

(C)

PLOT SCALE: 1=1

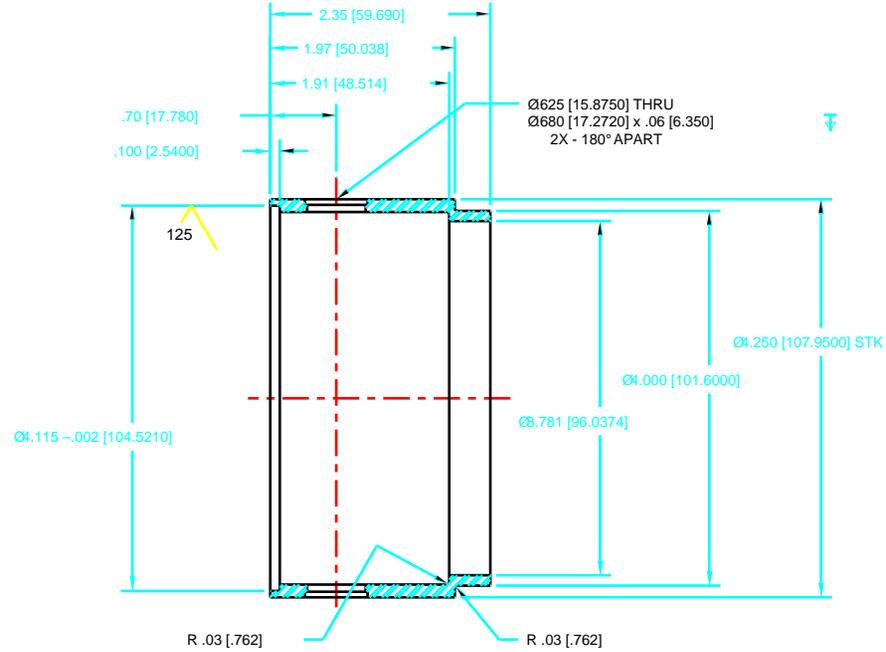
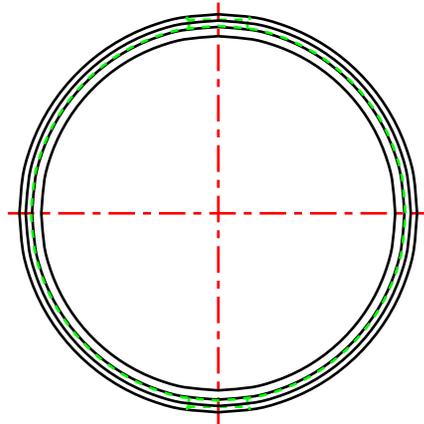
DWG. SCALE: 1

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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 MICRINCH 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.

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES TOLERANCES DECIMALS ANGULAR .X - .015 [.38] - .25 .XX - .010 [.25] .XXX - .005 [.127]		LOG NUMBER A18067		
SURFACE ROUGHNESS 250 ✓ 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		THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY		
DRAWN BY R. KRAKORA	DATE 3/94	CHIEF DESIGN ENGINEER D. SHU	DATE 6/8/94	ADVANCED PHOTON SOURCE B7 BM MIS-STEERING SAFETY MONITOR FEED THROUGH TUBE
CHECKED BY J. CHANG	DATE 6/8/94	GP LEADER T.M. KUZAY	DATE 6/8/94	
DESIGNER R. KRAKORA	DATE 3/94	PROJECT MGR.		
RESPONSIBLE ENGINEER J. CHANG	DATE 6/8/94	APPROVED/RELEASED		
MATERIAL SST 304 Ø.25 x .250 WALL		SCALE 1:1	SIZE C	DRAWING NUMBER P4105091407-310002-00
SHEET 1 of 1				

SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				

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