



NOTES:

1. MAKE FROM MDC'S 8" O.D. NONROTATABLE BLANK FLANGE CAT. #110030
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. 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.
4. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
5. DIMENSIONS IN [] ARE MILLIMETERS AND FOR REF. ONLY

1		Ø.000 O.D. X .120 WALL X 1.38 LG.	SST	1
ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN INCHES TOLERANCES DECIMALS ANGULAR .X ± .03 [7620] ± .25 ° .XX ± .01 [0.25] .XXX ± .005 [0.127] SURFACE ROUGHNESS 125 ✓ REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX. SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46 DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5		LOG NUMBER A2394700	THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY	
DRAWN BY MUSCIA	DATE 2/6/96	CHIEF DESIGN ENGINEER D. SHU	DATE	ADVANCED PHOTON SOURCE Y4 HORIZONTAL REFLECTING WATER COOLED X-RAY MULTI- RIGHT END CHAMBER COVER VACUUM FLANGE
CHECKED BY D. SHU		GP LEADER T.M. KUZAY		
DESIGNER SHU/MUSCIA	2/6/96	PROJECT MGR.		
RESPONSIBLE ENGINEER D. SHU		APPROVED/RELEASED		
MATERIAL SEE NOTE #1 & PARTS LIST		SCALE HALF	SIZE B	DRAWING NUMBER
		SHEET 1 of 1	P4105091204-220001-00	

SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				

DO NOT SCALE DRAWING