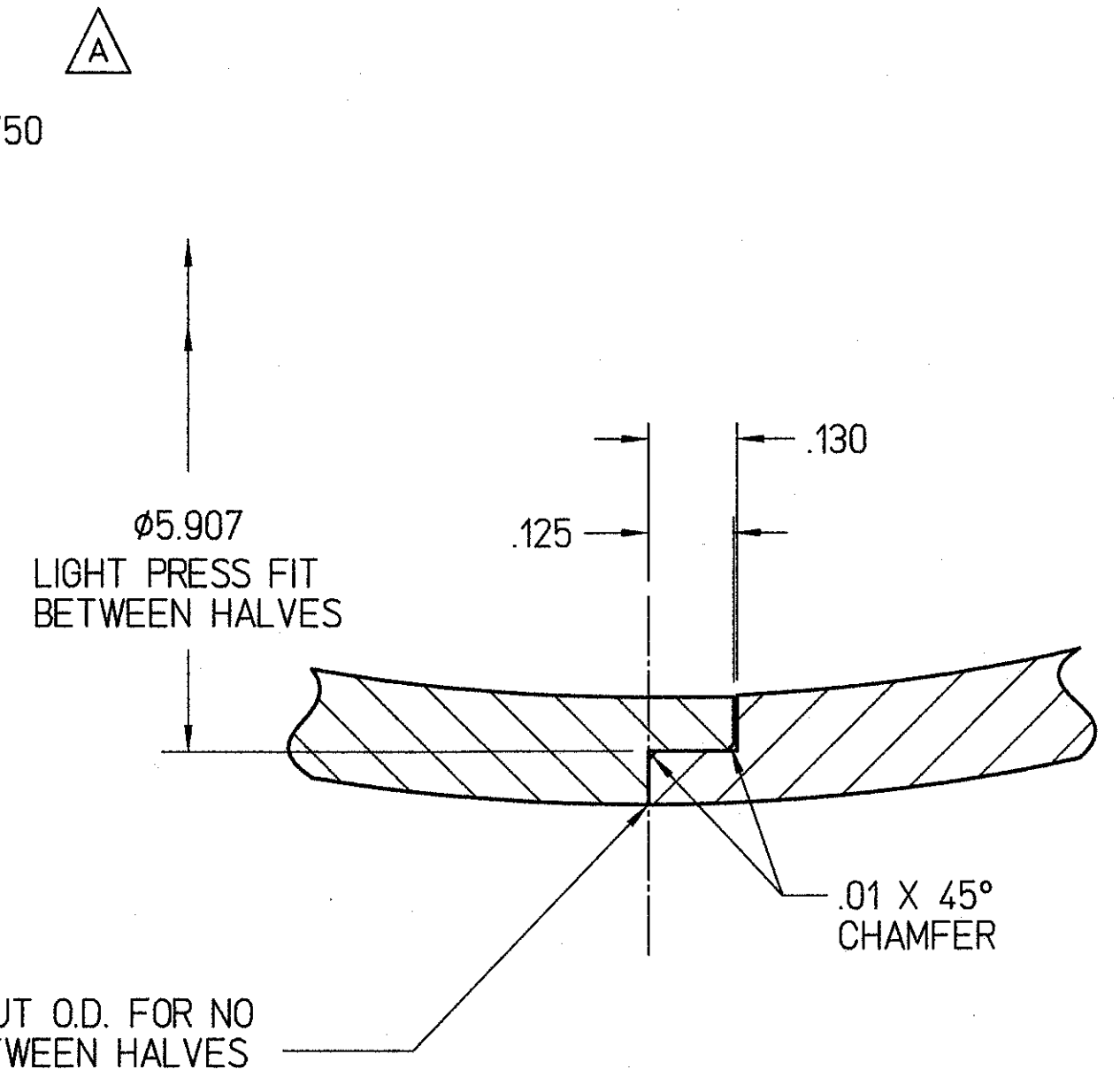
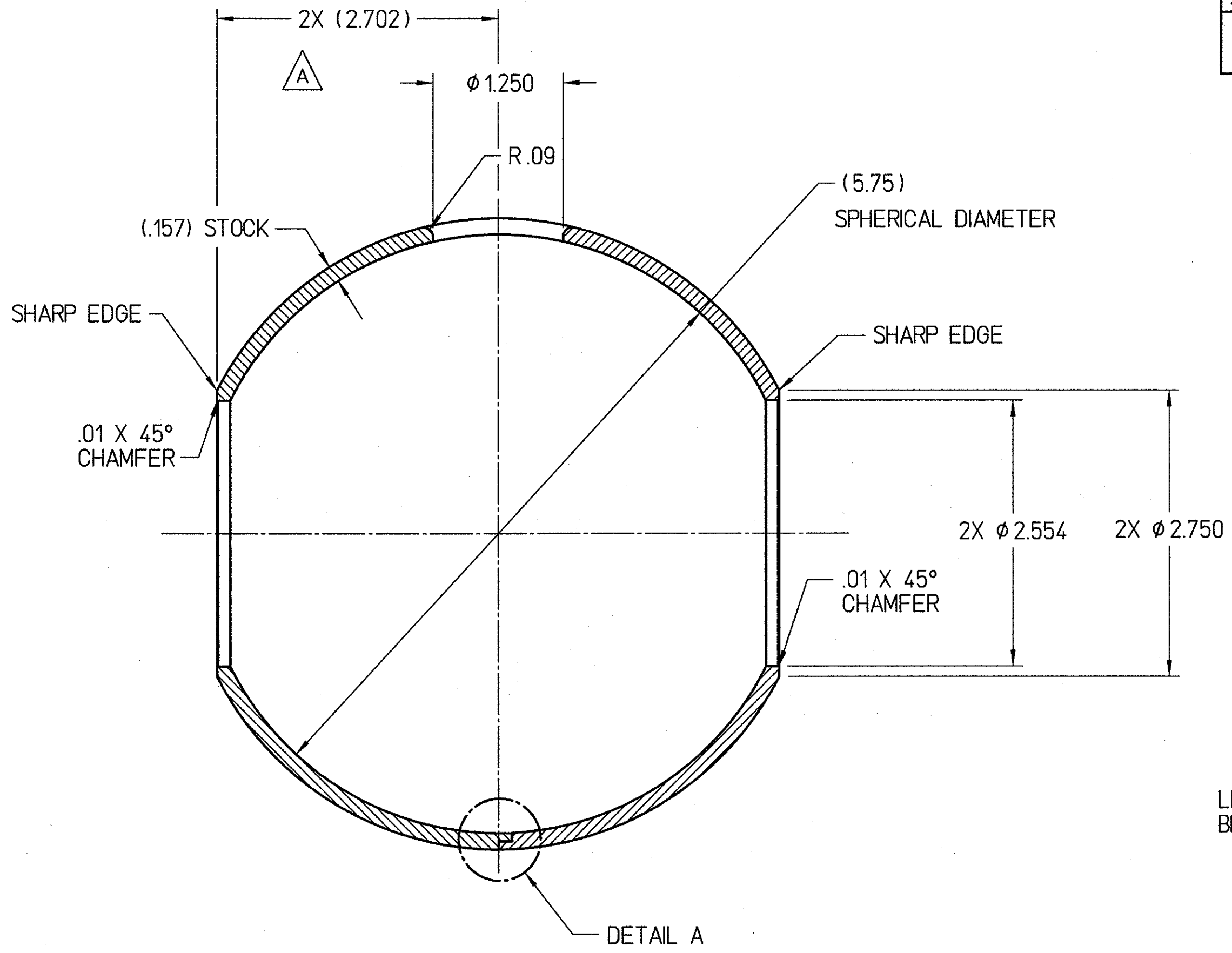


REVISION HISTORY				
ZONE	REV	DESCRIPTION	DATE	APPROVED
ALL	A	2X Ø2.750 WAS 2X Ø2.626.	3/12/12	<i>[Signature]</i>
			DM 3/12/12	<i>[Signature]</i>



DETAIL A
SCALE: 4:1

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
- MAKE FROM STOCK HEMISPHERE AS SHOWN ON JLAB DRAWING ACC-200-3000-0463.
- ALL EXTERIOR SURFACES SHALL BE MACHINED TO 16 FINISH.
- ALL INTERIOR SURFACES SHALL BE MACHINED TO 63 FINISH.
- MACHINE TONGUE AND GROOVE JOINT ON EACH HALF OF SPHERE THEN FASTEN HALVES TOGETHER AND MACHINE OUTSIDE DIAMETER AND BORES.
- 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		DIM & TOL PER ASME Y14.5 UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: FRACTIONS DECIMAL ANGLES * X ± .01 ± .50° XX ± .01 XXX ± .005		TRACKING NO. N/A	
MATERIAL SEE NOTES		THIRD ANGLE PROJECTION		APPROVALS DATE	
FINISH MACHINED SURFACES 63 UNLESS OTHERWISE NOTED DEBURR & BREAK ALL SHARP EDGES		DO NOT SCALE DRAWING		DRAWN D. MACHIE 18 JAN 12	
				CHECKED B. MATT POELKER 2/17/12	
				APPROVED B. MATT POELKER 2/17/12	
				APPROVED J. HANSKNECHT 2/17/12	
			SIZE DWG. NO. C ACC-200-3000-0460	REV. A	
			SCALE 1:1	USED ON ASSY NO. ACC-200-3000-0464 SHEET 1 OF 1	

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Jefferson Lab
Operated by Jefferson Science Associates, LLC

ACC INJECTOR LOAD LOCK GUN SPHERICAL ELECTRODE SHELL