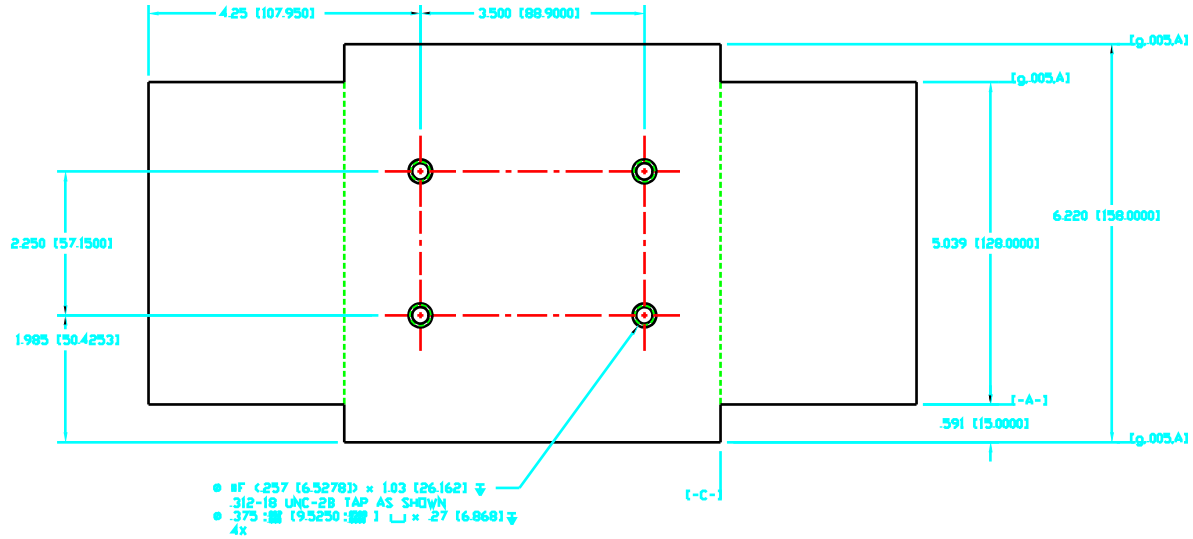

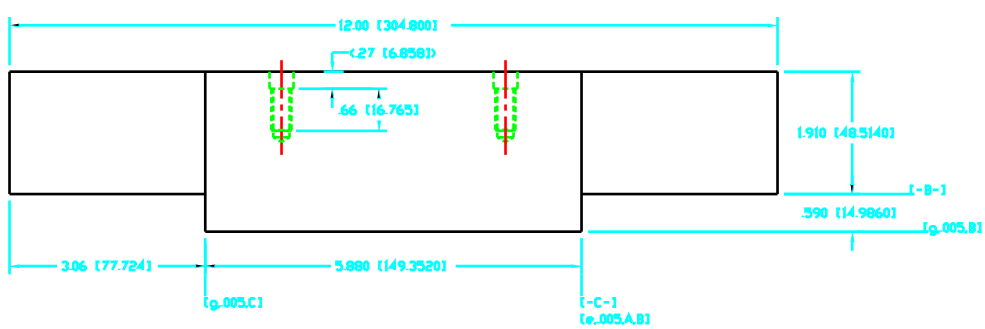

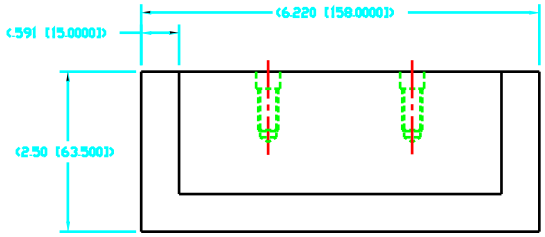

NOTES:

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 NICKEL AND IRON.
   TO COMPLY WITH MIL. SPEC. T-21014D, CLASS 4
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^{-9} TORR CAN BE ACHIEVED.
7. HANDLING: CLEAN COMPONENTS SHALL BE HANDLED WITH WHITE SILK GLOVES AND WRAPPED WITH ALUMINUM-FOIL-TYPE DRY ANNEAL A UNDER CLEAN ROOM CONDITIONS.
8. BREAK ALL SHARP CORNERS .02.
9. ALL DIMENSIONS IN [ ] ARE MILLIMETERS AND ARE FOR REFERENCE ONLY.

ITEM	DWG & ELECTRONIC FILE No	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
		PARTS LIST		

SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
	REVISIONS			

ELECTRONIC FILE NAME: A09881

DRAWN BY RICK KRAKORA	DATE 4/93	CHIEF DESIGN ENGINEER D.SHU	DATE 8/9/93
CHECKED BY T. SANCHEZ	DATE 7/26/93	APPROVED BY T. KUZAY	DATE 8/9/93
DESIGNED RICK KRAKORA	DATE 4/93	PROJECT MGR	DATE
MECHANICAL ENGINEER T. SANCHEZ	DATE 7/26/93	APPROVED/CONTROLLED	DATE

MATERIAL: SEE NOTE 4

SCALE 1=1 SHEET 1 of 1 SIZE D

THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY

TITLE: ADVANCED PHOTON SOURCE
S2 B.M. SAFETY SHUTTER
TUNGSTEN BLOCK
PLUG

DRAWING NUMBER: P4102020105-230001-00

PLOT SCALE:1=1