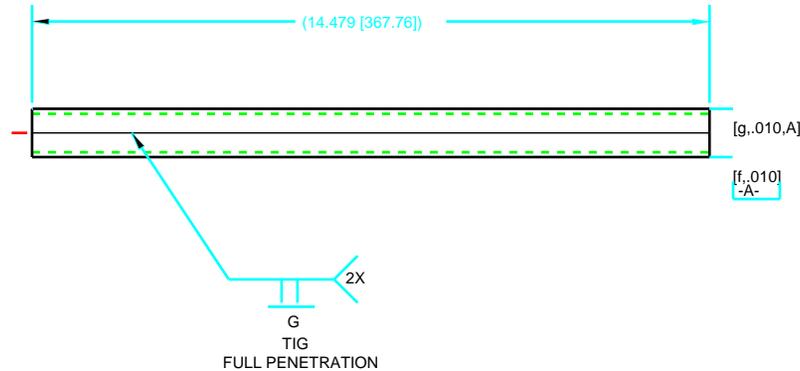
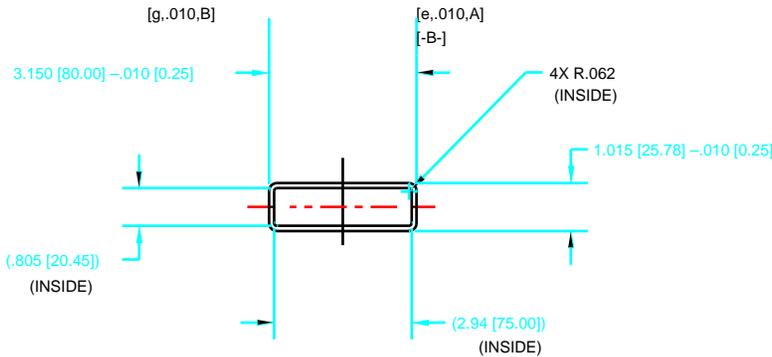


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NOTES:

1. 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
2. THIS IS A UHV PART, ELECTROPOLISHING IS NEEDED BEFORE WELDING. PRIOR TO ELECTROPOLISHING, THE PART NEEDS TO GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOW DOWN.
3. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
4. WALL THICKNESS NOT TO BE LESS THAN .100 AFTER MACHINING IF NEEDED.
5. DIMENSIONS IN [ ] ARE MILLIMETERS AND ARE FOR REFERENCE ONLY.
6. STRESS RELIEVE FOR DIMENSIONAL STABILITY BEFORE MACHINING.
7. WELD SHALL BE GAS TUNGSTEN ARC (GTAW) OR TUNGSTEN INERT GAS (TIG)

SY#	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				

ITEM	BYG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY	
<b>PARTS LIST</b>					
UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN INCHES TOLERANCES DECIMALS ANGLES X ± .03 (.7620) ± .25 ° XX ± .01 (0.25) XXX ± .005 (0.127)		LOG NUMBER <b>A2416800</b>	THIS DRAWING IS THE PROPERTY OF <b>ARGONNE NATIONAL LABORATORY</b>		
SURFACE ROUGHNESS 125 ✓ REMOVE ALL BURRS AND BREAK SHARP EDGES TO MAX. SURFACE FINISH TO BE IN ACCORDANCE WITH LATEST ASST 044 IDENTIFICATION & VERIFICATION IN ACCORDANCE WITH LATEST ASST 044		DRAWN BY E. TORRES-STERLING	DATE 3/15/96	CHEF DESIGN ENGINEER D. SHU	DATE 4/1/96
		CHECKED BY J. CHANG	DATE 3/22/96	OP LEADER T.M. KUZAY	DATE 4/2/96
		DESIGNER CHANG/TORRES	DATE 3/15/96	PROJECT MGR.	
		RESPONSIBLE ENGINEER J. CHANG	DATE 3/22/96	APPROVE/RELEASED	
		MATERIAL 12 GA. (.105) 304 STAINLESS STEEL	SCALE 1:2	SIZE C	DRAWING NUMBER P4105090403-410101-00
		DO NOT SCALE DRAWING	SHEET 1 of 1		

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