

(C)	PLOT SCALE: 1=1	DWG. SCALE: 1	A16184
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NOTES: 1. REWORK EXISTING FLANGE P.N.120018 (MDC)
 NOM. O.D. 4-1/2, NOM. I.D. BLANK
 AS SHOWN ABOVE.

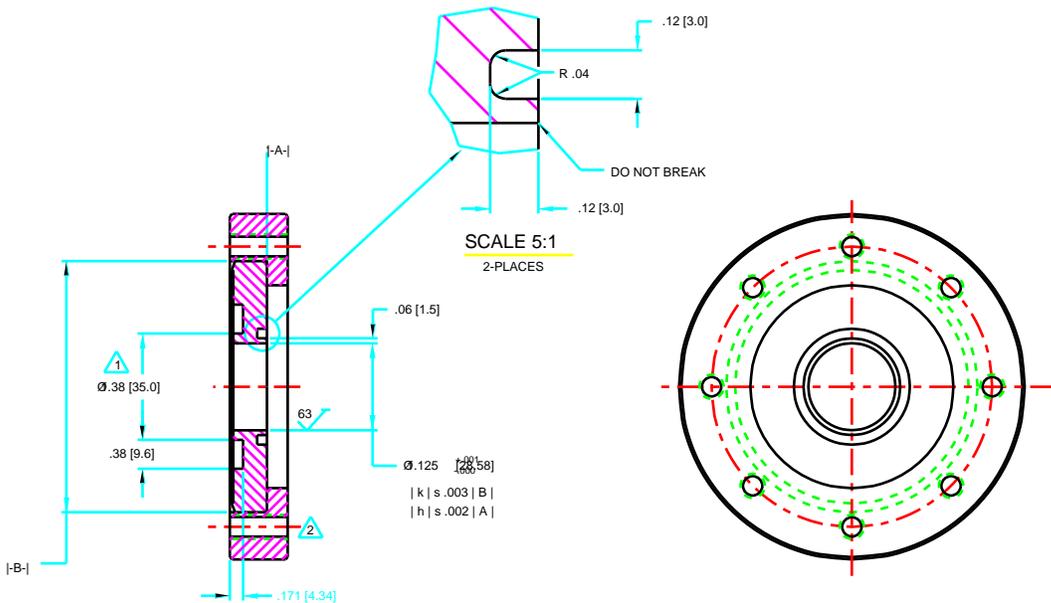
2. THIS IS A UHV PART.
 THE PART NEEDS TO GO THROUGH A
 MULTIPLE STEP CLEANING PROCESS INVOLVING
 DEGREASING, WASHING AND DRY NITROGEN
 BLOW DOWN BEFORE WELDING.

3. KEEP THE PART CLEAN, AND WRAP FOR
 UHV PACKING WITH ALUMINUM FOIL.

4. 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

5. ALL DIMENSIONS WITH ARE MILLIMETERS



SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
2	TAPPED HOLES;	J.G.	J.C.	2/14/94
1	GROOVE ADDED;	J.G.	J.C.	7/7/93

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES		THIS DRAWING IS THE PROPERTY OF		
LOG NUMBER A16184		ARGONNE NATIONAL LABORATORY		
DRAWN BY J.G.		DATE 4/8/93	DATE 4/20/93	TITLE ADVANCED PHOTON SOURCE
CHECKED BY J.CHANG		DATE 4/20/93	DATE 4/20/93	P3-20 BM FRONT END
DESIGNER J.G.		DATE 4/8/93		PHOTON SHUTTER COOLING
RESPONSIBLE ENGINEER J.CHANG		DATE 4/20/93		4-1/2" ROTATABLE FLANGE
MATERIAL SST 304		APPROVED/RELEASED		
SCALE 1:1		SIZE C		DRAWING NUMBER P4102020103-210003-02
SHEET 1 of 1				