0₁₀-10 mbar.l.s⁻¹) will be considered as unacceptable.
 All surfaces in contact with vacuum shall be cleaned and degreased and free from contamination, dirt,
 welding scale and oil, according to CERN EDMS document 347564. Advise to obtain this result can be provided if necessary.
 Any cleaning specification different from this shall be submitted to CERN's approval.

| QUA | DESCRIPTION | POS | MAT. | OBSERVATIONS | REF. CERN |
|-----|-----------------------------|-----|--------------------|--------------|-----------|
| 1 | SHORT CYLINDRICAL MEMBRANE | 2 | St. Steel 316LN | SPSBWSRE0016 | |
| | MEMBRANE CYLINDRIQUE COURTE | | Vacuum (CERN 1001) | ST0468142 | |
| 1 | DN200 FOR MEMBRANE (A) | 1 | St. Steel 316LN | SPSBWSRE0015 | |
| | DN200 POUR MEMBRANE (A) | | Vacuum (CERN 1001) | ST0468143 | |

| ENS/ASS | | | S.ENS/S.ASS | | |
|---------------------|-----------|------------|--------------|--|--|
| To be defined | | | | | |
| DES/DRA. | N CHRITIN | 2012-12-12 | | | |
| CONTROLLED | T CAPELLI | 2013-03-18 | | | |
| RELEASED | R VENESS | 2013-03-25 | | | |
| APPROVED | - | - | | | |
| CAD Document Number | | | ST0468145_02 | | |
| REPLACES | | | | | |

| RELEASED BY | FOR | GAC | SIZE | IND. |
|------------------|---------------|-----|--------------|------|
| PROJECT ENGINEER | FOR EXECUTION | - | SPSBWSRE0014 | 2 |