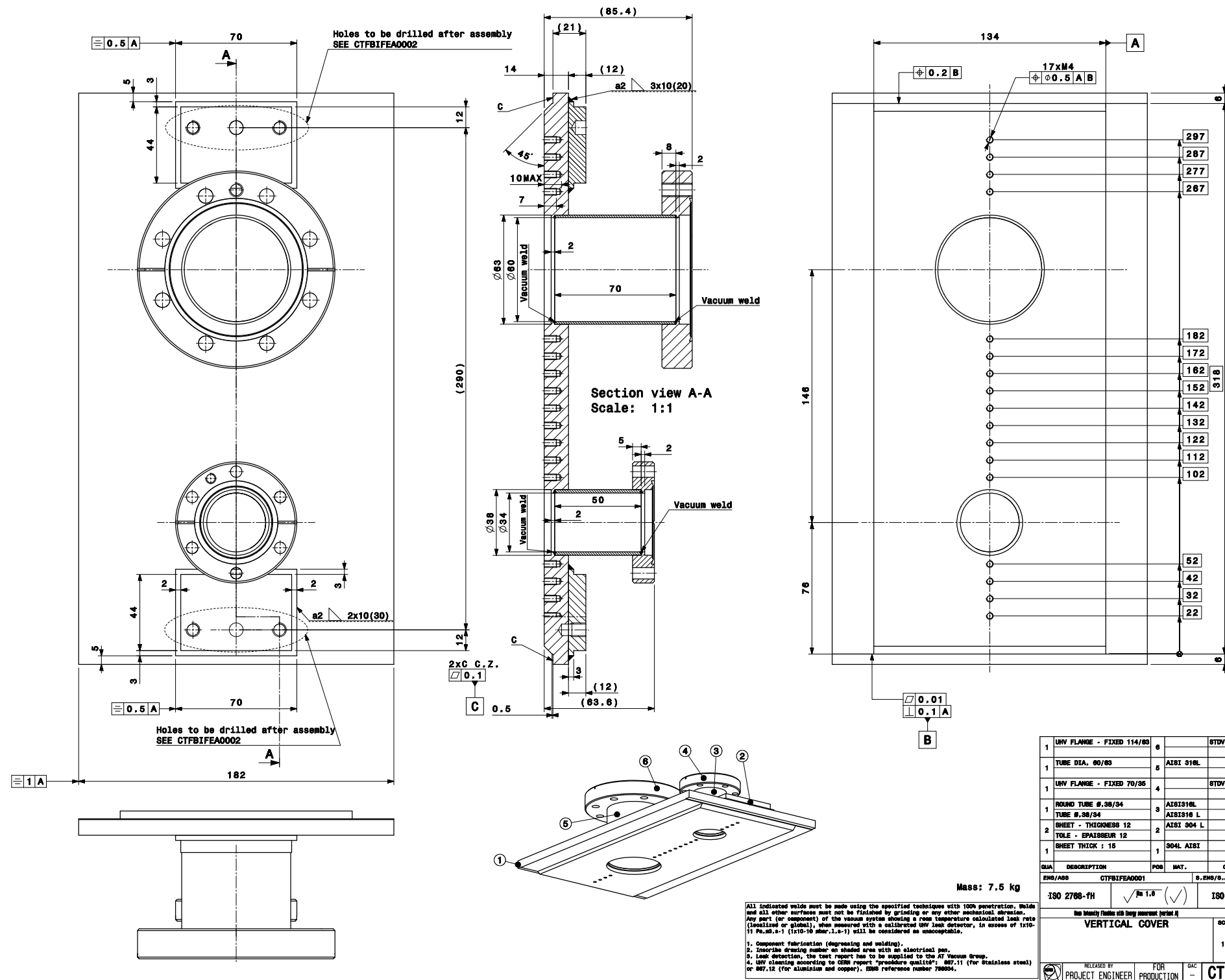


CONSTRUCTION OF THE VERTICAL COVER SHALL BE IN ACCORDANCE WITH THE DRAWING AND THE INSTRUCTIONS GIVEN THEREIN. THE MANUFACTURER SHALL BE RESPONSIBLE FOR THE QUALITY OF THE FABRICATION. THE FABRICATOR SHALL BE RESPONSIBLE FOR THE QUALITY OF THE FABRICATION. THE FABRICATOR SHALL BE RESPONSIBLE FOR THE QUALITY OF THE FABRICATION.



QTY	DESCRIPTION	POB	MAT.	OBSERVATIONS	REF. QDM
1	UVF FLANGE - FIXED 114/85	6		STDVFM0007	18.00.18 010.8
1	TUBE DIA. 60/63	5	AISI 316L		39.98.05 888.2
1	UVF FLANGE - FIXED 70/35	4		STDVFM0005	18.00.18 005.3
1	ROUND TUBE 6.38/34	3	AISI316L		39.98.05 885.5
2	SHEET - THICKNESS 12	2	AISI 304 L		44.69.33 012.2
1	SHEET THICK : 15	1	304L AISI		44.69.33 015.9

DES/DRA.	G. FOFAND	2009-06-19
CONTROLLED	N. CHITIN	2009-06-19
RELEASED	R. RUBER	2009-06-26

ISO 2768-FH	√ M 1.0 (✓)	ISO 13715	-0.05	+0.05
VERTICAL COVER				
SCALE: 1:1			REPLACES: CTFBIFEAD\CTFBIFEAD004	
RELEASED BY: PROJECT ENGINEER	FOR PRODUCTION	DWG. NO.:	CTFBIFEAD004	
				SIZE: 1

All indicated welds must be made using the specified technique 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 non temperature calculated leak rate (normal or global), when measured with a calibrated UHF leak detector, in excess of 1x10⁻¹¹ Pa.m³.s⁻¹ (1x10⁻¹⁰ mbar.l.s⁻¹) will be considered as unacceptable.

- Component fabrication (degreasing and welding).
- Inscribe drawing number on shaded area with an electrical pen.
- Leak detection, the test report has to be applied to the UHF Vacuum Group.
- UVF cleaning according to OEM report "procedure qualite": 887.11 (for Stainless steel) or 887.12 (for aluminium and copper). ISO reference number 78804.