



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

01	B.M. WAS I.D.	R.K.		
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		THIS DRAWING IS THE PROPERTY OF		
TOLERANCES		ARGONNE NATIONAL LABORATORY		
DECIMALS	ANGULAR			
.X - .03 [0.7620]	- .25			
.XX - .01 [0.25]				
.XXX - .005 [0.127]				
SURFACE ROUGHNESS 63 ✓				
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 A1528701		ARGONNE NATIONAL LABORATORY		
DRAWN BY J.GOGOL	DATE 4/7/94	CHIEF DESIGN ENGINEER D.SHU	DATE 5/12/94	TITLE ADVANCED PHOTON SOURCE
CHECKED BY J.CHANG	DATE 5/4/94	GP LEADER T.M.KUZAY	DATE 5/16/94	P6 B.M. W/M/S INTEGRAL SHUTTER BEAM STOP/COLIMATOR MIDDLE BLOCK
DESIGNER J.GOGOL	DATE 4/7/94	PROJECT MGR.		
RESPONSIBLE ENGINEER J.CHANG	DATE 5/4/94	APPROVED/RELEASED		
MATERIAL SEE NOTE #4				
SCALE 1:1		DRAWING NUMBER P4105090906-200011-01		
SHEET 1 of 1		SIZE C		