

NOTES:

1. LAST DASH NO. "XXX" INDICATES MICRON SIZE OF THRU HOLE
Ex. SS-1/4-28-SET-SCREW-200 -INDICATES 200 MICRON THRU HOLE
2. DASH "CAL" INSERTED INTO PART NUMBER PRIOR TO MICRON SIZE INDICATES FLOW CALIBRATED.
Ex. SS-1/4-28-SET-SCREW-CAL-XXX
3. ALL DIMENSIONS BEFORE PLATING
4. 0.060" DEEP MINIMUM
5. GROOVE OPTIONAL
6. FLAT BOTTOM TO DEPTH
7. THREAD TRACE PERMISSABLE.
8. ALL MACHINED SURFACES TO BE $63 \sqrt{\text{MIN}}$ UNLESS OTHERWISE SPECIFIED
9. BREAK ALL SHARP EDGES 0.005"
10. ALL DIAMETERS CONCENTRIC WITHIN 0.008" T.I.R.
11. PARTS TO BE FREE OF OILS, CUTTING FLUIDS, AND DEBRIS
12. PASSIVATE PER AMS2700E

REV	DESCRIPTION	INCORP BY	DATE
B	REVISED TOLERANCE ON $\varnothing 0.125"$	J. SCHUSTER	11/12/2018
C	DRAWING NUMBER CORRECTION	J. SCHUSTER	10/10/2019

Specifications

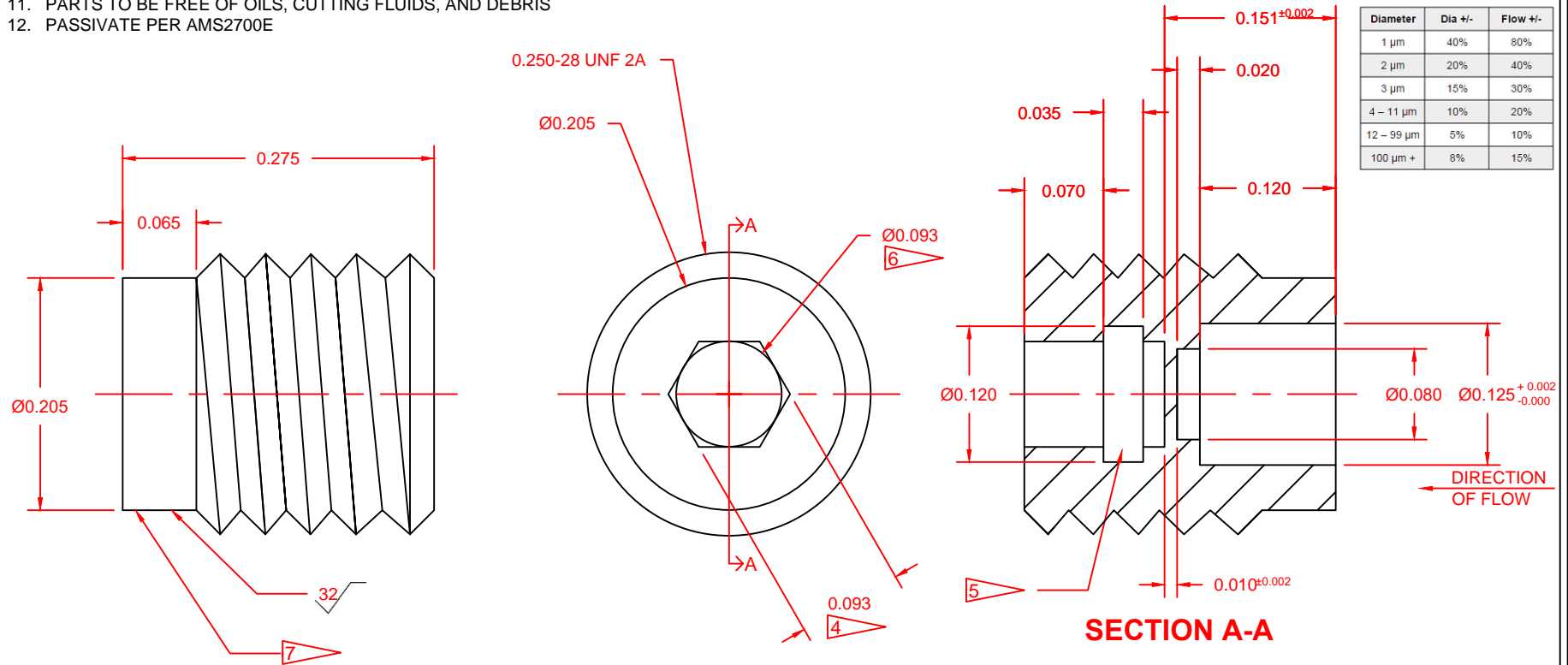
Diameter	1/4" - 28
Centering	$\pm 0.250\text{mm}$ ($\pm 0.00984"$)
Orifice Diameters	1 - 1000 μ (0.0000394" - 0.0394")

Optically Measured Tolerances

Diameter	Tolerance +/-
1 μm	50%
2 μm	40%
3 - 5 μm	20%
6 - 7 μm	15%
8 - 99 μm	10%
100+ μm	5%

Flow Calibrated Tolerances

Diameter	Dia +/-	Flow +/-
1 μm	40%	80%
2 μm	20%	40%
3 μm	15%	30%
4 - 11 μm	10%	20%
12 - 99 μm	5%	10%
100 μm +	8%	15%



THIS DOCUMENT CONTAINS INFORMATION THAT IS CONFIDENTIAL AND PROPRIETARY TO LENOX LASER. THIS DOCUMENT IS FURNISHED ON THE UNDERSTANDING THAT THE DOCUMENT AND THE INFORMATION IT CONTAINS WILL NOT BE COPIED OR DISCLOSED TO OTHERS EXCEPT WITH THE WRITTEN CONSENT OF LENOX LASER. WILL NOT BE USED FOR ANY PURPOSE OTHER THAN CONDUCTING BUSINESS WITH LENOX LASER, AND WILL BE RETURNED AND ALL FURTHER USE DISCONTINUED UPON REQUEST BY LENOX LASER.

UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN INCHES
DECIMAL VALUES ARE SHOWN WITH DECIMAL TOLERANCE VALUES
DECIMAL .X = ± 0.1 TOLERANCES
PLACES .XX = ± 0.01 APPLIED
IN THE .XXX = ± 0.005 TO THE
PRINT .XXXX = ± 0.0005 PRINT
FRACTIONAL AND ANGULAR VALUES ARE SHOWN WITH
FRACTIONAL OR ANGULAR TOLERANCE VALUES.
FRACTIONS = $\pm 1/16$
ANGLES = $\pm 1^\circ$

Material
SS-303
PER ASTM A582



Drawing Number
A
SS-1/4-28-SET-SCREW-XXX

REV
C

Used On

-

APPROVALS	DATE
DRAWN C. DRAPER	3/2/2016
CHK J. SCHUSTER	3/14/2016
ENGR J. SCHUSTER	3/14/2016
SHEET: 1 OF 1	DO NOT SCALE

Drawing Name
SS SET SCREW