



NOTES:

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

SY#	CHANGE DESCRIPTION	BY	CHKD	DATE
01	B.M. WAS I.D.		R.K.	
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>A1528901</b>	THIS DRAWING IS THE PROPERTY OF <b>ARGONNE NATIONAL LABORATORY</b>	
TOLERANCES		DATE	DATE	TITLE
DECIMALS		4/7/94	5/12/94	<b>ADVANCED PHOTON SOURCE</b> P6 B.M. W/M/S INTEGRAL SHUTTER BEAM STOP/COLLIMATOR HOUSING COVER
ANGLES		5/4/94	5/16/94	
X .03 [0.7620]		DESIGNER J.GOGOL	RESPONSIBLE ENGINEER J.CHANG	
XX .01 [0.25]		CHECKED BY J.CHANG	APPROVED/RELEASED	
XXX .005 [0.127]		DATE	DATE	SCALE
SURFACE ROUGHNESS $R_a$ 63 ✓		4/7/94	5/4/94	HALF
REMOVE ALL BUMPS AND BREAK SHARP EDGES .03 MAX.				SIZE
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1				C
MATERIAL				DRAWING NUMBER
304 STAINLESS STEEL				P4105090906-200013-01
DO NOT SCALE DRAWING				SHEET 1 of 1