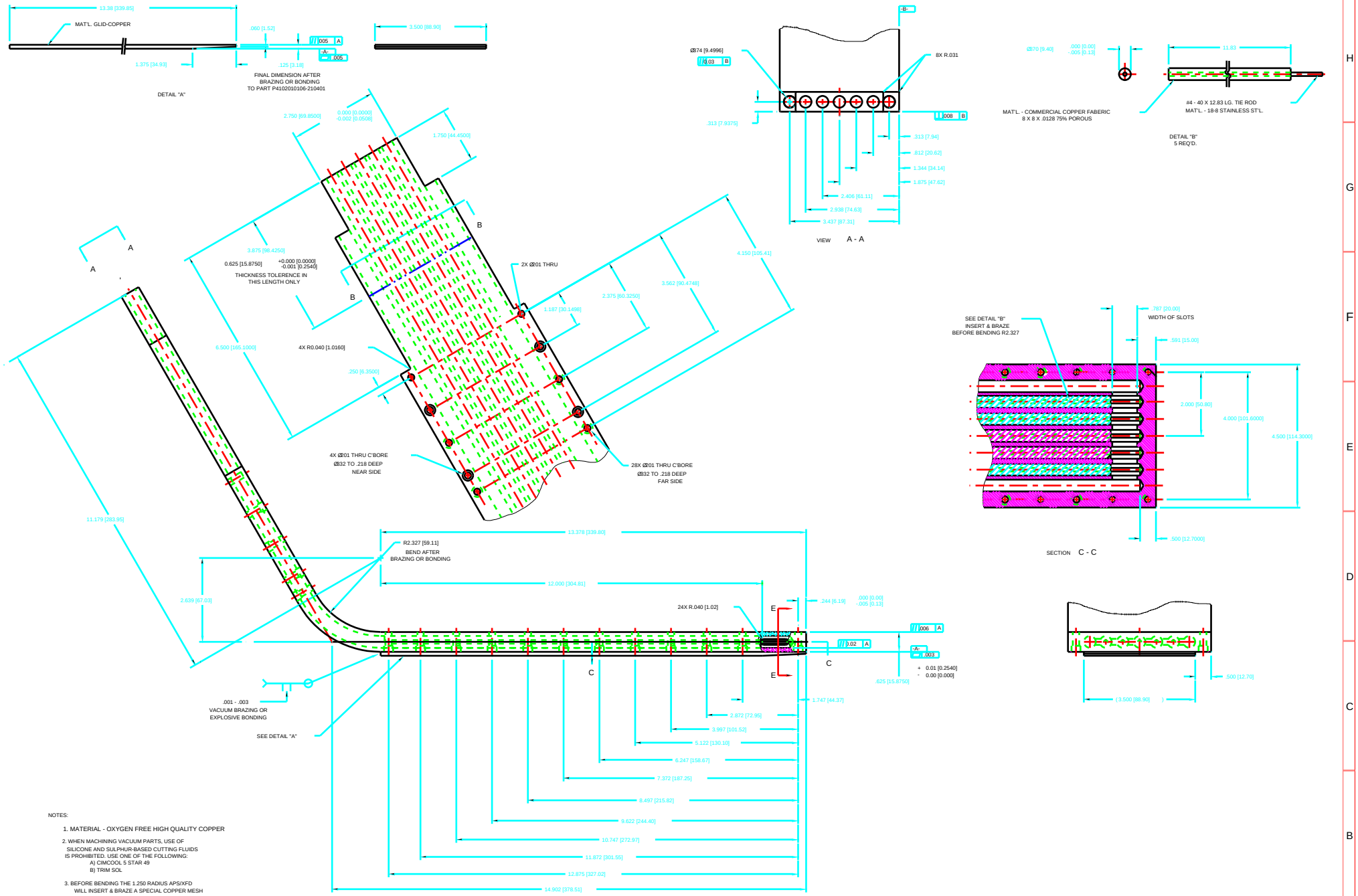
(E	PLOT SCALE: 1=1	DWG. SCALE: 1	A13467



NOTES:

1. MATERIAL - OXYGEN FREE HIGH QUALITY COPPER
2. 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
3. BEFORE BENDING THE 1.250 RADIUS APS/XFD WILL INSERT & BRAZE A SPECIAL COPPER MESH
4. ALL SURFACE FINISHES SHALL BE 63
5. THIS IS A UHV PART, ELECTROPOLISHING IS NEEDED BEFORE WELDING. PRIOR TO ELECTROPOLISHING, THE PART NEEDS TO GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOW DOWN.
6. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
7. DIMENSIONS IN [ ] ARE MILLIMETERS

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

PARTS LIST

UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES
TOLERANCES:
DECIMALS: X ± .03, XX ± .01, XXX ± .005
ANGULAR: ± .25
SURFACE ROUGHNESS: 63
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

SYM	CHANGE DESCRIPTION	BY	CHKD	DATE

REVISIONS

LOG NUMBER: A13467

THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY

DRAWN BY: MUSCIA	DATE: 3/26/93	CHIEF DESIGN ENGINEER: D. SHU	DATE: 9/14/93
CHECKED BY:		OP LEADER: T.M. KUZAY	9/14/93
DESIGNER: MUSCIA		PROJECT MGR:	
RESPONSIBLE ENGINEER: D. SHU	9/14/93	APPROVED/RELEASED:	

TITLE: ADVANCED PHOTON SOURCE
P2.2 ND PHOTON SHUTTER ABSORBER

MATERIAL: SEE NOTE #1

SCALE: 1:1 SHEET 1:4 SIZE: E

DRAWING NUMBER: P4102010106-210401-01