



NOTES:

1. 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
2. THIS IS A UHV PART, ELECTROPOLISHING IS NEEDED BEFORE WELDING. PRIOR TO ELECTROPOLISHING, THE PART NEEDS TO GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOW DOWN.
3. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
4. DIMENSIONS IN [] ARE MILLIMETERS AND FOR REF. ONLY

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE IN INCHES		A1458400	THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY	
TOLERANCES		ADVANCED PHOTON SOURCE		
DECIMALS ± .03 [.7620]		V1 APS FRONT END		
.XX ± .01 [0.25]		13 mm X 78 mm X 182 mm		
.XXX ± .005 [0.127]		DIFFERENTIAL TUBE FLANGE		
SURFACE ROUGHNESS 125 ✓		APPROVED/RELEASED		
REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX.		DO NOT SCALE DRAWING		
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1		SCALE HALF		
DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5		SHEET 1 of 1		
		DRAWING NUMBER		
		B P4105090701-820102-00		
		MATERIAL 304 STAINLESS STEEL		

SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				