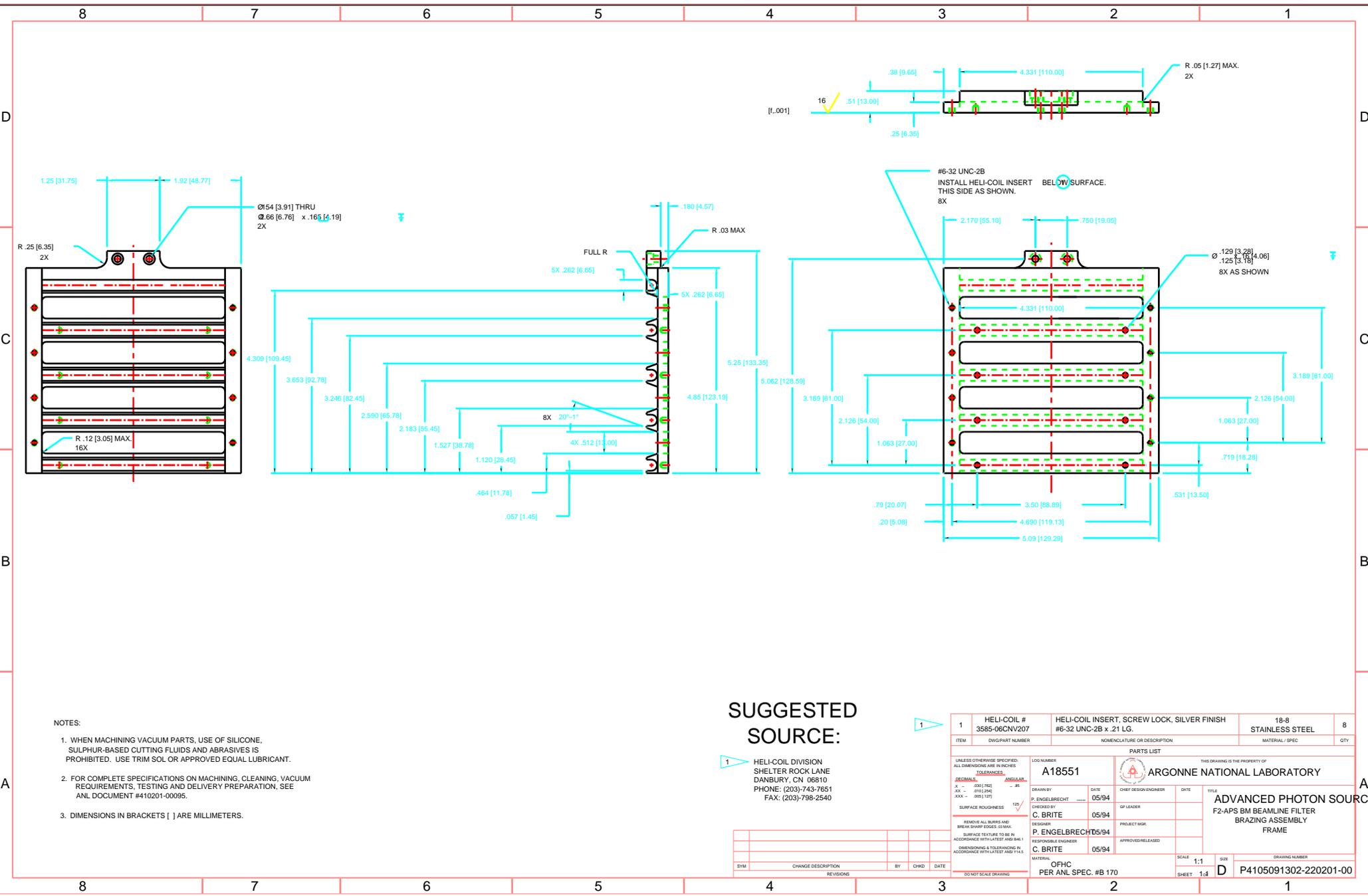


(D) PLOT SCALE: 1=1 DWG. SCALE: 1



- 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. DIMENSIONS IN BRACKETS [] ARE MILLIMETERS.

SUGGESTED SOURCE:

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

BY	CHANGE DESCRIPTION	BY	CHKD	DATE

1	HELI-COIL # 3585-06CNV207	HELI-COIL INSERT, SCREW LOCK, SILVER FINISH #6-32 UNC-2B x .21 LG.	18-8 STAINLESS STEEL	8
ITEM	DWG/PART NUMBER		NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC
PARTS LIST				
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES TOLERANCES:		THIS DRAWING IS THE PROPERTY OF		
DECIMALS	ANGULAR	ARGONNE NATIONAL LABORATORY		
± .001 (0.025)	± .05	LOG NUMBER A18551	DATE 05/94	TITLE ADVANCED PHOTON SOURCE F2-APS BM BEAMLINE FILTER BRAZING ASSEMBLY FRAME
± .002 (0.050)	± .05	DRAWN BY P. ENGELBRECHT	DATE	CHIEF DESIGN ENGINEER
± .005 (0.127)	± .05	DESIGNED BY C. BRITE	DATE 05/94	DATE
SURFACE ROUGHNESS 125		DESIGNER P. ENGELBRECHT	PROJECT MGR.	DATE
REMOVE ALL BURRS AND BREAK SHARP EDGES (R0.04)		RESPONSIBLE ENGINEER C. BRITE	APPROVED/RELEASED	DATE
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST AMS-B41		MATERIAL OFHC PER ANL SPEC. #B 170	SCALE 1:1	SHEET 1 of 1
DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5		DO NOT SCALE DRAWING	DRAWING NUMBER P4105091302-220201-00	