

+0.002 [0.05]
-0.000 [0.00]

2.000 [50.80]

+0.002 [0.05]
-0.000 [0.00]

1.530 [38.86]

8X R.12 [3.05]

.30 [7.75]

1.80 [45.72]

SECTION A - A

NOTES:

1. MAKE FROM MDC'S 4 1/2 O.D. VACUUM FLANGE CATALOG # 110018
2. THIS IS A ULTRA- HIGH VACUUM COMPONENT (UHV)
3. 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
4. FINISHING: WHEN MACHINING VACUUM PARTS USE OF ABRASIVE PAPER OR SANDING DISCS, BUFFING OR POLISHING COMPOUNDS, OR RESIN-BONDED GRINDING WHEELS IS PROHIBITED
5. CLEANING: THE COMPONENT MUST BE CLEANED SUCH THAT A UHV PRESSURE OF 1 X 10⁻⁹ TORR CAN BE ACHIEVED
6. HANDLING: THE COMPONENTS SHALL BE HANDLED WITH WHITE SILK GLOVES AND WRAPPED WITH ALUMINUM FOIL TYPE DRY ANNEAL AND UNDER CLEAN ROOM CONDITIONS
7. DIMENSIONS IN [] ARE MILLIMETERS AND FOR REF. ONLY

SYN	CHANGE DESCRIPTION	BY	CHKD	DATE

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN INCHES		LOG NUMBER	THIS DRAWING IS THE PROPERTY OF	
TOLERANCES		M1410002-00	ARGONNE NATIONAL LABORATORY	
DECIMALS	ANGULAR	DRAWN BY	CHIEF DESIGN ENGINEER	DATE
.X ± .1 [2.5]	± 0°30'	MUSCIA	D. SHU	3/20/98
.XX ± .01 [0.25]		CHECKED BY	GP LEADER	DATE
.XXX ± .005 [0.13]		J. CHANG	T.M. KUZAY	3/20/98
SURFACE ROUGHNESS 125 ✓		DESIGNER	PROJECT MGR.	DATE
REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX.		SHU/MUSCIA		
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1		RESPONSIBLE ENGINEER	APPROVED/RELEASED	DATE
DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5		D. SHU		3/20/98
MATERIAL SEE NOTE #1			SCALE HALF	SIZE
			SHEET 1 of 1	DRAWING NUMBER
			B	M1-410002-00

