

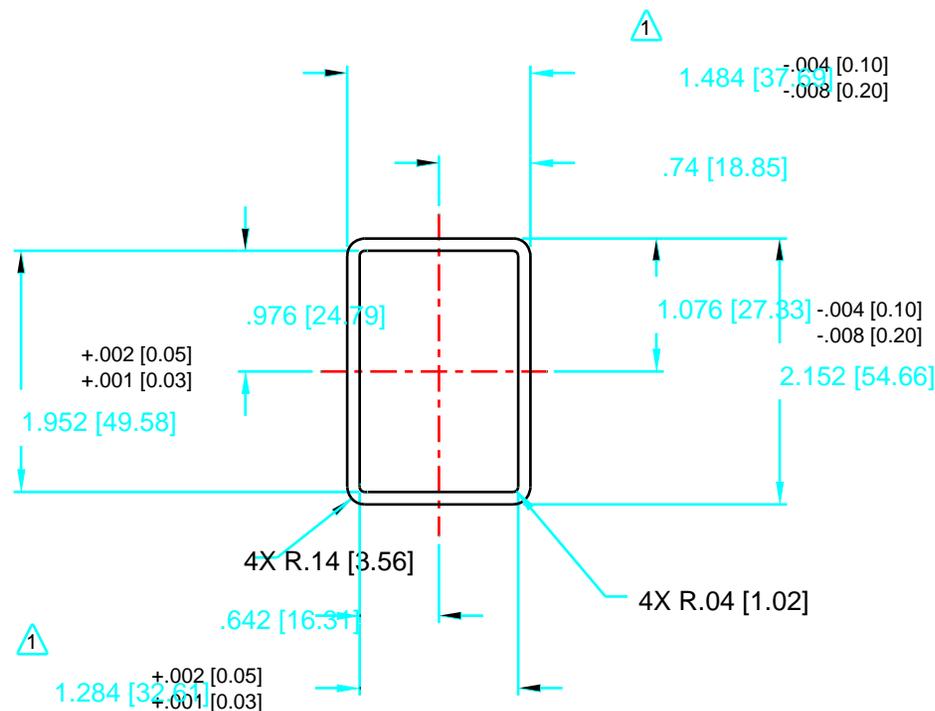
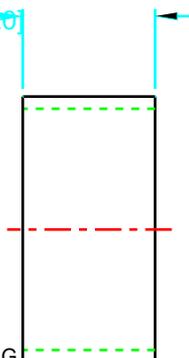
NOTES:

1. THIS IS A ULTRA- HIGH VACUUM COMPONENT (UHV)
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. FINISHING: WHEN MACHINING VACUUM PARTS USE OF ABRASIVE PAPER OR SANDING DISCS, BUFFING OR POLISHING COMPOUNDS, OR RESIN-BONDED GRINDING WHEELS IS PROHIBITED
4. CLEANING: THE COMPONENT MUST BE CLEANED SUCH THAT A UHV PRESSURE OF  $1 \times 10^{-9}$  TORR CAN BE ACHIEVED
5. HANDLING: THE COMPONENTS SHALL BE HANDLED WITH WHITE SILK GLOVES AND WRAPPED WITH ALUMINUM FOIL TYPE DRY ANNEAL AND UNDER CLEAN ROOM CONDITIONS
6. DIMENSIONS IN [ ] ARE MILLIMETERS AND FOR REF. ONLY
7. DIMENSIONS IN ( ) ARE FOR REF. ONLY
8. ALL SURFACES MUST BE MACHINED FOR CLEAN UP
9. DO NOT BREAK SHARP EDGES
10. WELD SHRINKAGE SHALL BE ADDED TO THIS LENGTH

SEE NOTE #10



1.07 [27.20]



1	1.484 [37.69] WAS 1.528 [38.81]			
	1.284 [32.61] WAS 1.328 [33.73]			
	1.07 [27.18] WAS 1.05 [26.70]	M.J.M	J.C.	2/2/99
SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
<b>PARTS LIST</b>				
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES		LOG NUMBER <b>P4510105-01</b>	THIS DRAWING IS THE PROPERTY OF <b>ARGONNE NATIONAL LABORATORY</b>	
<b>TOLERANCES</b> 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		DRAWN BY: <b>MUSCIA</b> CHECKED BY: <b>J. CHANG</b> DESIGNER: <b>CHANG/MUSCIA</b> RESPONSIBLE ENGINEER: <b>J. CHANG</b> MATERIAL: <b>304 STAINLESS STEEL</b>	DATE: <b>10/19/98</b> DATE: <b>11/25/98</b> DATE: <b>10/19/98</b> DATE: <b>11/25/98</b>	CHIEF DESIGN ENGINEER: <b>D. SHU</b> GP LEADER: <b>S.M.KUZAY</b> PROJECT MGR.: APPROVED/RELEASED:
		TITLE: <b>ADVANCED PHOTON SOURCE</b> <b>P4-50 INTEGRAL SHUTTER FOR 32-ID-A WHITE BEAM STOP RECTANGULAR TUBE</b>		
		SCALE: <b>1:1</b>	SIZE: <b>B</b>	DRAWING NUMBER: <b>P4-510105-01</b>
		SHEET: <b>14</b>		