LCLS Linac Coherent Light Source Stanford Synchrotron Radiation Laboratory Stanford Linear Accelerator Center

Issue Date: 12/14/07

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS ASSEMBLIES

VENDOR: ATLAS PART NAME: LCLS Vacuum Chamber Bi-metal flange

DRAWING #: L1440202-200050-01 SERIAL #: 38

P.O. #: 8A-00803 DATE:

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage. has burr on large flat o.d.	Accept/Reject
2. Obtain manufacturers certification data delivered with flange.	Accept/Reject
3. Verify the upstream and downstream flanges fit snugly on the chamber weld locations.	Accept/Reject
4. Leak check flange per section 3.4 and 3.5 of ESD 1.4-118	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE		
Slot thickness	7.00	± .08	7.19	Accept/Reject	- OK MJE
Overall length	24.71	+ 0 / -.10	24.58/24.58 24.56 24.58	Accept/Reject	- OK MATCH @ WELDING
Flatness	<= .03	N/A	< .03	Accept/Reject	
Angle	15°	± 0.3°	Re-Machined at Hitech to 15°	Accept/Reject	
Perpendicularity to A (2X)	<= .03	N/A	≤ .03	Accept/Reject	

INSPECTOR: MB & DN QA Supervisor: MJE

TEST EQUIPMENT USED: DIGITAL HT. GAUGE

COMMENTS:
Sealed @ 50 in lb torque (new gskt + anti-seize); < 2.5 X 10^-10 mb l/s LR RXO 12/28/07

Inside Surface polished with 60 + 30 micron polishing paper