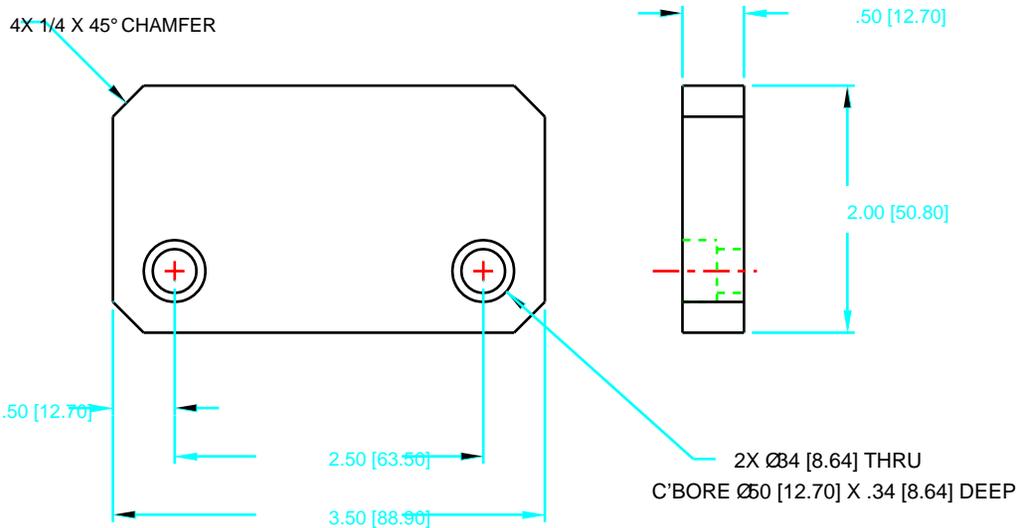


4X 1/4 X 45° CHAMFER



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. FINISHING: WHEN MACHINING VACUUM PARTS USE OF ABRASIVE PAPER OR SANDING DISCS, BUFFING OR POLISHING COMPOUNDS, OR RESIN-BONDED GRINDING WHEELS IS PROHIBITED
4. CLEANING: THE COMPONENT MUST BE CLEANED SUCH THAT A UHV PRESSURE OF 1×10^{-9} TORR CAN BE ACHIEVED
5. HANDLING: THE COMPONENTS SHALL BE HANDLED WITH WHITE SILK GLOVES AND WRAPPED WITH ALUMINUM FOIL. TYPE DRY ANNEAL AND UNDER CLEAN ROOM CONDITIONS
6. DIMENSIONS IN [] ARE MILLIMETERS AND FOR REF. ONLY

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 S3210102-00	THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY	
TOLERANCES DECIMALS .X - .1 [2.5] .XX - .01 [0.25] .XXX - .005 [0.13] SURFACE ROUGHNESS 125 ✓ REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX. SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1 DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5		CHIEF DESIGN ENGINEER D. SHU GP LEADER T.M. KUZAY PROJECT MGR. APPROVED/RELEASED	DATE 5/18/98 7/7/98 5/18/98 7/7/98	DATE 7/10/98 7/15/98 DATE
		TITLE ADVANCED PHOTON SOURCE S3 I.D. SAFETY SHUTTER COLLIMATOR RAIL END PLATE		
		MATERIAL 304 STAINLESS STEEL	SCALE 1:1	SIZE B
		DRAWING NUMBER S3-210102-00		SHEET 14
DO NOT SCALE DRAWING				