

(B)

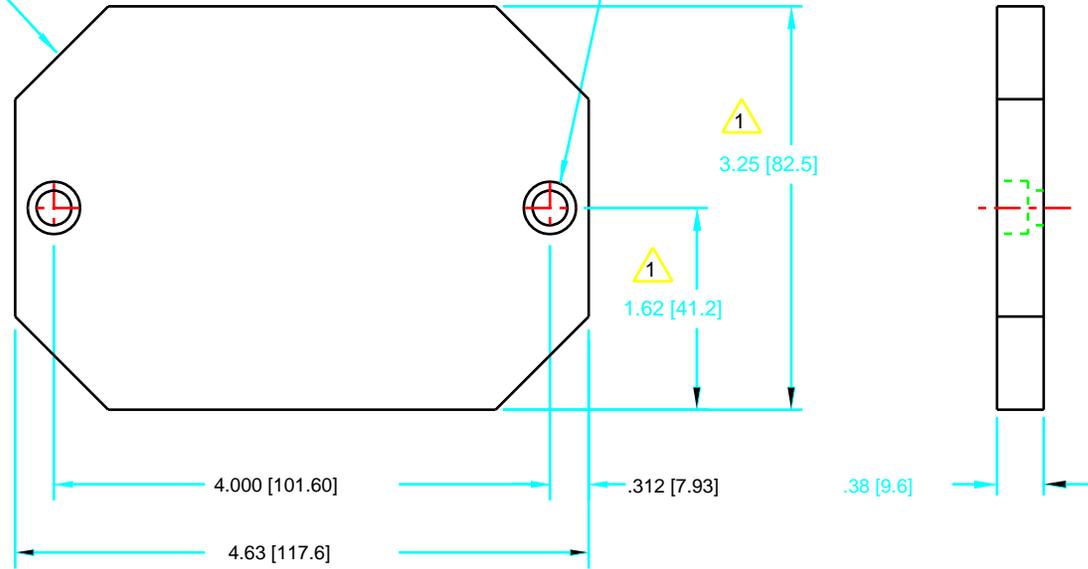
PLOT SCALE: 1=1

DWG. SCALE: 1

A2138601

4x .75 [19.0] x 45°

2x Ø281 [7.14] DRILL THRU
Ø422 [10.72] CT BORE x .25 [6.35] DP



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. 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 ✓

1	3.25 WAS .88; 1.62 WAS .38;	J.G.	J.C.	1/26/96
SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
	REVISIONS			

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY	
PARTS LIST					
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES		LOG NUMBER A2138601	THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY		
TOLERANCES DECIMALS ANGULAR X - .03 - .25 .XX - .01 .XXX - .005		DRAWN BY J.GOGOL	DATE 11/8/94	CHIEF DESIGN ENGINEER D.SHU	DATE 1/18/95
SURFACE ROUGHNESS ✓		CHECKED BY J.CHANG	DATE 1/13/95	GP LEADER T.M.KUZAY	DATE 1/18/95
REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX.		DESIGNER J.GOGOL	DATE 11/8/94	PROJECT MGR.	
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1		RESPONSIBLE ENGINEER J.CHANG	DATE 1/13/95	APPROVED/RELEASED	
DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5		MATERIAL 304 SST	SCALE 1:1	SIZE B	DRAWING NUMBER P4105090909-300002-01
DO NOT SCALE DRAWING			SHEET 1 of		

ADVANCED PHOTON SOURCE
P9-30 INTEGRAL SHUTTER (D)
STOP PLATE