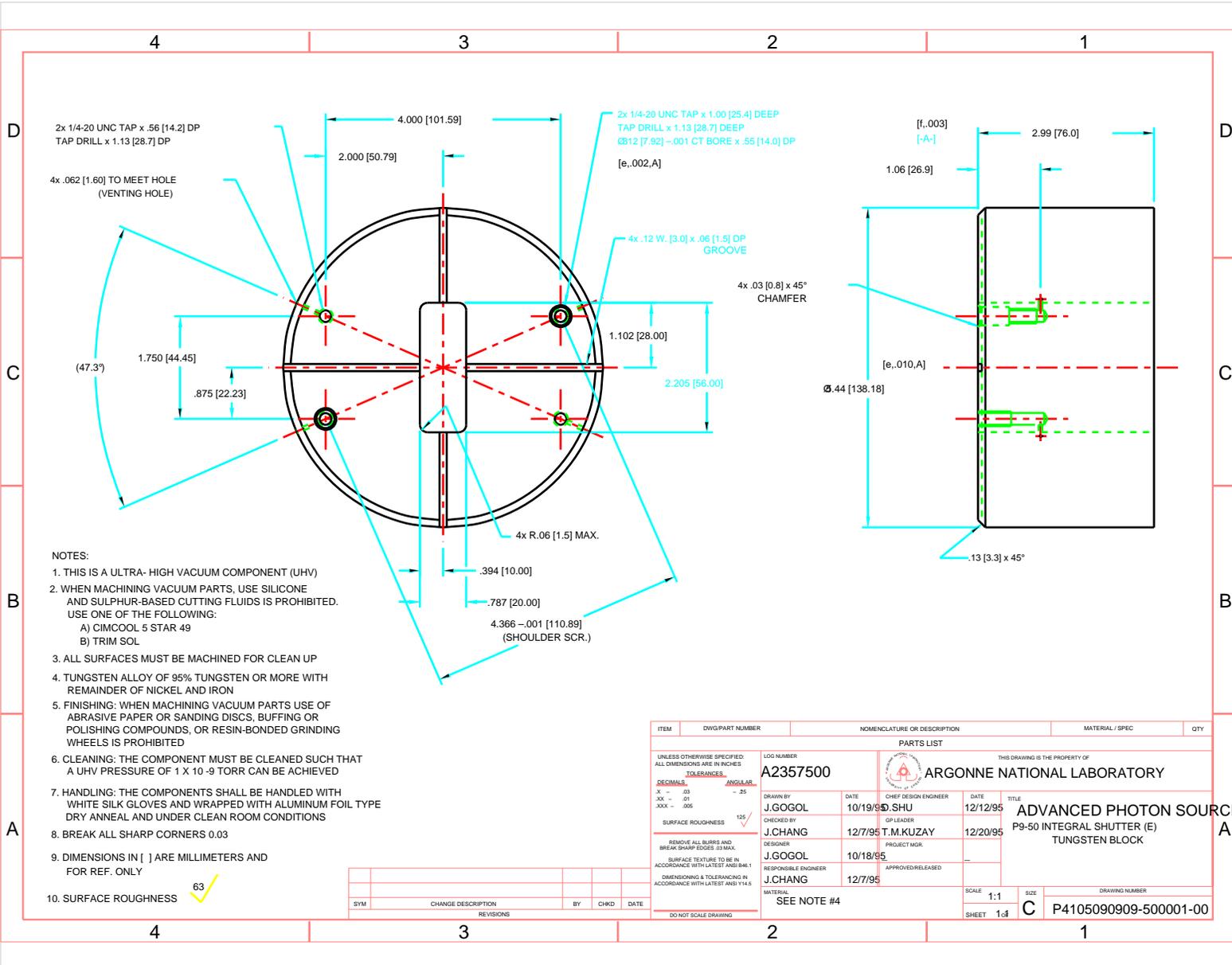


(C) PLOT SCALE: 1=1 DWG. SCALE: 1 A2357500



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. ALL SURFACES MUST BE MACHINED FOR CLEAN UP
4. TUNGSTEN ALLOY OF 95% TUNGSTEN OR MORE WITH REMAINDER OF NICKEL AND IRON
5. FINISHING: WHEN MACHINING VACUUM PARTS USE OF ABRASIVE PAPER OR SANDING DISCS, BUFFING OR POLISHING COMPOUNDS, OR RESIN-BONDED GRINDING WHEELS IS PROHIBITED
6. CLEANING: THE COMPONENT MUST BE CLEANED SUCH THAT A UHV PRESSURE OF 1×10^{-9} TORR CAN BE ACHIEVED
7. HANDLING: THE COMPONENTS SHALL BE HANDLED WITH WHITE SILK GLOVES AND WRAPPED WITH ALUMINUM FOIL TYPE DRY ANNEAL AND UNDER CLEAN ROOM CONDITIONS
8. BREAK ALL SHARP CORNERS 0.03
9. DIMENSIONS IN [] ARE MILLIMETERS AND FOR REF. ONLY
10. SURFACE ROUGHNESS \checkmark 63

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	THIS DRAWING IS THE PROPERTY OF	
TOLERANCES:		A2357500	ARGONNE NATIONAL LABORATORY	
DECIMALS:	ANGULAR:	DRAWN BY	DATE	TITLE
X - .03	- 25	J.GOGOL	10/19/95	ADVANCED PHOTON SOURCE
XX - .01		CHECKED BY	12/12/95	P9-50 INTEGRAL SHUTTER (E)
XXX - .005		J.CHANG	12/20/95	TUNGSTEN BLOCK
SURFACE ROUGHNESS \checkmark 125		DESIGNER	PROJECT MGR.	
REMOVE ALL BURRS AND BREAK SHARP EDGES TO MAX. SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANS B46.1		J.GOGOL	T.M.KUZAY	
DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5		RESPONSIBLE ENGINEER	APPROVED/RELEASED	
		J.CHANG	12/7/95	
		MATERIAL	SCALE	SIZE
		SEE NOTE #4	1:1	C
			SHEET	DRAWING NUMBER
			1 of 1	P4105090909-500001-00
DO NOT SCALE DRAWING				