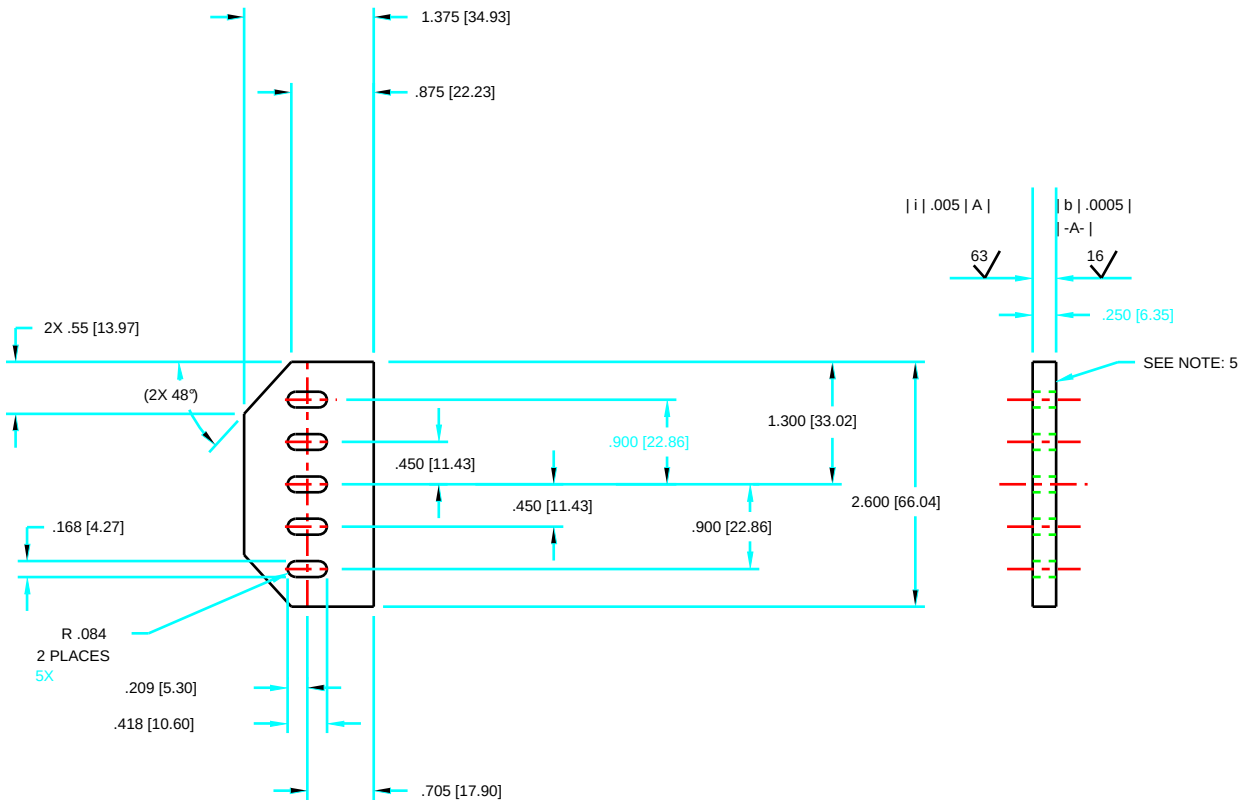
(℄	PLOT SCALE: 1=1	DWG. SCALE: 1	



NOTES:

1. THIS IS A UHV PART. ELECTROPOLISHING IS NEEDED. PRIOR TO ELECTROPOLISHING, THE PART NEEDS TO GO THROUGH A A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOW DOWN.
2. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
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 DIMENSIONS WITH [ ] ARE IN MILLIMETERS.
5. THIS SURFACE SHALL CONTACT WITH O.F.H.C. COPPER WHEN ASSEMBLE.

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY

PARTS LIST

UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES

TOLERANCES

DECIMALS	ANGULAR
.X – .015 [0.381]	– .25
.XX – .010 [0.254]	
.XXX – .006 [0.152]	

SURFACE ROUGHNESS 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

DO NOT SCALE DRAWING

LOG NUMBER A2535300

THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY

DRAWN BY corcuera	DATE 9/10/96	CHIEF DESIGN ENGINEER D. SHU	DATE 10/3/96
CHECKED BY J. CHANG	DATE 10/1/96	GP LEADER T. KUZAY	DATE 10/20/96
DESIGNER CHANG/ CORCUERA	DATE 9/10/96	PROJECT MGR.	DATE
RESPONSIBLE ENGINEER J. CHANG	DATE 10/1/96	APPROVED/RELEASED	DATE

TITLE

ADVANCED PHOTON SOURCE

M6 BM1 WHITE BEAM
FIXED MASK
COOLING PLATE

MATERIAL GLID-COP (GRADE AL-25)

SCALE 1:1 SHEET 1 of 1

SIZE C

DRAWING NUMBER P4105091006-200001-00

SYM	CHANGE DESCRIPTION	BY	CHKD	DATE

REVISIONS