



- NOTES:
1. THIS IS A ULTRA- HIGH VACUUM COMPONENT (UHV)
 2. WHEN MACHINING VACUUM PARTS, USE SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:
 - A) CIMCOOL 5 STAR 49
 - B) TRIM SOL
 3. THIS IS A UHV PART, ELECTROPOLISHING IS NEEDED. PRIOR TO ELECTROPOLISHING, THE PART NEEDS TO GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOWDOWN.
 4. KEEP THE PART CLEAN AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
 5. DIMENSIONS IN [] ARE MILLIMETERS AND FOR REF. ONLY
 6. SURFACE ROUGHNESS \checkmark 63

SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY	
PARTS LIST					
UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN INCHES		LOG NUMBER A2335900	THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY		
TOLERANCES DECIMALS ANGULAR X ± .03 ± .25 ° .XX ± .01 .XXX ± .005		DRAWN BY J.GOGOL	DATE 9/14/95	CHIEF DESIGN ENGINEER	DATE
SURFACE ROUGHNESS \checkmark		CHECKED BY	GP LEADER	ADVANCED PHOTON SOURCE X1-84 2ND CRYSTAL HOLDER FOR 3-ID-A KOHZU SINGLE SPRING PLATE	
REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX.		DESIGNER J.GOGOL	PROJECT MGR.		
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST AMSI 846		RESPONSIBLE ENGINEER	APPROVED/RELEASED		
DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST AMSI 1143		MATERIAL CARPENTER STEEL (39% NICKEL)		SCALE 2:1	SIZE B
DO NOT SCALE DRAWING				SHEET 1 of 1	DRAWING NUMBER P4105091103-840005-00