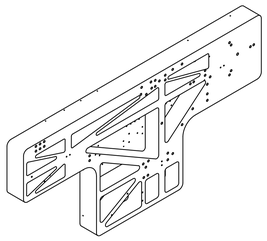
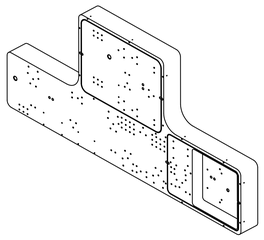
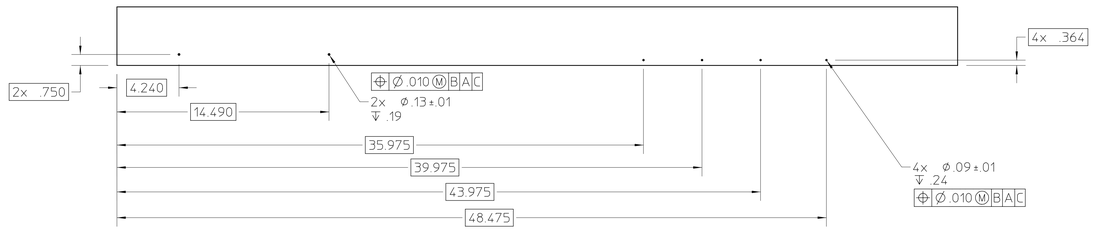
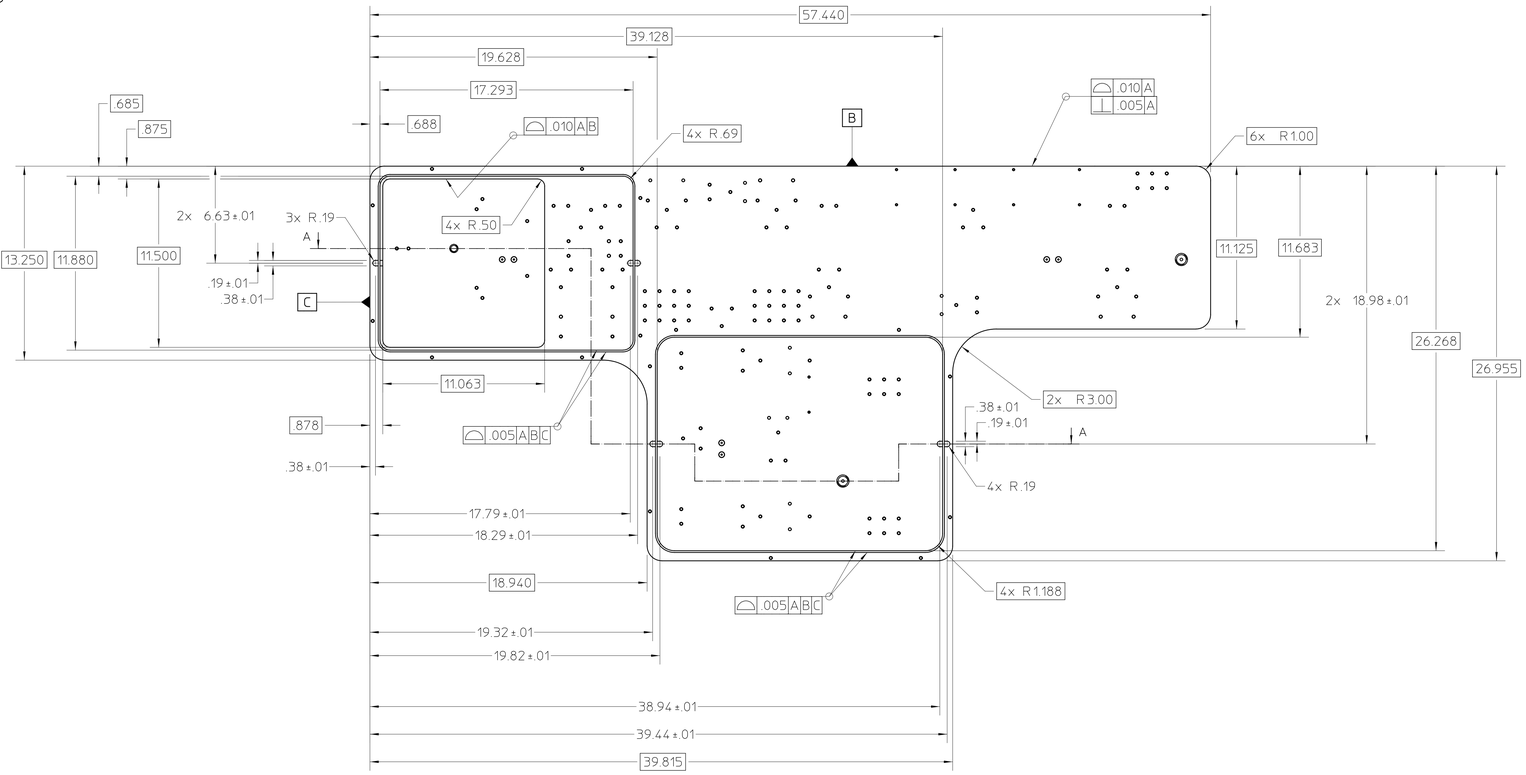


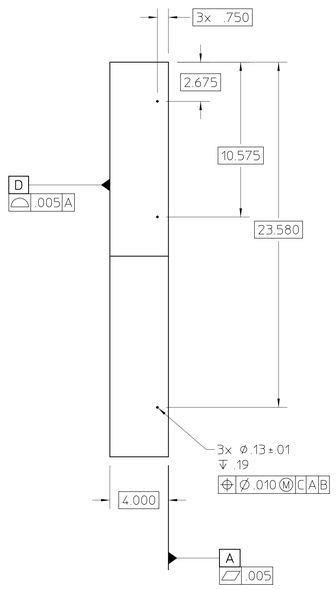
ISO VIEW BOTTOM
SCALE 1:10

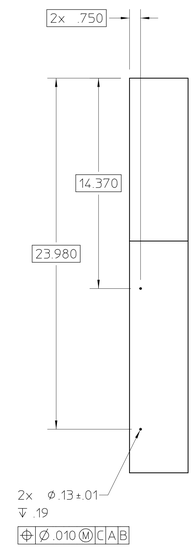


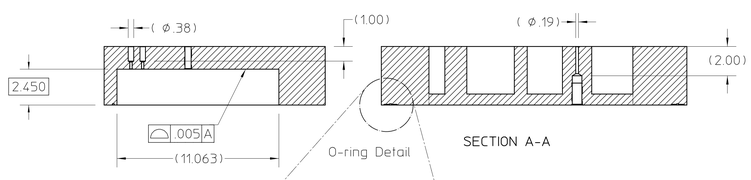
ISO VIEW TOP
SCALE 1:10

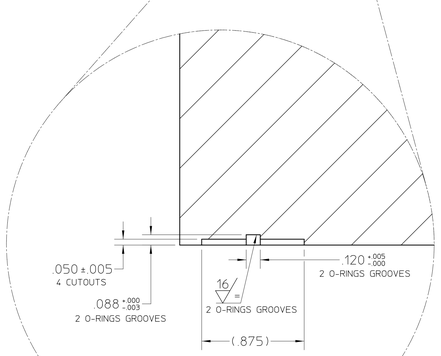


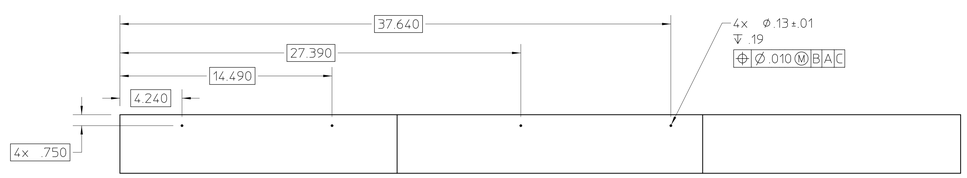












NOTES: (UNLESS OTHERWISE SPECIFIED)

1. THIS IS AN ULTRA HIGH VACUUM COMPONENT AND REQUIRES SPECIAL ATTENTION TO AVOID CONTAMINATION, REFER TO LBNL ENGINEERING SPECIFICATION #M20013 FOR CLEANING PROCEDURES.
2. USE OF SULPHUR-BEARING OR SILICONE-BEARING OILS, LUBRICANTS, OR COOLANTS IS PROHIBITED. USE OF POWER DRIVEN, RESIN BONDED, OR RUBBER BONDED ABRASIVES IS PROHIBITED. CERAMIC BONDED ABRASIVES,TUNGSTEN CARBIDE, AND DIAMOND WHEELS ARE ACCEPTABLE.
3. THIS IS AN ULTRA HIGH VACUUM COMPONENT. NO WELDING ON THIS PART IS PERMITTED WITHOUT PRIOR LBNL PERMISSION.
4. STRESS RELIEVE AFTER ROUGH CUTTING ALL POCKETS AT 375°F TO 400°F FOR 12 HOURS. KEEP THE T6 CONDITION.
5. ALL HIDDEN LINES MAY NOT BE SHOWN.
6. ALL DIMENSIONS ARE IN INCHES
7. ALL HOLES SHALL BE FREE OF DEBRIS.
8. TAKE EXTREME CARE NOT TO DING, SCRATCH, DENT, OR OTHERWISE MARK ANY MACHINED SURFACE. PROTECT FINISHED PART BY BAGGING OR SIMILAR METHOD TO MAINTAIN CLEANLINESS DURING SHIPMENT AND STORAGE.

REV	AUTHOR	APPROVER	DATE	CHANGE DESCRIPTION
C	ajdemell	ajdemell	06-28-05	ADD WIDTH DIMENSION, MOVE R.3 RADII, LOC. E8 CHANGE C TYPE TO B TYPE HOLE, LOC. F3 CHANGE A TYPE TO B TYPE HOLE
B	ajdemell	ajdemell	05-24-05	MOVE KINEMATIC MOUNT HOLES, 90° TABLE
A	ajdemell	ajdemell	05-23-05	INITIAL REVISION

UNLESS OTHERWISE SPECIFIED
TOLERANCES: .X± .-- .XX± .-- .XXX± .--- ; FRACTIONS: ± -/-- ; ANGLES: ± - .-°/INCH ; MACH. SURFS.: 125 OR BETTER
REF: ASME Y14.5M-1994, THREADS ARE CLASS 2
BREAK EDGES .016 MAX. ON MACHINED WORK
REMOVE BURRS, WELD SPLATTER & LOOSE SCALE

MAT 2: . NOTES:
MAT 1: PLATE, ALUMINUM 6061-T6 NOTES:

PROJECT NAME: Advanced Light Source
UNIQUE NUMBER: AL-0015-0271
DO NOT SCALE PRINT — CATEGORY CODE: AL9021
SCALE: 1 : 1
THIRD ANGLE PROJECTION

ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY
UNIVERSITY OF CALIFORNIA
ALS - INSTRUMENTATION
PEEM 3 ELECTRON OPTICS
MICROSCOPE BASE PLATE

SHEET 1 OF 3 | SIZE: E | DWG NO: 26C350 | REV C

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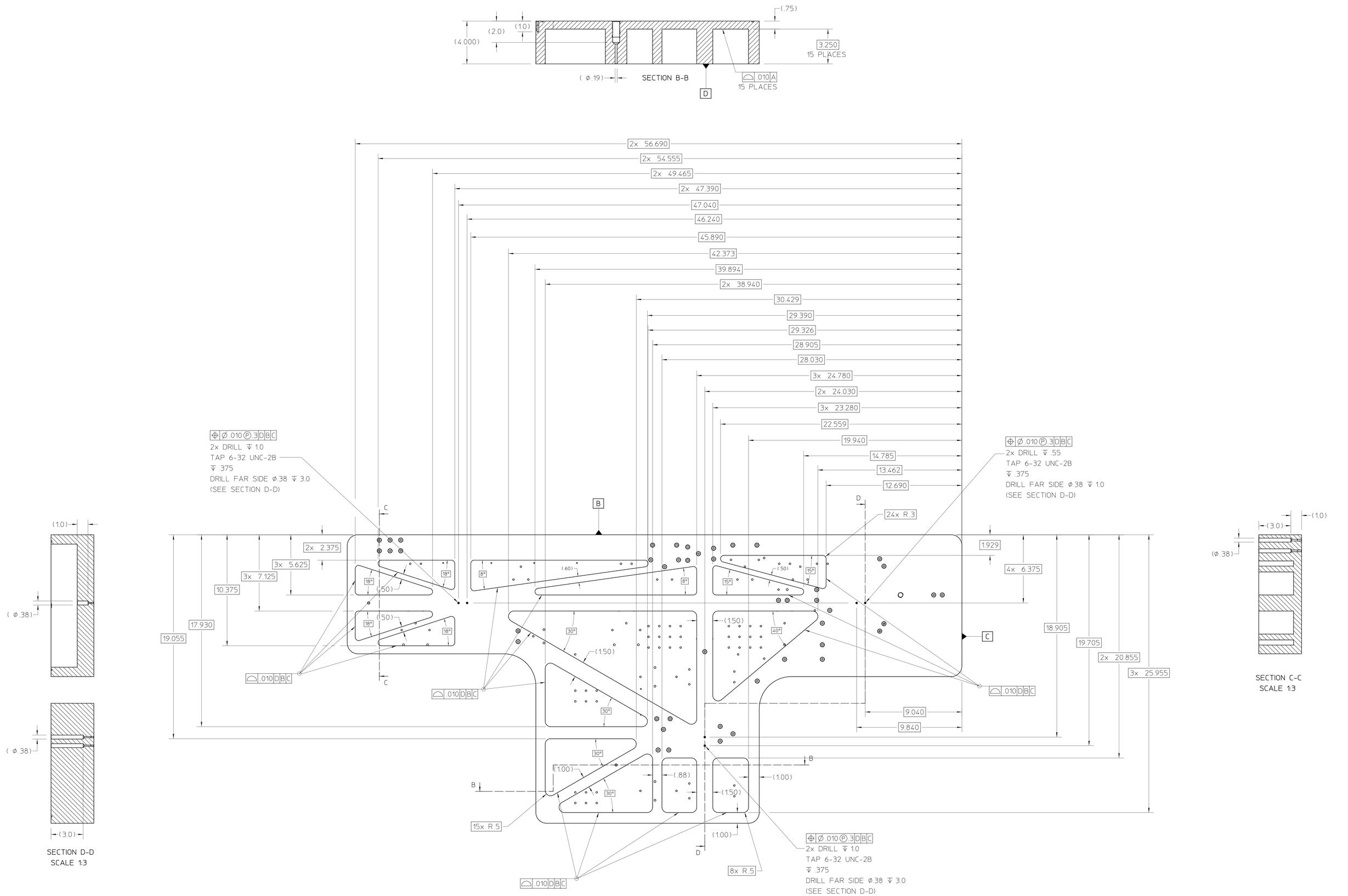

REV	AUTHOR	APPROVER	DATE	CHANGE DESCRIPTION
C	ajdemell	ajdemell	06-28-05	ADD WIDTH DIMENSION, MOVE R.3 RADII, LOC. E8 CHANGE C TYPE TO B TYPE HOLE, LOC. F3 CHANGE A TYPE TO B TYPE HOLE
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A	ajdemell	ajdemell	05-23-05	INITIAL REVISION

UNLESS OTHERWISE SPECIFIED
TOLERANCES: .X± .--- .XX± .-- .XXX± .---
FRACTIONS: ± -/--
ANGLES: ± - -°/INCH
MACH. SURFS.: 125√ OR BETTER
REF ASME Y14.5M-1994, THREADS ARE CLASS 2
BREAK EDGES .016 MAX. ON MACHINED WORK
REMOVE BURRS, WELD SPLATTER & LOOSE SCALE

MAT 2: . NOTES:
MAT 1: PLATE, ALUMINUM 6061-T6 NOTES:

PROJECT NAME: Advanced Light Source
UNIQUE NUMBER: AL-0015-0274
DO NOT SCALE PRINT SCALE: 1 : 1
CATEGORY CODE AL 9021
THIRD ANGLE PROJECTION

ERNEST ORLANDO LAWRENCE
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BERKELEY LAB

ALS - INSTRUMENTATION
PEEM 3 ELECTRON OPTICS
MICROSCOPE BASE PLATE

SHEET 2 OF 3 | SIZE: E | DWG NO: 26C350 | REV C

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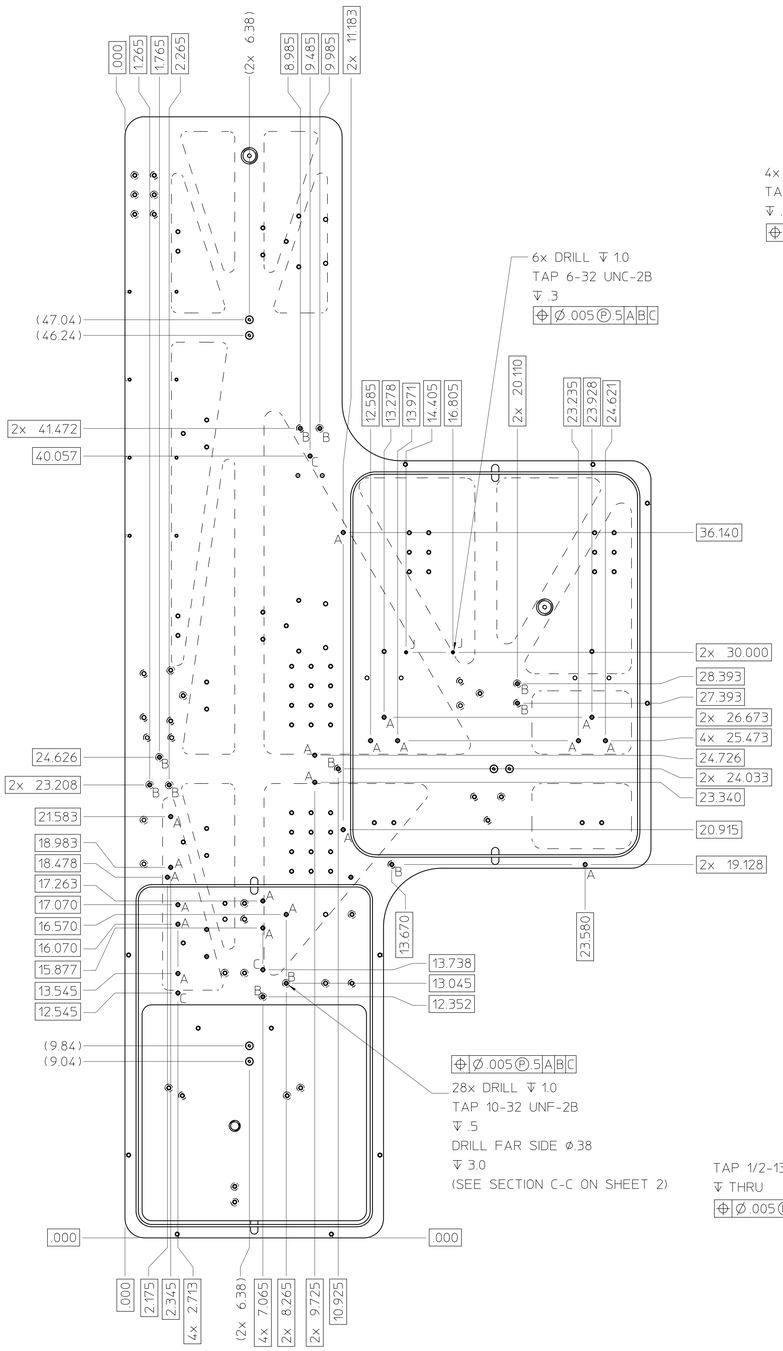
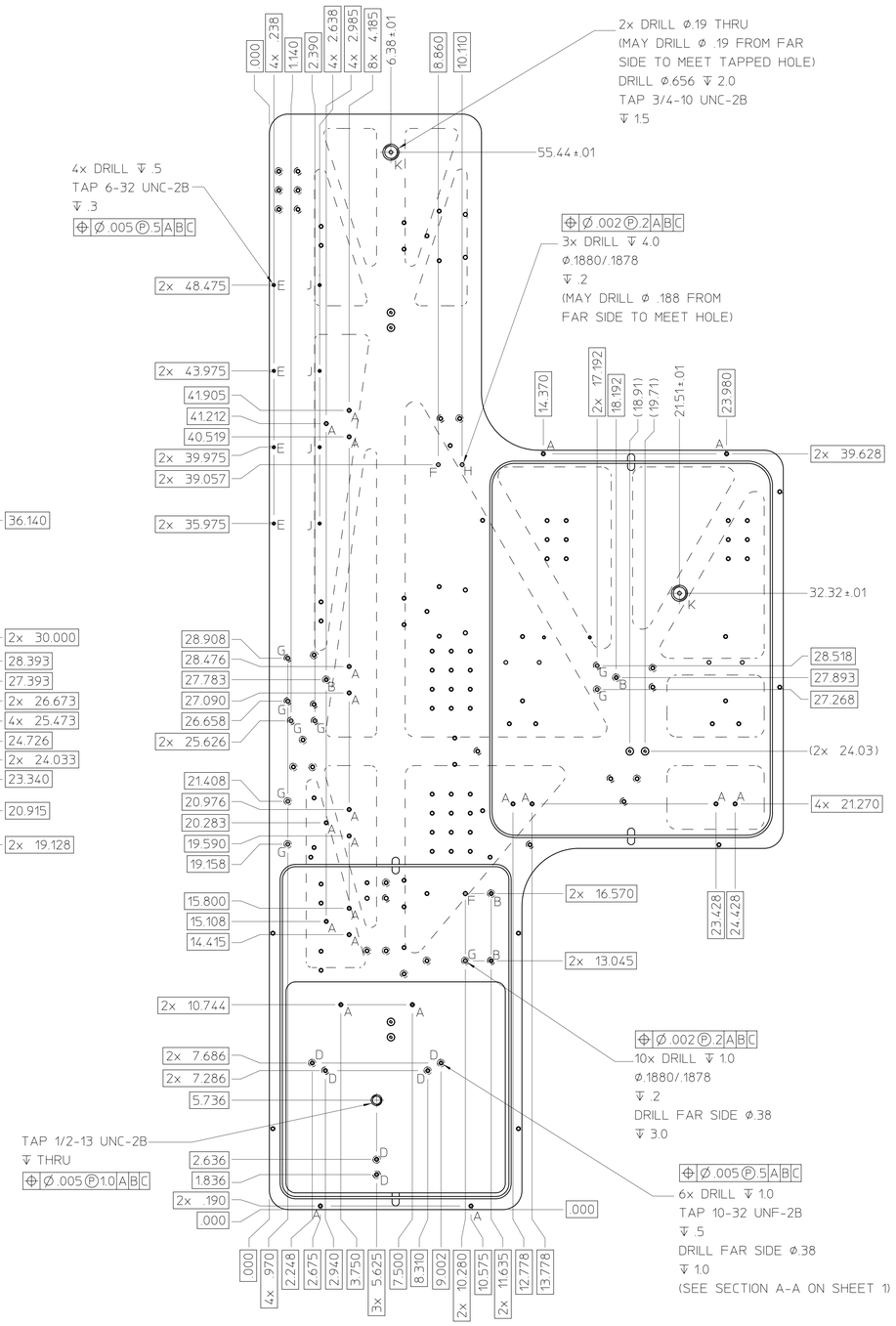


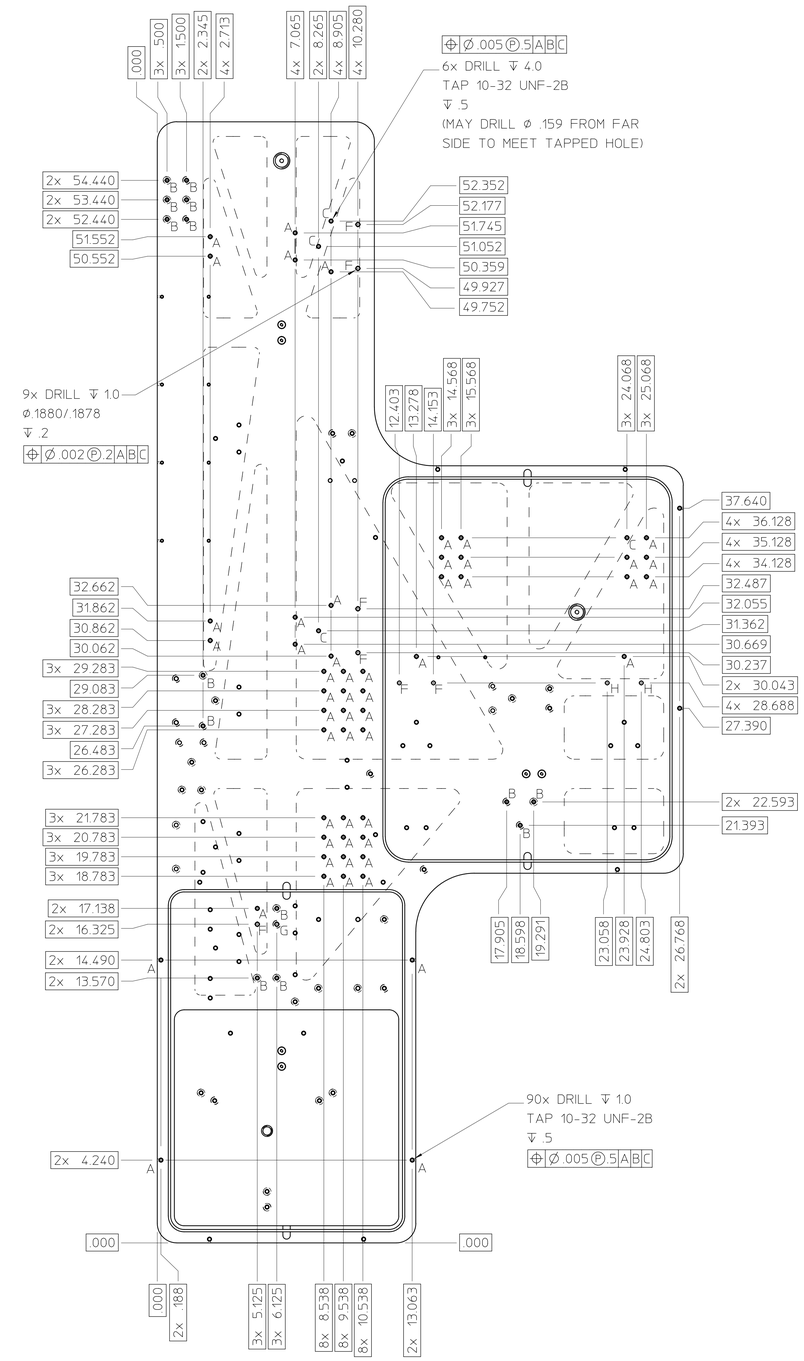
AUXILLARY FRONT VIEW #1

SCALE 1:3



AUXILLARY FRONT VIEW #2

SCALE 1:3



AUXILLARY FRONT VIEW #3

SCALE 1:3

HOLE DESCRIPTIONS

HOLE DESCRIPTOR	QUANTITY	DESCRIPTION (FOR REFERENCE ONLY)
A	90	DRILL ↧ 1.0, TAP 10-32 UNF-2B ↧ .5
B	28	DRILL ↧ 1.0, TAP 10-32 UNF-2B ↧ .5, DRILL FAR SIDE Ø.38 ↧ 3.0, (SEE SECTION C-C ON SHEET 2)
C	6	DRILL ↧ 4.0, TAP 10-32 UNF-2B ↧ .5, (MAY DRILL Ø .159 FROM FAR SIDE TO MEET TAPPED HOLE)
D	6	DRILL ↧ 1.0, TAP 10-32 UNF-2B ↧ .5, DRILL FAR SIDE Ø.38 ↧ 1.0, (SEE SECTION A-A ON SHEET 1)
E	4	DRILL ↧ .5, TAP 6-32 UNC-2B ↧ .3
F	9	DRILL ↧ 1.0, Ø.1880/.1878 ↧ .2
G	10	DRILL ↧ 1.0, Ø.1880/.1878 ↧ .2, DRILL FAR SIDE Ø.38 ↧ 3.0
H	3	DRILL ↧ 4.0, Ø.1880/.1878 ↧ .2, (MAY DRILL Ø .188 FROM FAR SIDE TO MEET HOLE)
J	6	DRILL ↧ 1.0, TAP 6-32 UNC-2B ↧ .3
K	2	DRILL ↧ 2.0, TAP 3/4-10 UNC-2B ↧ 1.5, DRILL FAR SIDE Ø.188 ↧ 2.0, (SEE SECTION B-B ON SHEET 2)

REV	AUTHOR	APPROVER	DATE	CHANGE DESCRIPTION
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TOLERANCES: .X± .- .XX± .-- .XXX± .---
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MACH. SURFS.: 125 OR BETTER
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MICROSCOPE BASE PLATE

SHEET 3 OF 3 SIZE: E DWG NO: 26C350 REV C

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