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 #: Ø5

P.O. #: 8A-00803 DATE: 12-18-07

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	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	24.707 / 24.706 24.686 / 24.707	Accept/Reject	
Flatness	<= .03	N/A	<.03	Accept/Reject	
Angle	15°	± 0.3°		Accept/Reject	RECUT AT HITECH
Perpendicularity to A (2X)	<= .03	N/A	A <.005 /	Accept/Reject	MB

INSPECTOR: MB & DN QA Supervisor: MJE

TEST EQUIPMENT USED: DIGITAL HEIGHT GAUGE

COMMENTS:
Sealed @ 55 in lb torque, ≤ 3.1 x 10^-10 mbl/s LR. 12/21/07