



NOTES:

- WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:
 - CIMCOOL 5 STAR 49
 - TRIM SOL
 - 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.
 - KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
 - DIMENSIONS IN [] ARE MILLIMETERS AND FOR REF. ONLY
- * TOLERANCE DETERMINED BY VENDOR FOR E BEAM WELD OR VACUUM BRAZING REQUIREMENT

SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE IN INCHES		LOG NUMBER	THIS DRAWING IS THE PROPERTY OF	
TOLERANCES		W4600102-00	ARGONNE NATIONAL LABORATORY	
DECIMALS	ANGULAR		TITLE	
.X ±.1 [2.5]	± 0°30'	DRAWN BY	CHIEF DESIGN ENGINEER	DATE
.XX ±.01 [0.25]		MUSCIA	D. Shu	12/5/97
.XXX ±.005 [0.13]		CHECKED BY	GP LEADER	DATE
SURFACE ROUGHNESS $\sqrt{125}$		D. SHU	T.M. Kuzay	12/5/97
REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX.		DESIGNER	PROJECT MGR.	DATE
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1		SHU/MUSCIA		
DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5		RESPONSIBLE ENGINEER	APPROVED/RELEASED	DATE
DO NOT SCALE DRAWING		D. SHU		12/5/97
MATERIAL			SCALE	SIZE
304 STAINLESS STEEL			HALF	B
			SHEET 1 of 1	DRAWING NUMBER
				W4-600102-00