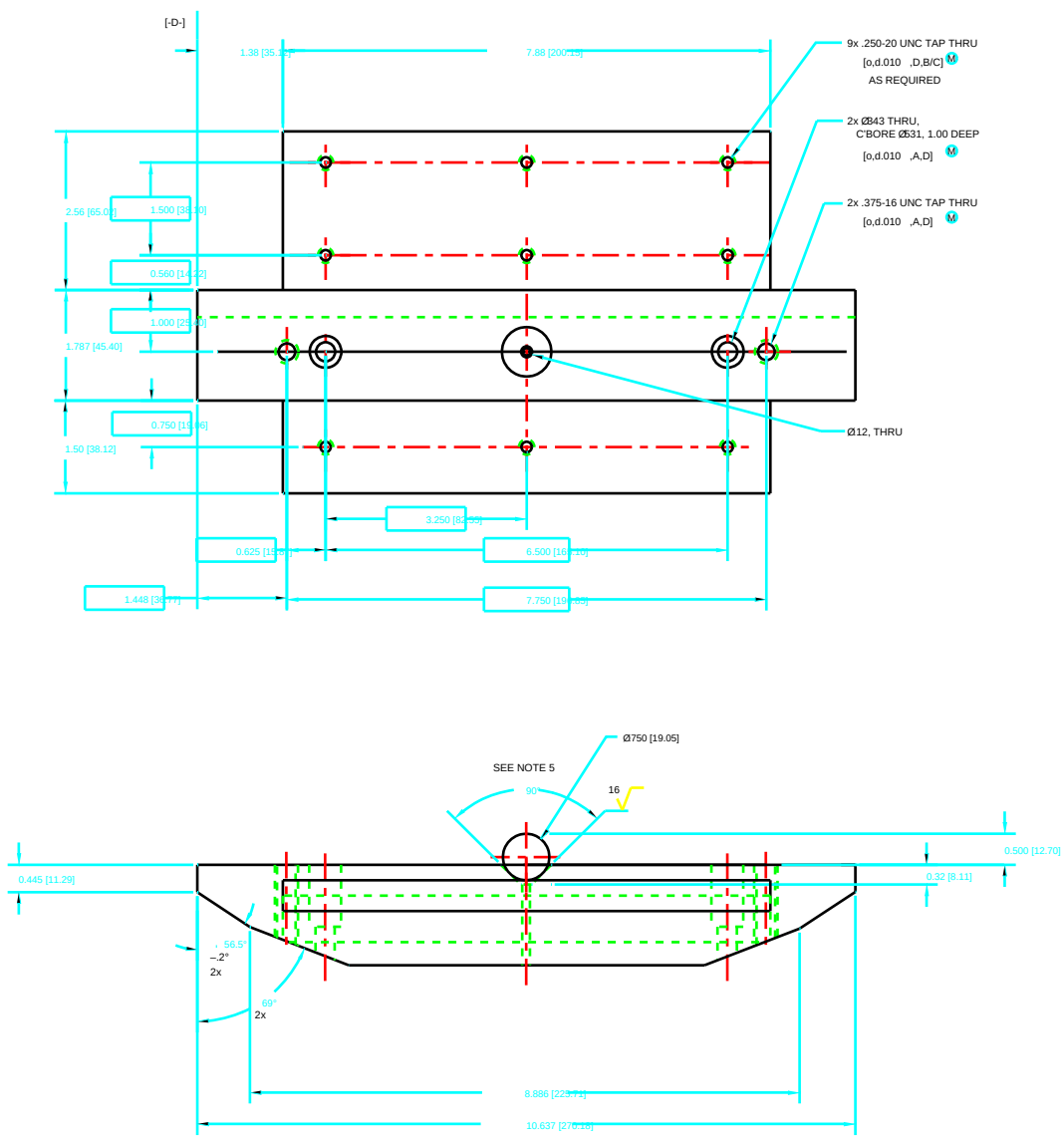

NOTES:

1. WHEN MACHINING VACUUM PARTS, THE USE OF SILICONE, SULPHUR-BASED CUTTING FLUIDS AND ABRASIVES IS PROHIBITED. USE EITHER TRIM SOL OR CIMCOOL 5 STAR 49 OR APPROVED EQUAL LUBRICANT.
2. FOR COMPLETE SPECIFICATIONS ON MACHINING, CLEANING, VACUUM REQUIREMENTS, TESTING AND DELIVERY PREPARATION, SEE ANL DOCUMENT #410201-00095.
3. FOR COMPLETE WELDING SPECIFICATIONS, SEE ANL DOCUMENT #AMS 2685C.
4. DIMENSIONS IN BRACKETS [ ] ARE MILLIMETERS AND FOR REF. ONLY.
5. HARDEN SURFACE SHOWN TO RC 56-58 - .06 MIN. DEPTH. SURFACE HARDENING OF ENTIRE PART IS PERMISSIBLE.

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

PARTS LIST

UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES

TOLERANCES

DECIMALS	ANGULAR
.X ± .1 [2.5]	± 0°30'
.XX ± .01 [0.25]	
.XXX ± .005 [0.13]	

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 Y5300005-00

THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY

DRAWN BY RF FUHRMANN	DATE	CHIEF DESIGN ENGINEER D. Shu	DATE
CHECKED BY BENSON	DATE	GP LEADER T.M. Kuzay	DATE
DESIGNER BENSON/FUHRMANN	DATE	PROJECT MGR.	DATE
RESPONSIBLE ENGINEER BENSON	DATE	APPROVED/RELEASED	DATE

TITLE
ADVANCED PHOTON SOURCE
Y5-30 MIRROR
KINEMATIC PLATE

MATERIAL STSTL 440 SEE NOTE 5

SCALE 1:1 SIZE D DRAWING NUMBER Y5-300005-00

SHEET 1 of 1

SYM	CHANGE DESCRIPTION	BY	CHKD	DATE

REVISIONS