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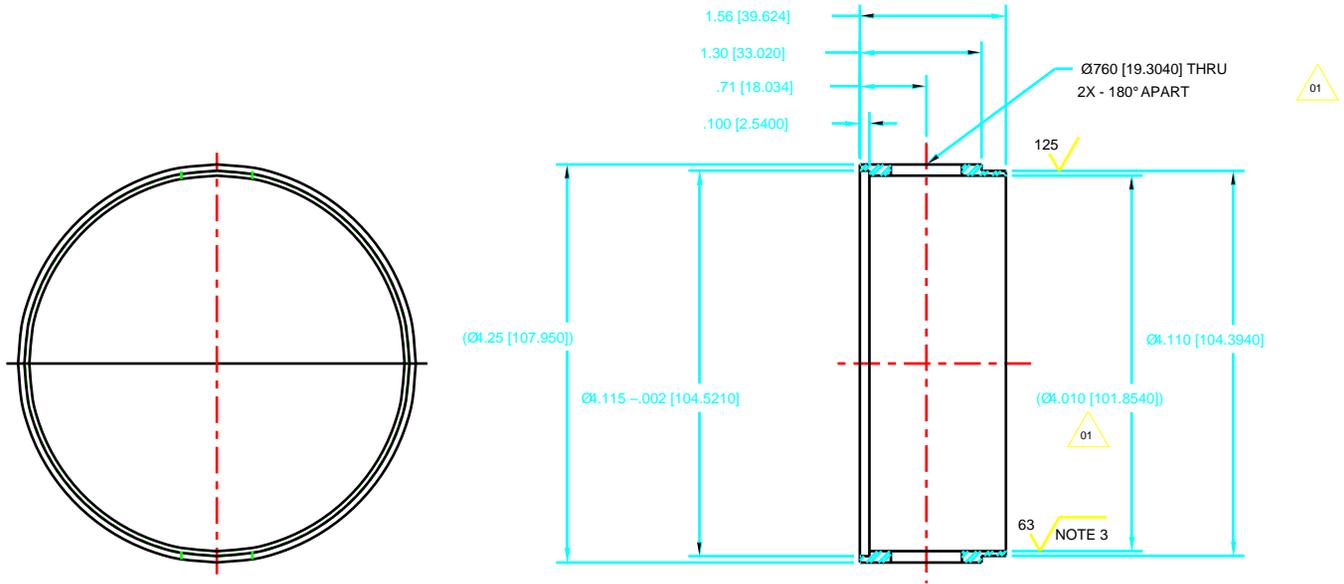
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NOTES:

1. THIS IS A ULTRA-HIGH VACUUM COMPONENT (UHV).
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. ELECTROPOLISHING IS NEEDED BEFORE WELDING. PRIOR TO ELECTROPOLISHING, THE COMPONENT NEEDS TO GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING, AND DRY NITROGEN BLOWDOWN. THE CHAMBER VACUUM SIDE SURFACE ROUGHNESS SHALL BE BETTER THAN 63 MICROINCH RMS AFTER ELECTROPOLISHING.
4. KEEP THE PART CLEAN AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
5. TOLERANCE SPECIFICATIONS TO CONFORM TO TOLERANCE BLOCK.
6. ALL DIMENSIONS IN [] ARE MILLIMETERS AND ARE FOR REFERENCE ONLY.

SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
01	Ø760 WAS Ø625 w/Ø680 CBORE	JSP	JC	1/29/96
01	WALL THKNS WAS .134	JSP	JC	1/29/96

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES		LOG NUMBER A1657701	THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY	
TOLERANCES		DESIGNER R.KRAKORA	DATE 2/94	CHIEF DESIGN ENGINEER D.SHU
DECIMALS		CHECKED BY J.CHANG	DATE 5/16/94	DATE 5/17/94
ANGULAR		DESIGNER R.KRAKORA	DATE 2/94	GP LEADER T.M.KUZAY
.X - .03 [.76]		PROJECT MGR. J.CHANG	DATE 5/16/94	DATE 5/18/94
.XX - .01 [0.25]		APPROVED/RELEASED		
.XXX - .005 [0.127]				
SURFACE ROUGHNESS 63				
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				
MATERIAL 304 SST Ø.25 x .120 WALL				
SCALE 1:1				
SHEET 1 of 1				
DRAWING NUMBER P4105091407-210002-01				

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