



- NOTES:
1. 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 NEEDS TO 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  $\checkmark$  63

REV	DESCRIPTION	DATE	BY	CHKD	APP'D	MATERIAL	QTY
1	ISSUED FOR FABRICATION	4/7/94	J.GOGOL	D.SHU	5/12/94	304 STAINLESS STEEL	1
2	0.062 DRILL ADDED	4/7/94	J.GOGOL	D.SHU	5/12/94	304 STAINLESS STEEL	1
3	B.M. WAS I.D.	4/7/94	J.GOGOL	T.M.KUZAY	5/16/94	304 STAINLESS STEEL	1
4	REVISION	4/7/94	J.GOGOL	J.CHANG	5/4/94	304 STAINLESS STEEL	1
5	REVISION	4/7/94	J.GOGOL	J.CHANG	5/4/94	304 STAINLESS STEEL	1

  

APPROVED FOR FABRICATION J.GOGOL 4/7/94	APPROVED FOR ASSEMBLY D.SHU 5/12/94	APPROVED FOR WELDING T.M.KUZAY 5/16/94	APPROVED FOR SHIPPING J.CHANG 5/4/94
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PARTS LIST 1 SHUTTER BEAM STOP/COLLIMATOR HOUSING WELDMENT 304 STAINLESS STEEL 1	THIS DRAWING IS THE PROPERTY OF <b>ARGONNE NATIONAL LABORATORY</b> ADVANCED PHOTON SOURCE P6 B.M. WIMS INTEGRAL SHUTTER BEAM STOP/COLLIMATOR HOUSING WELDMENT
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