NOTES:
1) ALL DIMENSIONS IN mm [INCHES]
2) PART MUST BE FULLY ANNEALED AFTER WELDING, BEFORE MACHINING.
3) DEGREASE AND PAINT ENTIRE PART WITH SHERWIN-WILLIAMS LIGHT GREY TILE-CLAD II HI-BILD EPOXY (#MC-56, A22) OR EQ. PREPARE ALL SURFACES AND APPLY PER MFR SPECIFICATIONS.
DO NOT PAINT MACHINED SURFACES, APPLY A LIGHT COATING OF OIL TO INHIBIT RUST. MACHINED SURFACES BETWEEN DATUMS -A- AS WELL AS SURFACES F, G & H TO BE PAINTED.
4) MINIMUM THREAD DEPTH SPECIFIED ON TAPPED HOLE NOTES. TAPPED HOLES MAY BE DRILLED AND/OR TAPPED THRU UNLESS NOTED.
5) STAMP OR ENGRAVE APS AND SLAC PART #S AS SHOWN. GIRDERS TO BE NUMBERED SEQUENTIALLY 001 THRU 038 (INCLUSIVE).
ALL CHARACTERS: 13-16mm [.5-.6] TALL x ⅄1-2mm [.03-.06]

HOLE	DESCRIPTION
A	.375-16UNC-2B x ⅄15[.6]
B	M6 x 1.0 x ⅄13[.5]
C	M8 x 1.25 x ⅄13[.5]
D	Ø6.35/6.37 [.250/.251] x⅄13 [.5]
E	Ø6.315/6.329 [.2486/.2492] x⅄13 [.5]
F	.250-20UNC-2B x⅄13 [.5]
G	.313-18UNC-2B x⅄13 [.5]
H	.250-20UNC-2B THRU ONE WALL
J	.500-13UNC-2B x ⅄20[.8]
K	Ø51[2.0] THRU BOTH WALLS
L	Ø31.8[1.25] THRU ONE WALL
M	M10 x 1.5 x ⅄15[.6]
N	Ø9.988/10.002 x ⅄15[.6] MIN
P	2X Ø14 [.55] THRU BOTH WALLS

CONSTRUCTION PRINT
MAY 3 2007
ADVANCED PHOTON SOURCE

05	SEE DCN #070526-13	RTK	ET	052607
04	SEE DCN #070522-01	RTK	ET	052207
03	SEE DCN #070201-03	RTK	ET	020207
02	SEE DCN #070124-01	RTK	ET	012207
01	SEE DCN #060118-14	RTK	ET	111006
ZONE	REV	DESCRIPTION	BY	APPROVED

REVISIONS

DRAWN	RTKWK	12-Sep-05	
DESIGNED	P. DEN HARTOG	12-Sep-05	
CHECKED	RTKWK	12-Sep-05	
ENGINEER	TARKHIEBERG	12-Sep-05	
PROJECT MGR	M. WHITE	12-Sep-05	
CONTRACTOR	V. MILTON	12-Sep-05	
RELEASED		12-Sep-05	

ARGONNE NATIONAL LABORATORY
ADVANCED PHOTON SOURCE
LCLS — LINAC COHERENT LIGHT SOURCE
UNDULATOR SYSTEM

UNDULATOR MAGNET
MAGNET ASSEMBLY & SUPPORTS
UNDULATOR SUPPORT ASSEMBLY
UNDULATOR SUPPORT GIRDER

SIZE	D
DWG NO	L-1430401-100400
REV	05
SCALE	1/4
DO NOT SCALE DRAWING	
SHEET 2 OF 3	

LCLS UND SUPT STRUCTURE
A3914805
L-1430401-100400
REL 12-Sep-05
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