

4

3

2

1

D

D

C

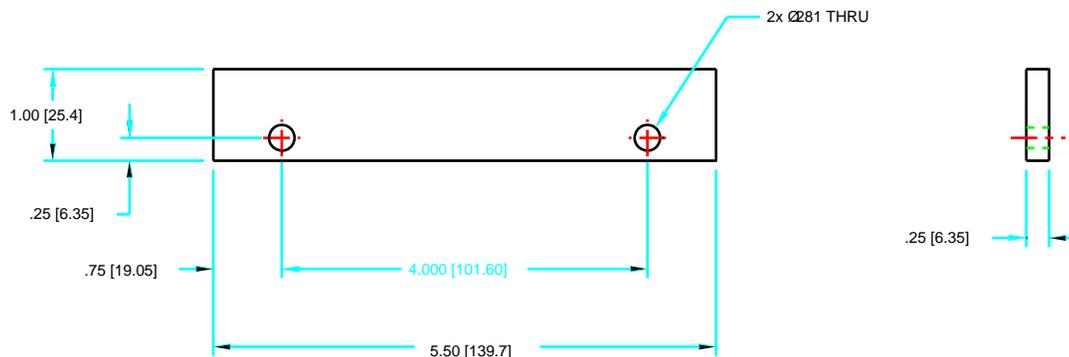
C

B

B

A

A



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
- 2. THIS IS A UHV PART, ELECTROPOLISHING IS NEEDED BEFORE WELDING. PRIOR TO ELECTROPOLISHING, THE PART MUST GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOW DOWN.
- 3. KEEP THE PART CLEAN AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
- 4. DIMENSIONS IN [] ARE MILLIMETERS AND FOR REF. ONLY
- 5. SURFACE ROUGHNESS 63 ✓

1	NOTES CHANGED;	J.G.		
SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES		LOG NUMBER A1857401	THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY	
TOLERANCES		DRAWN BY J.GOGOL		
DECIMALS	ANGULAR	DATE 5/5/94	DATE 6/27/94	TITLE ADVANCED PHOTON SOURCE
.X - .03 [7620]	- .25	CHECKED BY J.CHANG	DATE 6/26/94	GP LEADER T.M.KUZAY
.XX - .01 [828]		DESIGNER J.GOGOL	DATE 5/5/94	PROJECT MGR.
.XXX - .005 [127]		RESPONSIBLE ENGINEER J.CHANG	DATE 6/26/94	APPROVED/RELEASED
SURFACE ROUGHNESS 63 ✓		MATERIAL 304 SST		
REMOVE ALL BURRS AND BREAK SHARP EDGES: 10 MAX.		SCALE 1:1		
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1		SIZE C		
DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5		DRAWING NUMBER P4105090905-200002-01		
DO NOT SCALE DRAWING		SHEET 1 of 1		

4

3

2

1