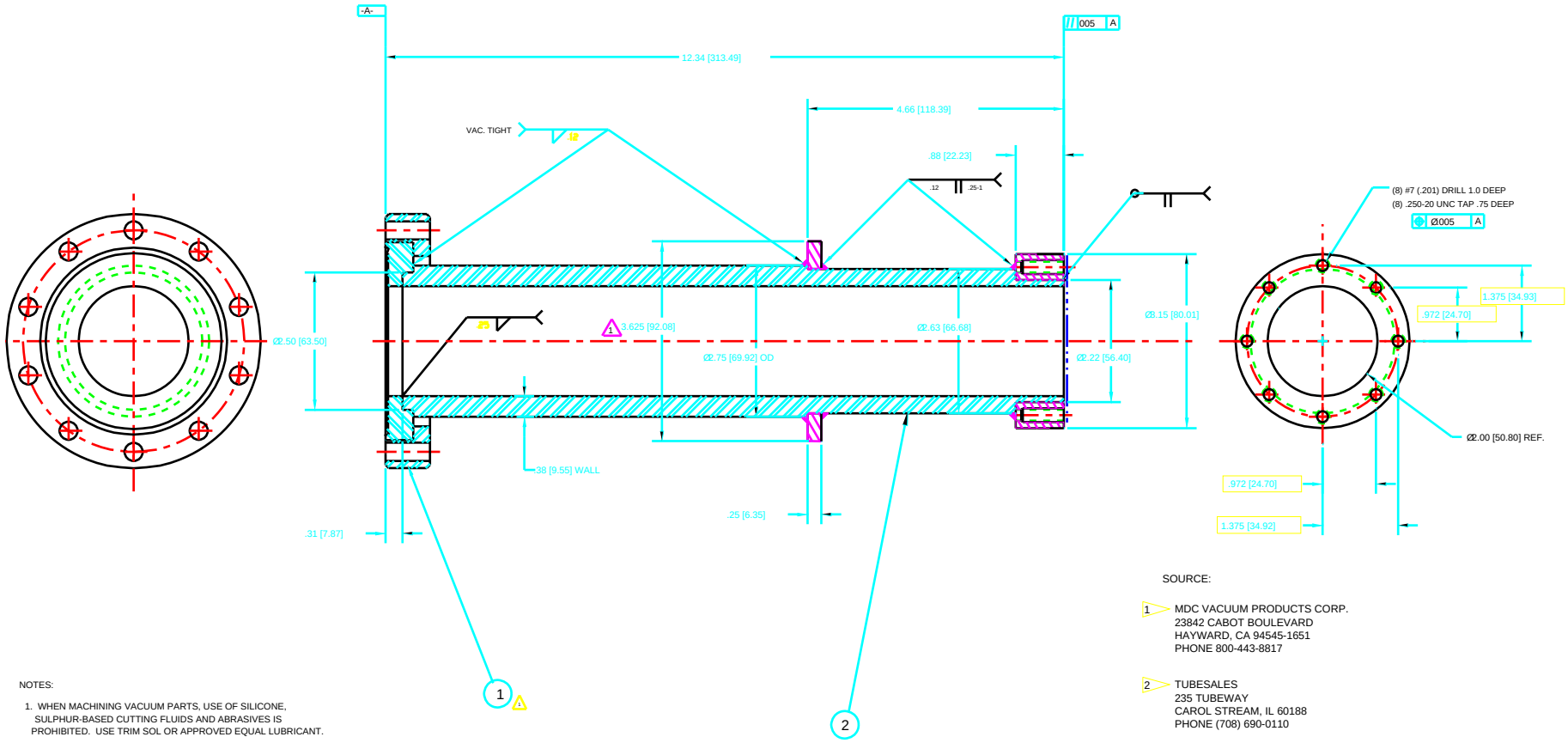

SOURCE:

1 MDC VACUUM PRODUCTS CORP.
23842 CABOT BOULEVARD
HAYWARD, CA 94545-1651
PHONE 800-443-8817

2 TUBESALES
235 TUBEWAY
CAROL STREAM, IL 60188
PHONE (708) 690-0110

NOTES:

1. WHEN MACHINING VACUUM PARTS, USE OF SILICONE, SULPHUR-BASED CUTTING FLUIDS AND ABRASIVES IS PROHIBITED. USE TRIM SOL OR APPROVED EQUAL LUBRICANT.
2. FOR COMPLETE SPECIFICATIONS ON MACHINING, CLEANING, VACUUM REQUIREMENTS, TESTING AND DELIVERY PREPARATION, SEE ANL DOCUMENT #410201-00095.
3. FOR COMPLETE WELDING SPECIFICATIONS, SEE ANL DOCUMENT #AMS 2685C.
4. DIMENSIONS IN BRACKETS [ ] ARE MILLIMETERS.
5. THERMALLY STABILIZE WELDMENT AT 650° F. +/_ 25° IN A VACUUM OR INERT ATMOSPHERE FOR 6 HOURS PER INCH OF THICKNESS, WITH A 6 HOUR MINIMUM HOLD. SLOW COOL LESS THAN 200° F. PER HOUR TO AMBIENT TEMPERATURE.

PARTS LIST

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
2		TUBING 2.75 OD X 2.00 ID	304 OR 304L ST ST'L	1
1	P4105090101-850101	VACUUM FLANGE 4.63 DIA. BLANK	STAINLESS STEEL	1

SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
2	3.625 was 3.600	RAF	CB	1/96
1	ROTATABLE FLANGE WAS NONROTATABLE	RAF	CB	10/95

REVISIONS

UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES
TOLERANCES
DECIMALS: .X ± .03 [.76]; .XX ± .01 [0.25]; .XXX ± .005 [0.127]
ANGULAR ± .5°
SURFACE ROUGHNESS 125
REMOVE ALL BURRS AND BREAK SHARP EDGES .03 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 A1645802

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DRAWN BY FUHRMANN	DATE 10/22/93	CHIEF DESIGN ENGINEER D. SHU	DATE 03/94
CHECKED BY C. BRITE	02/94	GP LEADER T.M. KUZAY	03/94
DESIGNER FUHRMANN	02/94	PROJECT MGR.	
RESPONSIBLE ENGINEER C. BRITE	02/94	APPROVED/RELEASED	

MATERIAL: SEE PARTS LIST

TITLE: ADVANCED PHOTON SOURCE
A1-LINEAR ACTUATOR, X-Z STEPPING, LIGHT LOAD WELDMENT

SCALE 1:1 | SHEET 1 of 1 | SIZE D | DRAWING NUMBER P4105090101-850106-02