



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

01	B.M. WAS I.D.	R.K.		
SYM	CHANGE DESCRIPTION	BY	CHKD	DATE

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES		LOG NUMBER A1528601	THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY	
TOLERANCES		DRAWN BY J.GOGOL		
DECIMALS	ANGULAR	DATE 4/7/94	CHIEF DESIGN ENGINEER D.SHU	DATE 5/12/94
.X - .03 [.7620]	.25	CHECKED BY J.CHANG	GP LEADER T.M.KUZAY	TITLE ADVANCED PHOTON SOURCE P6 B.M. W/M/S INTEGRAL SHUTTER BEAM STOP/COLLIMATOR UPPER BLOCK
.XX - .01 [0.25]		DESIGNER J.GOGOL	PROJECT MGR.	
.XXX - .005 [0.127]		RESPONSIBLE ENGINEER J.CHANG	APPROVED/RELEASED	
SURFACE ROUGHNESS ✓ 63		MATERIAL SEE NOTE #4		
REMOVE ALL BURRS AND BREAK SHARP EDGES .03 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 P4105090906-200010-01		
DO NOT SCALE DRAWING				