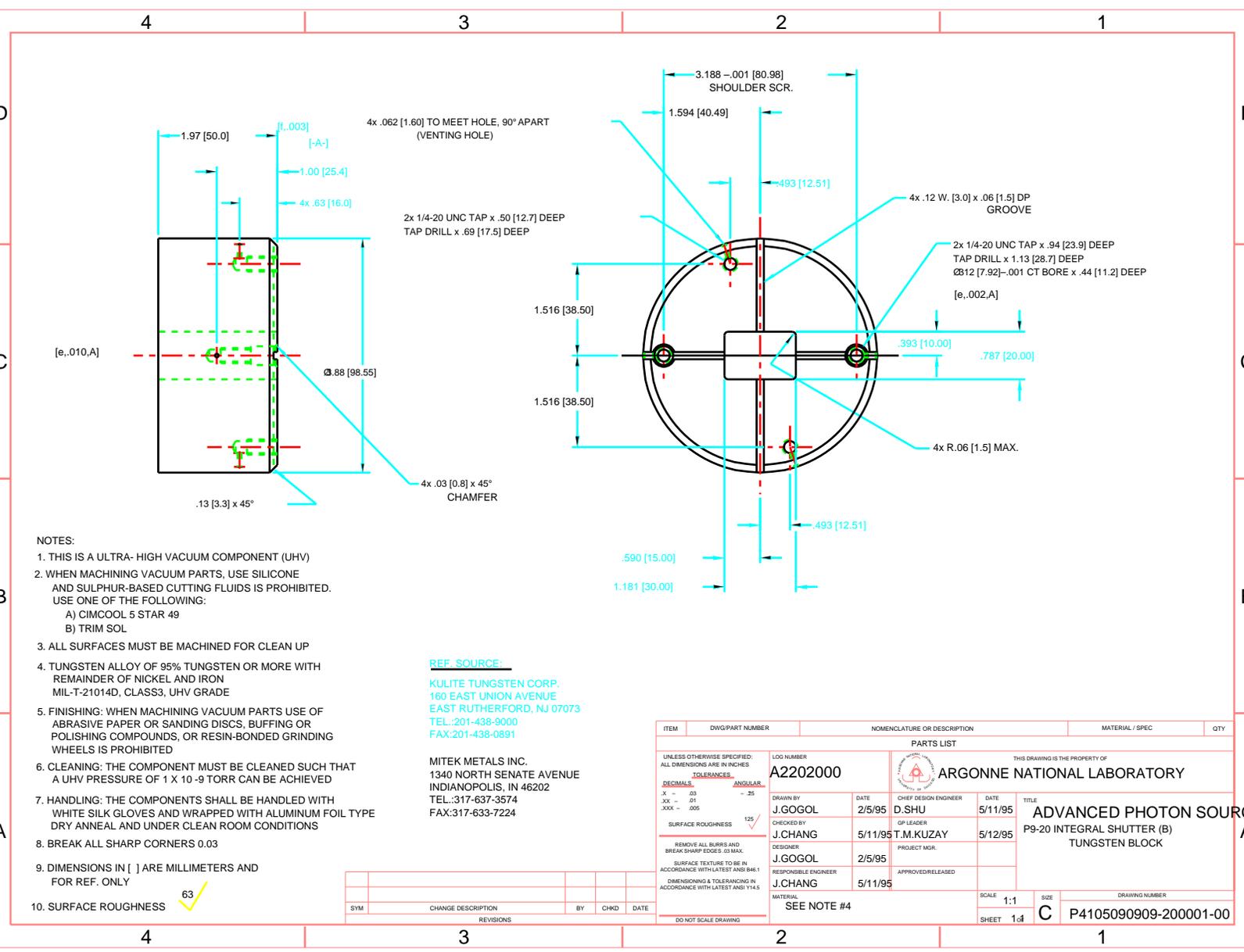


(C) PLOT SCALE: 1=1 DWG. SCALE: 1 A2202000



- NOTES:
1. THIS IS A 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. ALL SURFACES MUST BE MACHINED FOR CLEAN UP
 4. TUNGSTEN ALLOY OF 95% TUNGSTEN OR MORE WITH REMAINDER OF NICKEL AND IRON MIL-T-21014D, CLASS3, UHV GRADE
 5. FINISHING: WHEN MACHINING VACUUM PARTS USE OF ABRASIVE PAPER OR SANDING DISCS, BUFFING OR POLISHING COMPOUNDS, OR RESIN-BONDED GRINDING WHEELS IS PROHIBITED
 6. CLEANING: THE COMPONENT MUST BE CLEANED SUCH THAT A UHV PRESSURE OF 1×10^{-9} TORR CAN BE ACHIEVED
 7. HANDLING: THE COMPONENTS SHALL BE HANDLED WITH WHITE SILK GLOVES AND WRAPPED WITH ALUMINUM FOIL TYPE DRY ANNEAL AND UNDER CLEAN ROOM CONDITIONS
 8. BREAK ALL SHARP CORNERS 0.03
 9. DIMENSIONS IN [] ARE MILLIMETERS AND FOR REF. ONLY
 10. SURFACE ROUGHNESS \checkmark

REF SOURCE:
 KULITE TUNGSTEN CORP.
 160 EAST UNION AVENUE
 EAST RUTHERFORD, NJ 07073
 TEL.:201-438-9000
 FAX:201-438-0891

MITEK METALS INC.
 1340 NORTH SENATE AVENUE
 INDIANOPOLIS, IN 46202
 TEL.:317-637-3574
 FAX:317-633-7224

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 A2202000	THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY	
TOLERANCES DECIMALS .01 XX - .01 XXX - .005		ANGULAR - .5	DATE 2/5/95	DATE 5/11/95
SURFACE ROUGHNESS \checkmark 125		DESIGNER J.GOGOL	DATE 2/5/95	TITLE ADVANCED PHOTON SOURCE P9-20 INTEGRAL SHUTTER (B) TUNGSTEN BLOCK
REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX. SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST AND S4S-1		CHECKED BY J.CHANG	DATE 5/11/95	PROJECT MGR. T.M.KUZZAY
DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5		RESPONSIBLE ENGINEER J.CHANG	DATE 5/11/95	APPROVED/RELEASED
MATERIAL SEE NOTE #4		SCALE 1:1	SIZE 1d	DRAWING NUMBER P4105090909-200001-00