



NOTES:

1. 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
2. THIS IS A UHV PART, ELECTROPOLISHING IS NEEDED. PRIOR TO ELECTROPOLISHING, THE PART NEEDS TO GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOW DOWN.
3. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
4. DIMENSIONS IN [] ARE MILLIMETERS

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES TOLERANCES: DECIMALS ANGULAR X .05 .25 XX .02 .15 XXX .01 .10		LOG NUMBER A07440	THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY	
SURFACE ROUGHNESS 125		DESIGNED BY MUSCIA	DATE 8/3/92	TITLE ADVANCED PHOTON SOURCE P1 1 ST PHOTON SHUTTER SUPPORT STRUCTURE BOTTOM COVER SIDE PLATE RIGHT SIDE
REMOVE ALL BURRS AND BREAK SHARP EDGES (R3MM)		DESIGNER MUSCIA	PROJECT MGR.	
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST AMS-B-1 DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5		RESPONSIBLE ENGINEER	APPROVED/RELEASED	
DO NOT SCALE DRAWING		MATERIAL #7 GA. (.1874) 316 STAINLESS STEEL	SCALE 1:1	DRAWING NUMBER P4102010103-210302-00
REVISIONS		BY	CHKD	DATE
SYM	CHANGE DESCRIPTION			