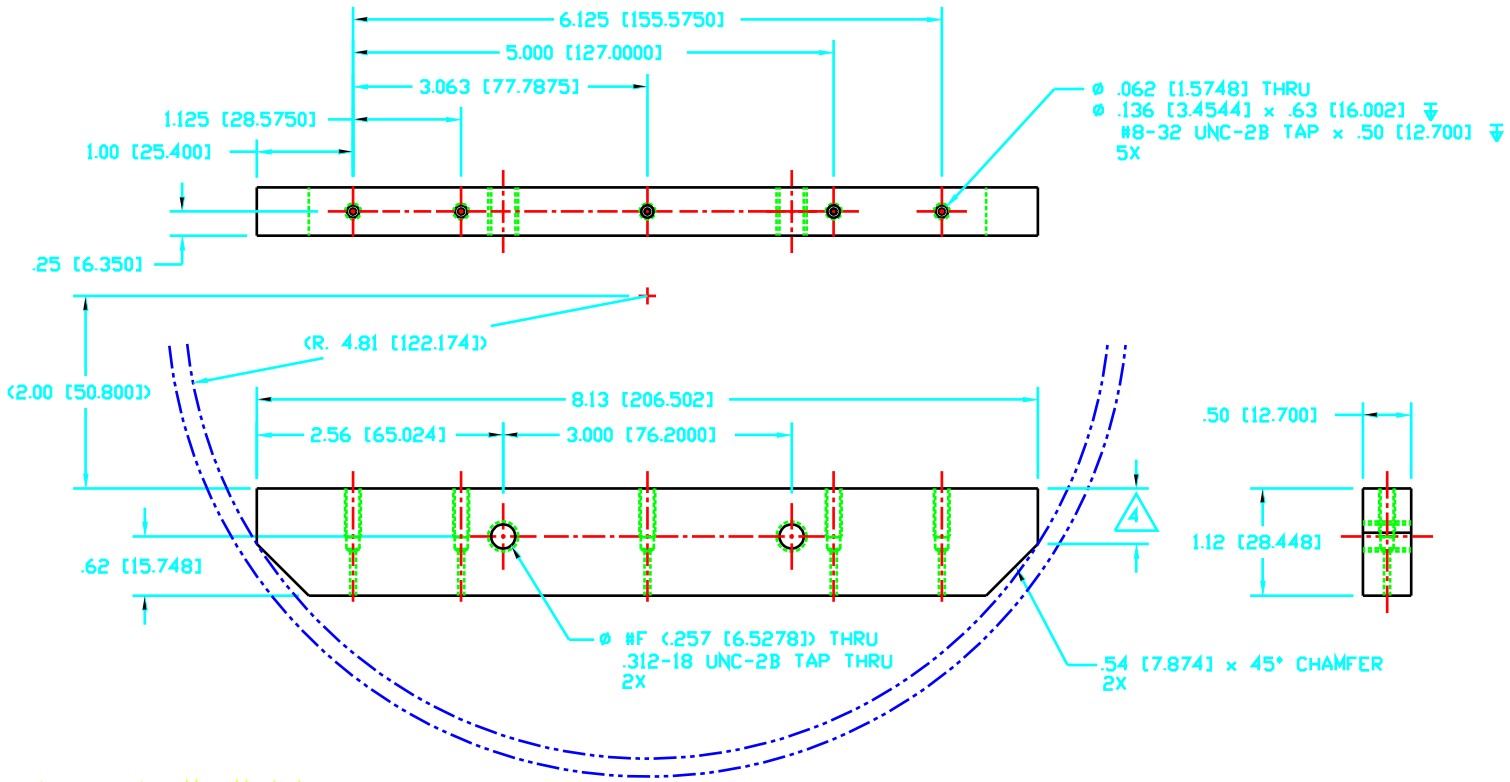

NOTE:

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. ELECTROPOLISH, TO 63 MICROINCH RMS. CLEAN PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOW DOWN BEFORE ELECTROPOLISHING.
4. DIM. TO BE DETERMINED BY 10.00 O.D. TUBING, ITEM (3) ; DWG No. P4102010108-210000.
5. ALL DIMENSIONS IN [ ] ARE MILLIMETERS AND ARE FOR REFERENCE ONLY.

ITEM	DWG. & ELECTRONIC FILE No.	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY

PARTS LIST

SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
02	UPDATED	RK		

REVISIONS

UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN INCHES
TOLERANCES
DECIMALS: .X ±.015; .XX ±.010; .XXX ±.005
ANGULAR: ±.25°
SURFACE ROUGHNESS 125√
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 ASME Y14.5
DO NOT SCALE DRAWING

ELECTRONIC FILE NUMBER: A18241

THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY

DRAWN BY: RICK KRAKORA	DATE: 12/92	CHIEF DESIGN ENGINEER: D. SHU	DATE: 8/9/93
CHECKED BY: T. SANCHEZ	DATE: 7/26/93	GP LEADER: T. KUZAY	DATE: 8/9/93
DESIGNER: RICK KRAKORA	DATE: 12/92	PROJECT MGR	DATE
RESPONSIBLE ENGINEER: T. SANCHEZ	DATE: 7/26/93	APPROVED/RELEASED	DATE

TITLE: ADVANCED PHOTON SOURCE
SI SAFETY SHUTTER
RAIL ASSEMBLY
RIB BAR

MATERIAL: .50 THK x SEE DWG SST 304
SCALE: 1=1
SHEET: 1 of 1
SIZE: C
DRAWING NUMBER: P4102010108-210104-02

PLOT SCALE: 1=1