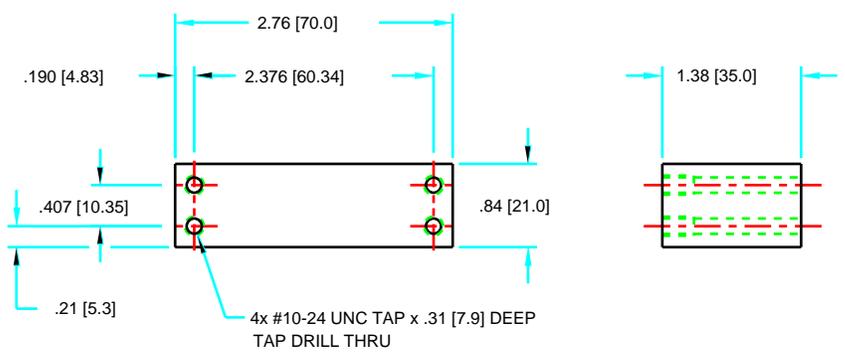


(B) PLOT SCALE: 1=1 DWG. SCALE: 1 A2072400

- NOTES:
- THIS IS A ULTRA- HIGH VACUUM COMPONENT (UHV)
  - WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:
    - CIMCOOL 5 STAR 49
    - TRIM SOL
  - ALL SURFACES MUST BE MACHINED FOR CLEAN UP
  - TUNGSTEN ALLOY OF 95% TUNGSTEN OR MORE WITH REMAINDER OF NICKEL AND IRON MIL-T-21014D, CLASS3, UHV GRADE
  - FINISHING: WHEN MACHINING VACUUM PARTS USE OF ABRASIVE PAPER OR SANDING DISCS, BUFFING OR POLISHING COMPOUNDS, OR RESIN-BONDED GRINDING WHEELS IS PROHIBITED
  - CLEANING: THE COMPONENT MUST BE CLEANED SUCH THAT A UHV PRESSURE OF  $1 \times 10^{-9}$  TORR CAN BE ACHIEVED
  - HANDLING: THE COMPONENTS SHALL BE HANDLED WITH WHITE SILK GLOVES AND WRAPPED WITH ALUMINUM FOIL TYPE DRY ANNEAL AND UNDER CLEAN ROOM CONDITIONS
  - BREAK ALL SHARP CORNERS 0.01 MINIMUM
  - DIMENSIONS IN [ ] ARE MILLIMETERS AND FOR REF. ONLY
  - SURFACE ROUGHNESS ✓ 63



REF. SOURCE:

KULITE TUNGSTEN CORP. 160 EAST UNION AVENUE EAST RUTHERFORD, NJ 07073 TEL.:201-438-9000 FAX:201-438-0891	MITEK METALS INC. 1340 NORTH SENATE AVENUE INDIANAPOLIS, IN 46202 TEL.:317-637-3574 FAX:317-633-7224
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APPROX. WT. = 2.0 LB.

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES		THIS DRAWING IS THE PROPERTY OF		
TOLERANCES		ARGONNE NATIONAL LABORATORY		
DECIMALS	ANGULAR			
.X - .03				
.XX - .01	- #5			
.XXX - .005				
SURFACE ROUGHNESS <span style="color: green;">✓</span>				
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				
MATERIAL SEE NOTE #4		LOG NUMBER <b>A2072400</b>		
DRAWN BY J.GOGOL	DATE 8/2/94	CHIEF DESIGN ENGINEER D.SHU	DATE 5/11/95	TITLE <b>ADVANCED PHOTON SOURCE</b>
CHECKED BY J.CHANG	DATE 5/11/95	GP LEADER T.M.KUZAY	DATE 5/12/95	<b>P9-20 INTEGRAL SHUTTER (B) TUNGSTEN BLOCK</b>
DESIGNER J.GOGOL	DATE 8/2/94	PROJECT MGR.		
RESPONSIBLE ENGINEER J.CHANG	DATE 5/11/95	APPROVED/RELEASED		
SCALE 1:1		SIZE B	DRAWING NUMBER	
SHEET 1 of 1		P4105090909-220001-00		

SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				