



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. DIM. TO BE DETERMINED BY 8.00 O.D. TUBING, ITEM #4: DWG. #S3-210000-00-1
5. CLEANING: THE COMPONENT MUST BE CLEANED SUCH THAT A UHV PRESSURE OF 1×10^{-9} TORR CAN BE ACHIEVED
6. HANDLING: THE COMPONENTS SHALL BE HANDLED WITH WHITE SILK GLOVES AND WRAPPED WITH ALUMINUM FOIL TYPE DRY ANNEAL AND UNDER CLEAN ROOM CONDITIONS
7. DIMENSIONS IN [] ARE MILLIMETERS AND FOR REF. ONLY

SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES		LOG NUMBER S3210106-00		
TOLERANCES		THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY		
DECIMALS	ANGULAR	ADVANCED PHOTON SOURCE S3 I.D. SAFETY SHUTTER COLLIMATOR MIDDLE RAIL RIB BAR		
.X - .1 [2.5]	- 0°30'			
.XX - .01 [0.25]				
.XXX - .005 [0.13]				
SURFACE ROUGHNESS 125 ✓		REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX.		
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1		SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI Y14.5		
DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5		DO NOT SCALE DRAWING		
MATERIAL 304 STAINLESS STEEL		SCALE 1:1		
REVISIONS		SHEET 1 of 1		
		DRAWING NUMBER S3-210106-00		