



- NOTES:
1. 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

2. THIS IS A UHV PART, THIS PART MUST GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOW DOWN.
3. PER MIL-T-21014D + OMEND 1
 1810 UHV GRADE COPPER FREE
4. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
5. DIMENSIONS IN [] ARE MILLIMETERS AND FOR REFERENCE ONLY.

REF. SOURCE

- MI-TECH METALS, INC.
 1340 N. SENATE AVE.
 INDIANAPOLIS, IN. 46202
 PHONE: 317-637-3574
- KULITE TUNGSTEN CORP.
 160 EAST UNION AVE.
 EAST RUTHERFORD, NJ. 08073
 PHONE: 201-438-9000
 FAX: 201-438-0891

BY	CHANGE DESCRIPTION	BY	CHKD	DATE
1	HIGH-DENSITY TUNGSTEN ALLOY			
	HD 18.5 WAS TZM MOLYBDENUM			
	ALLOY 364, REF. SOURCE ADDED			
	ELECTROPOLISHING REQUIREMENT			
	IN NOTE #2 REMOVED	M.J.M.		

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES TOLERANCES:		THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY		
DECIMALS .001		LOG NUMBER A2110701		
ANGULARS ± .01		DRAWN BY R. KRAKORA DATE 10/27/94 CHIEF DESIGN ENGINEER DATE 2/24/95		
SURFACE FINISH		DESIGNED BY D. SHU DATE 2/24/95 PROJECT MGR DATE 2/24/95		
REMOVE ALL BURRS AND BREAK SHARP EDGES (R&M)		RESPONSIBLE ENGINEER SHUKRAKORA DATE 10/27/94		
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST AMS-B-1		APPROVED/RELEASED DATE 2/24/95		
DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5		MATERIAL HIGH-DENSITY TUNGSTEN ALLOY		
DO NOT SCALE DRAWING		SCALE 1=1 SIZE D DRAWING NUMBER P4105091505-810002-01		