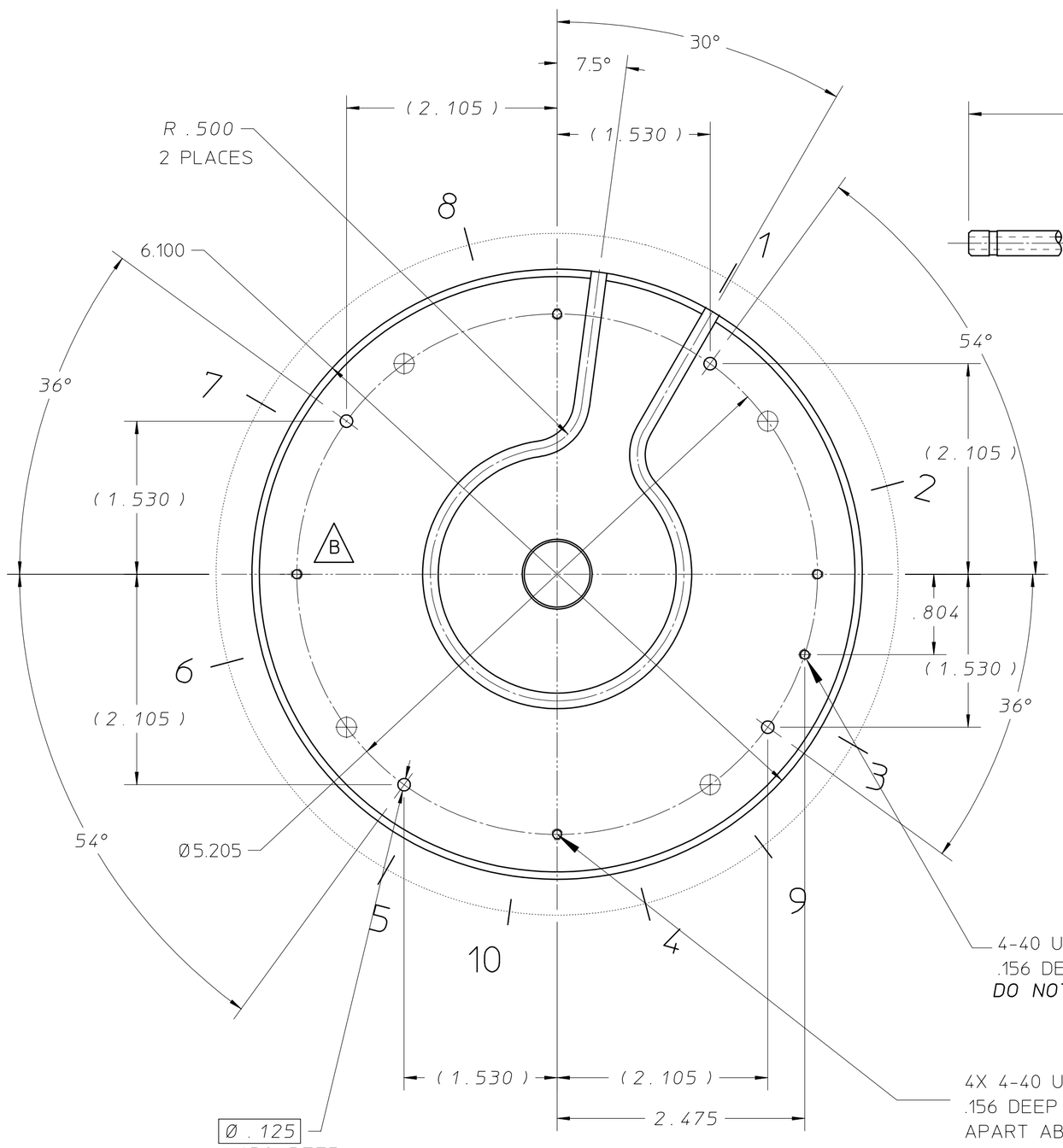
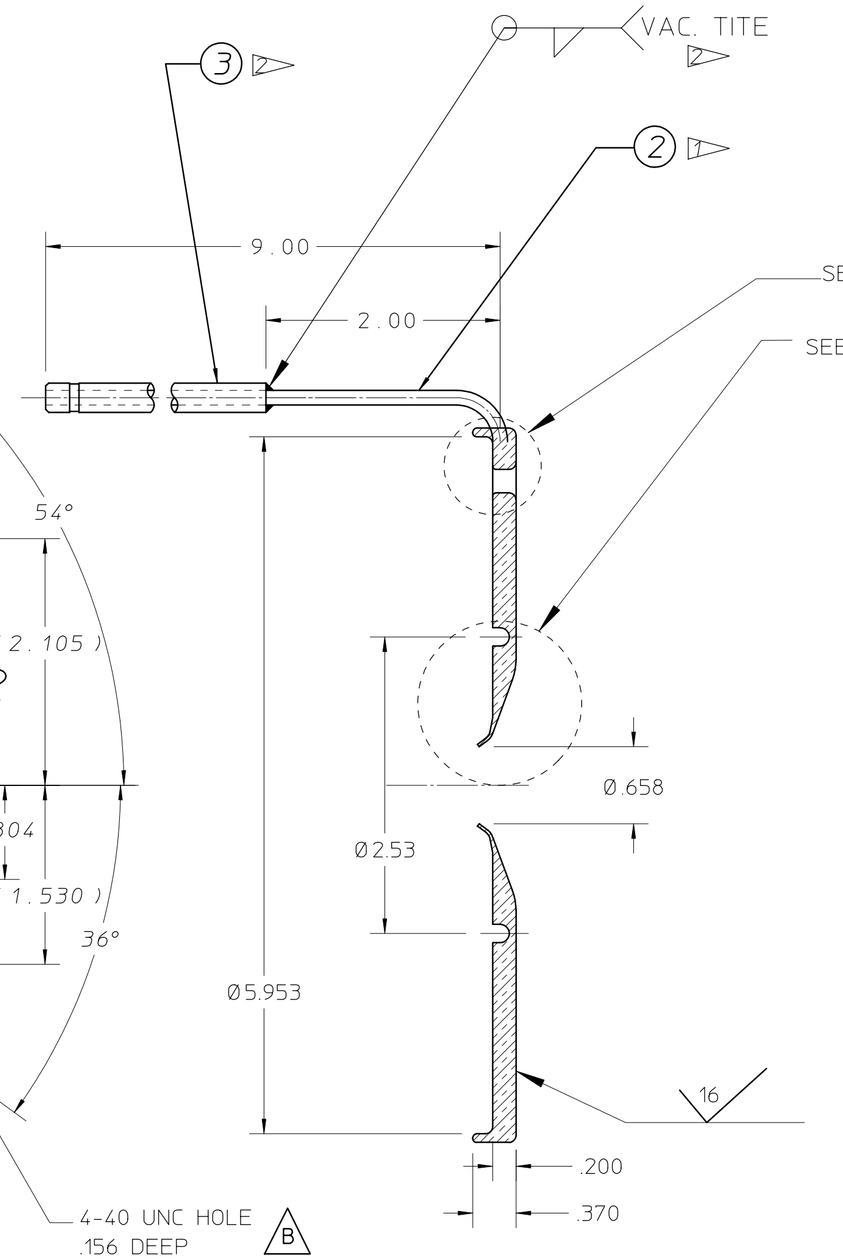
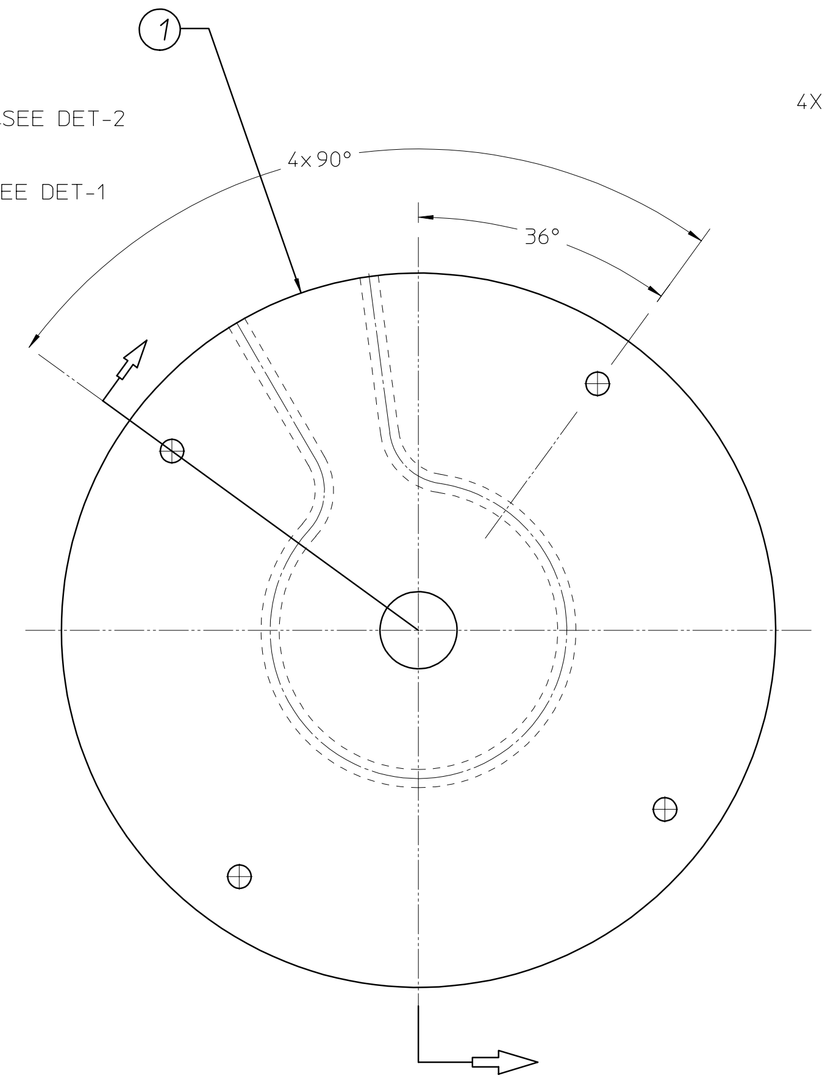
REQ	ITEM	PART NUMBER	DESCRIPTION
1	1	-	OFHC COPPER
A/R	2	-	TUBING, STAINLESS, Ø.125 X .030 WALL
2	3	21G7711-2	LEGRIS WATER FITTING PREP, LONG, CUT TO 7.0 LONG

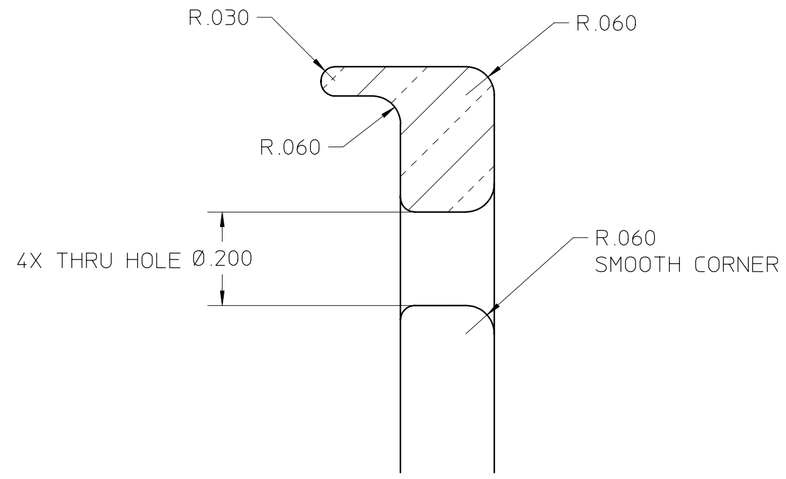




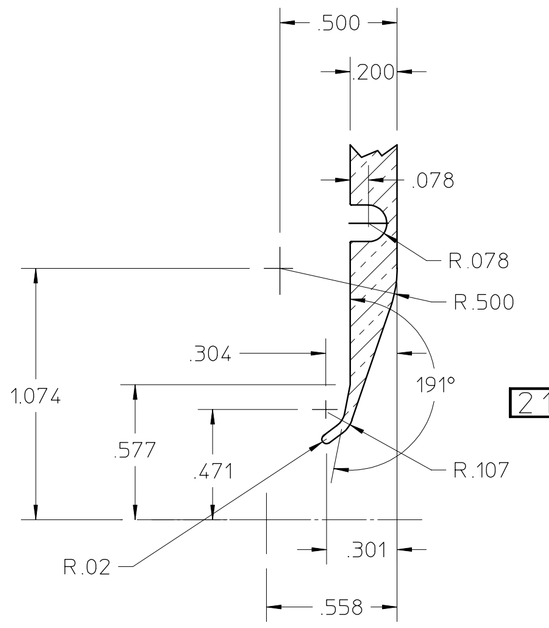


ADDITIONAL NOTES:

1. ITEM 2 SHALL BE SOLDER BRAZED INTO THE SLOT OF ITEM 1 AFTER MACHINING IS COMPLETE.
2. ITEM 3 SHALL BE WELDED TO ITEM 2 AFTER THE SOLDER BRAZE OPERATION.



DETAIL-2
(SIZE 2X)



21C8924C

DETAIL -1
(SIZE 2X)

REV	DWG	CHK	ZONE	DATE	CHANGES
C	DWC			9/01	ADDED ITEMS 2 AND 3 AND RELATED NOTES
B	DWC			8/01	CHANGED MATERIAL FROM GLIDCOP TO OFHC
B	DWC		B6	8/01	ADDED 4-40 HOLE
B	DWC		B8	8/01	ADDED .125 DIAMETER HOLE PATTERN
B	DWC		C8	8/01	ROTATED 4-40 HOLE BACK TO HORIZ.
A	DWC		C8	4/3/00	ROTATED 4-40 HOLE 22.5° FROM HORIZ.

UNLESS OTHERWISE SPECIFIED

TOLERANCES: .X ± .1 FRAC. ± 1/64; .XX ± .01 ANGLES ± 1°; .XXX ± .005 FINISH 125

THREADS ARE CLASS 2
CHAMFER ENDS OF ALL SCREW THREADS 30°.
CUT 1.5 PITCH THRD RELIEF WITH ROUND NOSE TOOL ON MACHINE CUT THREADS.
BREAK EDGES .016 MAX. ON MACHINED WORK.
REMOVE BURRS WELD SPLATTER & LOOSE SCALE
REFERENCES: ANSI Y14.5 & B46.1.

SHOP ORDERS

ACCT. NO. | SERIAL NO.
DATE ISSD | DATE REQD. | NO. REQD.
DELIVER TO
SURFACE TREATMENT: DEGREASE
IDENT. METH.: TAG
DWG. BY: S. MUKHERJEE DATE: 04-20-99
CHK. BY: D. CHENG DATE: 5/10/99

LAWRENCE BERKELEY LABORATORY
UNIVERSITY OF CALIFORNIA-BERKELEY

SNS - FRONT END SYSTEM
ION SOURCE PROTOTYPE DESIGN
ELECTRON DUMP ELECTRODE

PATENT CLEAR	DWG. TYPE	SHOWN ON	SCALE	DO NOT SCALE PRINTS
	PART	21C8934	FULL	
MICROFILMED	DESIGN ACCT. NO	CATEGORY CODE	DWG. NO.	SIZE / REV.
	8210-14	FE1100	21C8924	C