



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. FINISHING: WHEN MACHINING VACUUM PARTS USE OF ABRASIVE PAPER OR SANDING DISCS, BUFFING OR POLISHING COMPOUNDS, OR RESIN-BONDED GRINDING WHEELS IS PROHIBITED
5. CLEANING: THE COMPONENT MUST BE CLEANED SUCH THAT A UHV PRESSURE OF  $1 \times 10^{-9}$  TORR CAN BE ACHIEVED
6. WELD SHALL BE GAS TUNGSTEN, ARC (GTAW) OR ON VACUUM SIDE
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. DIMENSIONS IN [ ] ARE MILLIMETERS AND FOR REF. ONLY

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
3	P8-530102	TUNGSTEN MTG. BRACKET	304L SST	1
2		1.5" O.D. X .083 WALL X 1.785 LG. TUBING	304L SST	1
1	P8-530101	TUNGSTEM FLANGE	304 SST	1

UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES		LOG NUMBER <b>P8530100-00</b>		THIS DRAWING IS THE PROPERTY OF <b>ARGONNE NATIONAL LABORATORY</b>	
TOLERANCES		ANGULAR		TITLE	
.X - .1 [2.5]	- 0°30'	DRAWN BY <b>MUSCIA</b>		DATE <b>4/24/97</b>	DATE <b>6/6/97</b>
.XX - .01 [0.25]		CHECKED BY <b>J. CHANG</b>		DATE <b>5/20/97</b>	DATE <b>6/9/97</b>
.XXX - .005 [0.13]		DESIGNER <b>CHANG/MUSCIA</b>		DATE <b>4/24/97</b>	DATE
SURFACE ROUGHNESS $\sqrt{125}$		RESPONSIBLE ENGINEER <b>J. CHANG</b>		DATE <b>5/20/97</b>	DATE
REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX.		PROJECT MGR.		DATE	DATE
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1		APPROVED/RELEASED		DATE	DATE
DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5		MATERIAL <b>SEE PARTS LIST</b>		SCALE <b>1:1</b>	SIZE <b>C</b>
DO NOT SCALE DRAWING		DRAWING NUMBER <b>P8-530100-00</b>		SHEET <b>1 of 1</b>	

SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
	REVISIONS			