



SECTION 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
3. ALL SURFACES MUST BE MACHINED FOR CLEAN UP
4. TUNGSTEN ALLOY OF 95% TUNGSTEN OR MORE WITH REMAINDER OF NICKEL AND IRON
5. FINISHING: WHEN MACHINING VACUUM PARTS USE OF ABRASIVE PAPER OR SANDING DISCS, BUFFING OR POLISHING COMPOUNDS, OR RESIN-BONDED GRINDING WHEELS IS PROHIBITED
6. CLEANING: THE COMPONENT MUST BE CLEANED SUCH THAT A UHV PRESSURE OF 1×10^{-9} TORR CAN BE ACHIEVED
7. HANDLING: THE COMPONENTS SHALL BE HANDLED WITH WHITE SILK GLOVES AND WRAPPED WITH ALUMINUM FOIL TYPE DRY ANNEAL AND UNDER CLEAN ROOM CONDITIONS
8. BREAK ALL SHARP CORNERS 0.03
9. DIMENSIONS IN [] ARE MILLIMETERS AND FOR REF. ONLY
10. SURFACE ROUGHNESS $63 \checkmark$

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 A18577		
TOLERANCES		THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY		
DECIMALS	ANGULAR	DRAWN BY J.GOGOL		
.X - .03 [.7620]	- .25	DATE	CHIEF DESIGN ENGINEER	DATE
.XX - .01 [.25]		5/22/94	D.SHU	6/27/94
.XXX - .005 [.127]		CHECKED BY J.CHANG	GP LEADER	T.M.KUZAY
SURFACE ROUGHNESS $63 \checkmark$		6/26/94	PROJECT MGR.	6/28/94
REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX.		DESIGNER J.GOGOL	RESPONSIBLE ENGINEER J.CHANG	APPROVED/RELEASED
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1		5/22/94	6/26/94	
DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5		MATERIAL SEE NOTE #4		
DO NOT SCALE DRAWING		SCALE 1:1	SIZE C	DRAWING NUMBER P4105090905-200004-00
		SHEET 1 of 1		

ADVANCED PHOTON SOURCE
P5 I.D. W/M/S
INTEGRAL SHUTTER
MIDDLE BLOCK