



NOTES:

1. THIS IS A ULTRA- HIGH VACUUM COMPONENT (UHV)
2. 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
3. ALL SURFACES MUST BE MACHINED FOR CLEAN UP
4. TUNGSTEN ALLOY OF 95% TUNGSTEN OR MORE WITH REMAINDER OF NICKEL AND IRON MIL-T-21014D, CLASS3, UHV GRADE
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 X 10<sup>-9</sup> 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 0.01 MINIMUM
9. DIMENSIONS IN [ ] ARE MILLIMETERS AND FOR REF. ONLY
10. SURFACE ROUGHNESS 63 ✓

REF. SOURCE:

KULITE TUNGSTEN CORP.  
160 EAST UNION AVENUE  
EAST RUTHERFORD, NJ 07073  
TEL.:201-438-9000  
FAX:201-438-0891

MITEK METALS INC.  
1340 NORTH SENATE AVENUE  
INDIANAPOLIS, IN 46202  
TEL.:317-637-3574  
FAX:317-633-7224

APPROX. WT. = 3.7 LB.

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
<b>PARTS LIST</b>				
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES		LOG NUMBER <b>A2318700</b>	THIS DRAWING IS THE PROPERTY OF <b>ARGONNE NATIONAL LABORATORY</b>	
TOLERANCES		<b>ADVANCED PHOTON SOURCE</b>		
DECIMALS	ANGULAR	<b>P9-50 INTEGRAL SHUTTER (E)</b>		
X - .03	- .25	DRAWN BY <b>J.GOGOL</b>	DATE <b>8/8/95</b>	CHIEF DESIGN ENGINEER <b>D.SHU</b>
XX - .01		CHECKED BY <b>J.CHANG</b>	DATE <b>12/7/95</b>	DATE <b>12/12/95</b>
XXX - .005		DESIGNER <b>J.GOGOL</b>	DATE <b>8/8/95</b>	TITLE <b>TUNGSTEN BLOCK</b>
SURFACE ROUGHNESS 125 ✓		RESPONSIBLE ENGINEER <b>J.CHANG</b>	DATE <b>12/7/95</b>	PROJECT MGR. <b>T.M.KUZAY</b>
REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX.		APPROVED/RELEASED		
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1		MATERIAL <b>SEE NOTE #4</b>		
DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5		SCALE 1:1		
SYMBOL		DRAWING NUMBER <b>P4105090909-520002-00</b>		
REVISIONS		SHEET 1 of 1		
DO NOT SCALE DRAWING		SIZE <b>C</b>		