

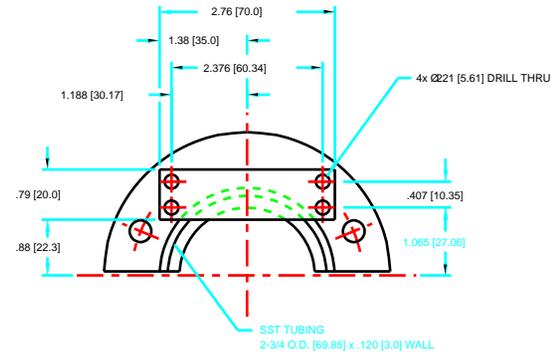
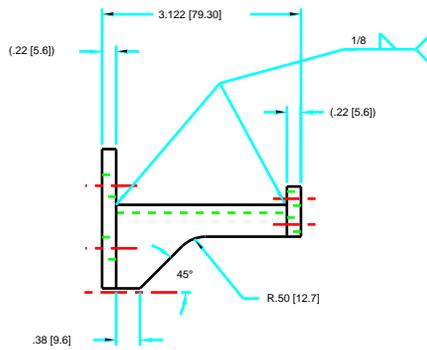
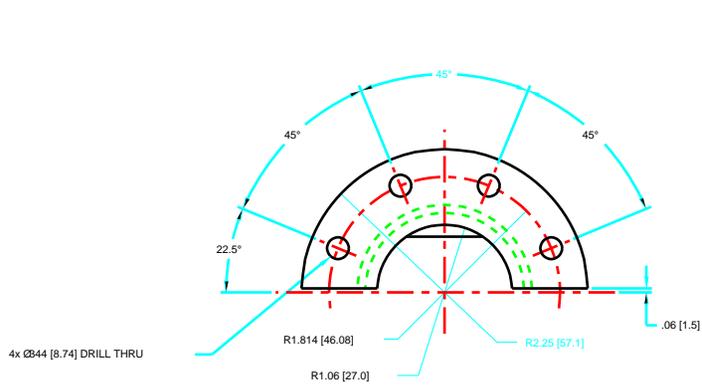
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NOTES:

- 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
- THIS IS A UHV PART. ELECTROPOLISHING IS NEEDED BEFORE WELDING. PRIOR TO ELECTROPOLISHING, THE PART NEEDS TO GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOW DOWN.
- KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
- DIMENSIONS IN [ ] ARE MILLIMETERS AND FOR REF. ONLY.
- SURFACE ROUGHNESS  $63$  ✓

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES DIMENSIONS: DECIMALS ANGLARS X - .01 - .99 XXX - .01 - .99		LOG NUMBER <b>A2072500</b>	THIS DRAWING IS THE PROPERTY OF <b>ARGONNE NATIONAL LABORATORY</b>	
SURFACE ROUGHNESS ✓		DRAWN BY <b>J.GOGOL</b>	DATE <b>8/2/94</b>	CHEF DESIGN ENGINEER <b>D.SHU</b>
REMOVE ALL BURRS AND BREAK SHARP EDGES TO RAIL. SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST AND S46.1 DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5		CHECKED BY <b>J.CHANG</b>	DATE <b>3/24/95</b>	DATE <b>3/31/95</b>
DO NOT SCALE DRAWING		DESIGNER <b>J.GOGOL</b>	DATE <b>8/2/94</b>	PROJECT MGR. <b>T.M.KUZAY</b>
		RESPONSIBLE ENGINEER <b>J.CHANG</b>	DATE <b>3/24/95</b>	APPROVED/RELEASED
		MATERIAL: <b>SST</b>		
		SCALE: 1:1		SHEET: 1 of 1
		DRAWING NUMBER: <b>P4105090909-220002-00</b>		

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