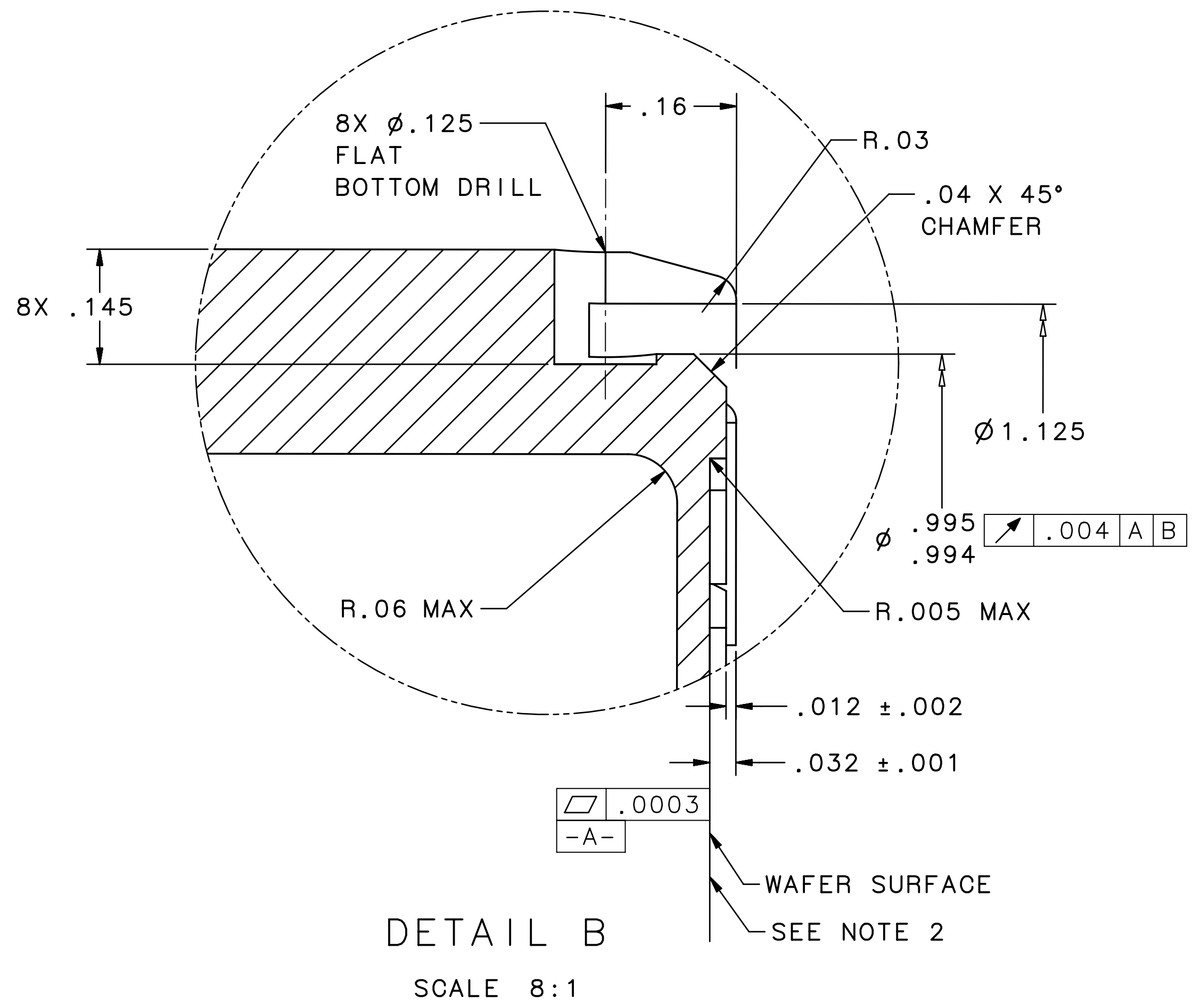
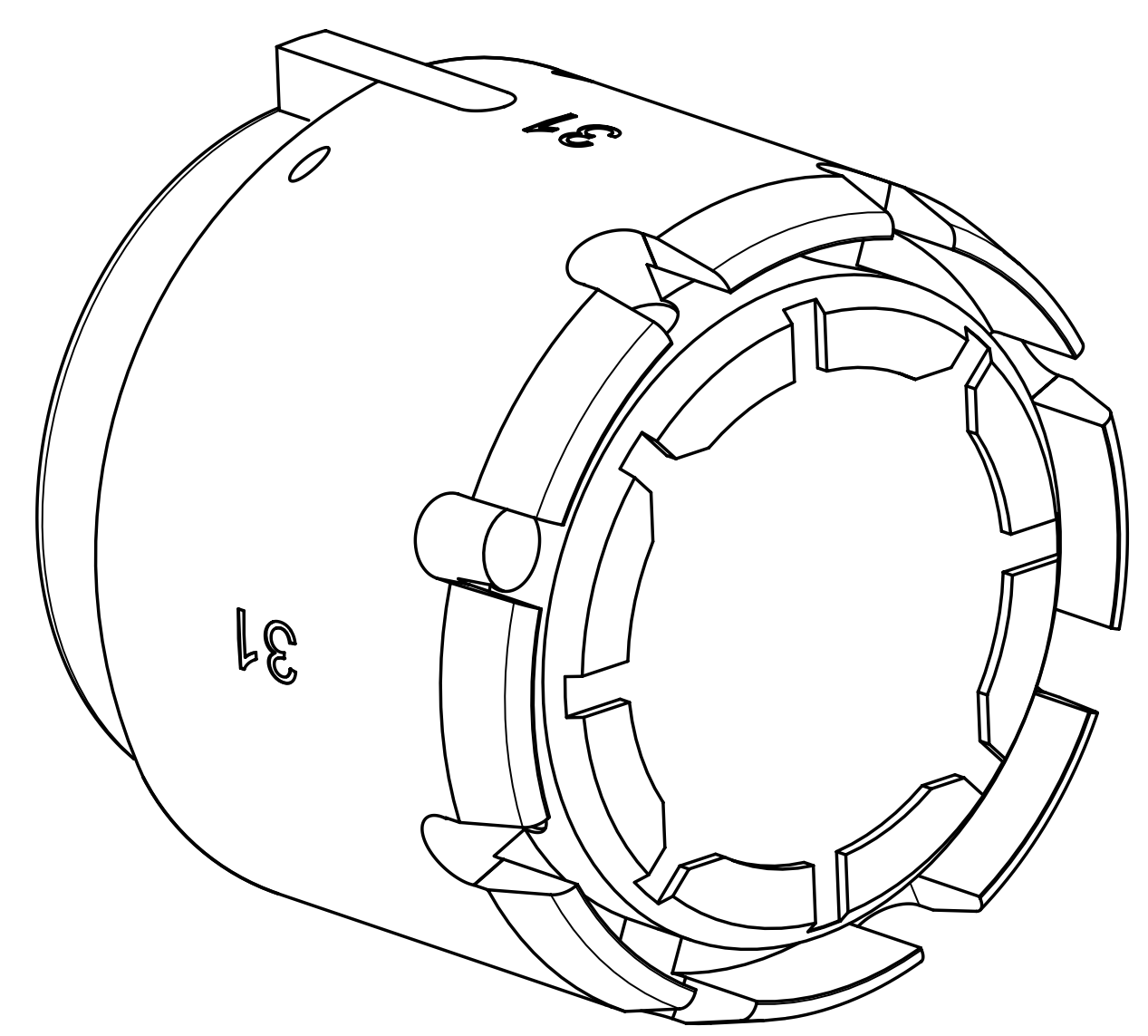


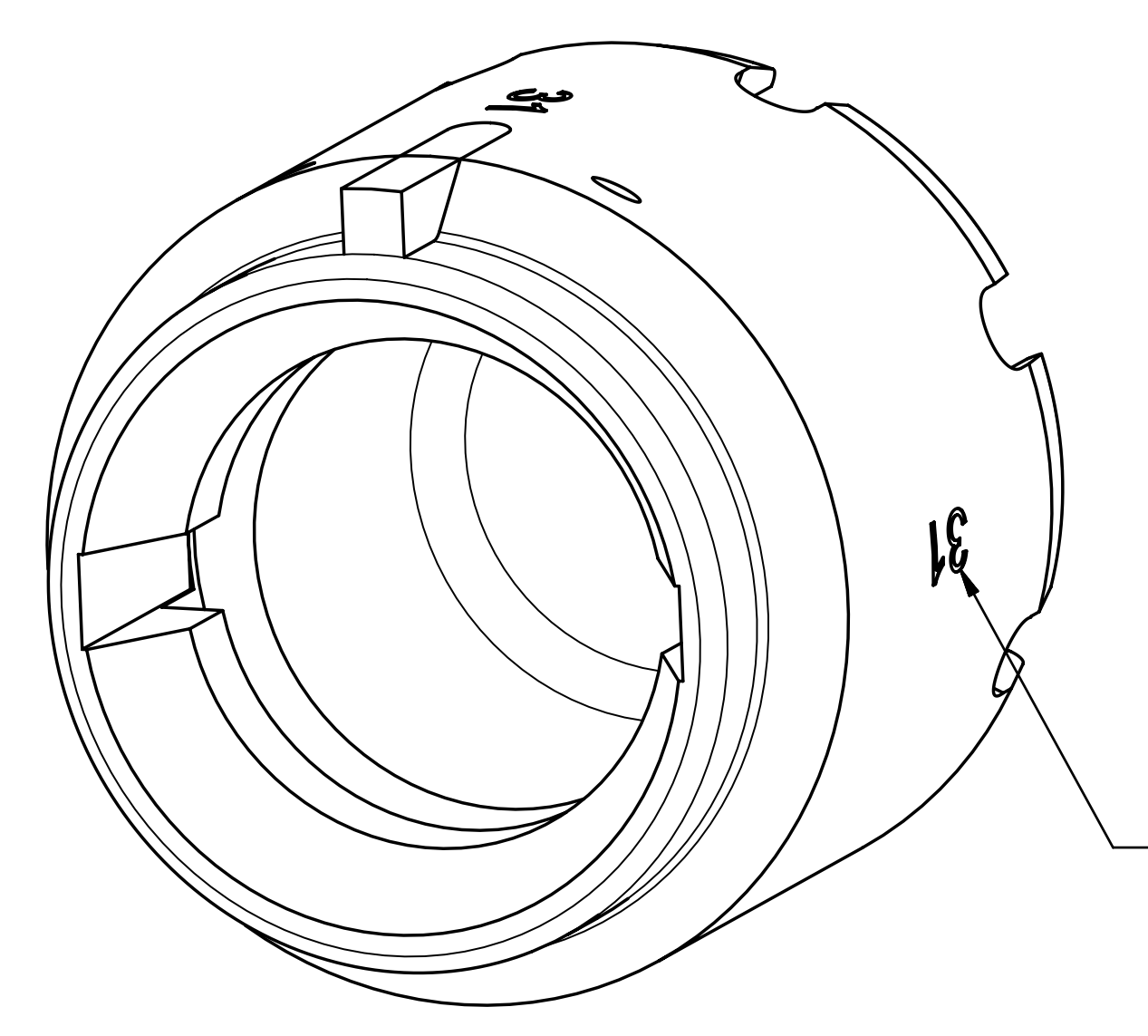
REVISION HISTORY				
ZONE	REV	DESCRIPTION	DATE	APPROVED
ALL	A	CHANGED OR UPDATED MULTIPLE DIMENSIONS	11/6/2017	D. MACHIE
			11/6/2017	M. POELKER



DETAIL B
SCALE 8:1

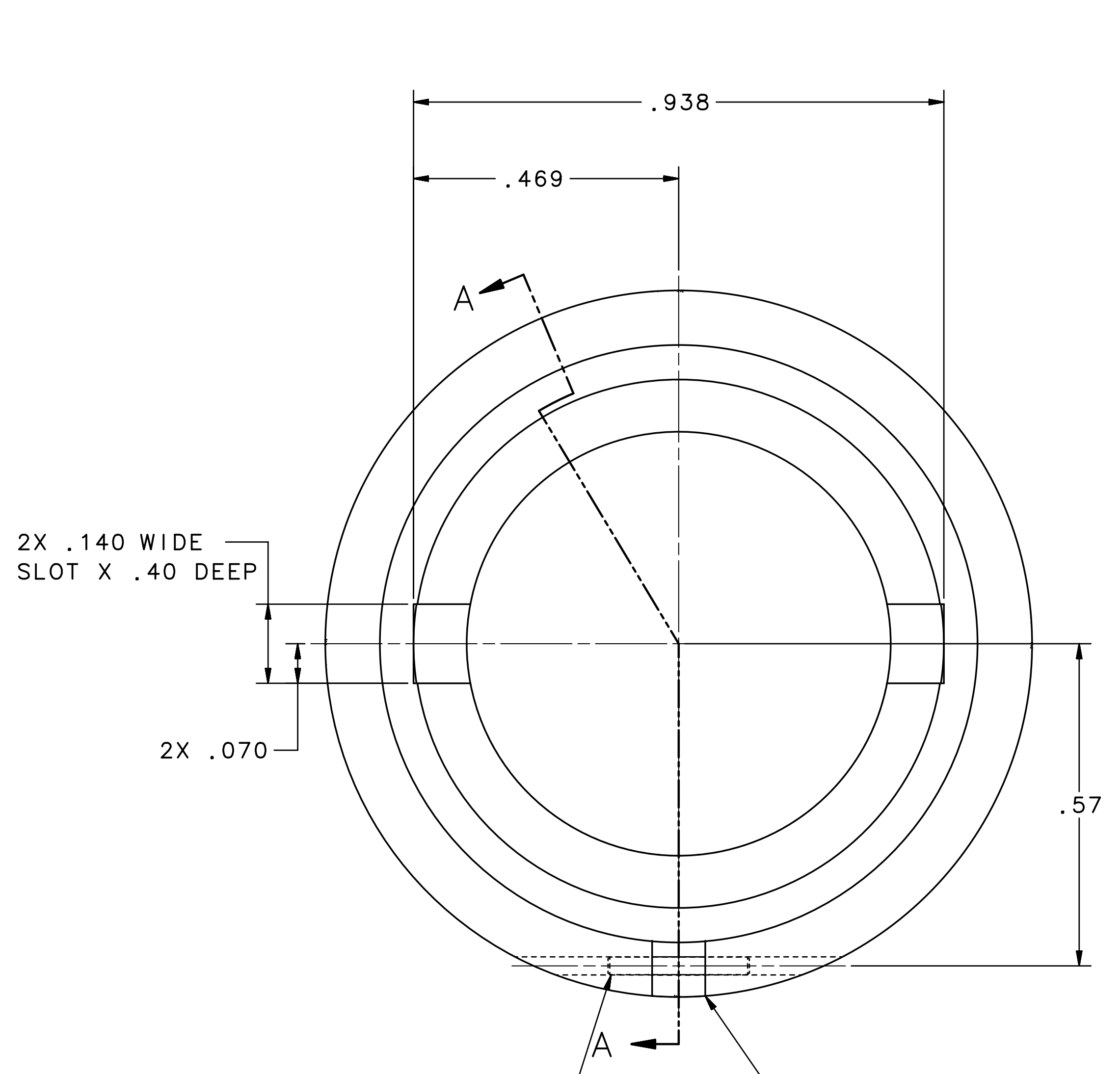


ISOMETRIC FRONT VIEW



ISOMETRIC BACK VIEW

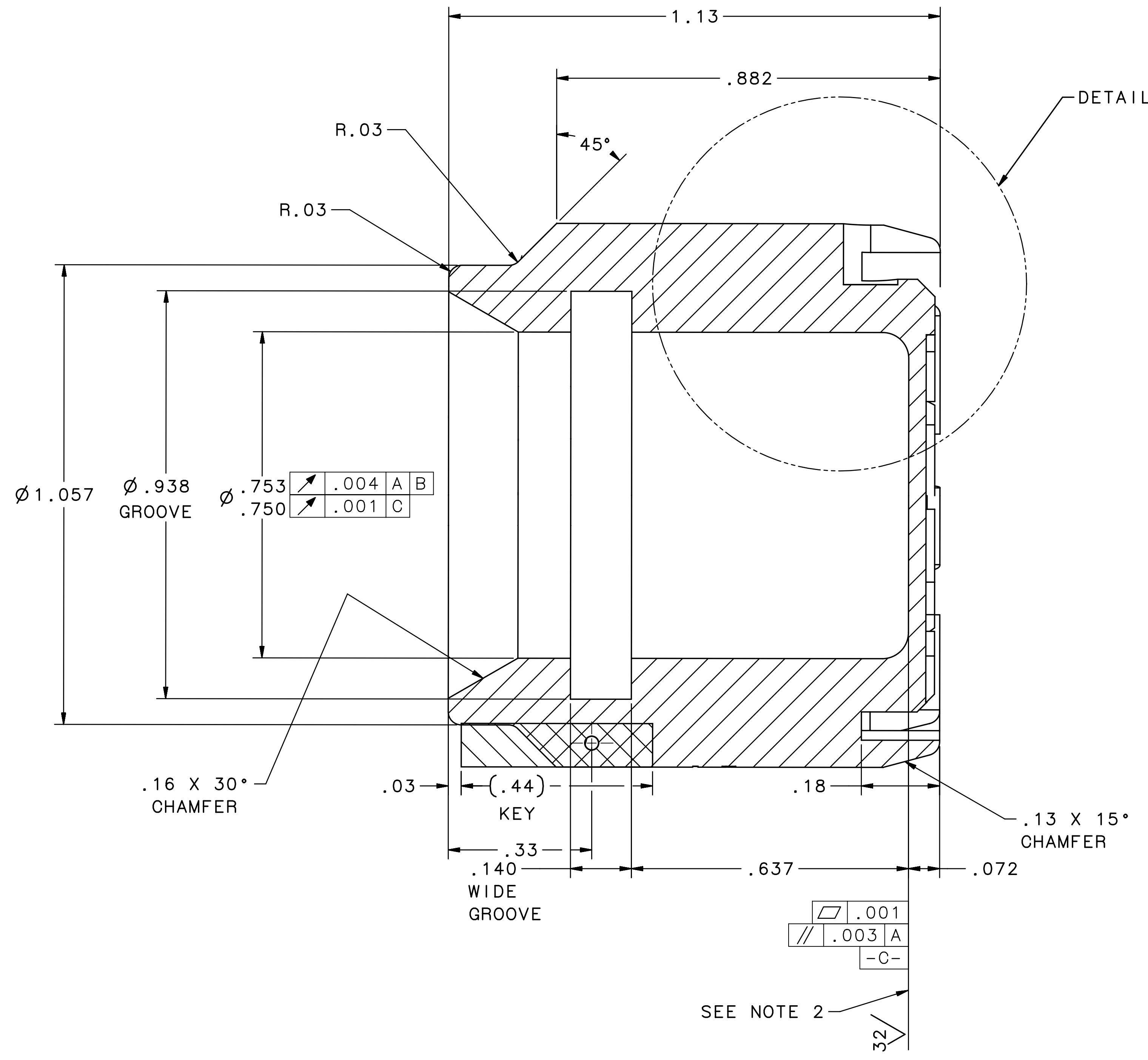
SEE NOTE 3



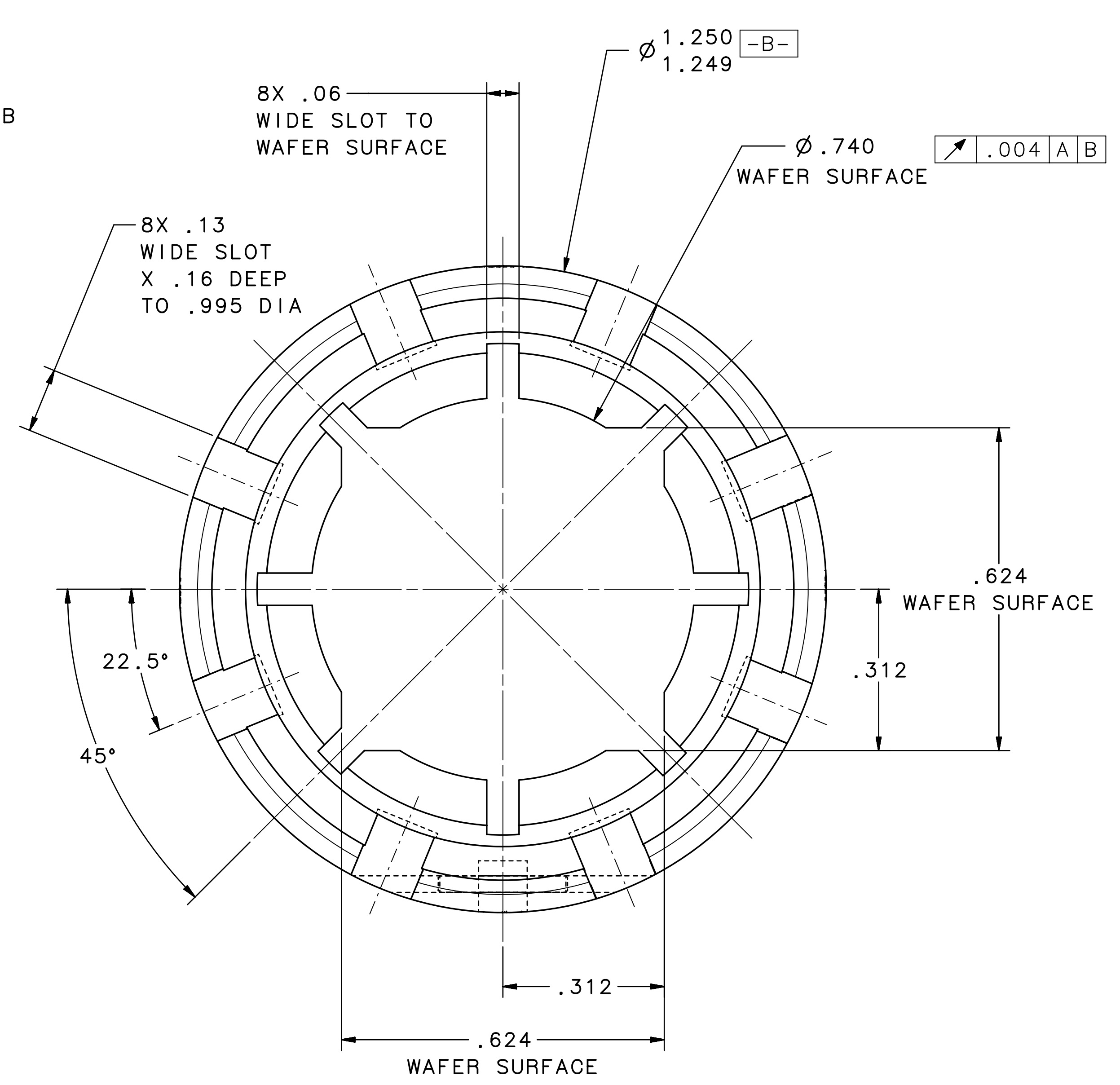
Ø .032 DOWEL PIN X .25 LONG. TYPE #316 STAINLESS STEEL.
DRILL AND REAM BODY AND KEY FOR PRESS FIT WITH DOWEL PIN

.094 X .094 KEY X .44 LONG. RADIUS ONE END. TYPE #316 STAINLESS STEEL
MACHINE BODY AND KEY FOR SLIP FIT TO EACH OTHER

VENDOR'S OPTION:
MACHINE EQUIVALENT CONFIGURATION ON OUTSIDE DIAMETER INTEGRAL WITH BODY.



SECTION A-A



NOTES:

- THIS IS AN ULTRA-HIGH VACUUM COMPONENT. THE FOLLOWING C.E.B.A.F. SPECIFICATIONS APPLY:
#22631-S-001 FABRICATION OF ULTRA-HIGH VACUUM EQUIPMENT
#22632-S-001 CLEANING AND HANDLING OF U.H.V. COMPONENTS
- BE SURE TO REMOVE ANY MATERIAL LEFT AT DEAD CENTER OF THE CROWN.
- SCRIBE OR ETCH CONSECUTIVE SERIAL NUMBER (#31 THROUGH #36) ON O.D. OF PUCK BODY, 4 PLACES EQUALLY SPACED
- MATERIAL CERTIFICATION REQUIRED
- FABRICATION SEQUENCE:
A. MACHINE PUCK, KEY AND DOWEL PIN.
B. TRIAL FIT-UP OF PUCK, KEY AND DOWEL PIN.
C. INITIAL CLEANING OF COMPONENTS (DO NOT ACID ETCH BEFORE KEY IS PINNED)
D. INSTALL KEY AND PIN INTO PUCK BODY.
E. ACID ETCH IN SOLUTION SUITABLE FOR MOLYBDENUM.
F. BAKE FOR 4 HOURS AT 900C IN VACUUM FURNACE.

EACH SHEET OF MULTI-SHEET DRAWINGS SHALL ALWAYS HAVE THE SAME REVISION LEVEL.				
DWG & TOL PER ASME Y14.5 UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ARE: FRACTIONS ±.001 DECIMAL ±.01 ANGLES ±.50°	MATERIAL ARC CAST MOLYBDENUM 99.95% PURE	United States Department of Energy Jefferson Lab Thomas Jefferson National Accelerator Facility Newport News Virginia	CEBAF INJECTOR 200keV GUN HIGH VOLTAGE GUN PUCK BODY	REV. A
THIRD ANGLE PROJECTION FINISH MACHINED SURFACES DEBUR & BREAK ALL SHARP EDGES DO NOT SCALE DRAWING	SCALE 6:1	DATE 15 MAY 17	SIZE DWG. NO. JL0047248	SHEET 1 OF 1
DRAWN K. HARDING	DATE 15 MAY 17	SCALE 6:1	REV. A	SHEET 1 OF 1