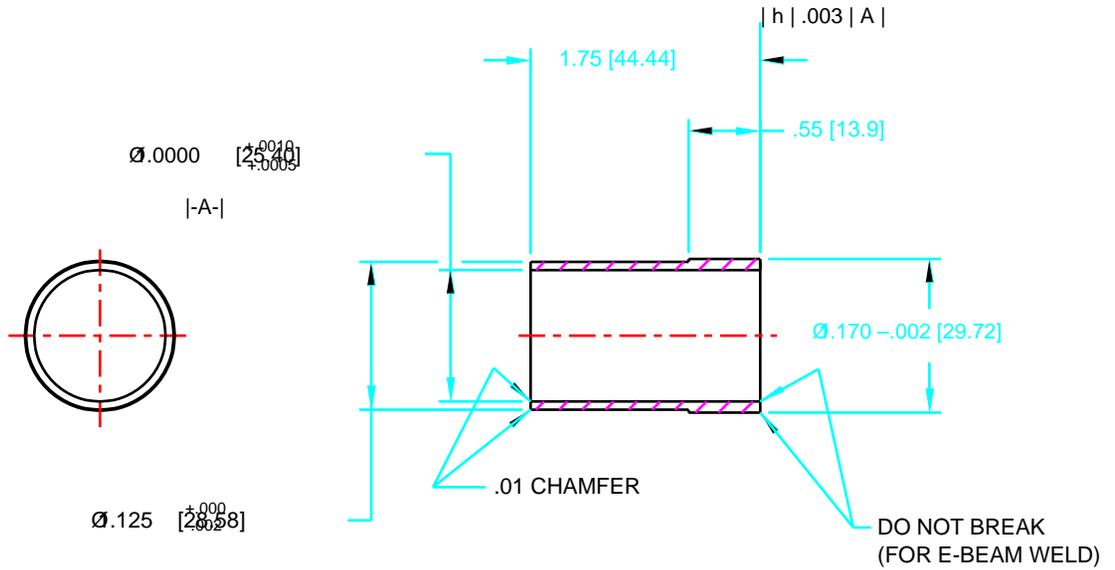


(B)

PLOT SCALE: 1=1

DWG. SCALE: 1



NOTES:

1. THIS IS A ULTRA- HIGH VACUUM COMPONENT (UHV)
2. WHEN MACHINING VACUUM PARTS, USE SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:
A) CIMCOOL 5 STAR 49
B) TRIM SOL
3. THIS IS A UHV PART. PRIOR TO WELDING, THE PART NEEDS TO GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOWDOWN.

4. KEEP THE PART CLEAN AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.

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

6. SURFACE ROUGHNESS

63

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY	
PARTS LIST					
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES		LOG NUMBER A2458200	THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY		
TOLERANCES DECIMALS ANGULAR .X - .03 - .25 .XX - .01 .XXX - .005		DRAWN BY J.GOGOL	DATE 5/13/96	CHIEF DESIGN ENGINEER D.SHU	DATE 5/23/96
SURFACE ROUGHNESS ✓		CHECKED BY J.CHANG	DATE 5/23/96	GP LEADER T.M.KUZAY	DATE 5/24/96
REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX.		DESIGNER J.GOGOL	DATE 5/13/96	PROJECT MGR.	
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1		RESPONSIBLE ENGINEER J.CHANG	DATE 5/23/96	APPROVED/RELEASED	
DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5		MATERIAL 304 SST	SCALE 1:1	SIZE B	DRAWING NUMBER P4105091009-400002-00
DO NOT SCALE DRAWING			SHEET 1 of 1		

SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				