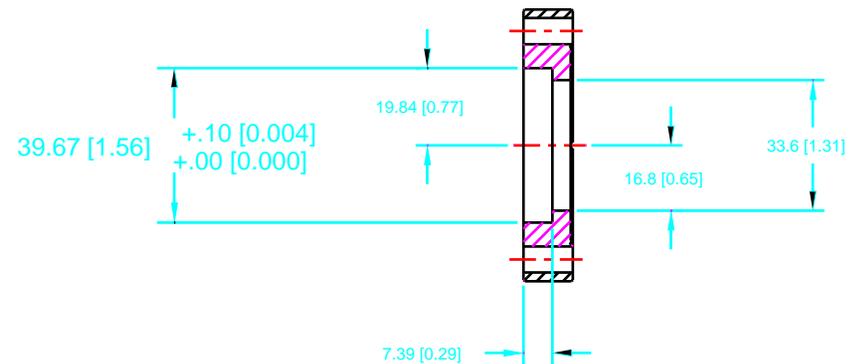
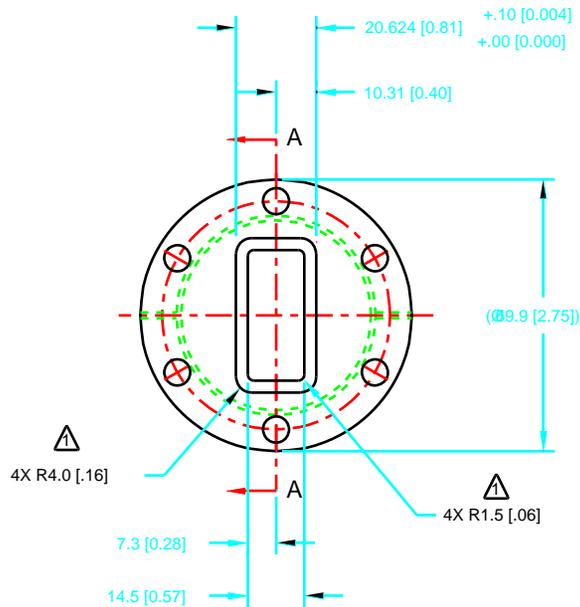


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SECTION A - A

NOTES:

1. MAKE FROM MDC'S NONROTATABLE VACUUM FLANGE CAT. #110008
2. THIS IS A ULTRA- HIGH VACUUM COMPONENT (UHV)
3. 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
4. ALL SURFACES MUST BE MACHINED FOR CLEAN UP
5. FINISHING: WHEN MACHINING VACUUM PARTS USE OF ABRASIVE PAPER OR SANDING DISCS, BUFFING OR POLISHING COMPOUNDS, OR RESIN-BONDED GRINDING WHEELS IS PROHIBITED
6. CLEANING: THE COMPONENT MUST BE CLEANED SUCH THAT A UHV PRESSURE OF 1×10^{-9} TORR CAN BE ACHIEVED
7. HANDLING: THE COMPONENTS SHALL BE HANDLED WITH WHITE SILK GLOVES AND WRAPPED WITH ALUMINUM FOIL TYPE DRY ANNEAL AND UNDER CLEAN ROOM CONDITIONS
8. BREAK ALL SHARP CORNERS 0.03
9. DIMENSIONS IN [] ARE INCHES AND FOR REF. ONLY

1	4X R4.0 [.16] WAS 8X R1.0 [.04]			
	4X R1.5 [.06] WAS 8X R1.0 [.04]	M.J.M		
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 MILLIMETERS TOLERANCES DECIMALS ANGLES .X ±.7 [0.03] ±.25° .XX ±.25 [0.01] .XXX ±.12 [0.005]		LOG NUMBER A2534501	THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY	
SURFACE ROUGHNESS 1.6 [63]		DRAWN BY MUSCIA	DATE 9/16/96	CHIEF DESIGN ENGINEER D. SHU
REMOVE ALL BURRS AND BREAK SHARP EDGES AS MAX.		CHECKED BY SHU/CHANG	DATE 11/16/96	GP LEADER M. KUZAY
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1		DESIGNER SHU/MUSCIA	DATE 9/16/96	PROJECT MGR.
MACHINING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.2		RESPONSIBLE ENGINEER D. SHU	DATE 11/16/96	APPROVED/RELEASED
DO NOT SCALE DRAWING		MATERIAL SEE NOTE #1	SCALE 1:1	SIZE C
			SHEET 1 of 1	DRAWING NUMBER P4105091005-400002-01

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