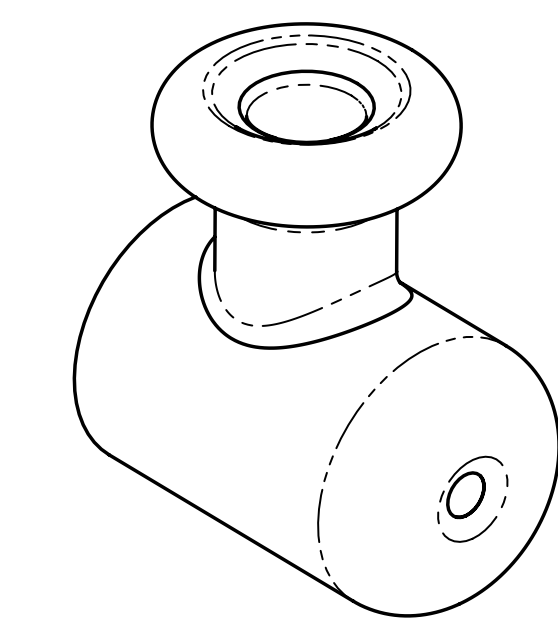


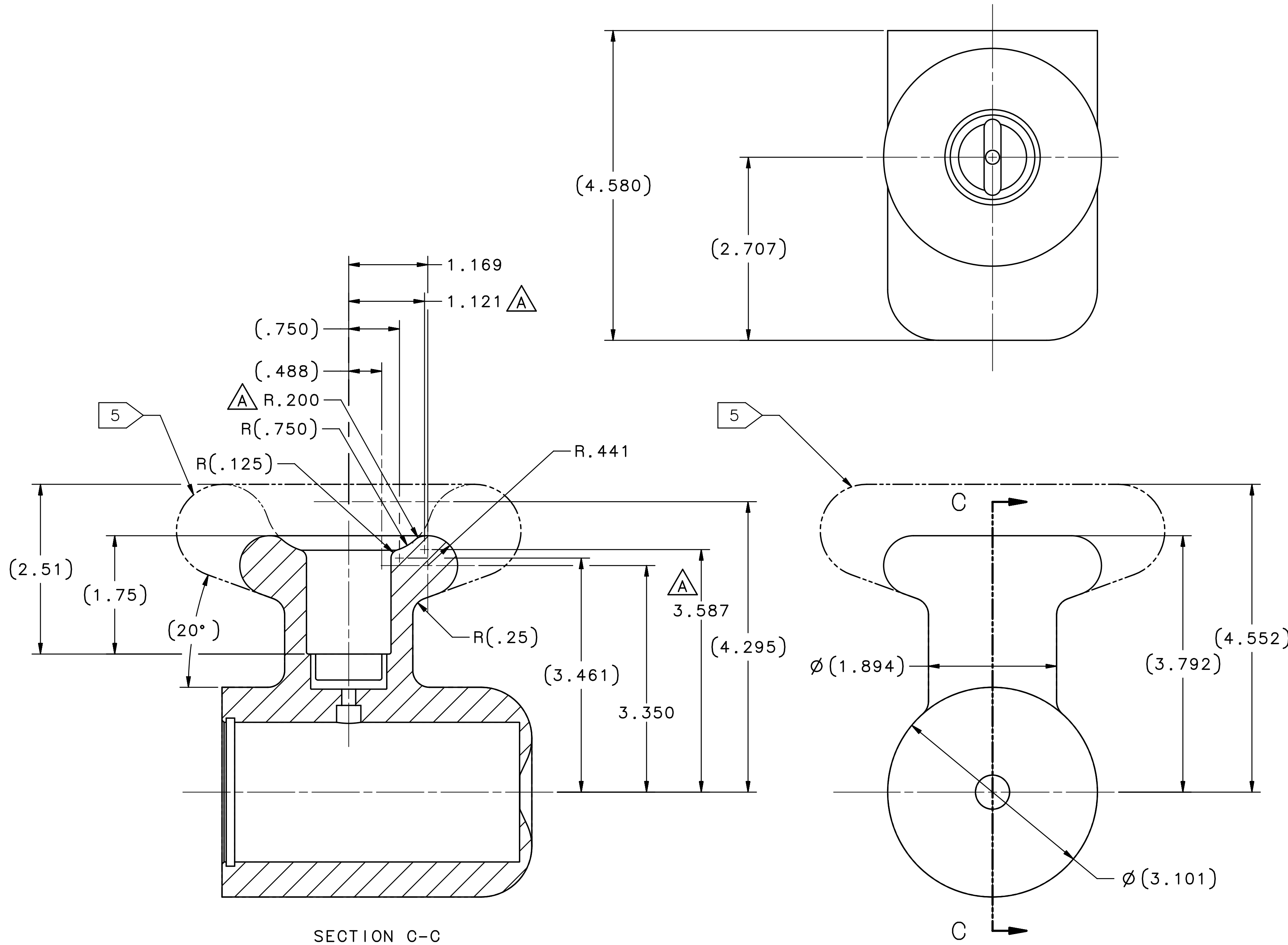
REVISION HISTORY			
ZONE	REV	DESCRIPTION	DATE/REVISER
B6	A	REMOVED SHARP EDGE WITH RADIUS (.20)	15NOV18/JA



ISO VIEW
SCALE 1:2

NOTES:

1. USE THE FOLLOWING JLAB SPECIFICATIONS
FABRICATION OF ULTRA HIGH VACUUM EQUIPMENT: #22631-S-001
CLEANING AND HANDLING OF U.H.V COMPONENTS: #22632-S-001
2. ALL EXTERIOR SURFACES SHALL BE MACHINED TO 16 FINISH.
3. ALL INTERIOR SURFACES SHALL BE MACHINED TO 63 FINISH.
4. AFTER FINAL MACHINING, ELECTROPOLISH ITEM, DIAMOND PASTE POLISH AND THEN HIGH PRESSURE RINSE.
5. SHAPE OF EXISTING TOP PORTION.
6. RE-MACHINE EXTERIOR TOP PORTION OF ELECTRODE ONLY. CARE MUST BE TAKEN NOT TO DAMAGE INTERNALS OR EXISTING LOWER PORTION OF ELECTRODE.
7. CAREFULLY BLEND EXISTING REMAINING EXTERIOR WITH NEW PROFILE.



SECTION C-C

DIM & TOL PER ASME Y14.5 2009. UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ARE: FRACTIONS DECIMAL ANGLES $\pm 1/8$.X $\pm .1$ $\pm .50^\circ$ $\pm .XX$ $\pm .01$ $\pm .XXX$ $\pm .003$	MATERIAL MODIFICATION JL0045108 ASTM A240 316L STAINLESS STEEL	United States Department of Energy Newport News Virginia
	FINISH: SEE NOTE MACHINE SURFACES: DEBURR & BREAK ALL SHARP EDGES UNLESS OTHERWISE NOTED	CEBAF INJECTOR 200 KeV GUN HIGH VOLTAGE GUN T-SHAPED ELECTRODE MODIFICATION
THIRD ANGLE PROJECTION 	DO NOT SCALE DRAWING DRAWN: J. ARMSTRONG DATE: 17OCT18	SIZE: D DWG. NO.: JL0069689 REV. A SCALE: 1:1 USED ON ASSY NO.: N/A SHEET 1 OF 1