

(C)

PLOT SCALE: 1=1

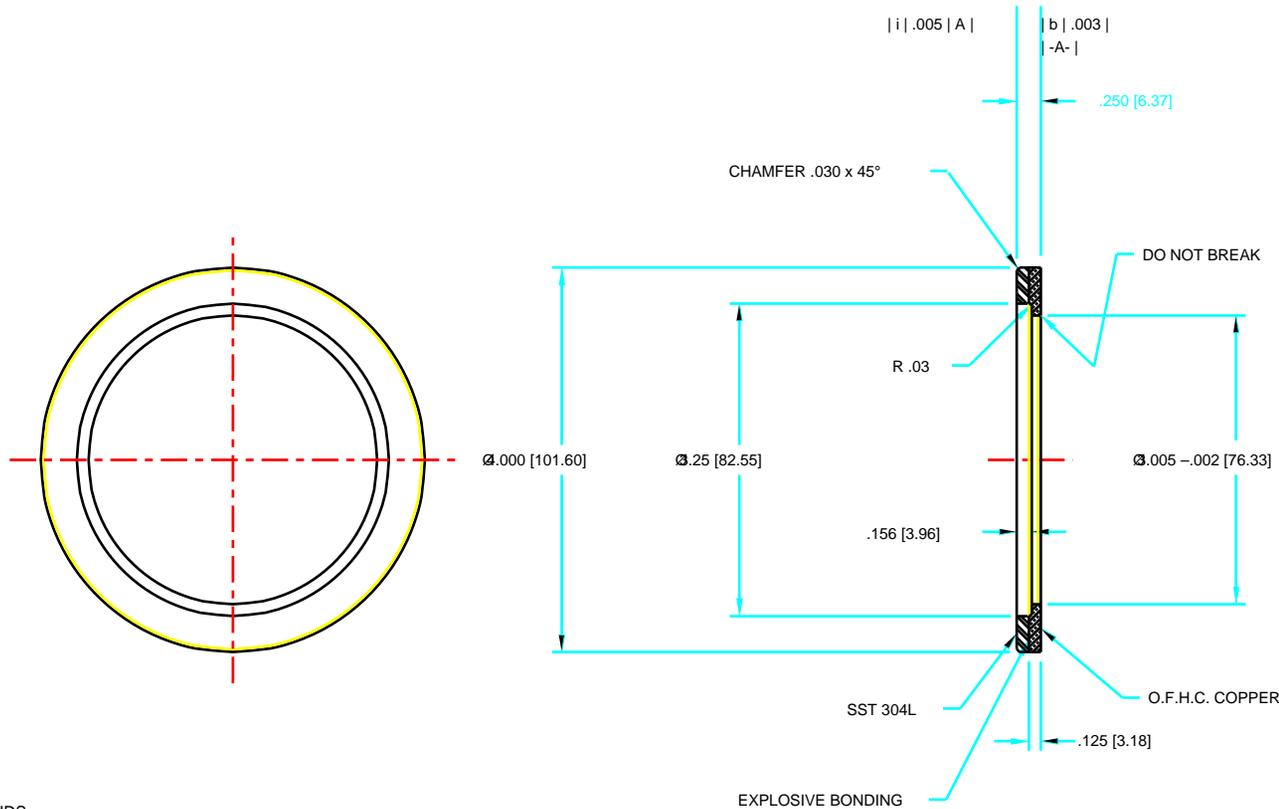
DWG. SCALE: 1

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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. CERTIFICATION OF 100° ULTRA SONIC TEST SHALL BE SIGNED BY A CONTRACTOR REPRESENTATIVE AUTHORIZED TO SIGN SUCH CERTIFICATION
3. THIS IS A UHV PART.
THE PART NEEDS TO GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOW DOWN.
4. KEEP THE ASSEMBLY CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
5. 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 A2540500	THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY	
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				
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 10/1/96	PROJECT MGR.	DATE
RESPONSIBLE ENGINEER J. CHANG		DATE 10/1/96	APPROVED/RELEASED	DATE
MATERIAL				
		SCALE 1:1	SIZE C	DRAWING NUMBER P4105091006-210003-00
		SHEET 1 of 1		

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