



- 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 ✓

APPROX. WT. = 2.5 LB.

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES		LOG NUMBER A2072600	THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY	
DECIMALS: .XX - .01 .XXX - .005 SURFACE ROUGHNESS ✓ REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX. SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1 DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5		TOLERANCES: ANGULAR: - .05 DRAWN BY: J.GOGOL CHECKED BY: J.CHANG DESIGNER: J.GOGOL RESPONSIBLE ENGINEER: J.CHANG MATERIAL: SST	DATE: 9/12/94 DATE: 3/24/95 DATE: 9/12/94 DATE: 3/24/95	DATE: 3/31/95 DATE: 4/4/95 TITLE: ADVANCED PHOTON SOURCE P9-20 INTEGRAL SHUTTER (B) COUNTER WEIGHT
CHIEF DESIGN ENGINEER: D.SHU GP LEADER: T.M.KUZAY PROJECT MGR. APPROVED/RELEASED		SCALE: 1:1 SIZE: C SHEET: 1 of 1	DRAWING NUMBER: P4105090909-220003-00	

SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				