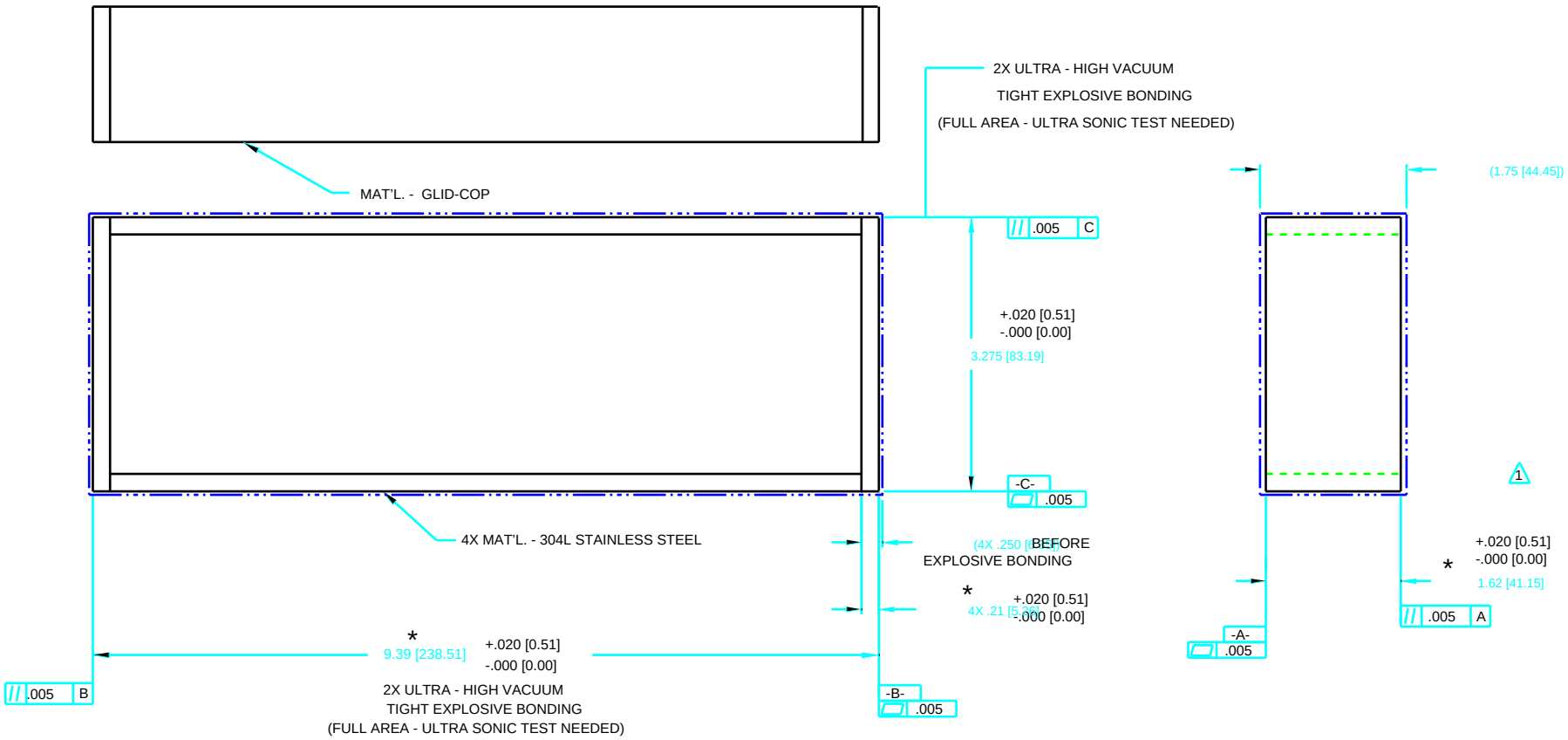

NOTES:

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
1	1/2 X 45° CHAMFER REMOVED	M.J.M.	J.C.	2/2/99

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: P4510101-01-1

THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY

DRAWN BY: MUSCIA	DATE: 10/14/98	CHIEF DESIGN ENGINEER: D. SHU	DATE: 11/29/98
CHECKED BY: J. CHANG	DATE: 11/25/98	GP LEADER: T.M. KUZAY	DATE: 12/10/98
DESIGNER: CHANG/MUSCIA	DATE: 10/14/98	PROJECT MGR.	DATE
RESPONSIBLE ENGINEER: J. CHANG	DATE: 11/25/98	APPROVED/RELEASED	DATE

MATERIAL: SEE ABOVE

TITLE: ADVANCED PHOTON SOURCE
P4-50 INTEGRAL SHUTTER
FOR 32-ID-A
WHITE BEAM STOP
BODY RIGHT HALF

SCALE 1:1 | SHEET 1 OF 2 | SIZE C | DRAWING NUMBER P4-510101-01-1