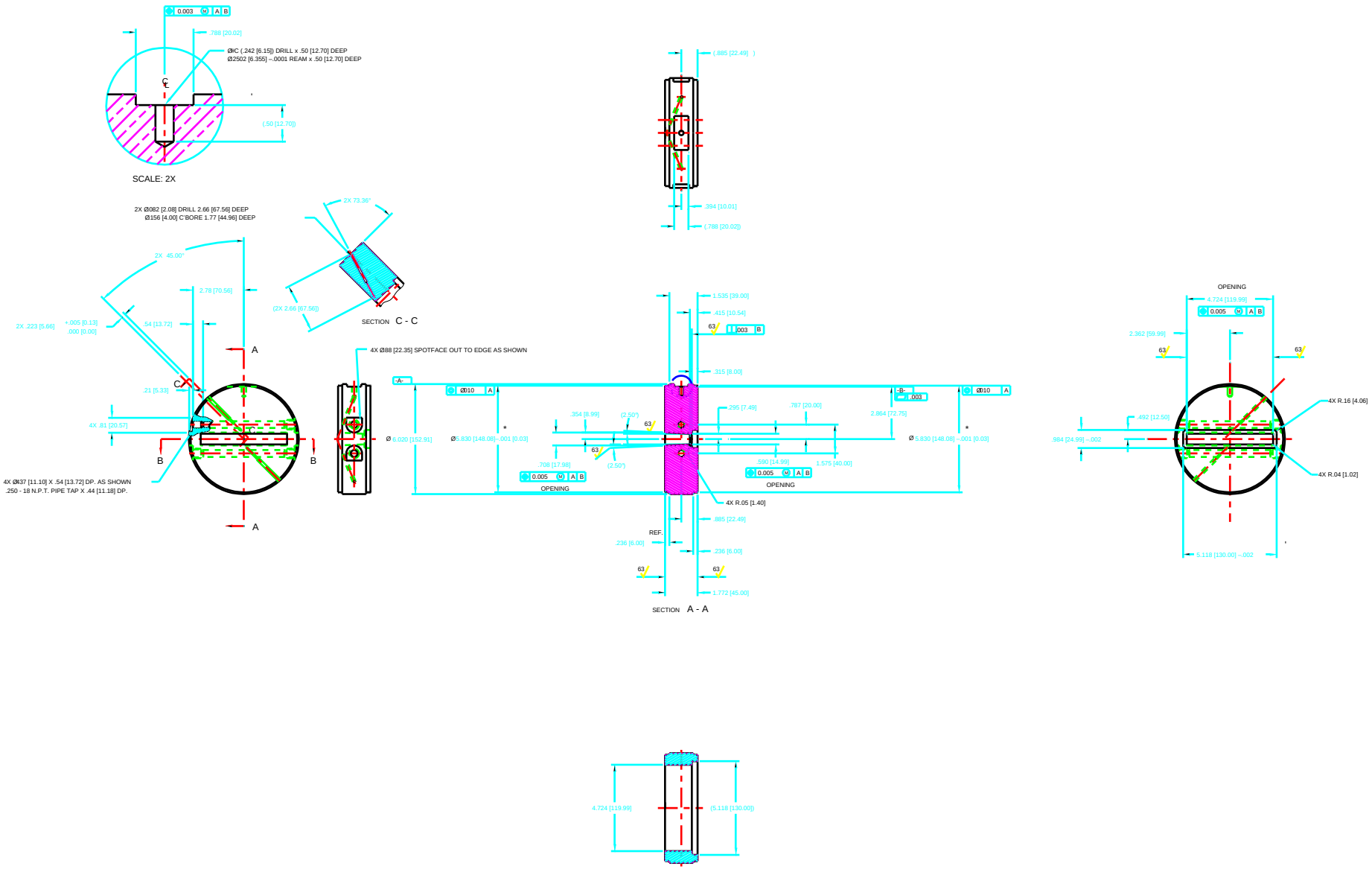

NOTES:

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. THIS IS A UHV PART, ELECTROPOLISHING IS NEEDED BEFORE WELDING. PRIOR TO ELECTROPOLISHING, THE PART MUST GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOW DOWN.
3. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
4. DIMENSIONS IN [ ] ARE MILLIMETERS AND FOR REF. ONLY

* TOLERENCE DETERMINED BY VENDOR FOR E BEAM WELD OR VACUUM BRAZING REQUIREMENT

1	DWG# WAS P4105090804-200101	RAF		10/94	

A1915101		ARGONNE NATIONAL LABORATORY	
FUHRMANN	9/30/94	D. SHU	10/13/94
J.WOTHE	10/12/94	T.M. KUZAY	10/13/94
D.SHU/FUHRMANN			
D. SHU	10/13/94		
OFHC COPPER		HALF	

ADVANCED PHOTON SOURCE
W4-20 BEAMLINE WINDOW
8" O.D. (15 X 120)
MAIN BODY

SCALE 1:1 | E | P4105090804-200101-01