



NOTES:

1. THIS IS A ULTRA- HIGH VACUUM COMPONENT (UHV)
2. 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
3. FINISHING: WHEN MACHINING VACUUM PARTS USE OF ABRASIVE PAPER OR SANDING DISCS, BUFFING OR POLISHING COMPOUNDS, OR RESIN-BONDED GRINDING WHEELS IS PROHIBITED
4. CERTIFICATION OF ULTRA SONIC TEST AND VACUUM EXAMINATION SHALL BE SIGNED BY A CONTRACTOR REPRESENTATIVE AUTHORIZED TO SIGN SUCH CERTIFICATION

5. DIMENSIONS IN [] ARE MILLIMETERS AND FOR REF. ONLY

* MACHINE AFTER EXPLOSIVE BONDING

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		THIS DRAWING IS THE PROPERTY OF		
TOLERANCES		ARGONNE NATIONAL LABORATORY		
DECIMALS	ANGLES	ADVANCED PHOTON SOURCE		
.12	0°30'	M4-40 32-ID FRONT END		
.01 (0.25)		4 TH FIXED MASK		
.005 (0.13)		MAIN BODY		
SURFACE ROUGHNESS 125 ✓		MATERIAL / SPEC		
REMOVE ALL BURRS AND BREAK SHARP EDGES TO MAX.		SCALE HALF		
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ASST D44		SIZE C		
DIMENSIONS & TOLERANCES IN ACCORDANCE WITH LATEST ASST T14		DRAWING NUMBER		
DO NOT SCALE DRAWING		M4-400001-00-1		
		SHEET 12		