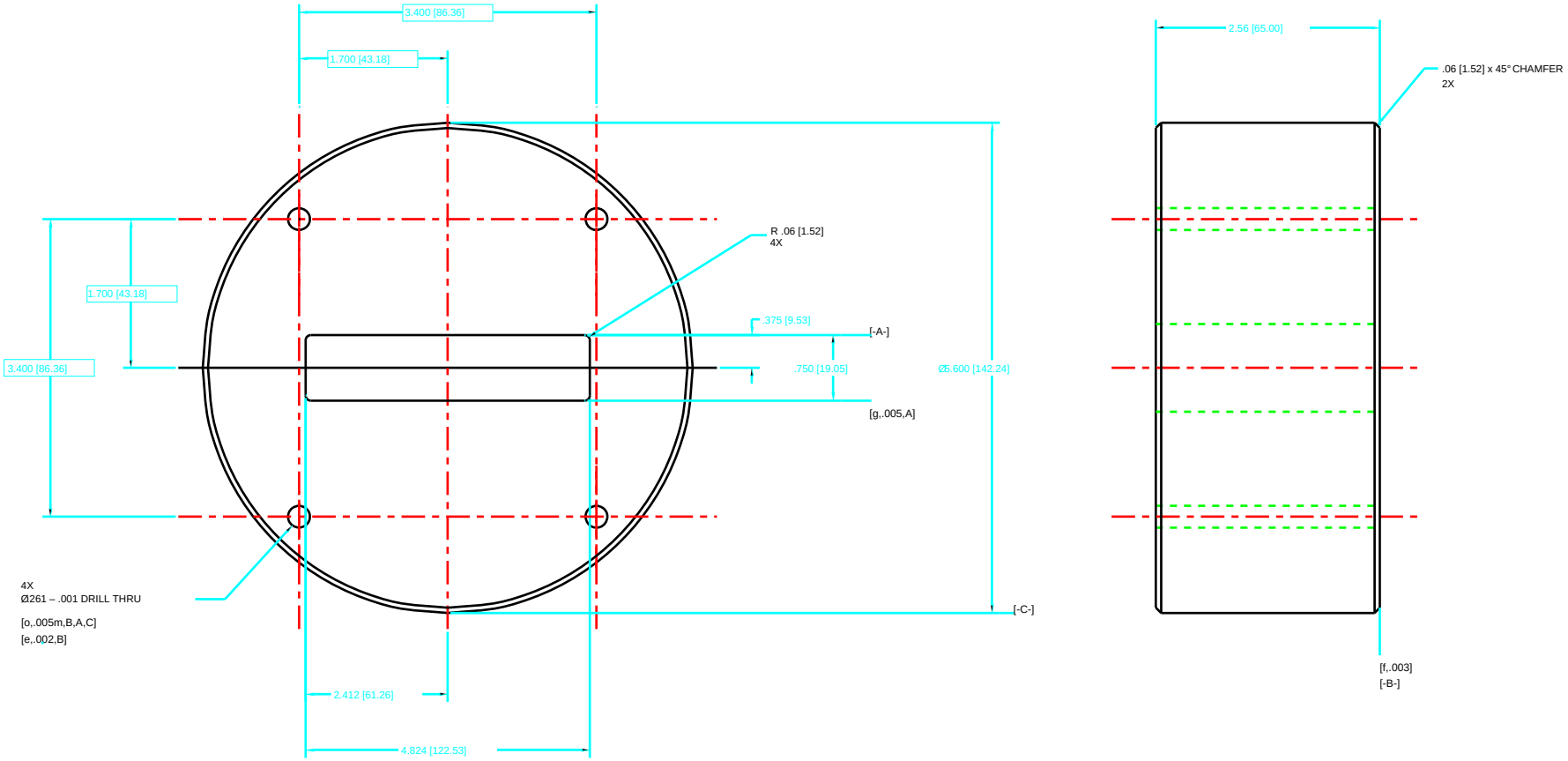

NOTES:

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 MIL-T-21014D, CLASS3, UHV GRADE
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 X 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

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

TOLERANCES

DECIMALS		ANGULAR
.X –	.03	– .25
.XX –	.01	
.XXX –	.005	

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 A2200600

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ARGONNE NATIONAL LABORATORY

DRAWN BY JOE GREK	DATE 02/16/95	CHIEF DESIGN ENGINEER D.SHU	DATE 4/21/95	TITLE ADVANCED PHOTON SOURCE
CHECKED BY J.CHANG	DATE 3/16/95	GP LEADER T.M.KUZAY	DATE 4/21/95	P8 BM MONO INTEGRAL P8-30 TUNGSTEN BLOCK
DESIGNER J.CHANG/J.GREK	DATE 02/15/95	PROJECT MGR	DATE	
RESPONSIBLE ENGINEER J.CHANG	DATE 3/16/95	APPROVED/RELEASED	DATE	

MATERIAL TUNGSTEN-SEE NOTE 4

SCALE 1:1 | SHEET 1 of 1 | SIZE C | DRAWING NUMBER P4105090908-300001-00