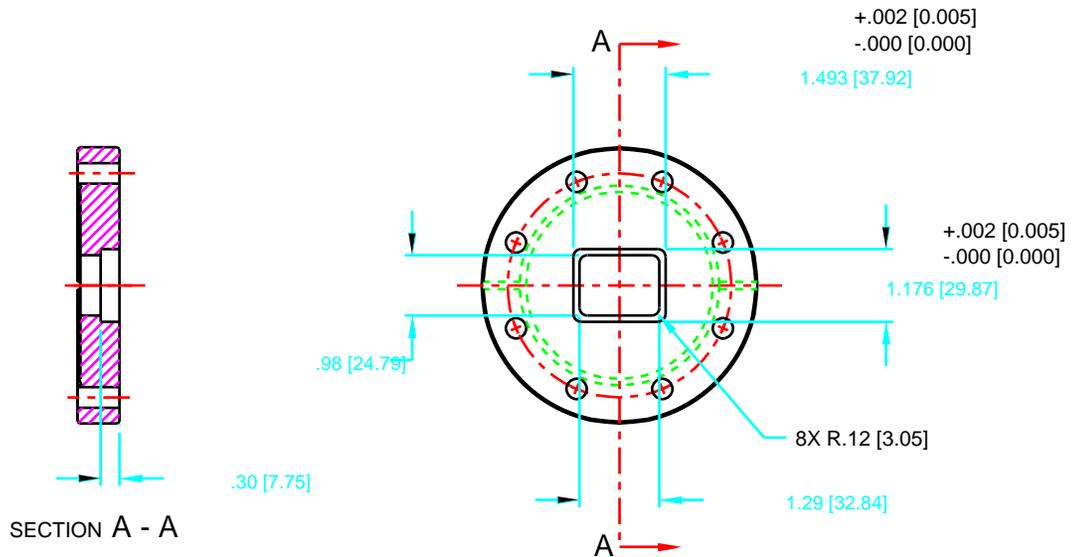


NOTES:

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  $1 \times 10^{-9}$  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



ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY	
<b>PARTS LIST</b>					
UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE IN INCHES		LOG NUMBER <b>M2410002-00</b>	THIS DRAWING IS THE PROPERTY OF <b>ARGONNE NATIONAL LABORATORY</b>		
<b>TOLERANCES</b> DECIMALS      ANGULAR .X            ± .1 [2.5]            ± 0°30' .XX          ± .01 [0.25] .XXX        ± .005 [0.13]		DRAWN BY MUSCIA	DATE 3/20/98	CHIEF DESIGN ENGINEER D. SHU	DATE 3/20/98
SURFACE ROUGHNESS $125 \sqrt{\text{ }}$		CHECKED BY J. CHANG	DATE 3/20/98	GP LEADER T.M. KUZAY	DATE 3/20/98
REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX.		DESIGNER SHU/MUSCIA	DATE 3/20/98	PROJECT MGR.	DATE
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46		RESPONSIBLE ENGINEER D. SHU	DATE 3/20/98	APPROVED/RELEASED	DATE
DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5		MATERIAL SEE NOTE#1		SCALE HALF	SIZE B
DO NOT SCALE DRAWING		DRAWING NUMBER <b>M2-410002-00</b>		SHEET 1 of 1	

SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				