



ZONE	REV	DESCRIPTION	DATE	APPROVED
ALL	A	ADDED TOOLING BALL HOLES FOR ALIGNMENT. TAPPED HOLES FOR SHED AND HANDLING.	12JULY18	M. POELKER P. ADDERLEY
8A	B	REVISED NOTE 2, MATERIAL WAS 316LIN.	17AUG18	M. POELKER P. ADDERLEY

VACUUM SIDE

ATM SIDE

FOR R28 INSULATOR

NOTES:

- 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 CEBAF QA SPECIFICATION: #91790-200. STAINLESS STEEL FLANGES FOR UHV APPLICATIONS #23661-S-001
- MACHINE FROM NOR-CAL PRODUCTS P/N 1000-000N OR EQUAL. 10.00 O.D.; NON-ROTATABLE; BLANK, CF FLANGE, TYPE 304 STAINLESS STEEL.
- PART NUMBER TO BE ENGRAVED OR ETCHED IN LOCATIONS SHOWN USING MINIMUM .25 HIGH CHARACTERS.
- PROTECT FLANGE FACES DURING AND AFTER PROCESSING WITH SUITABLE PLASTIC CAPS. DAMAGE TO KNIFE EDGES IS UNACCEPTABLE.

QTY	ITEM NO.	IDENTIFYING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL SPECIFICATION	NOTES
			TRACKING NO. N/A		
DOCUMENT CONTROL STAMP		U.S. Department of Energy Office of Science		U.S. Department of Energy Office of Science	
MATERIAL		APPROVALS		DATE	
SEE NOTES		DRAWN: D. MACHE		13JAN09	
FINISH UNLESS OTHERWISE SPECIFIED		CHECKED: B. MATT POELKER		2/1/09	
TOLERANCES ARE IN INCHES		APPROVED: J. HANSNECHT		2/1/09	
FRACTIONS: X/XXX ± .005		APPROVED: B. MATT POELKER		2/1/09	
DECIMALS: X.XX ± .01					
ANGLES: X° ± .50°					
THIRD ANGLE PROJECTION					
DO NOT SCALE DRAWING					

Jefferson Lab Operated by Jefferson Science Associates, LLC	
ACC INJECTOR LOAD LOCK GUN H.V. STALK FLANGE	REV. B
ACC-200-3000-0311	REV. B
SCALE: 1:1	SHEET 1 OF 1