



SCALE 10:1

SCALE 2X

- NOTES:
1. THIS IS A UHV PART.
THE PART NEEDS TO GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOW DOWN BEFORE WELDING.
 2. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
 3. 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
 4. ALL DIMENSIONS WITH ~~ARE~~ MILLIMETERS

SYM	CHANGE DESCRIPTION	BY	CHKD	DATE

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES		THIS DRAWING IS THE PROPERTY OF		
TOLERANCES		 ARGONNE NATIONAL LABORATORY		
DECIMALS		LOG NUMBER	TITLE	
.X - .03		P4410104-00	ADVANCED PHOTON SOURCE	
.XX - .01		DRAWN BY	DATE	DATE
.XXX - .005		MUSCIA	7/22/99	12/18/99
ANGULAR		CHECKED BY	CHIEF DESIGN ENGINEER	
125		J.CHANG	D.SHU	
SURFACE ROUGHNESS		DESIGNER	GP LEADER	
REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX.		CHANG/MUSCIA	T.M.KUZAY	
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1		RESPONSIBLE ENGINEER	PROJECT MGR.	
DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5		J.CHANG	APPROVED/RELEASED	
		MATERIAL	SCALE	SIZE
		SST 304	1:1	C
			SHEET	DRAWING NUMBER
			1 of 1	P4-410104-00