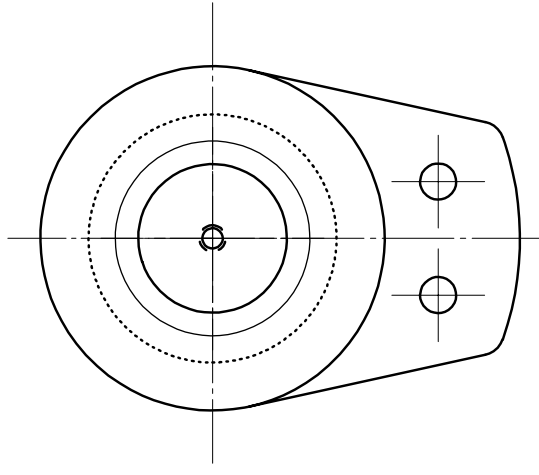
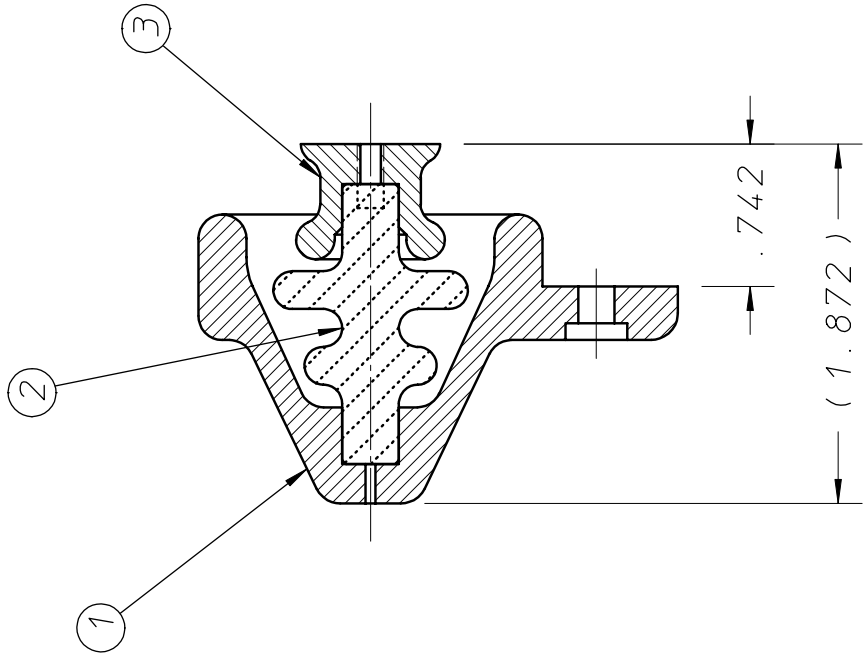
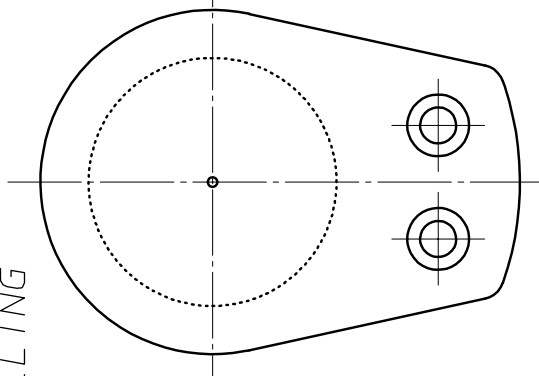


ADDITIONAL NOTES:

- PART (2) IS TO BE JOINED TO PARTS (1) AND (3) USING EPON/VERSAMID EPOXY.
- PRIOR TO JOINING, EPOXY MUST BE VACUUM PUMPED TO REDUCE THE GAS CONTENT. SEE ENGINEERING NOTE M8000, TITLED, "PREPARING EPON-VERSAMID EPOXY FOR VACUUM SERVICE".
- AFTER CURING, ENSURE THAT NO TRAPPED VOLUMES ARE LEFT IN THE JOINT BY DRILLING VENT HOLES, AND CHASING WITH A TAP IF NECESSARY.



REQD	ITEM	PART NUMBER	DESCRIPTION
1	1	21G7123	GROUND-CHOPPER INSULATOR SHIELD, OUTER
1	2	21G7131	GROUND-CHOPPER INSULATOR STANDOFF
1	3	21G7142	GROUND-CHOPPER INSULATOR SHIELD, INNER

UNLESS OTHERWISE SPECIFIED	SHOP ORDERS		LAWRENCE BERKELEY LABORATORY	
TOLERANCE .X ± .1 .XX ± .01 .XXX ± .010	ACCT NO	SER NO	UNIVERSITY OF CALIFORNIA-BERKELEY	
SURFACE FINISH 125 ✓	DATE RECD	NO RECD	SNS-FES ION SOURCE AND LEFT MECHANICAL SYSTEMS	
1. SAWED, FLAMECUT, SHEARED OR CUT STOCK FINISH.	SURFACE TREATMENT		GROUND-CHOPPER INSULATOR ASSEMBLY	
2. THREADS CLASS 2.	DEGREASE		PAT CLEAR	DWG TYPE SHOWN ON SCALE: FULL
3. CHAMFER ENDS OF ALL SCREW THRDS 30°.	IDENTIFIC TAG		DETAIL	21G7116
4. 1 1/2 PITCH RELIEF WITH ROUND NOSE TOOL ON ALL MACHINE CUT THRDS.	BY	DATE	MICROFILMED	DESIGN ACCT NO CATEGORY CODE DWG NO REV
5. BREAK EDGES 1/64 MAX. ON MACHINE WORK.	D. CHENG	5-20-99		8210-14 FE3111 21G7252A
6. REMOVE BURRS, LOOSE SCALE AND WELD SPLATTER.	CHK BY	DATE		
7. REF.-USASI OR ASA STDS SECT Y-14 & B46-1.				
A	DWC	9/15/01	ADDED REFERENCE TO ENG. NOTE M8000 TO NOTE 2.	
REV	DWN	CHK	DATE	DESCRIPTION