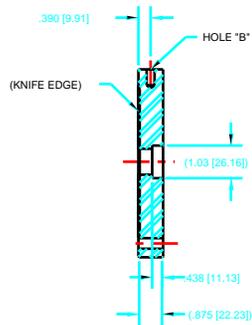
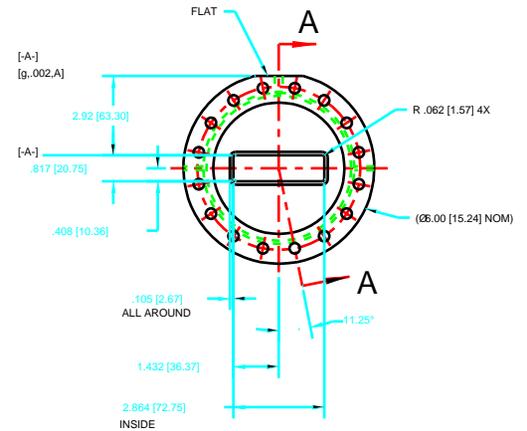


HOLE "B"

SCALE: 2X



SECTION A-A



NOTES:

1. MAKE FROM MDC'S NON-ROTATABLE 6" O.D. NOM. BLANK FLANGE CAT. # 110025
2. WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:
A) CIMCOOL 5 STAR 49
B) TRIM SOL
3. THIS IS A UHV PART. ELECTROPOLISHING IS NEEDED BEFORE WELDING. PRIOR TO ELECTROPOLISHING, THE PART NEEDS TO GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOW DOWN.
4. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
5. DIMENSIONS IN [] ARE MILLIMETERS

REV	DATE	DESCRIPTION	BY	CHKD	DATE
02		UPDATED DIMS			
01		CHANGE DESCRIPTION			

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES TOLERANCES: DECIMALS ANGULAR X .001/0.002 .001/0.002 XX .01/0.02 .001/0.001 XXX .005/0.01				
SURFACE ROUGHNESS 125				
REMOVE ALL BURRS AND BREAK SHARP EDGES (R MAX)				
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1				
DIMENSIONS & TOLERANCING BY ACCORDANCE WITH LATEST ANSI Y14.5				
DO NOT SCALE DRAWING				
LOG NUMBER A18054		THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY		
DRAWN BY E.G.	DATE 7/93	CHIEF DESIGN ENGINEER D. SHU	DATE 7/7/93	TITLE ADVANCED PHOTON SOURCE
DESIGNED BY T. SANCHEZ	DATE 7/7/93	PROJECT MGR T.M. KUZAY	DATE 7/8/93	K1 I.D. RATCHET WALL COLLIMATOR END FLANGE
DESIGNER SANCHEZ/E.G.				
RESPONSIBLE ENGINEER T. SANCHEZ	DATE 7/7/93	APPROVED/RELEASED		
MATERIAL SEE NOTE #1		SCALE 1=2	SHEET 1 of 1	DRAWING NUMBER P4102010102-220302-02