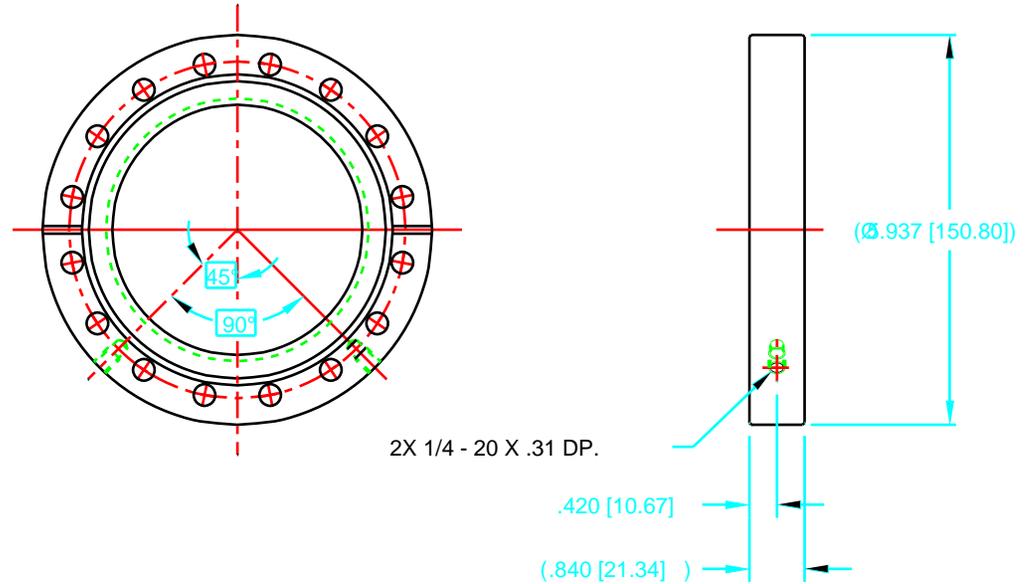


NOTES:

1. MAKE FROM MDC'S 6" O.D. ROTATABLE VACUUM FLANGE CAT. #100026
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. THIS IS A UHV PART, ELECTROPOLISHING IS NEEDED BEFORE WELDING. PRIOR TO ELECTROPOLISHING, THE PART MUST GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOW DOWN.
4. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
5. DIMENSIONS IN [ ] ARE MILLIMETERS AND FOR REF. ONLY



2X 1/4 - 20 X .31 DP.

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
<b>PARTS LIST</b>				
UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE IN INCHES		A2221600	THIS DRAWING IS THE PROPERTY OF <b>ARGONNE NATIONAL LABORATORY</b>	
<b>TOLERANCES</b> DECIMALS      ANGULAR .X      ± .03 [.7620]      ± .25 ° .XX      ± .01 [0.25] .XXX      ± .005 [0.127]		LOG NUMBER A2221600	TITLE <b>ADVANCED PHOTON SOURCE</b> L5-87 APS UNDULATOR WHITE BEAM H & V SLITS FIXED MASK RIGHT END VACUUM FLANGE	
SURFACE ROUGHNESS $125 \checkmark$ REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX. SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46 DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5		DRAWN BY MUSCIA	DATE 3/15/95	CHIEF DESIGN ENGINEER D. SHU
DO NOT SCALE DRAWING		CHECKED BY D. SHU	DATE 4/12/95	GP LEADER T.M. KUZAY
DO NOT SCALE DRAWING		DESIGNER MUSCIA	DATE 4/12/95	PROJECT MGR.
DO NOT SCALE DRAWING		RESPONSIBLE ENGINEER D. SHU	DATE 4/12/95	APPROVED/RELEASED
DO NOT SCALE DRAWING		MATERIAL SEE NOTE #1		SCALE    HALF SHEET    1 of 1
DO NOT SCALE DRAWING		SIZE    B		DRAWING NUMBER P4105091505-870004-00
SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				