



NOTES:

- WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:
 - CHIMCOOL 5 STAR 49
 - 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 $63 \checkmark$

SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
1	SST 304 WAS SST:	J.G.	J.C.	6/15/95

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES				
TOLERANCES: ANGULAR				
LOG NUMBER: A2073101				
ARGONNE NATIONAL LABORATORY				
THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY				
DRAWN BY: J.GOGOL	DATE: 8/2/94	CHIEF DESIGN ENGINEER: D.SHU	DATE: 10/19/94	TITLE: ADVANCED PHOTON SOURCE
CHECKED BY: J.CHANG	DATE: 10/17/94	SP LEADER: T.M.KUZAY	DATE: 10/19/94	
PROJECT MGR: J.GOGOL				
RESPONSIBLE ENGINEER: J.CHANG				
DATE: 10/17/94				
APPROVED/RELEASED:				
MATERIAL: SST 304				
SCALE: 1:1				
SHEET: 1 of 1				
DRAWING NUMBER: P4105090909-320002-01				