

(B)

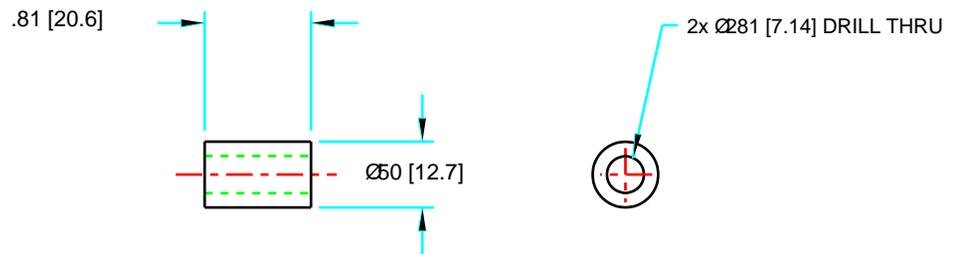
PLOT SCALE: 1=1

DWG. SCALE: 1

A2202200

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. THIS IS A UHV PART, ELECTROPOLISHING IS NEEDED BEFORE INSTALLATION. 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 ✓ 63



ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
<b>PARTS LIST</b>				
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES <u>TOLERANCES</u> DECIMALS      ANGULAR .X - .03      - .25 .XX - .01 .XXX - .005		LOG NUMBER <b>A2202200</b>	THIS DRAWING IS THE PROPERTY OF <b>ARGONNE NATIONAL LABORATORY</b>	
SURFACE ROUGHNESS <span style="color: green;">✓</span>		DRAWN BY <b>J.GOGOL</b>	DATE <b>2/8/95</b>	CHIEF DESIGN ENGINEER <b>D.SHU</b>
REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX. SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1		CHECKED BY <b>J.CHANG</b>	DATE <b>3/24/95</b>	GP LEADER <b>T.M.KUZAY</b>
DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5		DESIGNER <b>J.GOGOL</b>	DATE <b>2/8/95</b>	PROJECT MGR.
		RESPONSIBLE ENGINEER <b>J.CHANG</b>	DATE <b>3/24/95</b>	APPROVED/RELEASED
		MATERIAL <b>304 SST</b>	SCALE <b>1:1</b>	TITLE <b>ADVANCED PHOTON SOURCE P9-20 INTEGRAL SHUTTER (B) SPACER</b>
			SHEET <b>1 of 1</b>	SIZE <b>B</b>
			DRAWING NUMBER <b>P4105090909-200003-00</b>	
DO NOT SCALE DRAWING				

SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				