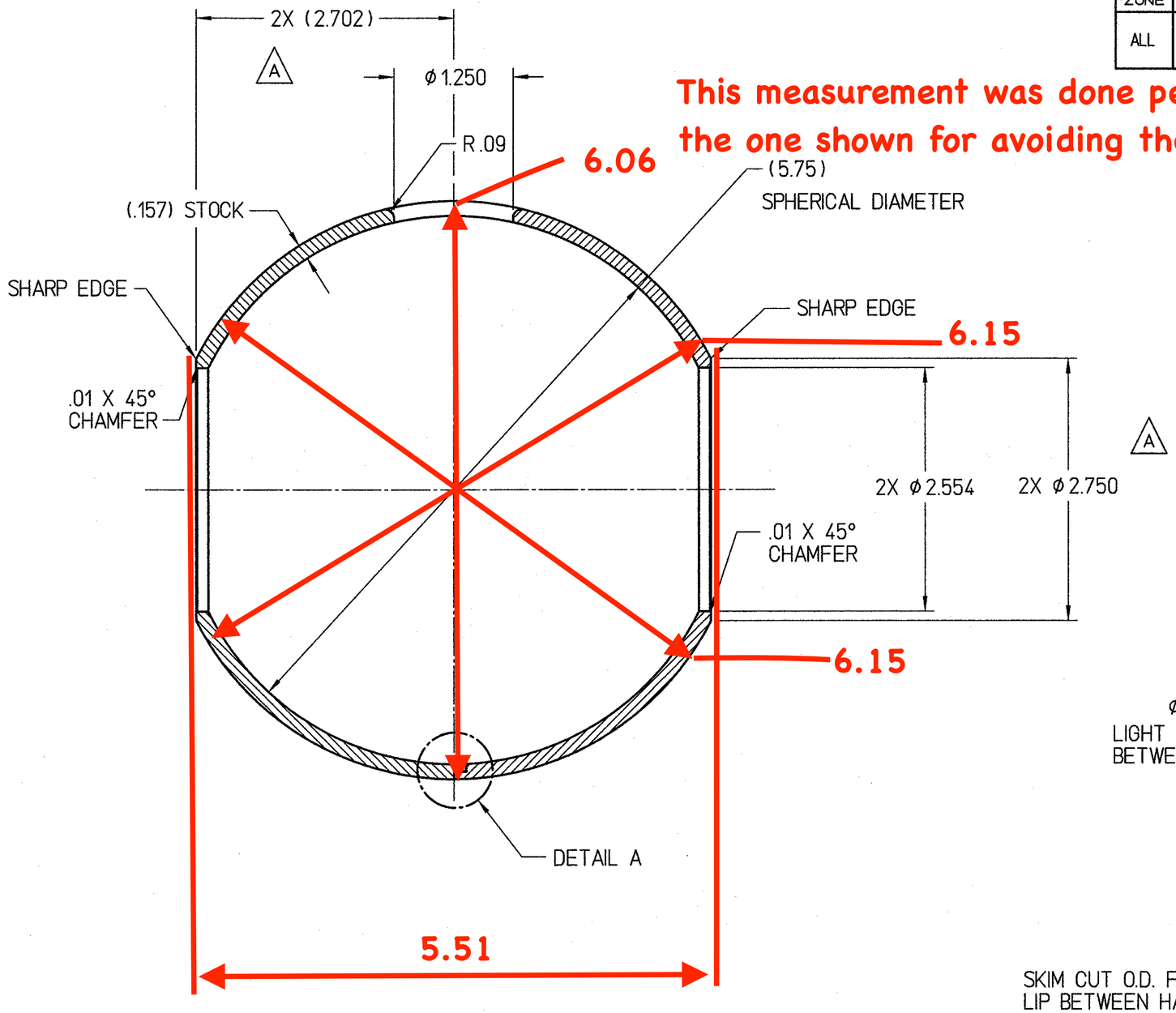
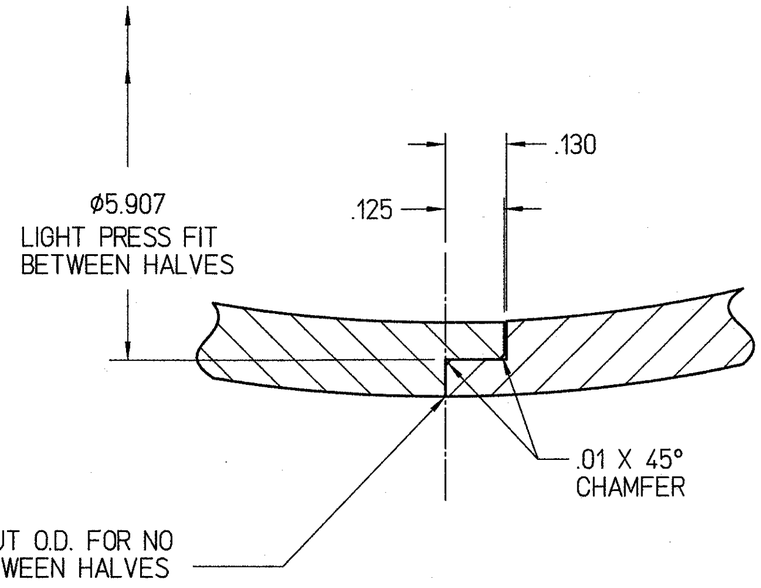
REVISION HISTORY				
ZONE	REV	DESCRIPTION	DATE	APPROVED
ALL	A	2X ⌀2.750 WAS 2X ⌀2.626. DM 3/12/12	3/12/12	



This measurement was done perpendicularly to the one shown for avoiding the 1.25 aperture



DETAIL A
SCALE: 4:1

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. MAKE FROM STOCK HEMISPHERE AS SHOWN ON JLAB DRAWING ACC-200-3000-0463.
3. ALL EXTERIOR SURFACES SHALL BE MACHINED TO 16 FINISH.
4. ALL INTERIOR SURFACES SHALL BE MACHINED TO 63 FINISH.
5. MACHINE TONGUE AND GROOVE JOINT ON EACH HALF OF SPHERE THEN FASTEN HALVES TOGETHER AND MACHINE OUTSIDE DIAMETER AND BORES.
6. AFTER FINAL MACHINING, BCP ITEM. CHEMICAL ETCHING ALLOWANCE IS .004 PER SURFACE.

QTY REQD	ITEM NO.	PART OR IDENTIFYING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL SPECIFICATION	NOTES

PARTS LIST

DOCUMENT CONTROL STAMP

MATERIAL: SEE NOTES

FINISH MACHINED SURFACES 63 UNLESS OTHERWISE NOTED
DEBURR & BREAK ALL SHARP EDGES

DO NOT SCALE DRAWING

DIM & TOL PER ASME Y14.5
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ARE:
FRACTIONS ± DECIMAL .X ± .1 .XX ± .01 .XXX ± .005 ANGLES ± .50°

THIRD ANGLE PROJECTION

TRACKING NO. N/A

APPROVALS	DATE
DRAWN D. MACHIE	18JAN12
CHECKED B. MATT POELKER	2/17/12
APPROVED B. MATT POELKER	2/17/12
APPROVED J. HANSKNECHT	2/17/12

U.S. Department of Energy Office of Science — Jefferson Lab Thomas Jefferson National Accelerator Facility — Operated by Jefferson Science Associates, LLC

ACC INJECTOR LOAD LOCK GUN SPHERICAL ELECTRODE SHELL

SIZE C | DWG. NO. ACC-200-3000-0460 | REV. A

SCALE 1:1 | USED ON ASSY NO. ACC-200-3000-0464 | SHEET 1 OF 1

Me10