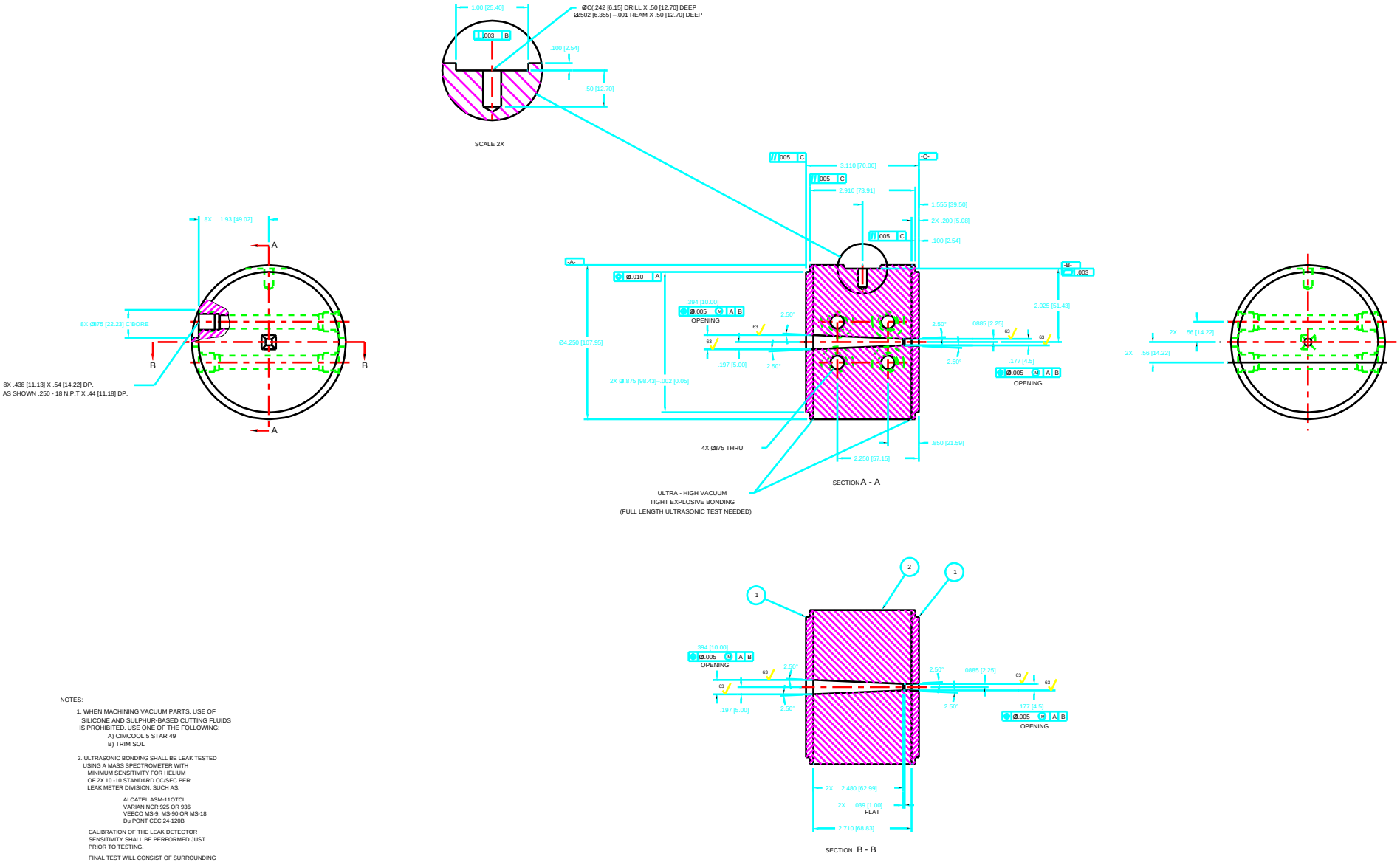

NOTES:

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. ULTRASONIC BONDING SHALL BE LEAK TESTED USING A MASS SPECTROMETER WITH MINIMUM SENSITIVITY FOR HELIUM OF 2X 10 -10 STANDARD CC/SEC PER LEAK METER DIVISION, SUCH AS:

   ALCATEL ASM-11OTCL
   VARIAN NCR 925 OR 936
   VEECO MS-9, MS-90 OR MS-18
   Du PONT CEC 24-120B

   CALIBRATION OF THE LEAK DETECTOR SENSITIVITY SHALL BE PERFORMED JUST PRIOR TO TESTING.

   FINAL TEST WILL CONSIST OF SURROUNDING THE ASSEMBLY (BAGGING) WITH HELIUM. THE ASSEMBLY WILL BE REJECTED IF A 2% DEFLECTION IN THE MOST SENSITIVE RANGE OF THE LEAK DETECTOR IS SENSED WITHIN 1 MIN.

3. CERTIFICATION OF ULTRA SONIC TEST AND VACUUM EXAMINATION SHALL BE SIGNED BY A CONTRACTOR REPRESENTATIVE AUTHORIZED TO SIGN SUCH CERTIFICATION

4. KEEP THE ASSEMBLY CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.

5. DIMENSIONS IN [ ] ARE MILLIMETERS AND FOR REF. ONLY

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC.	QTY.
2		BODY	GLID-COP	1
1		PLATE	304 SST	2

PARTS LIST

UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES
TOLERANCES
DECIMALS ANGULAR
.X ±.1 [.N0] ±°
.XX ± .01 [.0.25]
.XXX ± .005 [0.127]
SURFACE ROUGHNESS 125

REMOVE ALL BURRS AND BREAK SHARP EDGES .10 MAX.

SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1

DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ASME Y14.5

DO NOT SCALE DRAWING

LOG NUMBER A2177800

THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY

DRAWN BY MUSCIA	DATE 2/1/95	CHIEF DESIGN ENGINEER D. SHU	DATE 4/12/95
CHECKED BY D. SHU	4/12/95	GP LEADER T.M. KUZAY	4/12/95
DESIGNER MUSCIA	4/12/95	PROJECT MGR.	
RESPONSIBLE ENGINEER D. SHU	4/12/95	APPROVED/RELEASED	

MATERIAL SEE PARTS LIST

TITLE ADVANCED PHOTON SOURCE
L5-87 APS UNDULATOR
WHITE BEAM H & V SLITS
FIXED MASK
MAIN BODY

SCALE 1:1 SHEET 1 of 1 SIZE E DRAWING NUMBER P4105091505-870001-00

SYM	CHANGE DESCRIPTION	BY	CHKD	DATE

REVISIONS