



REQ	ITEM	PART NUMBER	DESCRIPTION
1	1	21G8084	VIEWPORT/FEEDTHRU FLANGE, MACHINING
1	2	21G8113	MODIFIED NW160 FLANGE
1	3	-	TUBING, 5.000" X .125" WALL, 1.25' LONG, STAINLESS STEEL 304
2	4	-	TUBING, 4.000" X .083" WALL, 2.22' LONG, STAINLESS TYPE 304
2	5	21G8093	FEEDTHRU FLANGE MACHINING

21G8104

UNLESS OTHERWISE SPECIFIED		SHOP ORDERS	
X ± .1	FRACTION ± 1/64	ACT 8212-CT	SERIAL NO.
XX ± .01	ANGLES ± 1°	DATE	ISSUED
XXX ± .005	FINISH 64-7	DELIVER TO	RECORD
TOLERANCES		SURFACE TREATMENT	
THREADS ARE CLASS 2		DEGREASE	
CHAMFER ENDS OF ALL SCREW THREADS 30°		IDENTIFY PARTS	
ALL PARTS TO BE IDENTIFIED		METH.	
BREAK EDGES .016 MAX. ON MACHINED WORK		DATE	
REMOVE BURRS WELD SPATTER & LOOSE SCALE		BY	
REFERENCES: ANSI Y14.5 & B46.1		CHK.	
REV. DWG. CHK. ZONE DATE		DATE	

LAWRENCE BERKELEY LABORATORY	
UNIVERSITY OF CALIFORNIA-BERKELEY	
SNS-FES ION SOURCE AND LEFT	
MECHANICAL SYSTEMS	
VIEWPORT/FEEDTHRU FLANGE WELDMENT	
ASSEMBLY	
SCALE FULL	
DESIGN ACT. NO. FE3111	
REV. NO. 21G8104	

REV. DWG. CHK. ZONE DATE