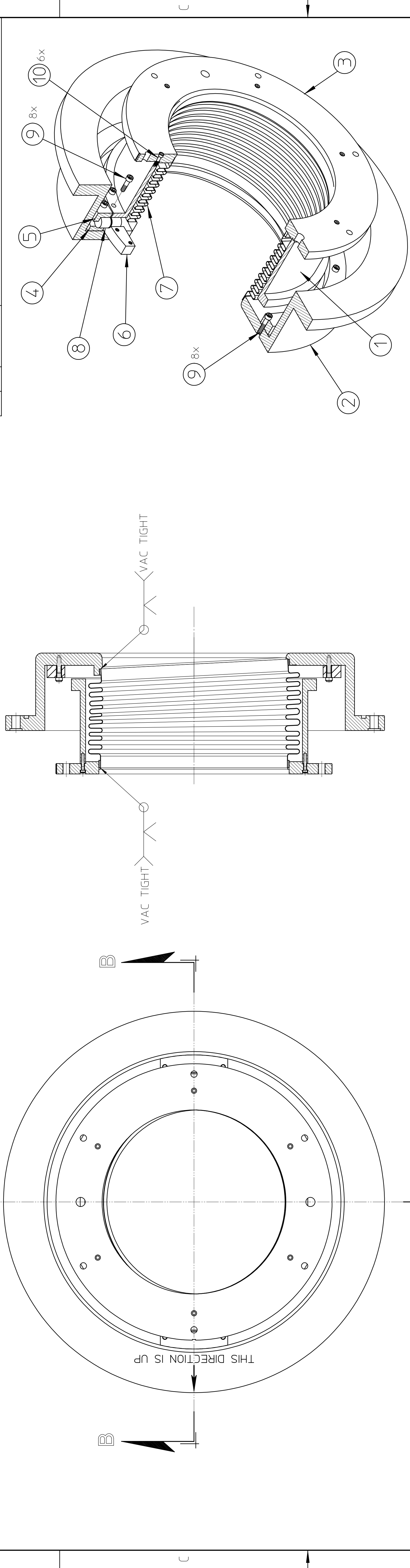


8 7 6 5 4 3 2 1

REQ	ITEM	PART NUMBER	DESCRIPTION
1	1	21C9836	SUPPORT CYLINDER
1	2	21C9826	BELLOWS FIXED FLANGE
1	3	21C9814	BELLOWS FLANGE
1	4	21C9844	PIN RETAINER RING
2	5	21C9852	PILLOW BLOCK OUTER
2	6	21C9862	PILLOW BLOCK INNER
1	7	7500SP-55095	FORMED METAL BELLOWS 7.5" IDx4.23" OAL 321 SST BELLOWS WITH 304 SST COLLAR 'HYPAN PRECISION PRODUCTS INC'
2	8	5016-600	FLEX PIVOT PIN 1/2"DIA *R P LUCE & CO INC*
16	9		CAPSCREW SOC HD #8-32UNCx3/4 STL CAD PL
6	10		CAPSCREW SOC HD #4-40UNCx3/8 STL CAD PL
A/R	11		LOC-TITE



SECTION A - A

NOTES: (UNLESS OTHERWISE SPECIFIED)
THE FOLLOWINGS STEPS SHALL BE FOLLOWED TO ASSEMBLE ALL PARTS:

1. ASSEMBLE ITEMS 4,8,5 & 9. USE LOC-TITE TO SECURE ITEM 9.
2. PERFORM CMM ALIGNMENT OF ITEM 4 WITH RESPECT TO ITEM 2. APPLY LOC-TITE TO ITEM 9 WHEN POSITION IS FIXED.
3. LEVEL ITEM 1 ON FLEX PIVOTS AND PERFORM CMM ALIGNMENT TO ENSURE CONCENTRICITY OF ITEM 1 WITH RESPECT TO ITEM 2. APPLY LOC-TITE TO ITEM 9 PRIOR TO TIGHTENING DOWN ITEM 6.
4. WELD ITEM 3 AND 7.
5. MOUNT WELDED BELLOWS ASSEMBLY ONTO ITEM 1 MAKING SURE THAT ITS ORIENTATION IS CORRECT (SEE NOTCH). APPLY LOC-TITE TO ITEM 10.
6. WELD ITEM 7 TO ITEM 2.

21G7584

SECTION B - B

A

UNLESS OTHERWISE SPECIFIED		SHOP ORDERS	
SIZE	FRAC ±	ACCT.	SERIAL
.XX ±	ANGLES ±	DATE	NO.
.XXX ±	FINISH 125/7	RECD.	RECD.
THREADS ARE CLASS 2	DELIVER TO		
CHAMFER ENDS OF ALL SCREW THREADS 30°	SURFACE TREATMENT DEGREASE		
DRILL POINTS TO BE FULLY RELIEF	IDENT. TAG		
BREAK EDGES .016 MAX. ON MACHINED WORK	DWG. RAY LOW	DATE	SCALE
REMOVE BURRS WELD SPATTER & LOOSE SCALE	BY	07-14-00	1/2
REFERENCES: ANSI Y14.5 & B46.1	BY: DAN CHENG	07-14-00	2
	CHANGES		

LAWRENCE BERKELEY LABORATORY	
UNIVERSITY OF CALIFORNIA-BERKELEY	
ION BEAM TECHNOLOGY	
SNS-FES ION SOURCE AND LEPT STRUCTURE	
ION SOURCE BELLOWS ADJUSTMENT ASSEMBLY	
PATENT CLEAR	DWG. TYPE SHOWN ON SCALE HALF
ASSEMBLY 21G5776	DWG. NO. 21G7584
DESIGN ACT. NO. 8212-AC	FE3111
REV.	SIZE
1	1

8 7 6 5 4 3 2 1