

D

C

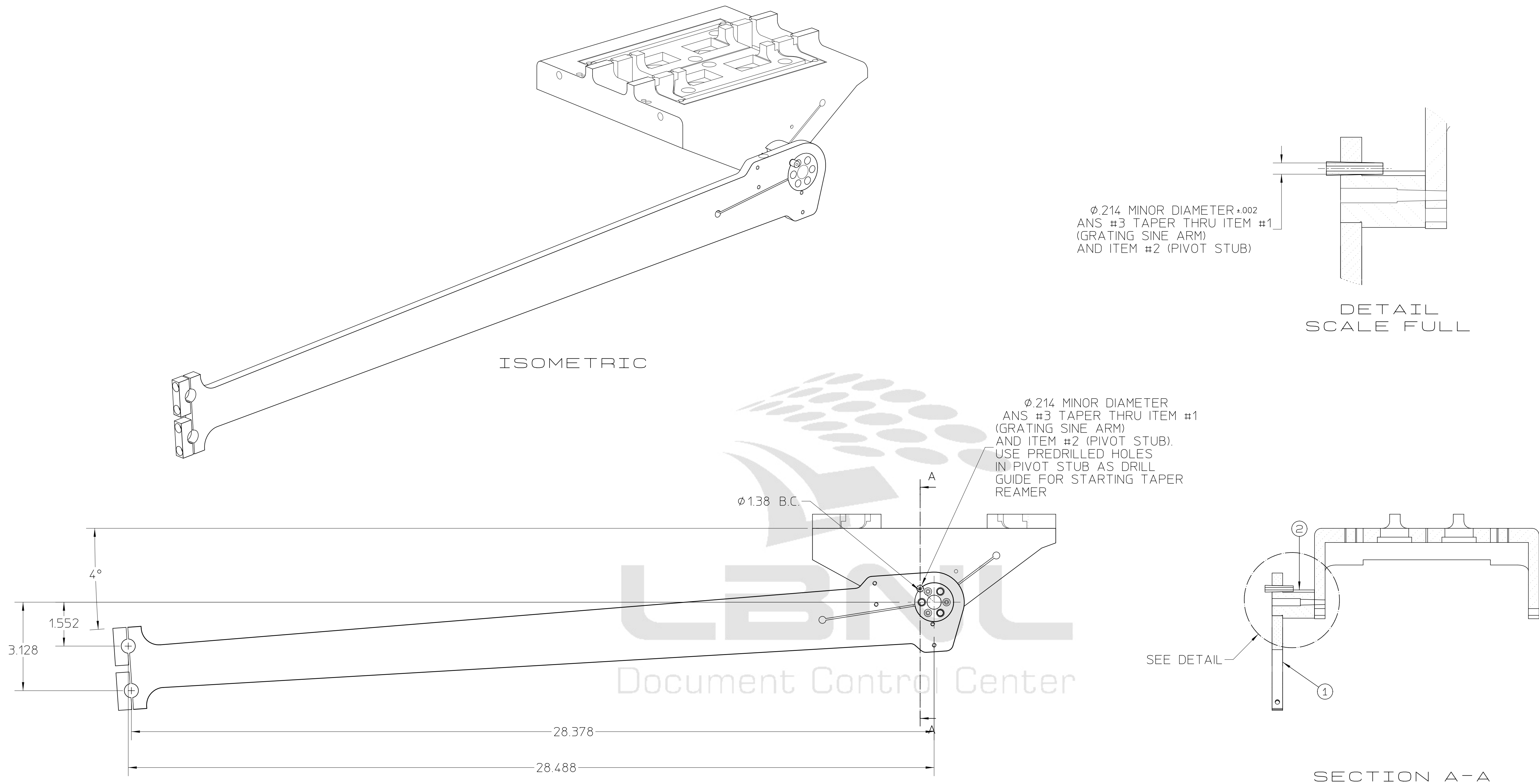
B

D

C

B

A



UNLESS OTHERWISE SPECIFIED:

- THIS IS AN ULTRA HIGH VACUUM (UHV) PART AND REQUIRES SPECIAL ATTENTION TO AVOID UHV CONTAMINATION. READ LBNL SPECIFICATION M773 BEFORE PERFORMING ANY FABRICATION.
- 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.
- SURFACE TREATMENT: THIS IS A UHV PART. FABRICATE AND CLEAN PER LBL SPEC. #M775.
- 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

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

REV	AUTHOR	APPROVER	DATE	CHANGE DESCRIPTION
B	wingert	wingert	06-15-05	ADDED REFERENCE DIMENSIONS.
A	wingert	wingert	05-23-05	INITIAL REVISION

UNLESS OTHERWISE SPECIFIED
TOLERANCES
FRACTIONS: $\frac{X}{Y}$ - $\frac{XX}{YY}$ - $\frac{XXX}{YYY}$ - $\frac{XXXX}{YYYY}$
ANGLES: \pm $^{\circ}$ - $^{\circ}$ / INCH
MACH. SURFS.: 125 $\sqrt{\text{BETTER}}$ 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:	NOTES:
PROJECT NAME:	ERNEST ORLANDO LAWRENCE
PROJECT NUMBER:	BERKELEY NATIONAL LABORATORY
DO NOT SCALE PRINT	CATEGORY CODE:
SCALE: 1:2	AL 40 45
THIRD ANGLE PROJECTION	SHEET 1 OF 1
SIZE: D	DWG NO: 26C423
REV B	REV B

GRATING CRADLE PIVOT MATCH TAPER REAM ASSY
ALS - INSERTION DEVICE BEAMLINES
BL 4.0.2 - MONOCHROMATOR