



TYP. PROJECTION - 2 PLACES

NOTES:

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

REV	CHANGE DESCRIPTION	BY	CHKD	DATE

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN INCHES		LOG NUMBER A14944	THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY	
TOLERANCES		DATE	DATE	TITLE
DECIMALS	ANGLES	5/16/93	12/3/93	ADVANCED PHOTON SOURCE
.1	.05	DRAWN BY J.G.	CHEF DESIGN ENGINEER D. SHU	OP LEADER T. M. KUZAY
.2	.01	CHECKED BY J. CHANG	12/3/93	12/3/93
.3	.005	DESIGNER J.G.	5/16/93	PROJECT MGR.
SURFACE ROUGHNESS R_a		RESPONSIBLE ENGINEER J. CHANG	12/3/93	APPROVED/RELEASED
REMOVE ALL BURRS AND BEVEL SHARP EDGES TO MAX.		MATERIAL 304 SST		
SURFACE FINISH TO BE IN ACCORDANCE WITH LATEST ASH		SCALE 1:2	SIZE C	DRAWING NUMBER P4105090707-820001-00
SURFACE FINISH TO BE IN ACCORDANCE WITH LATEST ASH		SHEET 1 of 1		
DO NOT SCALE DRAWING				