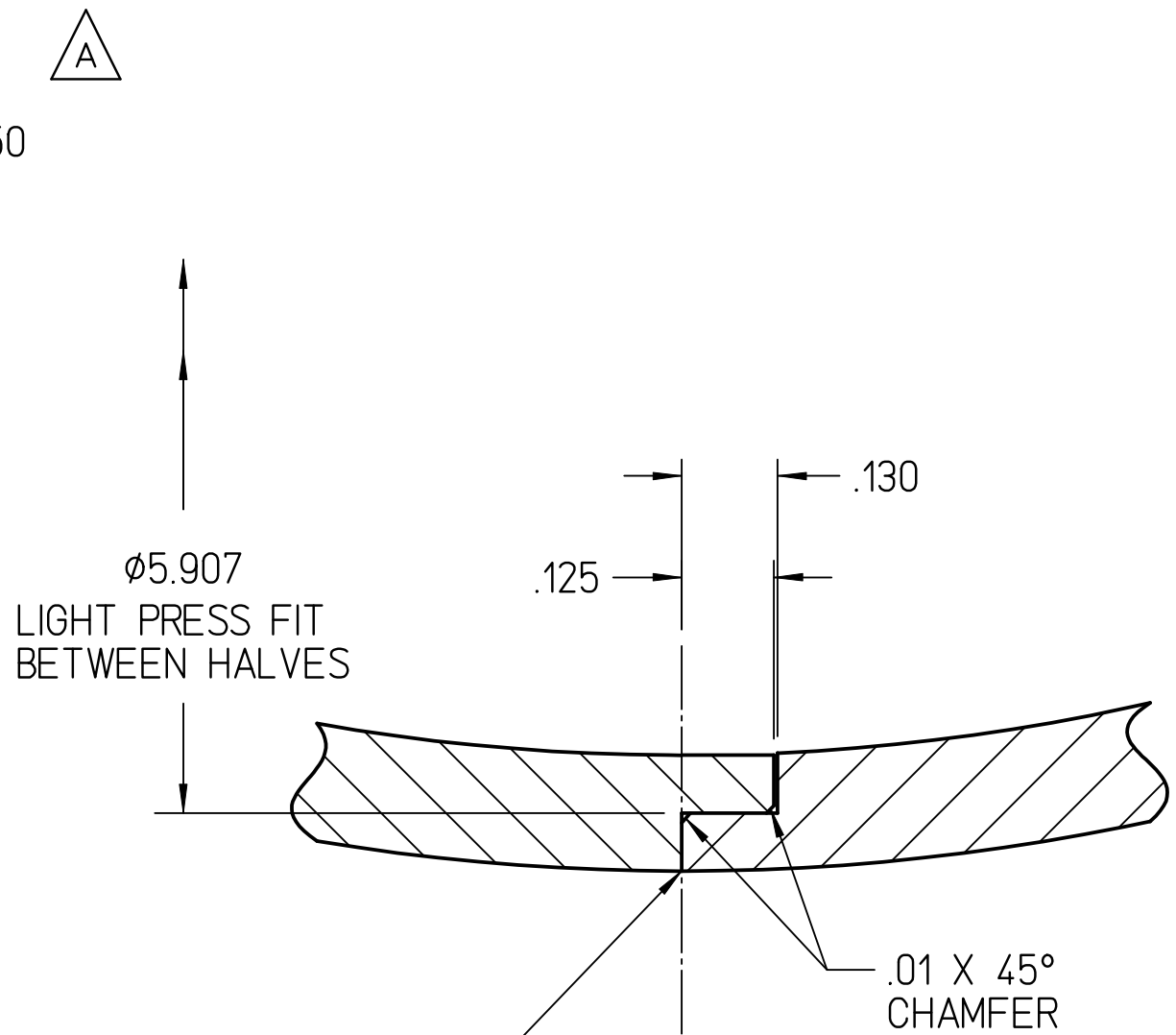
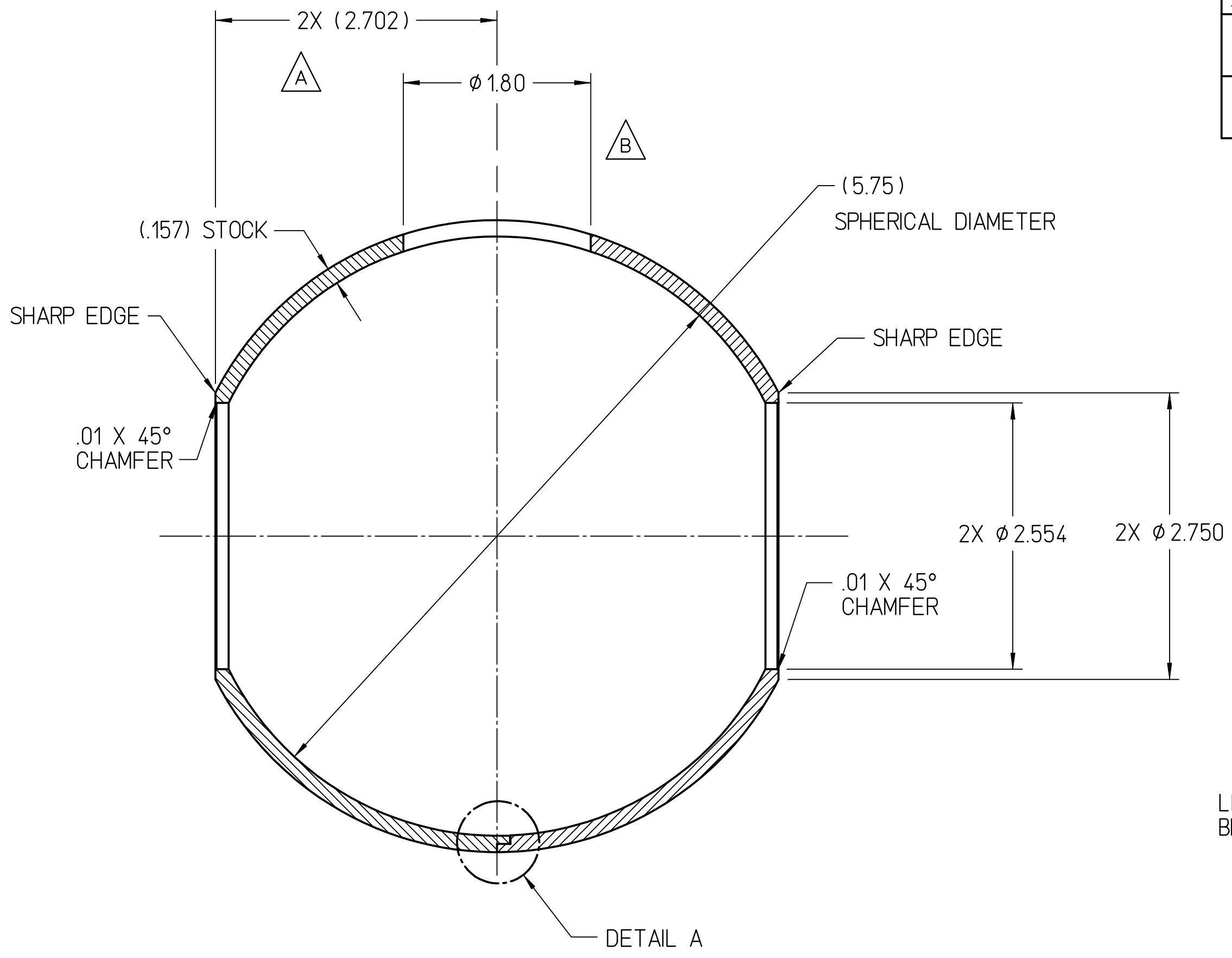


4 3 2 1

REVISION HISTORY				
ZONE	REV	DESCRIPTION	DATE	APPROVED
ALL	A	2X $\phi$ 2.750 WAS 2X $\phi$ 2.626. DM 3/12/12	3/12/12	B.M.P. J.H.
3D	B	$\phi$ 1.80 WAS $\phi$ 1.250, DELETED R .09. DM 9/02/14	9/02/14	B.M.P. J.H.



**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
<b>PARTS LIST</b>					
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				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	
<b>DO NOT SCALE DRAWING</b>				U.S. Department of Energy Office of Science <b>Jefferson Lab</b> Thomas Jefferson National Accelerator Facility Operated by Jefferson Science Associates, LLC	
				ACC INJECTOR LOAD LOCK GUN SPHERICAL ELECTRODE SHELL	
				SIZE DWG. NO. REV. <b>C</b> ACC-200-3000-0460 <b>B</b>	
				SCALE 1:1 USED ON ASSY NO. ACC-200-3000-0464 SHEET 1 OF 1	

4 3 2 1 Me10