

4

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D

D

C

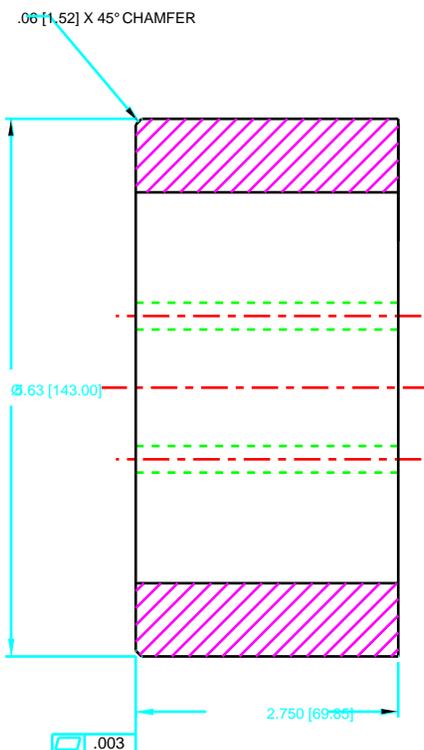
C

B

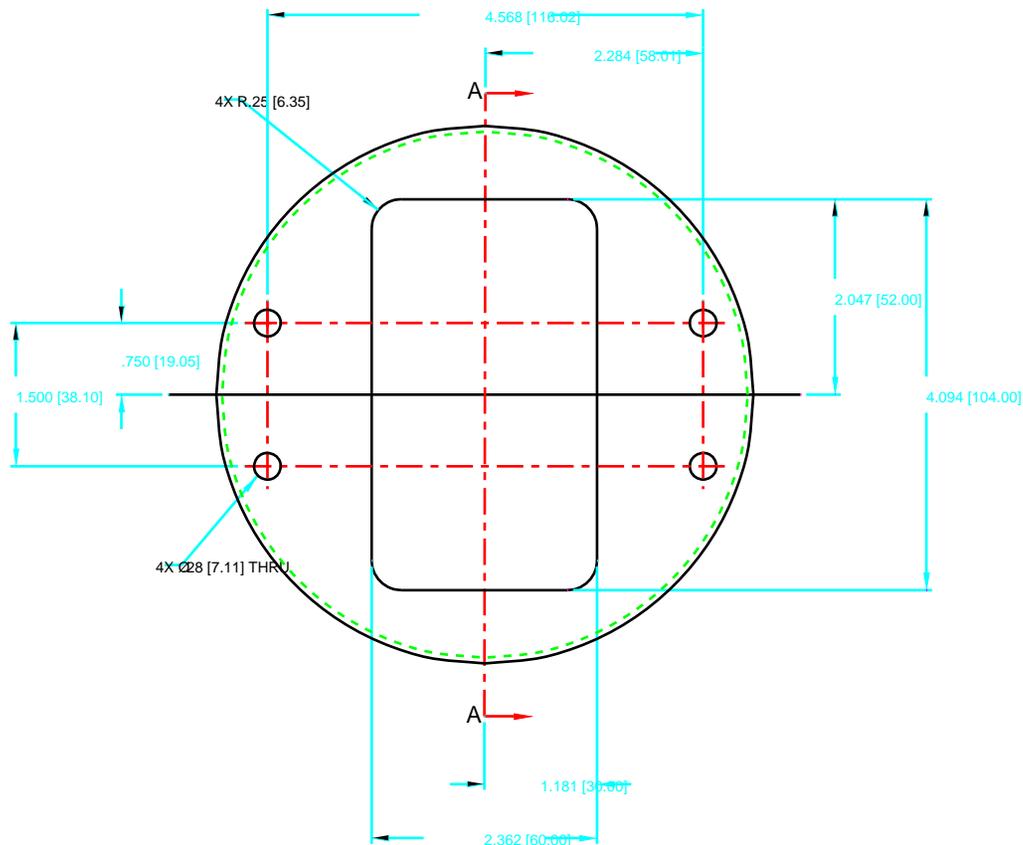
B

A

A



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. FINISHING: WHEN MACHINING VACUUM PARTS USE OF ABRASIVE PAPER OR SANDING DISCS, BUFFING OR POLISHING COMPOUNDS, OR RESIN-BONDED GRINDING WHEELS IS PROHIBITED
4. CLEANING: THE COMPONENT MUST BE CLEANED SUCH THAT A UHV PRESSURE OF  $1 \times 10^{-9}$  TORR CAN BE ACHIEVED
5. HANDLING: THE COMPONENTS SHALL BE HANDLED WITH WHITE SILK GLOVES AND WRAPPED WITH ALUMINUM FOIL TYPE DRY ANNEAL AND UNDER CLEAN ROOM CONDITIONS
6. DIMENSIONS IN [ ] ARE MILLIMETERS AND FOR REF. ONLY
7. DIMENSIONS IN ( ) ARE FOR REF. ONLY

| SYMBOL    | CHANGE DESCRIPTION | BY | CHKD | DATE |
|-----------|--------------------|----|------|------|
|           |                    |    |      |      |
| REVISIONS |                    |    |      |      |

| ITEM  | DWG/PART NUMBER | NOMENCLATURE OR DESCRIPTION  | MATERIAL / SPEC                        | QTY                                   |          |         |               |         |                  |  |                    |  |
|---|-----------------|--|--|---------------------------------------|----------|---------|---------------|---------|------------------|--|--------------------|--|
| <p>UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES</p> <p><b>TOLERANCES</b></p> <table border="1"> <tr> <th>DECIMALS</th> <th>ANGULAR</th> </tr> <tr> <td>.X - .1 [2.5]</td> <td>- 0°30'</td> </tr> <tr> <td>.XX - .01 [0.25]</td> <td></td> </tr> <tr> <td>.XXX - .005 [0.13]</td> <td></td> </tr> </table> <p><b>SURFACE ROUGHNESS</b> 125 ✓</p> <p>REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX.</p> <p>SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1</p> <p>DIMENSIONING &amp; TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5</p> |                 |  |  |                                       | DECIMALS | ANGULAR | .X - .1 [2.5] | - 0°30' | .XX - .01 [0.25] |  | .XXX - .005 [0.13] |  |
| DECIMALS  | ANGULAR         |  |  |                                       |          |         |               |         |                  |  |                    |  |
| .X - .1 [2.5]   | - 0°30'         |  |  |                                       |          |         |               |         |                  |  |                    |  |
| .XX - .01 [0.25]  |                 |  |  |                                       |          |         |               |         |                  |  |                    |  |
| .XXX - .005 [0.13]  |                 |  |  |                                       |          |         |               |         |                  |  |                    |  |
| LOG NUMBER<br><b>P8810002-00</b>  |                 | <p>THIS DRAWING IS THE PROPERTY OF</p> <p><b>ARGONNE NATIONAL LABORATORY</b></p> |  |                                       |          |         |               |         |                  |  |                    |  |
| DRAWN BY<br><b>MUSCIA</b>   |                 | DATE<br><b>5/18/00</b>   | CHIEF DESIGN ENGINEER<br><b>D. SHU</b> | DATE                                  |          |         |               |         |                  |  |                    |  |
| CHECKED BY<br><b>J. CHANG</b>   |                 | DATE   | GP LEADER<br><b>P. DEN HARTOG</b>      | DATE                                  |          |         |               |         |                  |  |                    |  |
| DESIGNER<br><b>CHANG/MUSCIA</b>   |                 | DATE<br><b>5/18/00</b>   | PROJECT MGR.                           | DATE                                  |          |         |               |         |                  |  |                    |  |
| RESPONSIBLE ENGINEER<br><b>J. CHANG</b>   |                 | DATE   | APPROVED/RELEASED                      | DATE                                  |          |         |               |         |                  |  |                    |  |
| MATERIAL<br><b>304 STAINLESS STEEL</b>  |                 | SCALE<br><b>1:1</b>  | SIZE<br><b>C</b>                       | DRAWING NUMBER<br><b>P8-810002-00</b> |          |         |               |         |                  |  |                    |  |
| DO NOT SCALE DRAWING  |                 | SHEET<br><b>1 of 1</b>   |  |                                       |          |         |               |         |                  |  |                    |  |

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