



- NOTES:
1. THIS IS AN 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, ELECTROPOLISHING IS NEEDED BEFORE WELDING. PRIOR TO ELECTROPOLISHING, 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  $\sqrt{63}$

REV	CHANGE DESCRIPTION	BY	CHKD	DATE
2	ADD Ø.36 CTB	AC		
1	PRESS FIT WAS SLIP FIT;	J.G. J.C.		11/14/95
1	ITEM 1,2,3 ADD; NOTE UPDATE;	J.G. J.C.		11/14/95
1	Ø.63 VENT HOLES ADDED;	J.G. J.C.		11/14/95

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
3	P4105091103-830016	X1-83 MODIFIED FITTING	316 SST	1
2	P4105091103-830015	X1-83 TUBING	304 SST	1
1	P4105091103-830014	X1-83 TUBING	304 SST	1

  

UNLESS OTHERWISE SPECIFIED:		LOG NUMBER		THIS DRAWING IS THE PROPERTY OF	
ALL DIMENSIONS ARE IN INCHES		A2322402		ARGONNNE NATIONAL LABORATORY	
TOLERANCES:		DATE		TITLE	
XX - .01	ANGULAR	8/24/95		ADVANCED PHOTON SOURCE	
XX - .05		8/24/95		X1-83 CRYSTAL HOLDER FOR	
XX - .005		8/31/95		3-ID-A KOHZU	
SURFACE ROUGHNESS 125		PROJECT MGR.		FIXED PLATE WELDMENT	
		APPROVED/RELEASED			
		DATE			
		8/31/95			
		DATE			
		8/31/95			
		DATE			
		8/31/95			

  

SCALE	SHEET	TOTAL SHEETS	DWG. NUMBER
1:1	1 of 1	1	P4105091103-830002-02