



- NOTES:
1. WHEN MACHINING VACUUM PART, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:  
A) CIMCOOL 5 STAR 49  
B) TRIM SOL
  2. 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 BLOWDOWN.
  3. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
  4. DIMENSIONS IN [ ] ARE MILLIMETERS AND FOR REFERENCE ONLY.
  5. WALL THICKNESS NOT TO BE LESS THAN .100 AFTER MACHINING IF NEEDED.

REV	CHANGE DESCRIPTION	BY	CHKD	DATE
01	WAS 5.197 INSIDE; ADDED .105	DB		

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES TOLERANCES:		LOG NUMBER <b>A0989801</b>		
DECIMALS .010 - .250 .005 - .020 XXX - .005		ANGULAR .25		
SURFACE ROUGHNESS 125		THIS DRAWING IS THE PROPERTY OF <b>ARGONNE NATIONAL LABORATORY</b>		
REMOVE ALL BURRS AND BREAK SHARP EDGES (S.M.M.)		DRAWN BY <b>RICK KRAKORA</b> 4/93		
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST AMS-B4		DATE <b>4/93</b>		
DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5		CHIEF DESIGN ENGINEER <b>D. SHU</b> 4/16/93		
DO NOT SCALE DRAWING		DESIGNER <b>T. SANCHEZ</b> 4/15/93		
		PROJECT MGR. <b>T.M. KUZAY</b> 4/16/93		
		APPROVED/RELEASED <b>T. SANCHEZ</b> 4/15/93		
		MATERIAL <b>12 GA. (.105) 304 SST</b>		
		SCALE <b>1=1</b>		
		SHEET <b>1 of 1</b>		
		DRAWING NUMBER <b>P4102020102-220101-01</b>		

ADVANCED PHOTON SOURCE  
K2 B.M. SECOND COLLIMATOR  
VACUUM CHAMBER  
RECTANGULAR TUBING