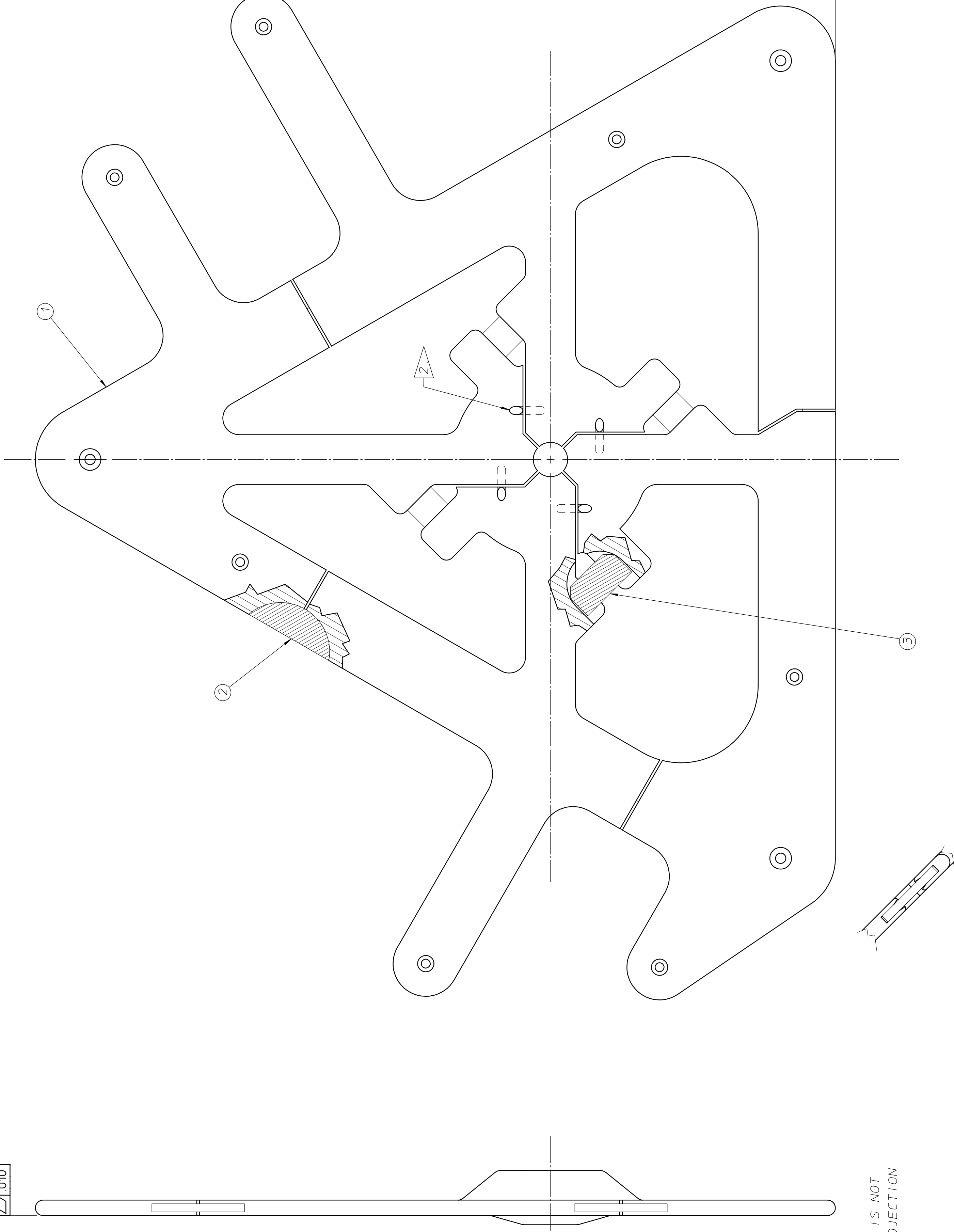


- ADDITIONAL NOTES:
- PART SHALL NOT HAVE ANY SHARP EDGES, EXCEPT WHERE INDICATED. BREAK ALL OTHER EDGES TO .030"
 - THE FOUR SEGMENTS OF ITEM ① ARE TO BE SET ON BLOCKS AND ALIGNED WITH A #39 (Ø.995) DRILL ROD SET IN TO THE PIN HOLES.
 - ITEMS ② AND ③ SHALL BE JOINED TO ITEM ① USING EPON/VERSAMID EPOXY.
 - PRIOR TO JOINING, EPOXY MUST BE VACUUM PUMPED TO REMOVE GAS CONTENT. REFER TO ENG. NOTE M8000 TITLED, "PREPARING EPON-VERSAMID EPOXY FOR VACUUM SERVICE."
 - WET ALL CONTACT SURFACES OF THE CERAMIC (ITEMS ② AND ③), AS WELL AS THE INSIDE SURFACES OF ITEM ① PRIOR TO INSERTION.
 - REMOVE ALL EXCESS EPOXY FROM THE JOINTS AFTER ASSEMBLY.
 - ALLOW TO CURE FOR 24 HOURS BEFORE REMOVING FROM BLOCKING FIXTURE.

-A-
1.010



THIS VIEW IS NOT
A TRUE PROJECTION

REQ	ITEM	PART NUMBER	DESCRIPTION
1	1	2167106	CHOPPER ELECTRODE SECOND MACHINING
4	2	2167362	CERAMIC STANDOFF KEY, ROUND
4	3	2167372	CERAMIC STANDOFF KEY, RECTANGULAR

-B-
0.005 A

2167114A

UNLESS OTHERWISE SPECIFIED		SHOP ORDERS	
X ± .1	FRAC ± 1/64	ACCT. DATE	SERIAL NO.
XX ± .01	ANGLES ± 1°	DELIVER TO	NO. RECD.
XXX ± .001	FINISH 125.7	SURFACE TREATMENT	
CHAMFER ENDS OF ALL SCREW THREADS 30°		DEGREASE	
ALL PARTS TO BE REFINISHED		TAG	
BREAK EDGES .016 MAX. ON MACHINED WORK		DATE 6-9-99	
REMOVE BURRS WELD SPATTER & LOOSE SCALE		BY D. CHENG	
REFERENCES: ANSI Y14.5 & B46.1		CHK. DATE	

LAWRENCE BERKELEY LABORATORY			
UNIVERSITY OF CALIFORNIA-BERKELEY			
SNS-FES ION SOURCE AND LEFT			
MECHANICAL SYSTEMS			
PATENT CLEAR	DMG. TYPE	SHOWN ON SCALE	DD NOT SCALE PRINTS
ASSEMBLY	2167356	FULL	2167114
DESIGN ACCT. NO.	8210-14	FE3111	2167114
REV.	1		A

8 7 6 5 4 3 2 1 A