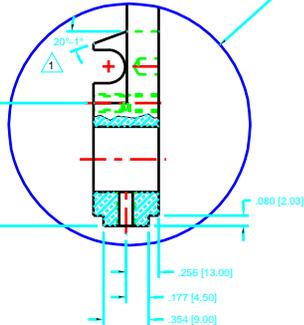


- NOTES:
- WHEN MACHINING VACUUM PARTS, USE OF SILICONE, SULPHUR-BASED CUTTING FLUIDS AND ABRASIVES IS PROHIBITED. USE TRIM SOL OR APPROVED EQUAL LUBRICANT.
 - FOR COMPLETE SPECIFICATIONS ON MACHINING, CLEANING, VACUUM REQUIREMENTS, TESTING AND DELIVERY PREPARATION, SEE ANL DOCUMENT #410201-00095.
 - DIMENSIONS IN BRACKETS [] ARE MILLIMETERS.



DETAIL "A"
SCALE: 2=1

SUGGESTED SOURCE:

1 HELI-COIL DIVISION
SHELTER ROCK LANE
DANBURY, CN 06810
PHONE: (203)-743-7651
FAX: (203)-798-2540

NO	CHANGE DESCRIPTION	BY	CHKD	DATE
1	ADDED ANGULAR TOLERANCE --1°	PJE	CB	05/94
1	DIMENSION R.12 (20X) WAS R.01 (12X)	PJE	CB	05/94

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
1	HELI-COIL # 3585-06CNV207	HELI-COIL INSERT, SCREW LOCK, SILVER FINISH	18-8 STAINLESS STEEL	15
		#6-32 UNC-2B x .21 LG.		

LOG NUMBER		DATE		DATE		DATE	
A18423		12/93		03/94			
DRAWN BY P. ENGELBRECHT		DATE 12/93		CHIEF DESIGN ENGINEER D. SHU		DATE 03/94	
DESIGNED BY C. BRITE		DATE 01/94		PROJECT MGR. T.M. KUZAY		DATE 03/94	
RESPONSIBLE ENGINEER P. ENGELBRECHT		DATE 12/93		APPROVED/RELEASED			
DESIGNER C. BRITE		DATE 02/94					
MATERIAL OFHC							
PER ANL SPEC. #B 170							

SCALE	SHEET	DWG. NUMBER
1:1	1 of 1	P4102010107-320201-01

ADVANCED PHOTON SOURCE
F1-APS ID BEAMLINE FILTER
BRAZING ASSEMBLY
FRAME