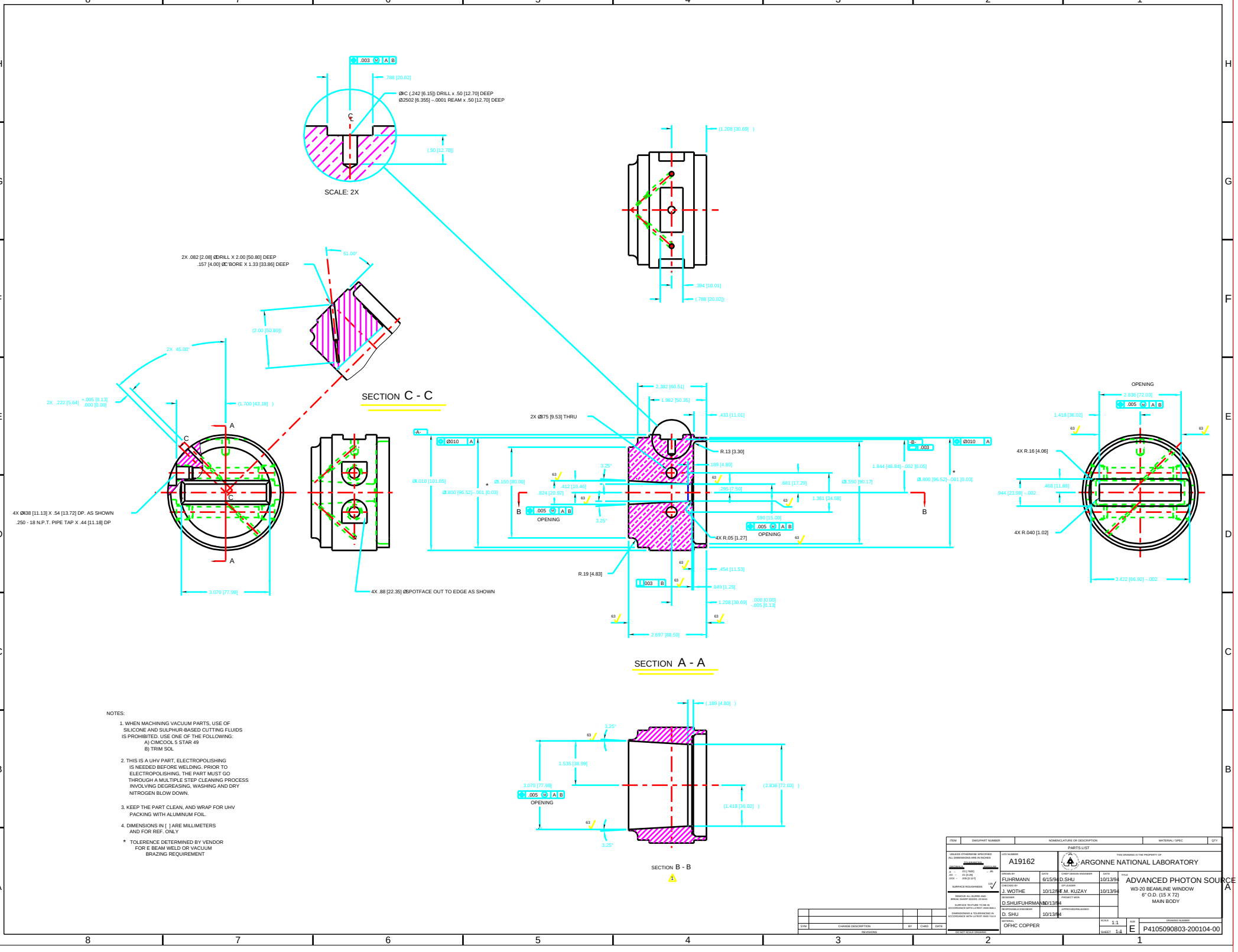

NOTES:

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 MUST 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

* TOLERENCE DETERMINED BY VENDOR FOR E BEAM WELD OR VACUUM BRAZING REQUIREMENT

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY

PARTS LIST

UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES

SURFACE ROUGHNESS

REMOVE ALL BURRS AND BREAK SHARP EDGES .015 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

LOG NUMBER: A19162

THIS DRAWING IS THE PROPERTY OF: ARGONNE NATIONAL LABORATORY

DRAWN BY: FUHRMANN	DATE: 6/15/94	CHIEF DESIGN ENGINEER: D.SHU	DATE: 10/13/94
CHECKED BY: J. WOTHE	DATE: 10/12/94	DIV LEADER: M. KUZAY	DATE: 10/13/94
DESIGNER: D.SHU/FUHRMANN	DATE: 10/13/94	PROJECT MGR.	
RESPONSIBLE ENGINEER: D. SHU	DATE: 10/13/94	APPROVED/RELEASED	

TITLE: ADVANCED PHOTON SOURCE
W3-20 BEAMLINE WINDOW
6" O.D. (15 X 72)
MAIN BODY

MATERIAL: OFHC COPPER

SCALE: 1:1 SIZE: E DRAWING NUMBER: P4105090803-200104-00

SHEET 1 of 1

SYM	CHANGE DESCRIPTION	BY	CHKD	DATE

REVISIONS