



- 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 NICKEL AND IRON.  
TO COMPLY WITH MIL. SPEC. T-21014D, CLASS 4
  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  $1 \times 10^{-10}$  TORR CAN BE ACHIEVED.
  7. HANDLING: CLEAN COMPONENTS SHALL BE HANDLED WITH WHITE SILK GLOVES AND WRAPPED WITH ALUMINUM-FOIL-TYPE DRY ANNEAL A UNDER CLEAN ROOM CONDITIONS.
  8. BREAK ALL SHARP CORNERS .02.
  9. ALL DIMENSIONS IN [ ] ARE MILLIMETERS AND ARE FOR REFERENCE ONLY.

ITEM	DWG. & ELECTRONIC FILE No.	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES				
TOLERANCES				
DECIMALS ANGLES				
X	- .015	- .25		
XXX	- .005			
SURFACE ROUGHNESS				
REMOVE ALL BURRS AND BREAK SHARP EDGES TO MAX.				
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST AND 846-1				
DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST AND 114-1				
DO NOT SCALE DRAWING				
01	DM1.250 WAS .72	RK		
01	DM1.2.835 (72.0000) WAS 2.756 (70.0000)	RK		
SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				
ELECTRONIC FILE NUMBER		THIS DRAWING IS THE PROPERTY OF		
A18179		ARGONNE NATIONAL LABORATORY		
DRAWN BY	DATE	CHIEF DESIGN ENGINEER	DATE	TITLE
RICK KRAKORA	12/92	D.SHU	8/9/93	ADVANCED PHOTON SOURCE
DRAWN BY	DATE	PROJECT MGR	DATE	
T. SANCHEZ	7/26/93	T. KUZAY	8/9/93	S1 I.D. SAFETY SHUTTER
DRAWN BY	DATE	APPROVED/RELEASED	DATE	
RICK KRAKORA	12/92	T. SANCHEZ	7/26/93	TUNGSTEN BLOCK
RESPONSIBLE ENGINEER	DATE	APPROVED/RELEASED	DATE	BASE END
T. SANCHEZ	7/26/93			
MATERIAL		SCALE	SIZE	DRAWING NUMBER
SEE NOTE 4		1=1	D	P4102010108-230002-01
		SHEET	1 of 1	