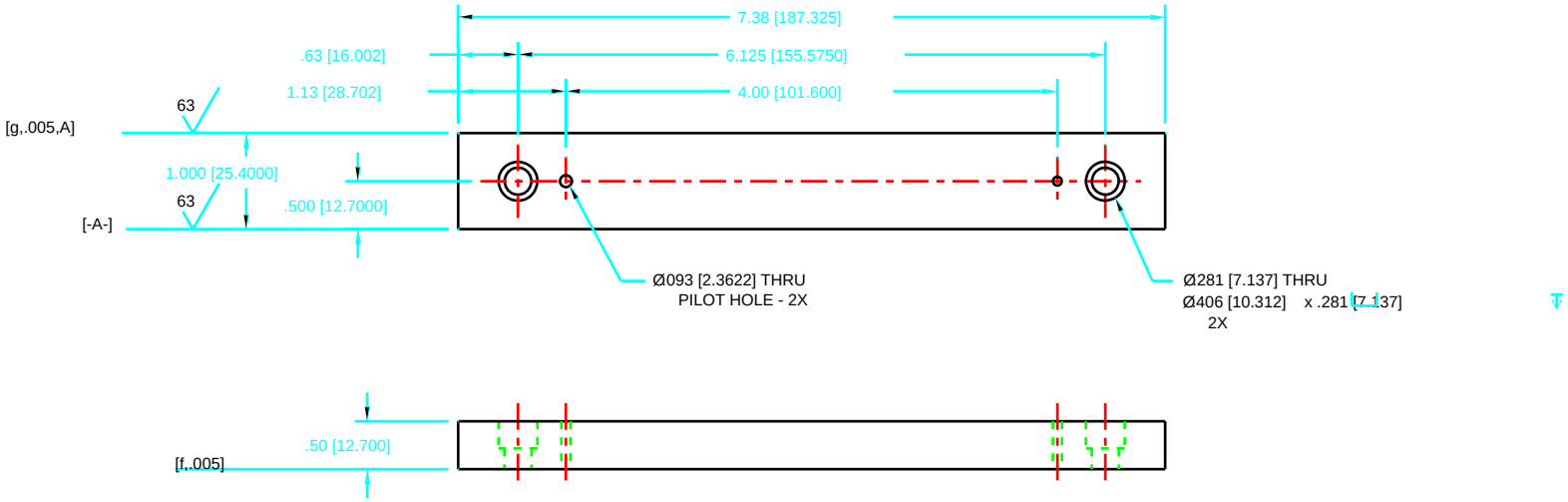

NOTE:

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.
3. 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

REVISIONS

UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES

TOLERANCES

DECIMALS	ANGULAR
.X – .015	– .25
.XX – .010	
.XXX – .005	

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 ANSI Y14.5

DO NOT SCALE DRAWING

ELECTRONIC FILE NUMBER: A09943

THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY

DRAWN BY: RICK KRAKORA	DATE: 4/93	CHIEF DESIGN ENGINEER	DATE
CHECKED BY	DATE	GP LEADER	DATE
DESIGNER	DATE	PROJECT MGR	DATE
RESPONSIBLE ENGINEER	DATE	APPROVED/RELEASED	DATE

TITLE: ADVANCED PHOTON SOURCE
S2 B.M. SAFETY SHUTTER RAIL ASSEMBLY STOP BAR

MATERIAL: .63 THK x SEE DWG SST 304

SCALE: 1=1

SHEET: 1 OF 1

SIZE: C

DRAWING NUMBER: P4102020105-210101-00

PLOT SCALE: 1=1