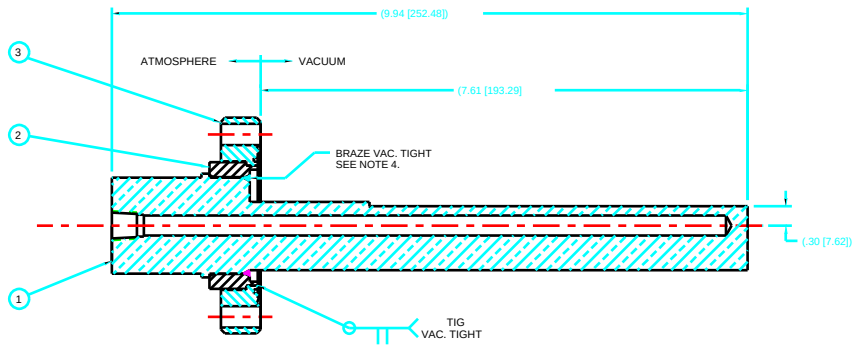
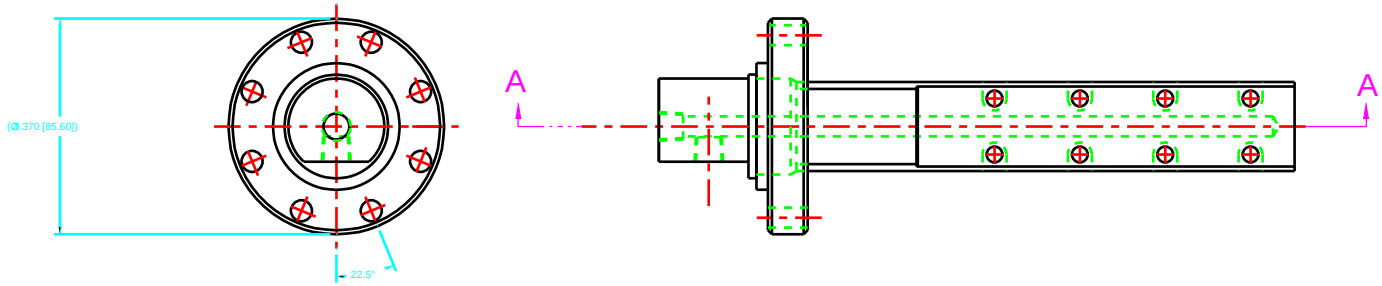
(D)	PLOT SCALE: 1=1	DWG. SCALE: 1	



SECTION A-A



NOTES:

1. WHEN MACHINING VACUUM PARTS, USE OF SILICONE, SULPHUR-BASED CUTTING FLUIDS AND ABRASIVES IS PROHIBITED. USE TRIM SOL OR APPROVED EQUAL LUBRICANT.
2. FOR COMPLETE SPECIFICATIONS ON MACHINING, CLEANING, VACUUM REQUIREMENTS, TESTING AND DELIVERY PREPARATION, SEE ANL DOCUMENT #410201-00095.
3. FOR COMPLETE WELDING SPECIFICATIONS, SEE ANL DOCUMENT #AMS 2685C.
4. FOR COMPLETE BRAZING SPECIFICATIONS, SEE ANL DOCUMENT #AMS 2664E.
5. DIMENSIONS IN BRACKETS [ ] ARE MILLIMETERS.

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
3	P4102010107-340103-00	VACUUM FLANGE, 3-3/8" NON-ROTATABLE, 3.37 O.D. x 1.87 I.D. x .62 THK.	304 STAINLESS STEEL	1
2	P4102010107-340102-00	RING 1.980 O.D. x 1.502 I.D. x .750 THK.	304 OR 304L STAINLESS STEEL	1
1	P4102010107-340101-00	FRAME 1.620 O.D. x 9.94 LG.	OXYGEN FREE COPPER	1

PARTS LIST

SYM	CHANGE DESCRIPTION	BY	CHKD	DATE

REVISIONS

UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES

TOLERANCES

DECIMALS: .X ± .030 [.762]; .XX ± .010 [.254]; .XXX ± .005 [.127]

ANGULAR ± .25

SURFACE ROUGHNESS 125

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 A15647

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DRAWN BY P. ENGELBRECHT	DATE 01/94	CHIEF DESIGN ENGINEER D. SHU	DATE 03/94
CHECKED BY C. BRITE	01/94	GP LEADER T.M. KUZAY	03/94
DESIGNER P. ENGELBRECHT	01/94	PROJECT MGR.	
RESPONSIBLE ENGINEER C. BRITE	02/94	APPROVED/RELEASED	

TITLE
ADVANCED PHOTON SOURCE
F1-APS ID BEAMLINE FILTER
COOLING ASSEMBLY
BRAZING ASSEMBLY

MATERIAL SEE PARTS LIST

SCALE 1:1 SHEET 1 of 1

SIZE D

DRAWING NUMBER P4102010107-340100-00