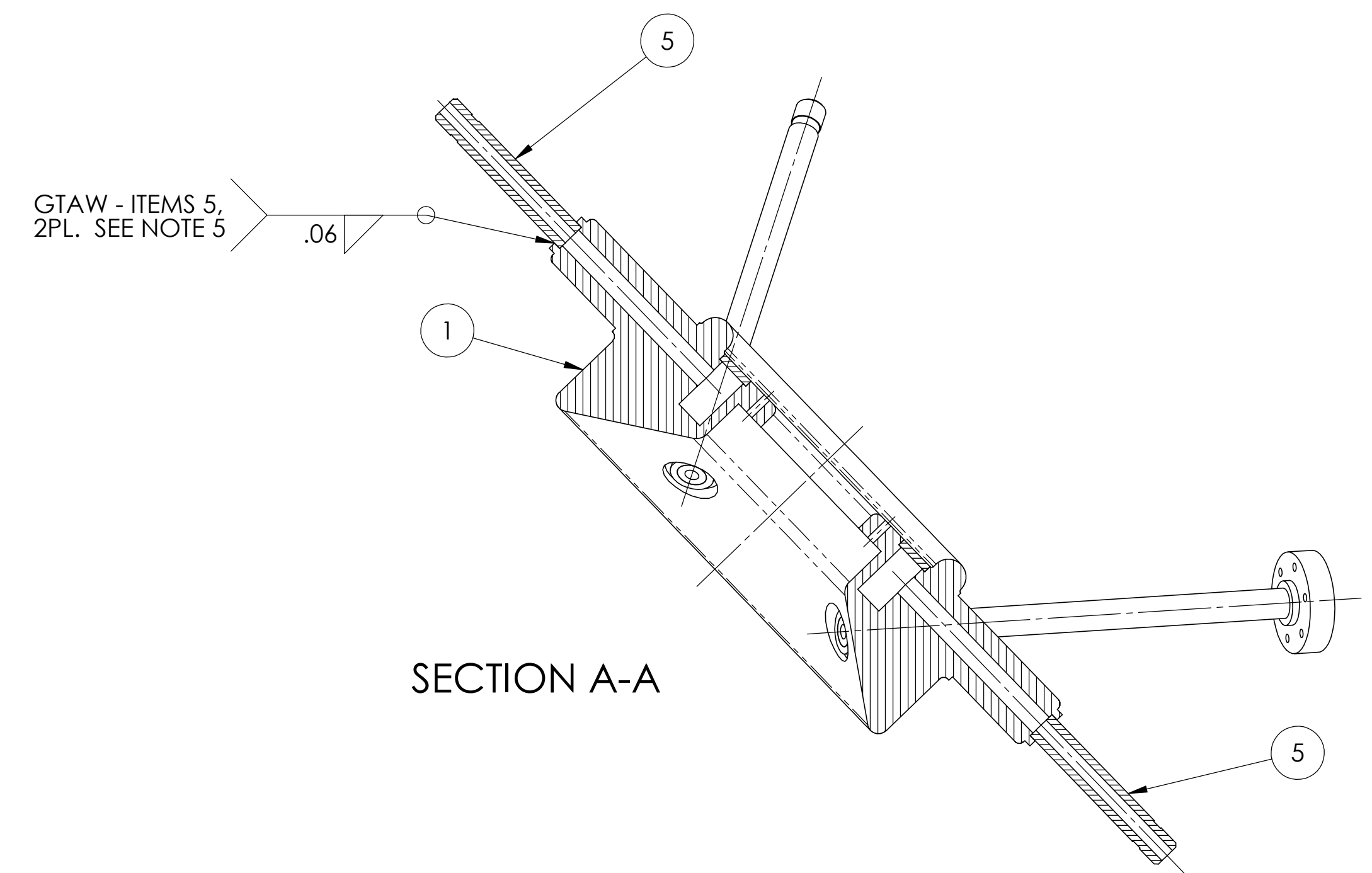
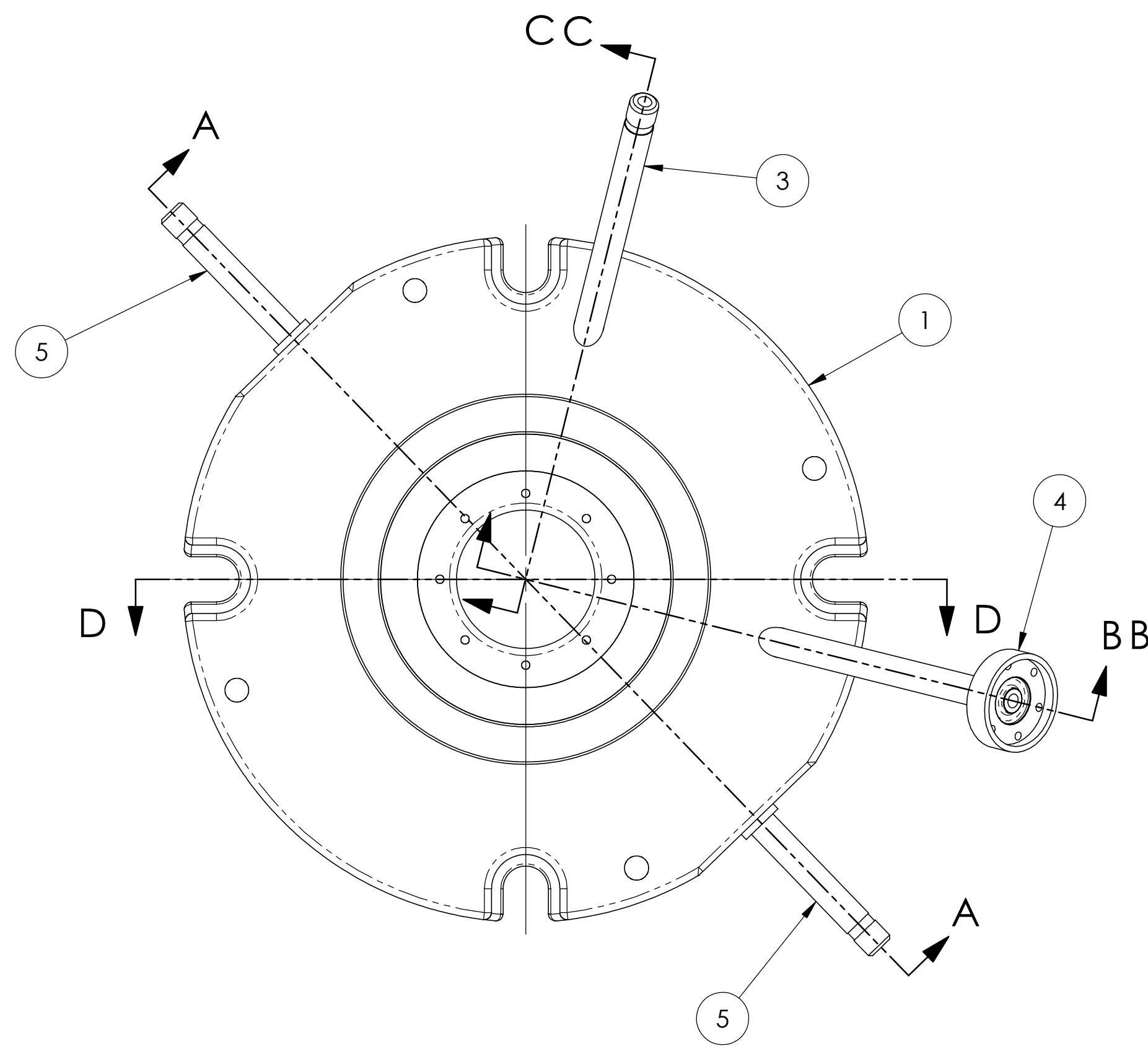
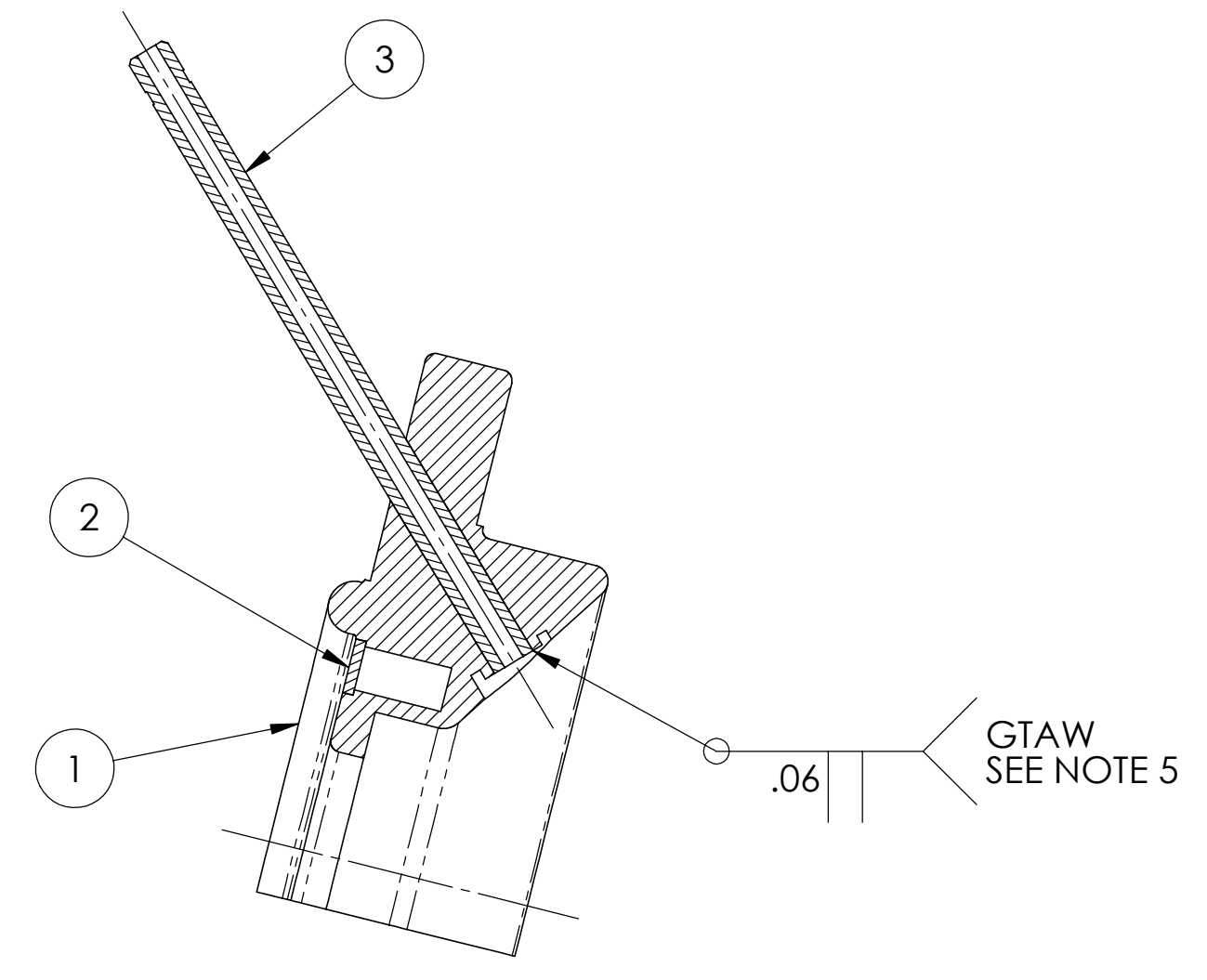


NOTES:

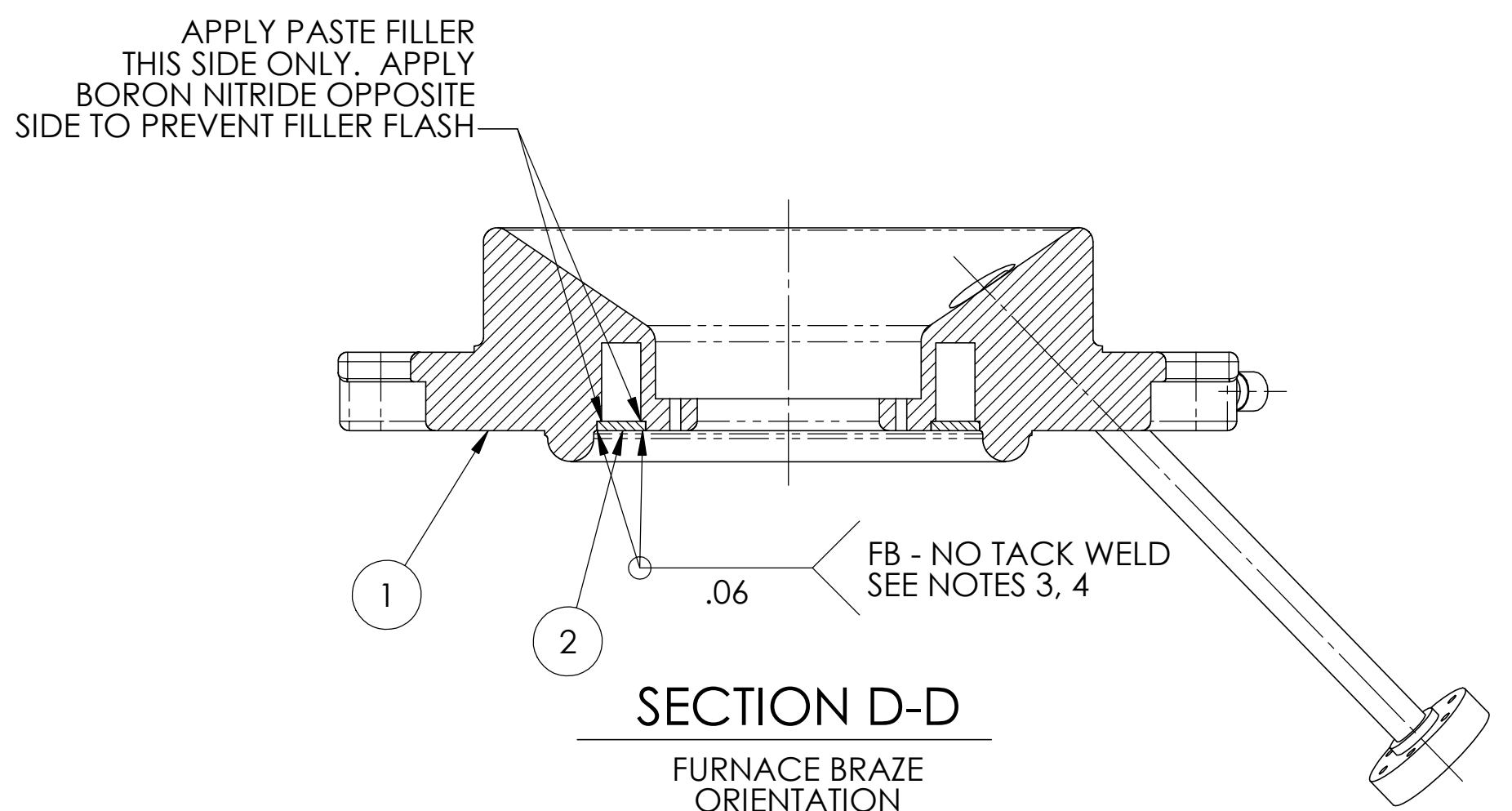
- 1) VACUUM TIGHT TO 10E-6 TORR.
- 2) CLEANING, WELDING AND VACUUM PROCEDURES PER LBNL ENGINEERING NOTE M8184.
- 3) BRAZE FILLER: NICKLE, SILVER OR COPPER BASED BRAZING ALLOY.
- 4) AFTER BRAZING, INSPECT JOINT VACUUM SIDE (ARROW SIDE) FOR SMOOTH PHYSICAL TRANSITION AND ABSENCE OF FILLER FLASH. POST-GRIND AS REQUIRED WITH DIE GRINDER TO ACHIEVE 32 MICRO-INCH FINISH BLEND OR BETTER.
- 5) WELD TUBES AFTER BRAZING TO MINIMIZE REQUIRED FURNACE VOLUME.



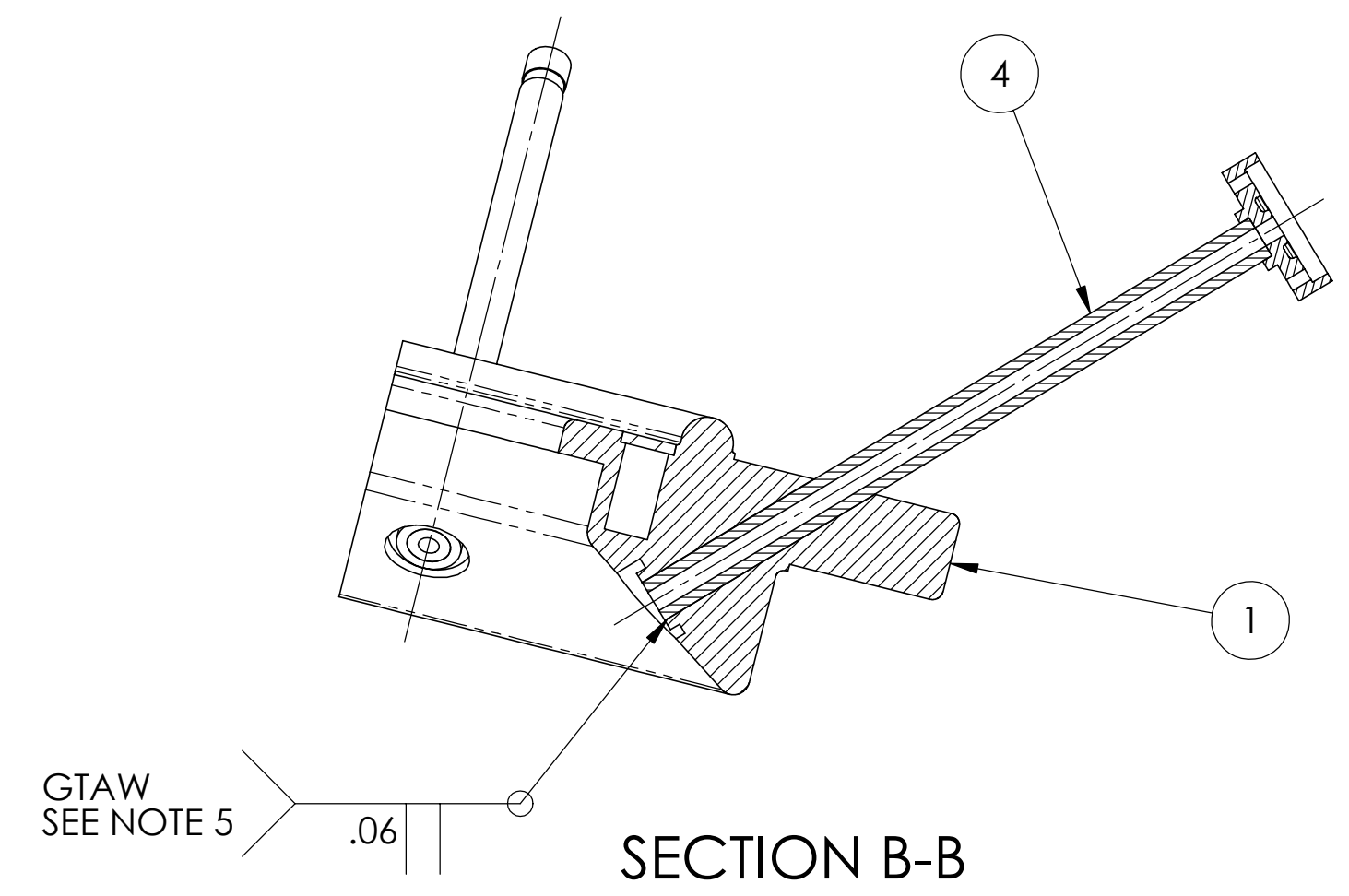
SECTION A-A



SECTION C-C



SECTION D-D  
FURNACE BRAZE ORIENTATION



SECTION B-B

ITEM	QTY	PART NO.	DESCRIPTION
5	2	27A335	TUBE, WATER
4	1	27A360	WELDMENT, VIEW PORT
3	1	27A336	TUBE, GAS, CATHODE
2	1	27A332	COVER, WATER, CATHODE FLANGE
1	1	27A331	CATHODE FLANGE MACHINING

REV	DRAWN BY	APPVD.	DATE	DESCRIPTION
B	PAL	R. KELLER	12/15/03	EBW DESIGN CHANGED TO BRAZE.
A	PAL	R. KELLER	12/01/03	INITIAL RELEASE

UNLESS OTHERWISE SPECIFIED		PROJECT NAME:	ERNEST ORLANDO LAWRENCE
.X ±.1_INCH .XX ±.01_INCH .XXX ±.005_INCH		PROJECT NUMBER:	BERKELEY NATIONAL LABORATORY
FRACTIONS: -/-		NEXT ASSEMBLY:	UNIVERSITY OF CALIFORNIA
ANGLES: 0.1° / INCH		CALC. WT.	KG. 4.6 LB.
MACH. SURFS.: 125 MICRO-INCH ✓ FB BETTER		SCALE:	1:1
DO NOT SCALE DRAWING. INTERPRET PER ASME Y14.5M-1994. THREADS ARE CLASS 2. BREAK MACHINED EDGES. 016 MAX. REMOVE BURRS, WELD SPLATTER & LOOSE SCALE.		THIRD ANGLE PROJECTION	SHEET 1 OF 1

HYBRID ION SOURCE (HYBRIS)		WELDMENT, CATHODE FLANGE	
SCALE: 1:1		SIZE: D	DWG NO: 27A330
REV B		REV B	

