



NOTES:

- THIS IS A ULTRA- HIGH VACUUM COMPONENT (UHV)
 - 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
 - FINISHING: WHEN MACHINING VACUUM PARTS USE OF ABRASIVE PAPER OR SANDING DISCS, BUFFING OR POLISHING COMPOUNDS, OR RESIN-BONDED GRINDING WHEELS IS PROHIBITED
 - CERTIFICATION OF ULTRA SONIC TEST AND VACUUM EXAMINATION SHALL BE SIGNED BY A CONTRACTOR REPRESENTATIVE AUTHORIZED TO SIGN SUCH CERTIFICATION
 - DIMENSIONS IN [] ARE MILLIMETERS AND FOR REF. ONLY
- * MACHINE AFTER EXPLOSIVE BONDING

REV	CHANGE DESCRIPTION	BY	CHKD	DATE
3	4X .75 [19.05] X 45° CHAMFER WAS			
	4X .50 [12.70] X 45° CHAMFER	M.J.M	J.C.	1/6/99
2	4X .50 [12.70] X 45° CHAMFER ADDED	M.J.M	J.C.	6/19/98
1	NO CHANGE, NO DRAWING	M.J.M		

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE IN INCHES		THIS DRAWING IS THE PROPERTY OF		
TOLERANCES		ARGONNE NATIONAL LABORATORY		
DIMENSIONS		ADVANCED PHOTON SOURCE		
FRACTIONS		M2-40 APS 4-ID FRONT END		
DECIMALS		2 ND FIXED MASK		
ANGLES		MAIN BODY		
HOLE DIA		M2410001-03-1		
SURFACE FINISH		SCALE HALF		
REMOVE ALL BURRS AND BREAK SHARP EDGES TO MAX.		SIZE C		
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ASST B4		DRAWING NUMBER		
REVISIONS & TOLERANCES IN ACCORDANCE WITH LATEST ASST B4		M2-410001-03-1		
DO NOT SCALE DRAWING		SHEET 12		