



NOTES:

1. THIS IS A ULTRA- HIGH VACUUM COMPONENT (UHV)
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. FINISHING: WHEN MACHINING VACUUM PARTS USE OF ABRASIVE PAPER OR SANDING DISCS, BUFFING OR POLISHING COMPOUNDS, OR RESIN-BONDED GRINDING WHEELS IS PROHIBITED
4. CLEANING: THE COMPONENT MUST BE CLEANED SUCH THAT A UHV PRESSURE OF 1×10^{-9} TORR CAN BE ACHIEVED
5. HANDLING: THE COMPONENTS SHALL BE HANDLED WITH WHITE SILK GLOVES AND WRAPPED WITH ALUMINUM FOIL TYPE DRY ANNEAL AND UNDER CLEAN ROOM CONDITIONS
6. DIMENSIONS IN [] ARE MILLIMETERS AND FOR REF. ONLY

SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES		LOG NUMBER M2410003-00	THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY	
TOLERANCES DECIMALS ANGULAR .X - .1 [2.5] - 0°30' .XX - .01 [0.25] .XXX - .005 [0.13]		DRAWN BY MUSCIA CHECKED BY J. CHANG DESIGNER SHU/MUSCIA RESPONSIBLE ENGINEER D. SHU	DATE 2/17/98 DATE 3/20/98 DATE 2/17/98 DATE 3/20/98	CHIEF DESIGN ENGINEER D. SHU GP LEADER T.M. KUZAY PROJECT MGR. APPROVED/RELEASED DATE
SURFACE ROUGHNESS 125 ✓		TITLE ADVANCED PHOTON SOURCE M2-40 APS 4-ID FRONT END 2 ND FIXED MASK RECTANGULAR EXTENSION TUBE		
REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX.		SCALE 1:1 SIZE B		
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1		DRAWING NUMBER M2-410003-00		
DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5		SHEET 14		
DO NOT SCALE DRAWING				