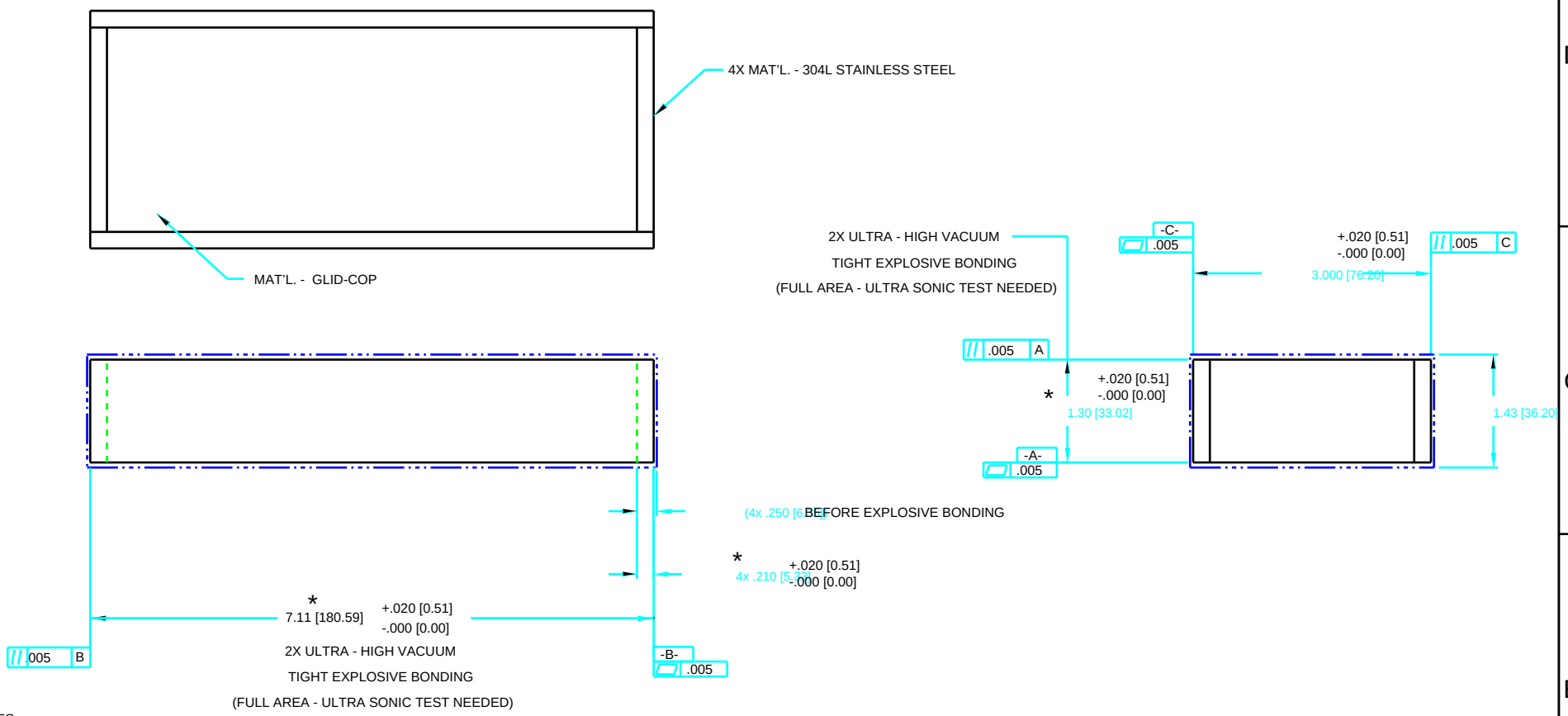

NOTES:

1. THIS DRAWING IS FOR EXPLOSIVE BONDING USE ONLY.
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. FINISHING: WHEN MACHINING VACUUM PARTS USE OF ABRASIVE PAPER OR SANDING DISCS, BUFFING OR POLISHING COMPOUNDS, OR RESIN-BONDED GRINDING WHEELS IS PROHIBITED
5. ASSEMBLY SHALL BE ULTRASONICALLY TESTED AND CERTIFIED. CERTIFICATION OF ULTRA SONIC TEST SHALL BE SIGNED BY A CONTRACTOR REPRESENTATIVE TO SIGN SUCH CERTIFICATION
6. DIMENSIONS IN [ ] ARE MILLIMETERS AND FOR REF. ONLY
7. DIMENSIONS IN ( ) ARE FOR REF. ONLY

* MACHINE AFTER EXPLOSIVE BONDING

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

PARTS LIST

SYM	CHANGE DESCRIPTION	BY	CHKD	DATE

REVISIONS

UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES

TOLERANCES

DECIMALS: .X – .1 [2.5]; .XX – .01 [0.25]; .XXX – .005 [0.13]

ANGULAR – 0°30'

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: M7420101-00-1

THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY

DRAWN BY: MUSCIA	DATE: 2/4/00	CHIEF DESIGN ENGINEER: D. SHU	DATE: 4/11/00
CHECKED BY: J. CHANG	DATE: 4/10/00	GP LEADER: T.M. KUZAY	DATE: 4/12/00
DESIGNER: SHU/MUSCIA	DATE: 2/4/00	PROJECT MGR.	DATE
RESPONSIBLE ENGINEER: D. SHU	DATE: 4/11/00	APPROVED/RELEASED	DATE

TITLE: ADVANCED PHOTON SOURCE
M7-42 FIXED MASK
FOR 3-ID-A X-LENS
UPPER HALF BODY

MATERIAL: SEE ABOVE

SCALE: 1:1 SHEET 1 OF 2

SIZE: C

DRAWING NUMBER: M7-420101-00-1