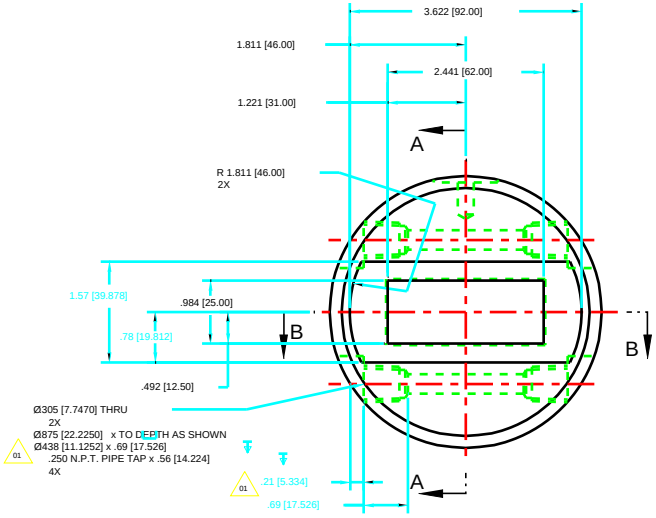
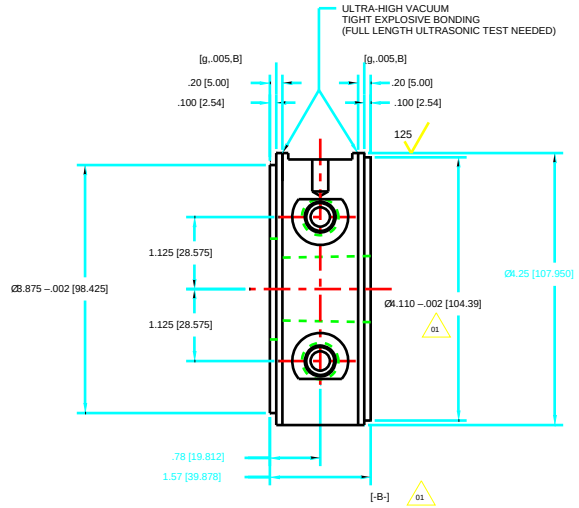
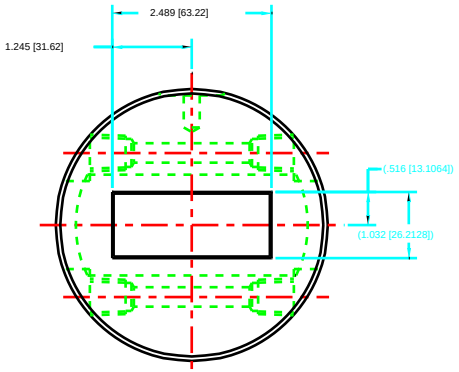
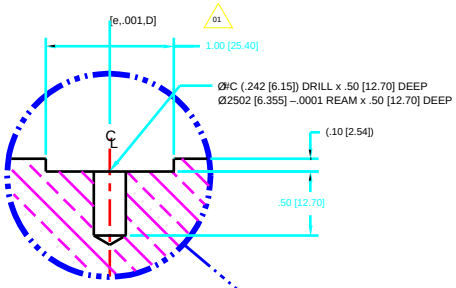
( )D	PLOT SCALE: 1=1	DWG. SCALE: 1	A1838901

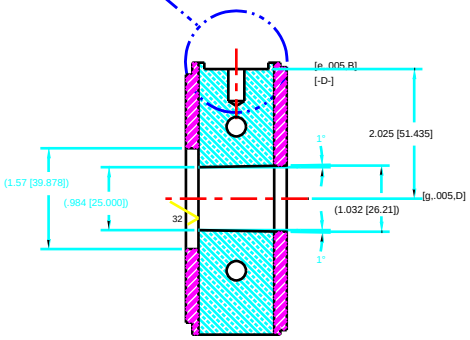




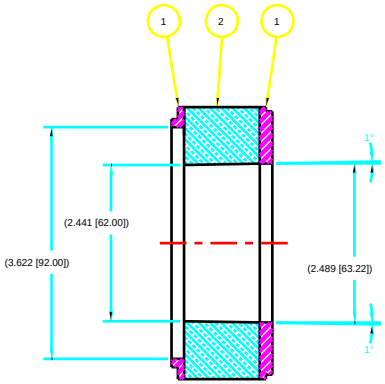




SCALE: 2X



SECTION A-A



SECTION B-B

NOTES:

1. THIS IS AN ULTRA-HIGH 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. 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.
4. THE COMPONENT SHALL BE LEAK TESTED USING A MASS SPECTROMETER WITH MINIMUM SENSITIVITY FOR HELIUM OF 2 x 10 STANDARD CC/SEC PER LEAK METER DIVISION, SUCH AS:
   ALCATEL ASM-110TCL
   VARIAN NCR 925 OR 936
   VEECO MS-9, MS-90 OR MS-18
   DuPONT CEC 24-120B

   CALIBRATION OF THE LEAK DETECTOR SENSITIVITY SHALL BE PERFORMED JUST PRIOR TO TESTING.

   FINAL TESTING WILL CONSIST OF SURROUNDING THE ASSEMBLY (BAGGING) WITH HELIUM. THE ASSEMBLY WILL BE REJECTED IF A 2% DEFLECTION IN THE MOST SENSITIVE RANGE OF THE LEAK DETECTOR IS SENSED WITHIN 1 MIN.
5. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
6. CERTIFICATION OF ULTRASONIC TEST AND VACUUM EXAMINATION SHALL BE SIGNED BY A CONTRACTOR REPRESENTATIVE TO SIGN SUCH CERTIFICATIONS.
7. TOLERANCE SPECIFICATIONS TO CONFORM TO TOLERANCE BLOCK.
8. DIMENSIONS IN [ ] ARE MILLIMETERS AND ARE FOR REFERENCE ONLY.

SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
01	Ø.110 WAS Ø.000; D WAS C;	JG	JC	4/29/96
01	DIM. .21 WAS .32; DATUM B ADDED;	JG	JC	4/29/96
01	4x 1/4" PIPE TAP WAS 2x;	JG	JC	4/29/96
01	1/4" PIPE TAP NOTE CHANGED;	JG	JC	4/29/96

REVISIONS

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
2		CHAMBER	GLID-COP	1
1		PLATE	SST 304	2

PARTS LIST

UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES
TOLERANCES
DECIMALS: .X ± .03, .XX ± .01, .XXX ± .005
ANGULAR ± .25
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

LOG NUMBER A1838901

THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY

DRAWN BY R.KRAKORA	DATE 5/94	CHIEF DESIGN ENGINEER D.SHU	DATE 6/21/94
CHECKED BY J.CHANG	6/20/94	GP LEADER T.M.KUZAY	6/21/94
DESIGNED R.KRAKORA	5/94	PROJECT MGR.	
RESPONSIBLE ENGINEER J.CHANG	6/20/94	APPROVED/RELEASED	

TITLE
ADVANCED PHOTON SOURCE
B7 ID BEAM MIS-STEERING
SAFETY MONITOR
MOUNTING BRACKET
COOLING BLOCK

MATERIAL SEE B.O.M.
SCALE 1:1
SHEET 1 of 1
SIZE D
DRAWING NUMBER P4105091407-400001-01