



SECTION A - A

NOTES:

1. MAKE FROM MDC'S CAT. #110031
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

SYM	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 A2089700	THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY	
TOLERANCES		DESIGNED BY FUHRMANN	DATE 6/9/94	CHIEF DESIGN ENGINEER D. SHU
DECIMALS		CHECKED BY J. WOTHE	DATE 10/12/94	GP LEADER T.M. KUZAY
.X ± .03 (0.7620)		DESIGNER D. SHU/FUHRMANN	DATE 10/13/94	PROJECT MGR.
.XX ± .01 (0.25)		RESPONSIBLE ENGINEER D. SHU	DATE 10/13/94	APPROVED/RELEASED
.XXX ± .005 (0.127)		MATERIAL SEE NOTE #1	SCALE HALF	SIZE C
SURFACE ROUGHNESS 125 ✓		DRAWING NUMBER P4105090804-200103-00		
REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX.		SHEET 1 of 1		
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1		DRAWING NUMBER P4105090804-200103-00		
MACHINING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5		DO NOT SCALE DRAWING		