



**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  $\sqrt{63}$

B	.020 [0.50] THK		1
A	.010 [0.25] THK		1
ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC
PARTS LIST			
UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN INCHES		LOG NUMBER <b>A2336600</b>	THIS DRAWING IS THE PROPERTY OF <b>ARGONNE NATIONAL LABORATORY</b>
TOLERANCES	DECIMALS	ANGULAR	TITLE <b>ADVANCED PHOTON SOURCE</b>
.X ± .03	.25 °		X1-84 2ND CRYSTAL HOLDER FOR 3-ID-A KOHZU DOUBLE SPRING
.XX ± .01			
.XXX ± .005			
SURFACE ROUGHNESS $\sqrt{63}$	REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX.	DRAWN BY <b>J.GOGOL</b>	DATE 9/14/95
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST AMSI 144	DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST AMSI 114	CHECKED BY	CHIEF DESIGN ENGINEER
		DESIGNER <b>J.GOGOL</b>	DATE
		RESPONSIBLE ENGINEER	GP LEADER
		MATERIAL <b>440 STAINLESS STL HARDEN TO 35 Rc</b>	PROJECT MGR.
		SCALE 2:1	APPROVED/RELEASED
		SHEET 1 of 1	DRAWING NUMBER <b>P4105091103-840008-00</b>
		DO NOT SCALE DRAWING	

SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				