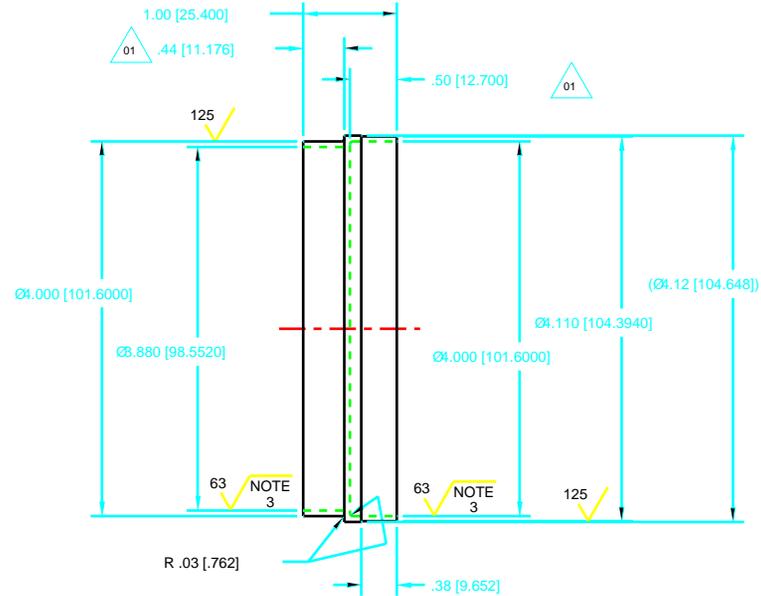
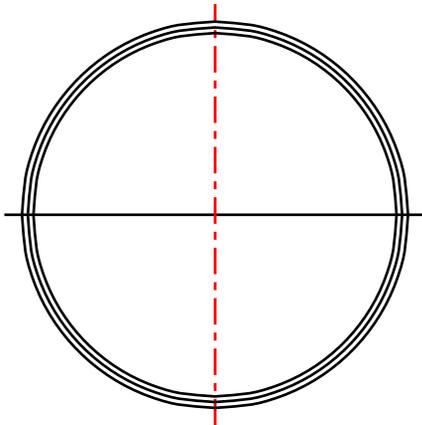


4 3 2 1



NOTES:

- THIS IS A ULTRA-HIGH VACUUM COMPONENT (UHV).
- 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
- 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 VACUUM SIDE SURFACE ROUGHNESS SHALL BE BETTER THAN 63 MICROINCH RMS AFTER ELECTROPOLISHING.
- KEEP THE PART CLEAN AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
- TOLERANCE SPECIFICATIONS TO CONFORM TO TOLERANCE BLOCK.
- ALL DIMENSIONS IN [] ARE MILLIMETERS AND ARE FOR REFERENCE ONLY.

01	.44 WAS .38; .50 WAS .56	JSP	JC	1/29/96
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 TOLERANCES DECIMALS ANGULAR .X - .03 [.76] - .25 .XX - .01 [0.25] .XXX - .005 [0.127] SURFACE ROUGHNESS 63 ✓		LOG NUMBER A1657901 THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY		
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		DRAWN BY R.KRAKORA CHECKED BY J.CHANG DESIGNER R.KRAKORA RESPONSIBLE ENGINEER J.CHANG	DATE 2/94 5/16/94 2/94 5/16/94	CHIEF DESIGN ENGINEER D.SHU GP LEADER T.M.KUZAY PROJECT MGR. APPROVED/RELEASED
		TITLE ADVANCED PHOTON SOURCE B7 ID BEAM MIS-STEERING SAFETY MONITOR LONG TUBE		
		MATERIAL 304 SST Ø.12 x .120 WALL		SCALE 1:1 SHEET 1 of 1
		DRAWING NUMBER P4105091407-210004-01		

4 3 2 1