



NOTES:

1. 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
2. THIS IS A UHV PART, ELECTROPOLISHING IS NEEDED BEFORE WELDING. PRIOR TO ELECTROPOLISHING, THE PART MUST GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOW DOWN.
3. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
4. DIMENSIONS IN [] ARE MILLIMETERS AND FOR REF. ONLY

SECTION A - A

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY										
PARTS LIST														
UNLESS OTHERWISE SPECIFIED LOG NUMBER ALL DIMENSIONS ARE IN INCHES		A17040	THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY											
TOLERANCES DECIMALS ANGULAR .X ± .03 [0.7620] ± .25 ° .XX ± .01 [0.25] .XXX ± .005 [0.127]		DRAWN BY MUSCIA CHECKED BY DESIGNER SHU/MUSCIA RESPONSIBLE ENGINEER	DATE 3/14/94 CHIEF DESIGN ENGINEER GP LEADER PROJECT MGR. APPROVED/RELEASED	TITLE ADVANCED PHOTON SOURCE M1 APS FRONT END 1-ST FIXED MASK 4" O.D. EXTENSION TUBE										
SURFACE ROUGHNESS $\sqrt{125}$ ✓ REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX. SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1 DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5		MATERIAL 304 STAINLESS STEEL	SCALE HALF	SIZE B										
<table border="1" style="width:100%; border-collapse: collapse;"> <tr> <th style="width:10%;">SYM</th> <th style="width:60%;">CHANGE DESCRIPTION</th> <th style="width:10%;">BY</th> <th style="width:10%;">CHKD</th> <th style="width:10%;">DATE</th> </tr> <tr> <td colspan="5" style="text-align: center;">REVISIONS</td> </tr> </table>		SYM	CHANGE DESCRIPTION	BY	CHKD	DATE	REVISIONS					DRAWING NUMBER P4102010101-210011-00		SHEET 1 of 1
SYM	CHANGE DESCRIPTION	BY	CHKD	DATE										
REVISIONS														
DO NOT SCALE DRAWING														