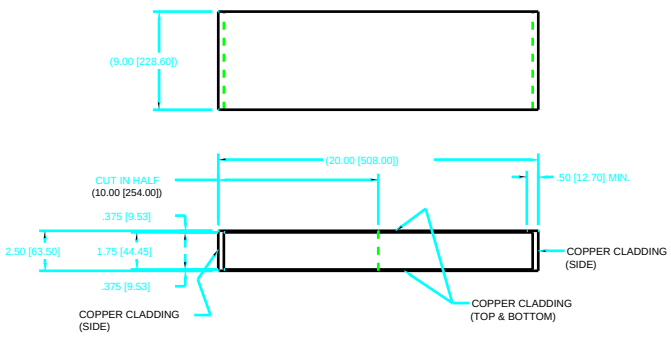
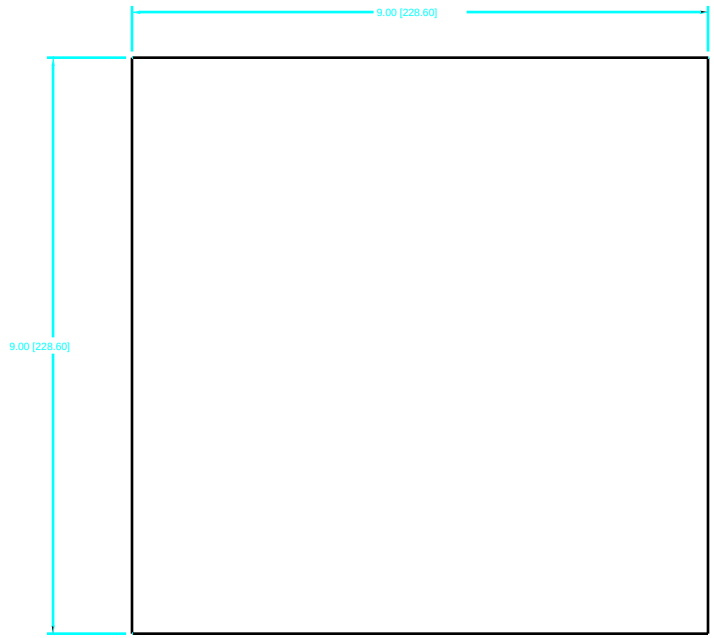
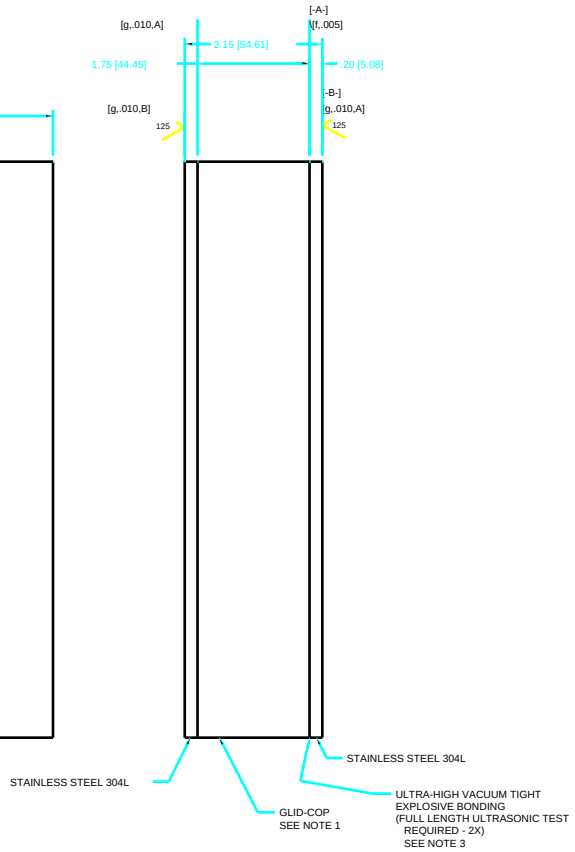


COPPER CLADDING

SCALE: N.T.S.



FINAL PLATE DIM'S



NOTES

1. MATERIAL: MAKE FROM 9" x 20" x 25"
   GLID-COP AL15 OXYGEN FREE
   (SEE DIAGRAM ABOVE FOR CUTTING)

2. PRIOR TO EXPLOSIVE BONDING, MACHINING OF GLID-COP IS REQUIRED TO REMOVE CLADDINGS AS FOLLOWS:

   REMOVE COPPER CLADDING FRO BOTH TOP & BOTTOM EVENLY (.375 [9.53]) TO 1.75 [44.45] AS SHOWN.

   CUT PLATE IN HALF AS SHOWN.

   REMOVE COPPER CLADDING FROM BOTH SIDES EVENLY AT A MIN. OF .50 [12.70].

3. ULTRASONIC EXAMINATION:
   ALL EXPLOSIVE BONDED MATERIALS SHALL BE ULTRASONICALLY INSPECTED ACCORDING TO ASTM A578/A578M WITH THE FOLLOWING SUPPLEMEMNTARY REQUIREMENTS.

   S1. SCANNING SHALL BE CONTINUOUS OVER 100% OF THE PLATE SURFACE.

   S2. ACCEPTANCE STANDARD SHALL BE NO DISCONTINUITIES IN THE BONDED AREA TO BE UTILIZED IN THE FINAL PART.

4. NONDESTRUCTIVE EXAMINATION:
   THE ULTRASONIC EXAMINATION OF EXPLOSIVE BONDED MATERIALS SHALL CONFORM TO ASTM A578/A578-90, STRAIGHT BEAM ULTRASONIC EXAMINATION OF PLAIN AND CLAD STEEL PLATES FOR SPECIAL APPLICAITONS.

5. WHEN MACHINING VACUUM PARTS, USE OF SILICONE SULPHUR-BASED CUTTING FLUIDS AND ABRASIVES IS PROHIBITED. USE TRIM SOL OR APPROVED EQUAL LUBRICANT.

6. FOR COMPLETE SPECIFICATIONS ON MACHINING, CLEANING, VACUUM REQUIREMENTS, TESTING AND DELIVERY PREPARATION, SEE A.N.L. DOCUMENT #410201-00095.

7. ALL DIMENSIONS IN [ ] ARE MILLIMETERS AND ARE FOR REFERENCE ONLY.

SUGGESTED EXPLOSIVE BONDING SOURCE:

NORTHWEST TECHNICAL INDUSTIRES, INC.
547 DIAMOND POINT RD.
SEQUIM, WA. 98382
PHONE: (206)-683-4167
FAX: (206)-683-4158

SUGGESTED GLID-COP SOURCE:

SCM METAL PRODUCTS, INC.
2601 WECK DRIVE
RESEARCH TRIANGLE PARK, N.C. 27709
PHONE: (919)-544-9090
FAX: (919)-544-7998

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		ANGULAR
.X ±	.015 [.381]	± .25
.XX ±	.010 [.254]	
.XXX ±	.005 [.127]	

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 A2198000

THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY

DRAWN BY R. KRAKORA	DATE 2/95	CHIEF DESIGN ENGINEER	DATE	TITLE	
CHECKED BY C. BRITE	DATE 2/95	GP LEADER	DATE	ADVANCED PHOTON SOURCE L7 SOFT X-RAY VERTICAL EXIT SLIT	
DESIGNER R. KRAKORA	DATE 2/95	PROJECT MGR	DATE		
RESPONSIBLE ENGINEER C. BRITE	DATE 2/95	APPROVED/RELEASED	DATE	FLEXURE PLATE	
MATERIAL SEE NOTES				SCALE 1:1 / SHEET 1 of 1	SIZE D / DRAWING NUMBER P4105091507-210102-00