



- NOTES:
- THIS DRAWING IS FOR EXPLOSIVE BONDING USE ONLY.
 - THIS IS A ULTRA- HIGH VACUUM COMPONENT (UHV)
 - WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:
 - CIMCOOL 5 STAR 49
 - TRIM SOL
 - FINISHING: WHEN MACHINING VACUUM PARTS USE OF ABRASIVE PAPER OR SANDING DISCS, BUFFING OR POLISHING COMPOUNDS, OR RESIN-BONDED GRINDING WHEELS IS PROHIBITED
 - ASSEMBLY SHALL BE ULTRASONICALLY TESTED AND CERTIFIED. CERTIFICATION OF ULTRA SONIC TEST SHALL BE SIGNED BY A CONTRACTOR REPRESENTATIVE TO SIGN SUCH CERTIFICATION
 - DIMENSIONS IN [] ARE MILLIMETERS AND FOR REF. ONLY
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*** MACHINE AFTER EXPLOSIVE BONDING**

| 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 | | LOG NUMBER P4510101-00-1 | | |
| TOLERANCES | | THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY | | |
| DECIMALS | ANGULAR | DRAWN BY MUSCIA | | |
| .X - .1 [2.5] | - 0'30' | DATE | CHIEF DESIGN ENGINEER | DATE |
| .XX - .01 [0.25] | | 10/14/98 | D. SHU | 11/29/98 |
| .XXX - .005 [0.13] | | CHECKED BY | DATE | TITLE |
| | | J. CHANG | 11/25/98 | ADVANCED PHOTON SOURCE |
| SURFACE ROUGHNESS | 125 | DATE | GP LEADER | DATE |
| | | 10/14/98 | M. KUZAY | 12/10/98 |
| REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX. | | DESIGNER | PROJECT MGR. | DATE |
| SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1 | | CHANG/MUSCIA | DATE | |
| DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5 | | RESPONSIBLE ENGINEER | DATE | APPROVED/RELEASED |
| | | J. CHANG | 11/25/98 | |
| MATERIAL SEE ABOVE | | SCALE 1:1 | | |
| | | SIZE C | | |
| | | DRAWING NUMBER P4-510101-00-1 | | |
| | | SHEET 12 | | |