

(C)

PLOT SCALE: 1=1

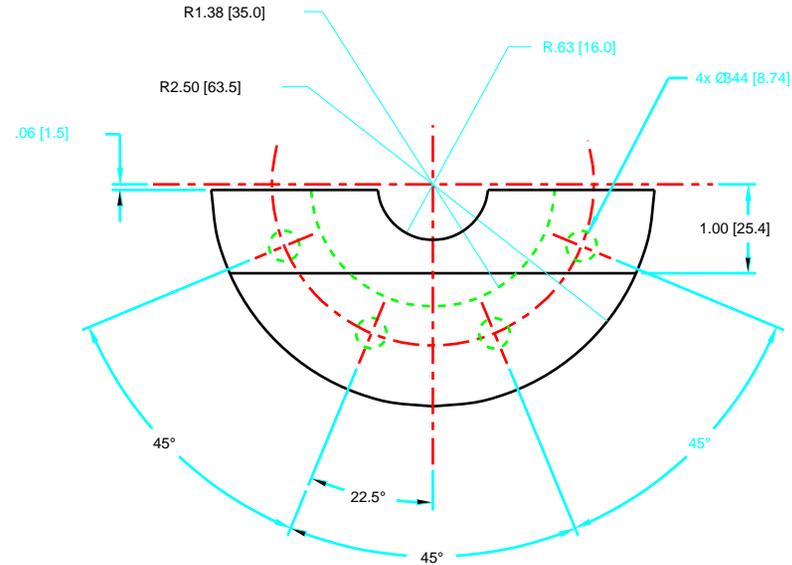
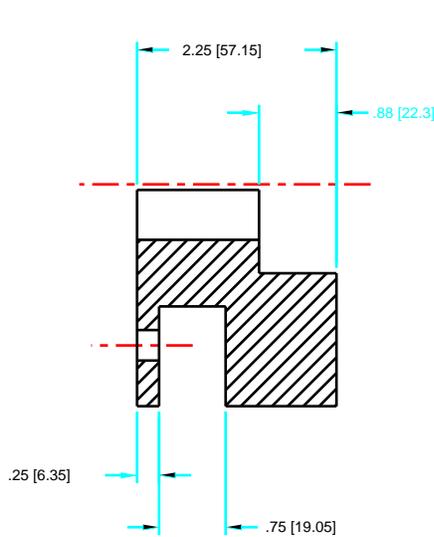
DWG. SCALE: 1

A2073201

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NOTES:

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

APPROX. WT. = 3.3 LB.

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ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES		LOG NUMBER A2073201		
TOLERANCES		THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY		
DECIMALS	ANGULAR	TITLE ADVANCED PHOTON SOURCE P9-30 INTEGRAL SHUTTER (D) COUNTER WEIGHT		
.XX - .01	- .25	DRAWN BY J.GOGOL	DATE 9/12/94	CHIEF DESIGN ENGINEER D.SHU
.XXX - .005		CHECKED BY J.CHANG	DATE 10/19/94	GP LEADER T.M.KUZAY
SURFACE ROUGHNESS $63 \checkmark$		DESIGNER J.GOGOL	DATE 9/12/94	PROJECT MGR.
REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX.		RESPONSIBLE ENGINEER J.CHANG	DATE 10/17/94	APPROVED/RELEASED
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1		MATERIAL SST 304		
DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5		SCALE 1:1		
DO NOT SCALE DRAWING		SIZE C		
DRAWING NUMBER P4105090909-320003-01		SHEET 1 of 1		

REV	DESCRIPTION	BY	CHKD	DATE
1	SST 304 WAS SST;	J.G.	J.C.	6/15/95
REVISIONS				

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