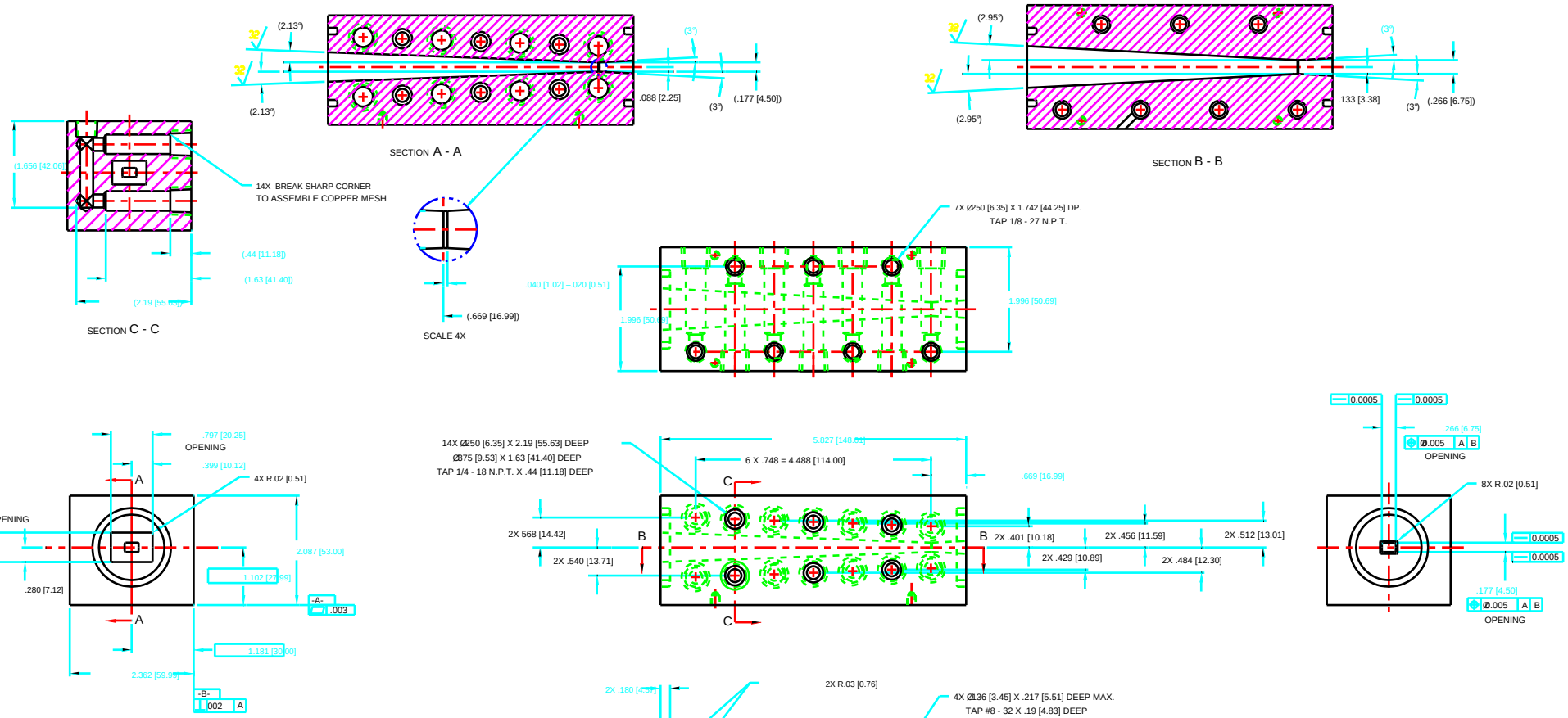

REF. SOURCE

MITEK METALS, INC.
1340 NORTH SENATE AVE.
INDIANAPOLIS, IN 46202
TEL: 1-317-637-3574
FAX: 1-317-633-7224

NOTES:

1. TUNGSTEN ALLOY OF 97% TUNGSTEN OR MORE WITH REMAINDER OF NICKEL AND IRON PER MIL-T-210140, CLASS 4, DOUBLE SINTER CYCLE UHV GRADE (HD 18.5 V)
2. THIS IS A ULTRA- HIGH VACUUM COMPONENT (UHV)
3. 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
4. ALL SURFACES MUST BE MACHINED FOR CLEAN UP
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: THE COMPONENTS SHALL BE HANDLED WITH WHITE SILK GLOVES AND WRAPPED WITH ALUMINUM FOIL TYPE DRY ANNEAL AND UNDER CLEAN ROOM CONDITIONS
8. 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
TOLERANCES
DECIMALS: .X ± .01 [.420]; .XX ± .01 [0.25]; .XXX ± .005 [0.127]
ANGULAR: ± 25'
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
DO NOT SCALE DRAWING

LOG NUMBER: L5930001-00

THIS DRAWING IS THE PROPERTY OF
ARGONNE NATIONAL LABORATORY

DRAWN BY: MUSCIA	DATE: 1/26/98	CHIEF DESIGN ENGINEER: D. SHU	DATE: 2/10/98
CHECKED BY: J. CHANG	DATE: 2/10/98	GP LEADER: T.M. KUZAY	DATE: 2/18/98
DESIGNER: SHU/MUSCIA	DATE: 1/26/98	PROJECT MGR.	
RESPONSIBLE ENGINEER: D. SHU	DATE: 2/10/98	APPROVED/RELEASED	

TITLE
ADVANCED PHOTON SOURCE
L5-93 APS UNDULATOR
WHITE BEAM H & V
GRAZING - INCIDENCE
MOVEABLE MASK
MAIN BODY

MATERIAL: SEE NOTE #1
SCALE: 1:1
SIZE: D
SHEET: 1 of 1
DRAWING NUMBER: L5-930001-00