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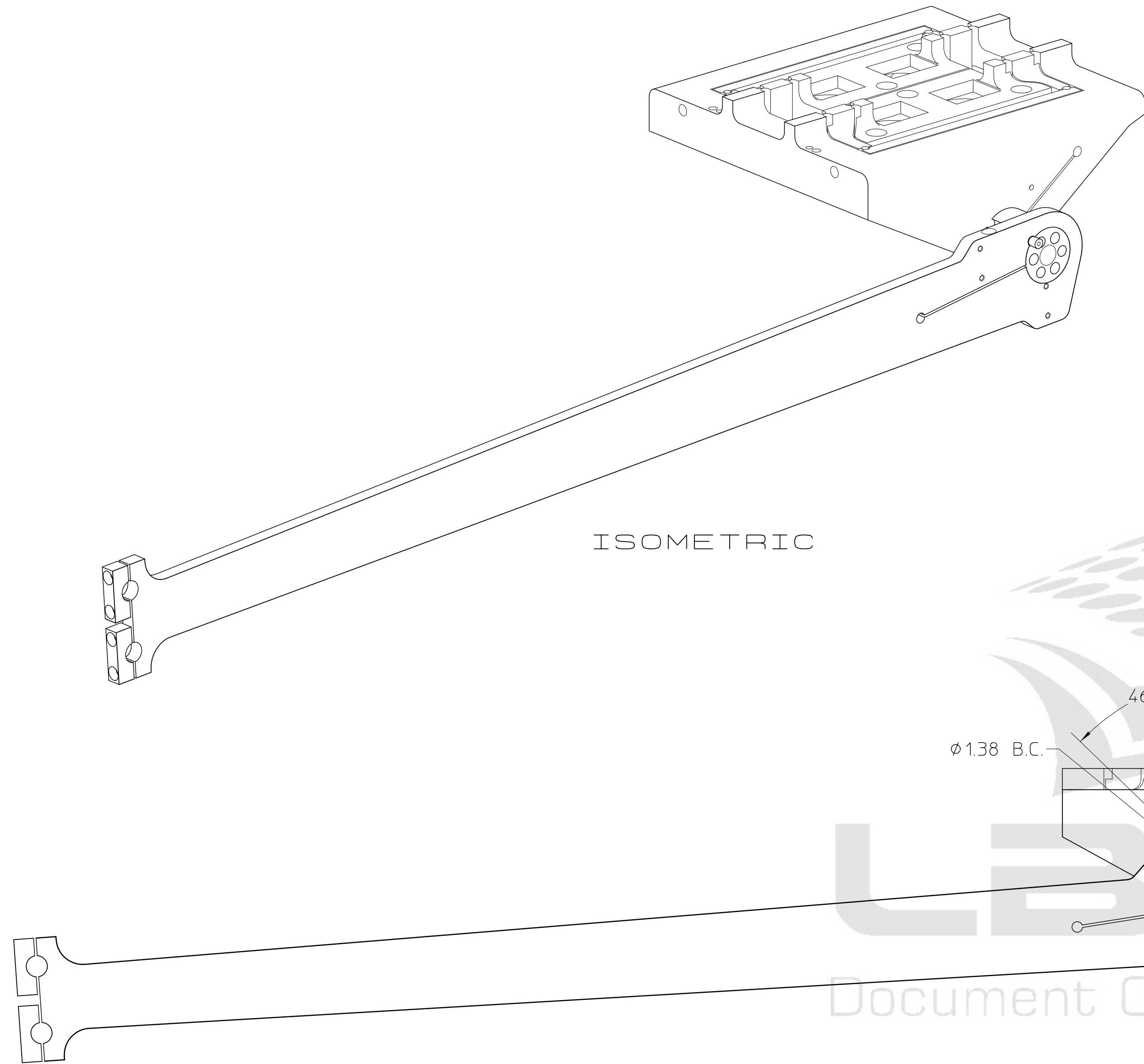
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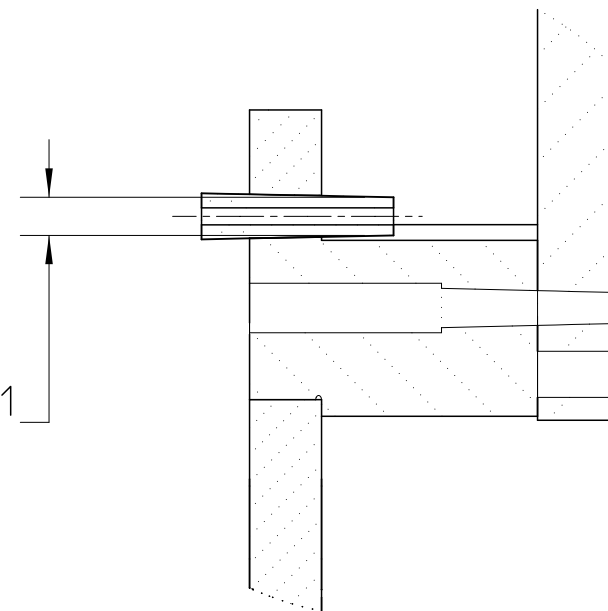
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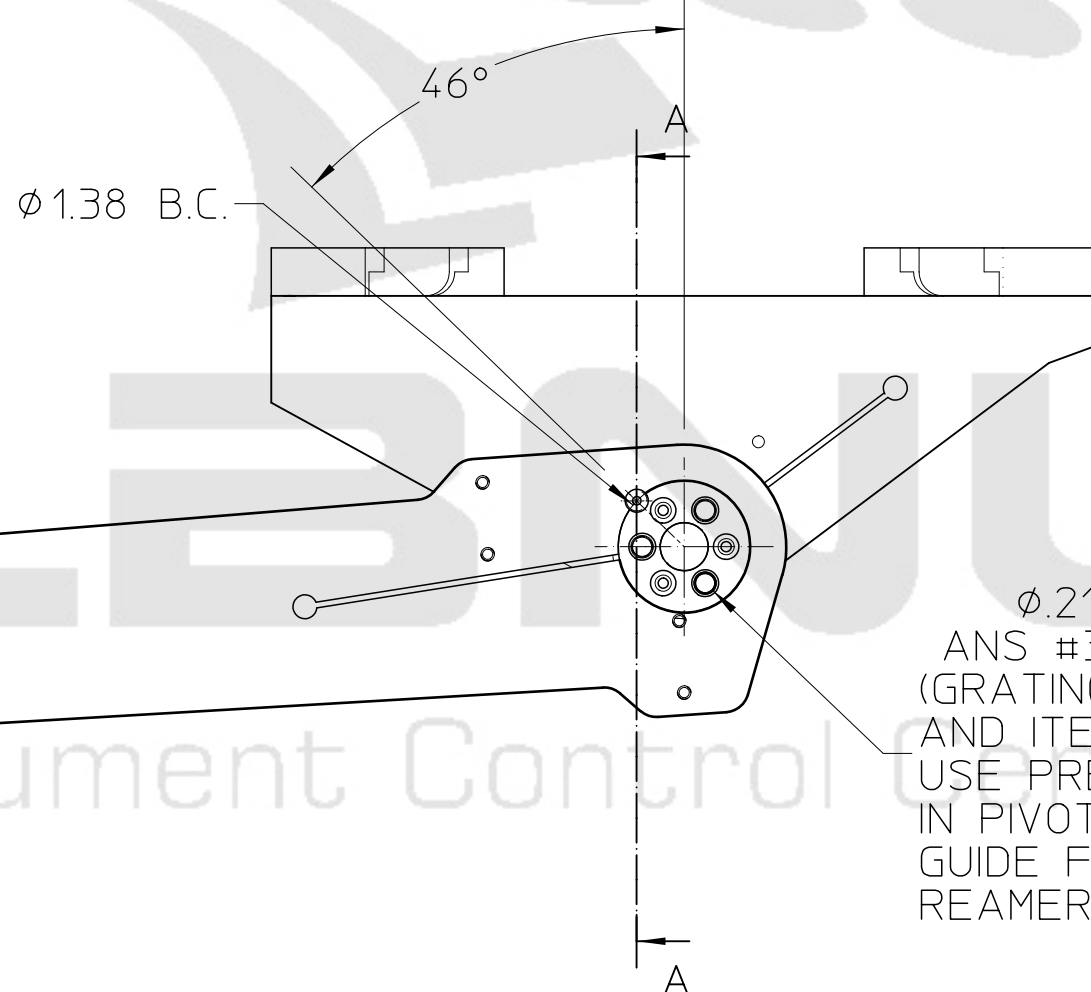
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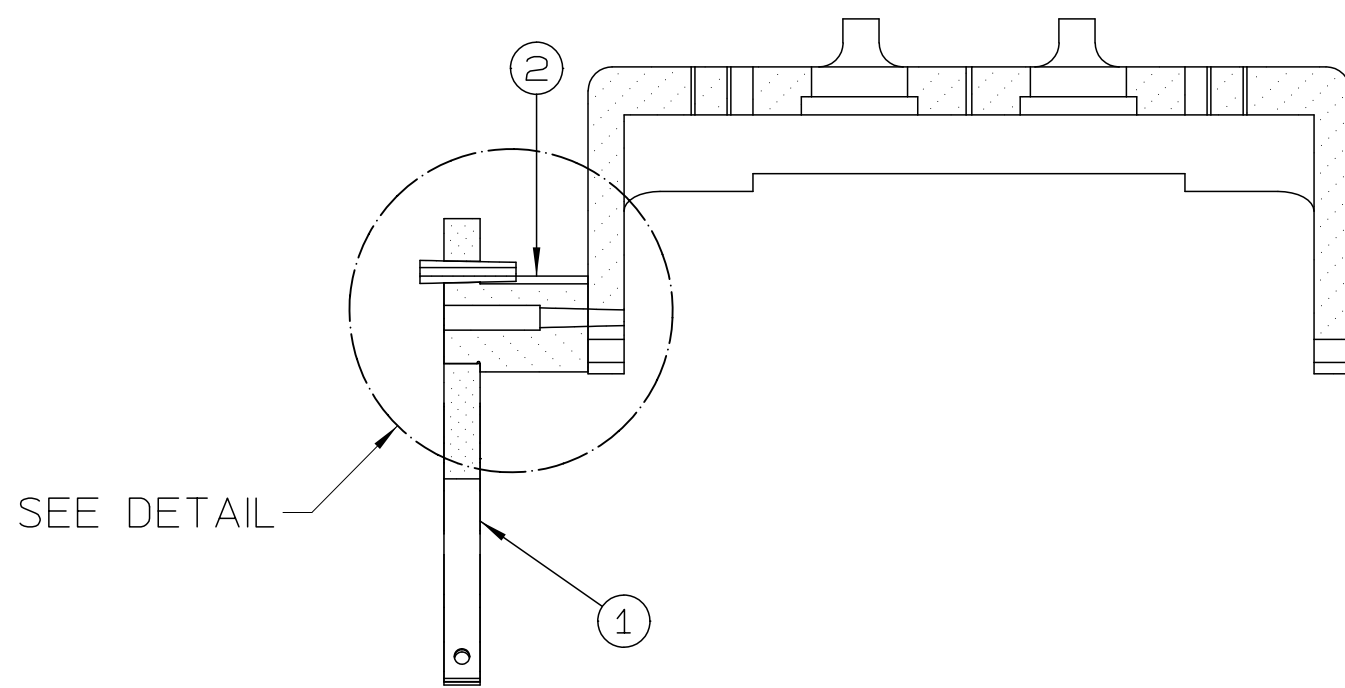
Ø.214 MINOR DIAMETER ±.002
ANS #3 TAPER THRU ITEM #1
(GRATING SINE ARM)
AND ITEM #2 (PIVOT STUB)



DETAIL
SCALE FULL



Ø.214 MINOR DIAMETER
ANS #3 TAPER THRU ITEM #1
(GRATING SINE ARM)
AND ITEM #2 (PIVOT STUB).
USE PREDRILLED HOLES
IN PIVOT STUB AS DRILL
GUIDE FOR STARTING TAPER
REAMER



SECTION A-A


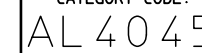
UNLESS OTHERWISE SPECIFIED.

- 1) THIS IS AN ULTRA HIGH VACUUM (UHV) PART AND REQUIRES SPECIAL ATTENTION TO AVOID UHV CONTAMINATION. READ LBNL SPECIFICATION M773 BEFORE PERFORMING ANY FABRICATION.
- 2) ALL WELDS ARE TO BE VACUUM LEAK TIGHT AND ARE TO BE HELIUM LEAK TESTED. THE LEAK RATE IS NOT TO EXCEED 2×10^{-9} cc/sec He.
- 3) SURFACE TREATMENT: THIS IS A UHV PART. FABRICATE AND CLEAN PER LBL SPEC. #M775.
- 4) PROTECT FINISHED PART BY BAGGING OR SIMILAR METHOD TO PROTECT AND MAINTAIN CLEANLINESS DURING SHIPMENT AND STORAGE. TAKE EXTREME CARE NOT TO DING, SCRATCH, DENT, OR OTHERWISE MARK ANY MACHINED SURFACE.

ORDER OF OPERATION: MATCH TAPER REAM

- 1) ITEM #1 (GRATING CRADLE). USING A Ø.50 DOWEL PIN, SECURE THE PIVOT STUB TO THE CRADLE USING 3x ITEM #5 (SCKT HD CAP SCREWS).
- 2) MATCH REAM AS SPECIFIED.
- 3) MOUNT AND ALIGN SINE ARM TO ANGLE SPECIFIED AND CLAMP IN PLACE.
- 4) MATCH REAM AS SPECIFIED.

| REV | AUTHOR | APPROVER | DATE | CHANGE DESCRIPTION |
|-----|---------|----------|----------|--------------------|
| A | wingert | wingert | 05-23-05 | INITIAL REVISION |

| | | | | | | |
|--|----------------------------------|--|----------------------------------|--|--|--|
| | | MAT 2: , | | NOTES: | | |
| | | MAT 1: , | | NOTES: | | |
| UNLESS OTHERWISE SPECIFIED | | PROJECT NAME: PROJECT NUMBER: | | ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY UNIVERSITY OF CALIFORNIA  | | |
| TOLERANCES | X ± . - - XX ± . - - XXX ± . - - | | | | | |
| | FRACTIONS: * - / - - | | | | | |
| | ANGLES: * - . - ° / INCH | | | | | |
| TOLERANCES | MACH. SURFS.: 125 ✓ OR BETTER | | ALS - INSERTION DEVICE BEAMLINES | | | |
| REF: ASME Y14.5M-1994, THREADS ARE CLASS 2 | | DO NOT SCALE PRINT | | BL 4.0.2 - MONOCHROMATOR | | |
| BREAK EDGES .016 MAX. ON MACHINED WORK | | CATEGORY CODE: SCALE: 1 : 2 | | GRATING CRADLE PIVOT MATCH TAPER REAM ASSY | | |
| REMOVE BURRS, WELD SPLATTER & LOOSE SCALE | | THIRD ANGLE PROJECTION  | | 1 SHEET OF 1 | | |
| | | | | SIZE: D DWG NO 26C423 | | |
| | | | | REV A | | |