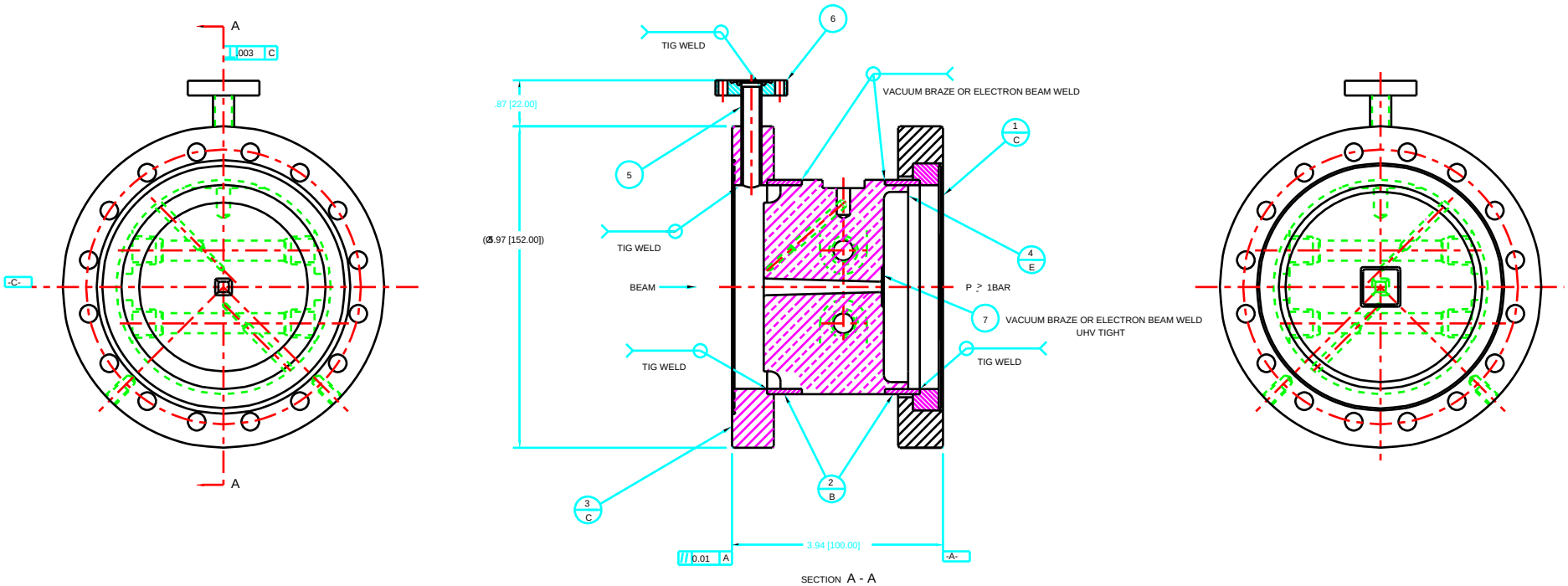
(D)	PLOT SCALE: 1=1	DWG. SCALE: 1	A2012600



NOTES:

1. THIS IS A UHV PART, ELECTROPOLISHING IS NEEDED BEFORE WELDING. PRIOR TO ELECTRO-POLISHING, THE PART MUST GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOW DOWN.
2. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
3. MAXIMUM BAKE TEMPERATURE 200°C
4. ALL DIMENSIONS WITH [ ] ARE MILLIMETERS AND FOR REF. ONLY

REF. SOURCE

1 MDC VACUUM PROD. CORP.
ADVENT ASSOCIATES
5808 N. ST. LOUIS AVE.
CHICAGO, IL. 60659
312 - 583 - 7979

2 ELECTROFUSION CO.
34325 ARDENWOOD BLVD.
FREMONT CA. 94555
1 - 800 - 4BE - FOIL

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
2 7		.656" X .656" X 0.01"–0.001 BERYLLIUM WINDOW	BERYLLIUM FOIL	1
6	#110002	1 1/3 O.D. NONROTATABLE VACUUM FLANGE	SST	1
5		.375 O.D. X .035 WALL X 1.83 LG. TUBE	SST	1
4	P4102010109-930101	W1-93 COMM. BERYLLIUM WINDOW MAIN BODY	OFHC COPPER	1
3	P4102010109-210004	4" I.D. BE WINDOW LEFT SIDE VACUUM FLANGE	SST	1
2	P4102010109-210002	4" I.D. BE WINDOW ADAPTER RING	304 SST	2
1	P4102010109-210001	4" I.D. BE WINDOW RIGHT SIDE VACUUM FLANGE	SST	1

PARTS LIST

SYM	CHANGE DESCRIPTION	BY	CHKD	DATE

REVISIONS

UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES
TOLERANCES
DECIMALS: .X ± .03 [.7620]; .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: A2012600

THIS DRAWING IS THE PROPERTY OF: ARGONNE NATIONAL LABORATORY

DRAWN BY: MUSCIA	DATE: 8/15/94	CHIEF DESIGN ENGINEER: D. SHU	DATE: 10/14/94
CHECKED BY: J. WOTHE	DATE: 10/14/94	GP LEADER: T. M. KUZAY	DATE: 10/14/94
DESIGNER: MUSCIA	DATE: 10/14/94	PROJECT MGR.	
RESPONSIBLE ENGINEER: D. SHU	DATE: 10/14/94	APPROVED/RELEASED	

TITLE: ADVANCED PHOTON SOURCE
W1-93 I.D. FRONT END
COMMISSIONING BERYLLIUM
WINDOW WELDMENT ASSEMBLY

MATERIAL: SEE PARTS LIST

SCALE: 1:1 SHEET 1 of 1

SIZE: D

DRAWING NUMBER: P4102010109-930100-00