



NOTES:

1. MAKE FROM "MDC"NONROTATABLE BLANK FLANGE CAT. #110032
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. THE PART NEEDS TO GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING WASHING AND DRY NITROGEN BLOW DOWN.
4. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
5. DIMENSIONS IN [] ARE MILLIMETERS AND ARE FOR REFERENCE ONLY.

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE IN INCHES.		LOG NUMBER	THIS DRAWING IS THE PROPERTY OF	
TOLERANCES		U2320803-00	ARGONNE NATIONAL LABORATORY	
DECIMALS	ANGULAR		TITLE	
.X ± .1 [2.5]	± 0°30'		ADVANCED PHOTON SOURCE	
.XX ± .01 [0.25]			U2 - 32	
.XXX ± .005 [0.13]			TRANSITION PIPE	
SURFACE ROUGHNESS 125 ✓			FLANGE NONROTATABLE	
REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX.			10" O.D. X 6" I.D.	
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1				
DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5				
DO NOT SCALE DRAWING				
		DRAWN BY	DATE	CHIEF DESIGN ENGINEER
		corcuera	8/22/97	D. SHU
		CHECKED BY	DATE	GP LEADER
		J. CHANG	8/27/97	T. KUZAY
		DESIGNER	DATE	PROJECT MGR.
		CORCUERA/CHANG	8/22/97	
		RESPONSIBLE ENGINEER	DATE	APPROVED/RELEASED
		J. CHANG	8/27/97	
		MATERIAL	SCALE	SIZE
		SEE NOTE # 1	1:2	B
			SHEET 1 of 1	DRAWING NUMBER
				U2-320803-00

SYN	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				