

(B)

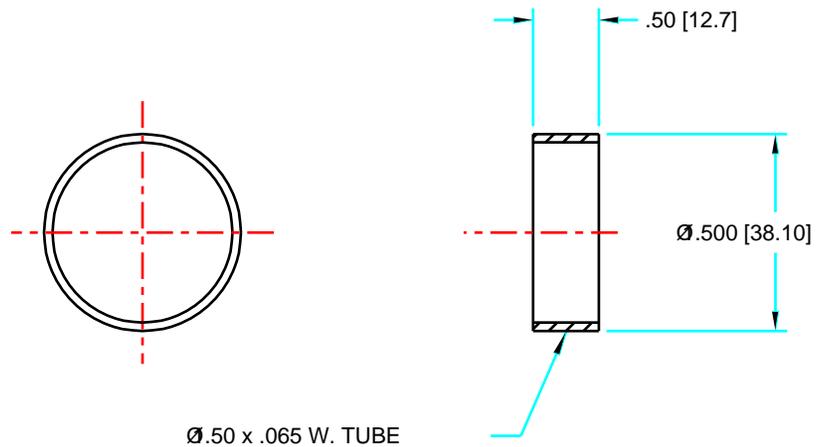
PLOT SCALE: 1=1

DWG. SCALE: 1

A2307600

NOTES:

- WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:
 - CIMCOOL 5 STAR 49
 - TRIM SOL
- THIS IS A UHV PART, ELECTROPOLISHING IS NEEDED BEFORE WELDING. PRIOR TO ELECTROPOLISHING, THE PART MUST GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOW DOWN.
- KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
- DIMENSIONS IN [] ARE MILLIMETERS AND FOR REFERENCE ONLY.



ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES		LOG NUMBER A2307600	THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY	
TOLERANCES DECIMALS ANGULAR .X - .03 - .25 .XX - .01 .XXX - .005		DRAWN BY J.GOGOL CHECKED BY J.CHANG DESIGNER J.GOGOL RESPONSIBLE ENGINEER J.CHANG MATERIAL 304 SST	CHIEF DESIGN ENGINEER D.SHU GP LEADER T.M.KUZAY PROJECT MGR. APPROVED/RELEASED	DATE 6/30/95 8/13/95 8/15/95 DATE DATE
SURFACE ROUGHNESS 63 ✓		TITLE ADVANCED PHOTON SOURCE M9-30 2 ID-D FIXED MASK EXTENSION TUBE		
REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX.		SCALE 1:1 SIZE B DRAWING NUMBER		
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1		SHEET 1 of 1 P4105091009-300005-00		
DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5		DO NOT SCALE DRAWING		
SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				