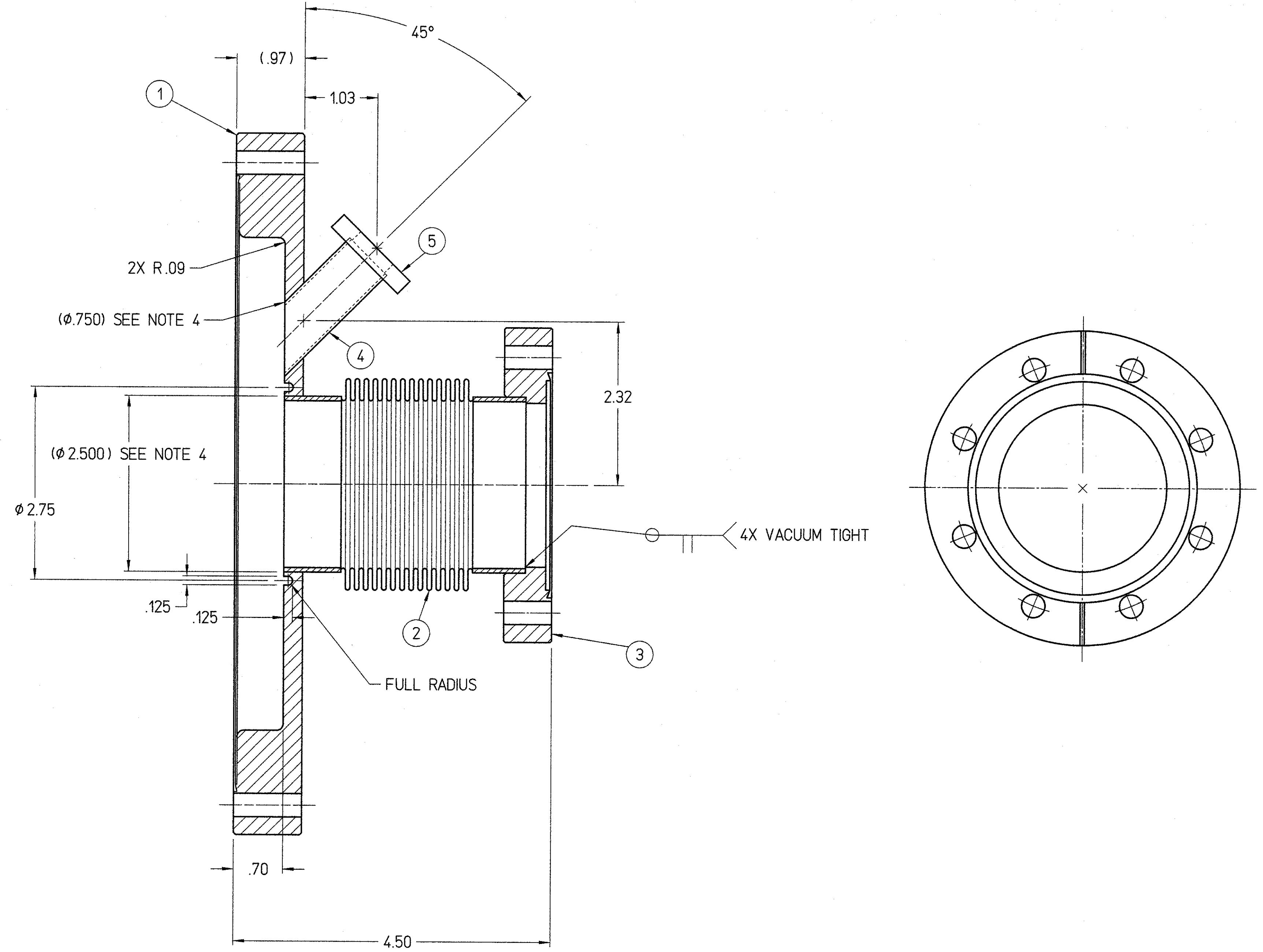
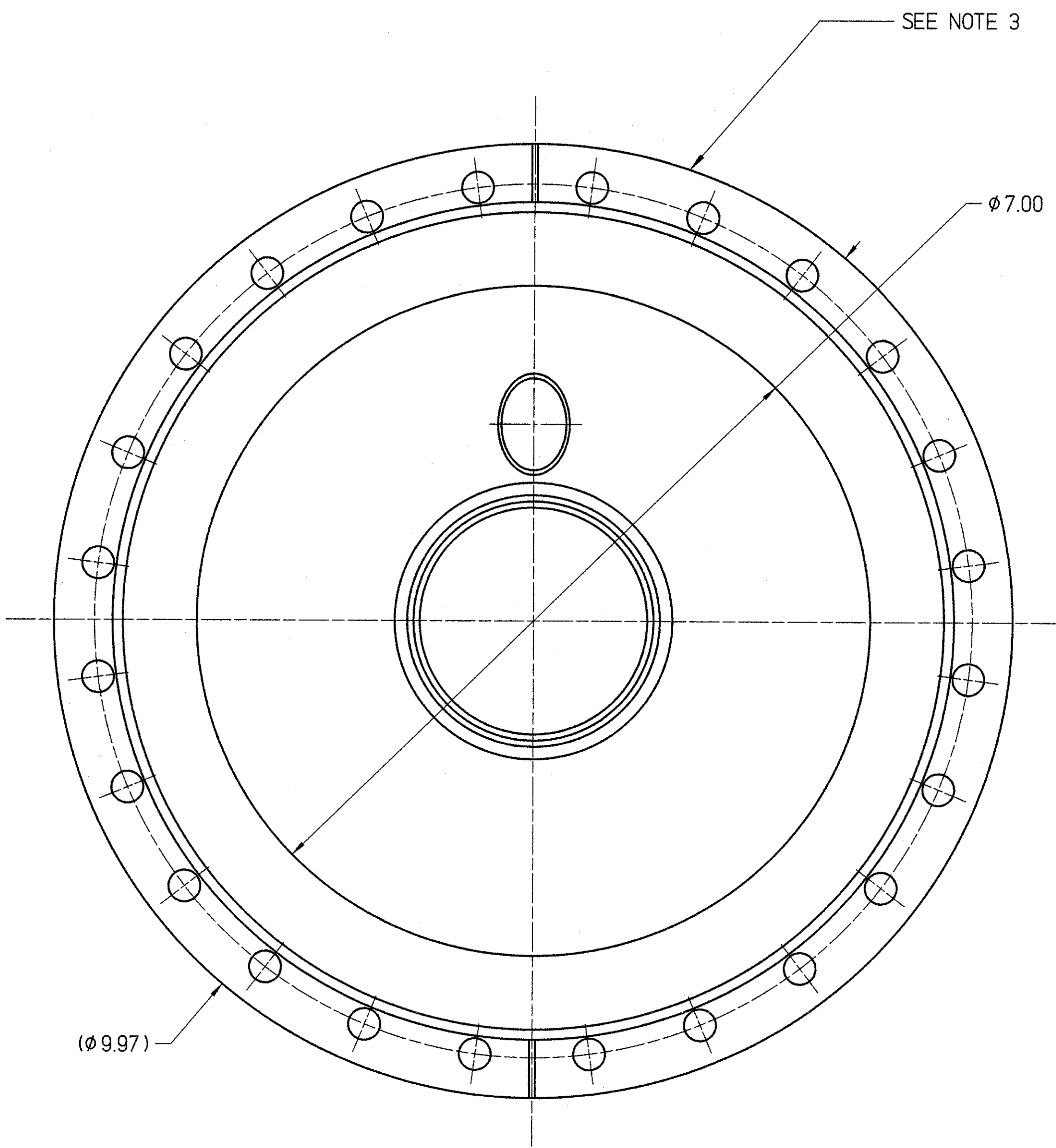


REVISION HISTORY				
ZONE	REV	DESCRIPTION	DATE	APPROVED



NOTES:

- USE THE FOLLOWING C.E.B.A.F. SPECIFICATIONS FABRICATION OF ULTRA HIGH VACUUM EQUIPMENT: #22631-S-001
CLEANING AND HANDLING OF U.H.V. COMPONENTS: #22632-S-001
WELDING SPECIFICATION FOR U.H.V. COMPONENTS: #22633-S-001
HELIUM LEAK TEST FOR U.H.V. COMPONENTS: #22634-S-001
CEBAF QA SPECIFICATION: #91790-200
STAINLESS STEEL FLANGES FOR UHV APPLICATIONS #23661-S-001
- ALL TOLERANCES APPLY AFTER WELDING.
- PART NUMBER TO BE ENGRAVED OR ETCHED IN LOCATION SHOWN USING MINIMUM .25 HIGH CHARACTERS.
- HOLES SHALL BE MATCH BORED TO SUIT TUBING.
- PROTECT FLANGE FACES DURING AND AFTER PROCESSING WITH SUITABLE PLASTIC CAPS. DAMAGE TO KNIFE EDGES IS UNACCEPTABLE.

QTY	ITEM NO.	PART OR IDENTIFYING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL SPECIFICATION	NOTES
1	5	K.J. LESKER CO. F0133N075TLN	FLANGE, 1.33 O.D., NON-ROTATABLE X .75 NOM I.D., TAPPED	STAINLESS STEEL TYPE 316LN	
1	4		TUBING, .75 O.D. X .035 WALL	STAINLESS STEEL TYPE 316L	
1	3	K.J. LESKER CO. F0450N250NLN	FLANGE, 4.50 O.D., NON-ROTATABLE X 2.50 NOM I.D.	STAINLESS STEEL TYPE 316LN	
1	2	ACC-200-3000-0335	H.V. CHAMBER BELLOWS		
1	1	K.J. LESKER CO. F1000N000NLN	FLANGE, 10 O.D., NON-ROTATABLE BLANK	STAINLESS STEEL TYPE 316LN	

DOCUMENT CONTROL STAMP 	DIM & TOL PER ASME Y14.5 UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: FRACTIONS DECIMAL ANGLES * * * * * XXX ± .005 * 50°		TRACKING NO. N/A	U.S. Department of Energy Office of Science Operated by Jefferson Science Associates, LLC
	MATERIAL SEE PARTS LIST	THIRD ANGLE PROJECTION 	APPROVALS DRAWN: D. MACHE CHECKED: <i>[Signature]</i> APPROVED: <i>[Signature]</i>	
FINISH MACHINED SURFACES 63 UNLESS OTHERWISE NOTED DEBURR & BREAK ALL SHARP EDGES	DO NOT SCALE DRAWING	ACC INJECTOR LOAD LOCK GUN H.V. CHAMBER U.S. FLANGE		REV. -
SIZE DWG. NO. ACC-200-3000-0336		SCALE 1:1		USED ON ASSY NO. ACC-200-3000-0300 SHEET 1 OF 1