



NOTES:

1. WHEN MACHINING VACUUM PARTS, THE USE OF SILICONE, SULPHUR-BASED CUTTING FLUIDS AND ABRASIVES IS PROHIBITED. USE EITHER TRIM SOL OR CIMCOOL 5 STAR 49 OR APPROVED EQUAL LUBRICANT.
2. FOR COMPLETE SPECIFICATIONS ON MACHINING, CLEANING, VACUUM REQUIREMENTS, TESTING AND DELIVERY PREPARATION, SEE ANL DOCUMENT #410201-00095.
3. FOR COMPLETE WELDING SPECIFICATIONS, SEE ANL DOCUMENT #AMS 2685C.
4. DIMENSIONS IN BRACKETS [ ] ARE MILLIMETERS AND FOR REF. ONLY.
5. HARDEN SURFACE SHOWN TO RC 56-58 - .06 MIN. DEPTH. SURFACE HARDENING OF ENTIRE PART IS PERMISSIBLE.

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES TOLERANCES: DECIMALS ANGLE .XX - .125 XX - .125 XXX - .005 (12)		LOG NUMBER <b>Y5300007-00</b>	PARTS LIST THIS DRAWING IS THE PROPERTY OF <b>ARGONNE NATIONAL LABORATORY</b>	
SURFACE FINISHES 125 SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST AMS 2685C		DESIGNED BY <b>RF FUHRMANN</b>	DATE 11/15/21	CHIEF DESIGN ENGINEER <b>D. Shu</b>
DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5		DESIGNER <b>BENSON/FUHRMANN</b>	DATE 11/15/21	PROJECT MGR. <b>T.M. Kuzay</b>
DO NOT SCALE DRAWING		APPROVED/RELEASED <b>BENSON</b>	DATE	DATE
MATERIAL <b>ST3TL 440</b>		SCALE <b>1:1</b>		SIZE <b>D</b>
SEE NOTE 5		DRAWING NUMBER <b>Y5-300007-00</b>		SHEET <b>1 of 1</b>

BY	CHANGE DESCRIPTION	BY	CHKD	DATE