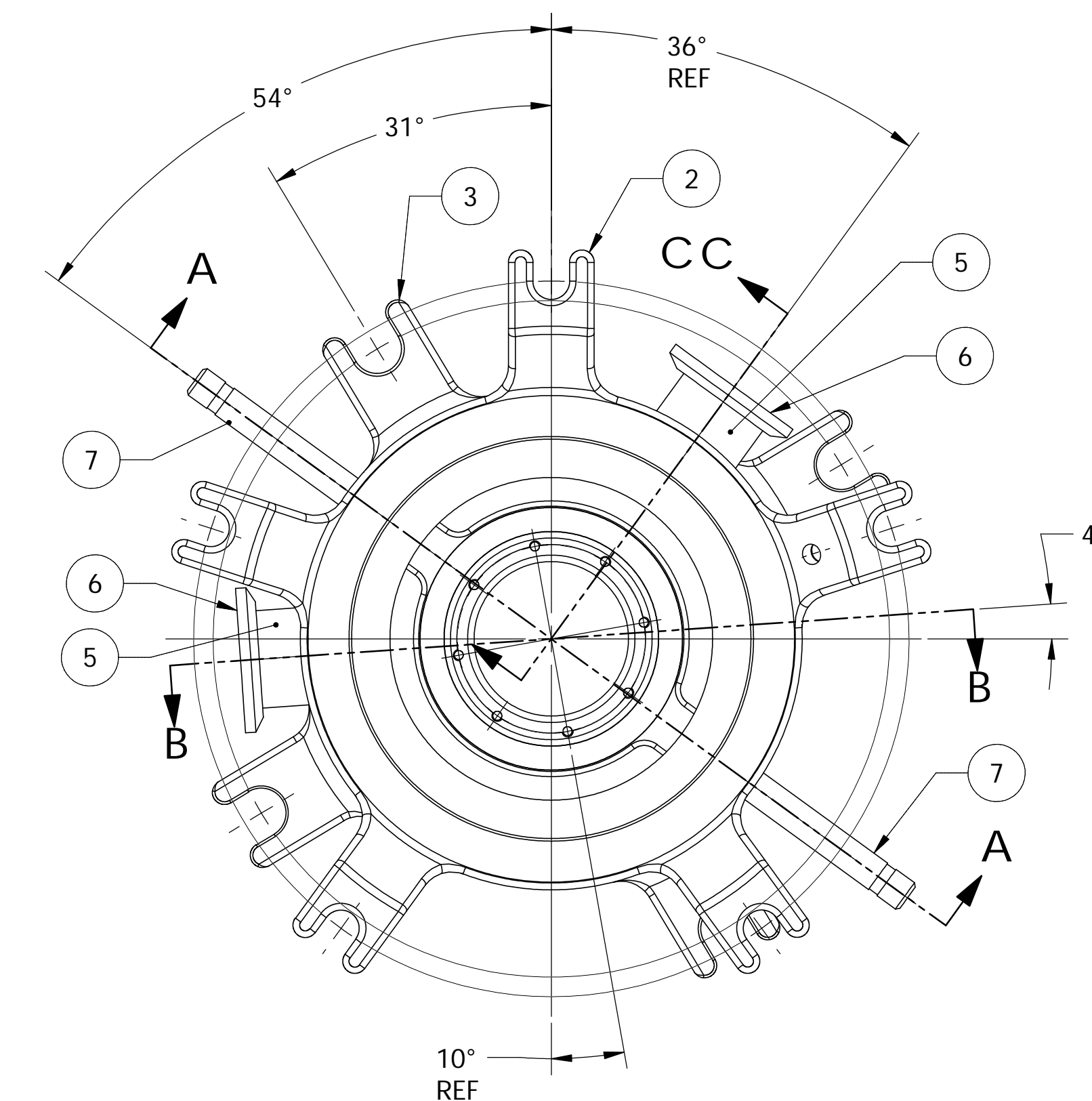
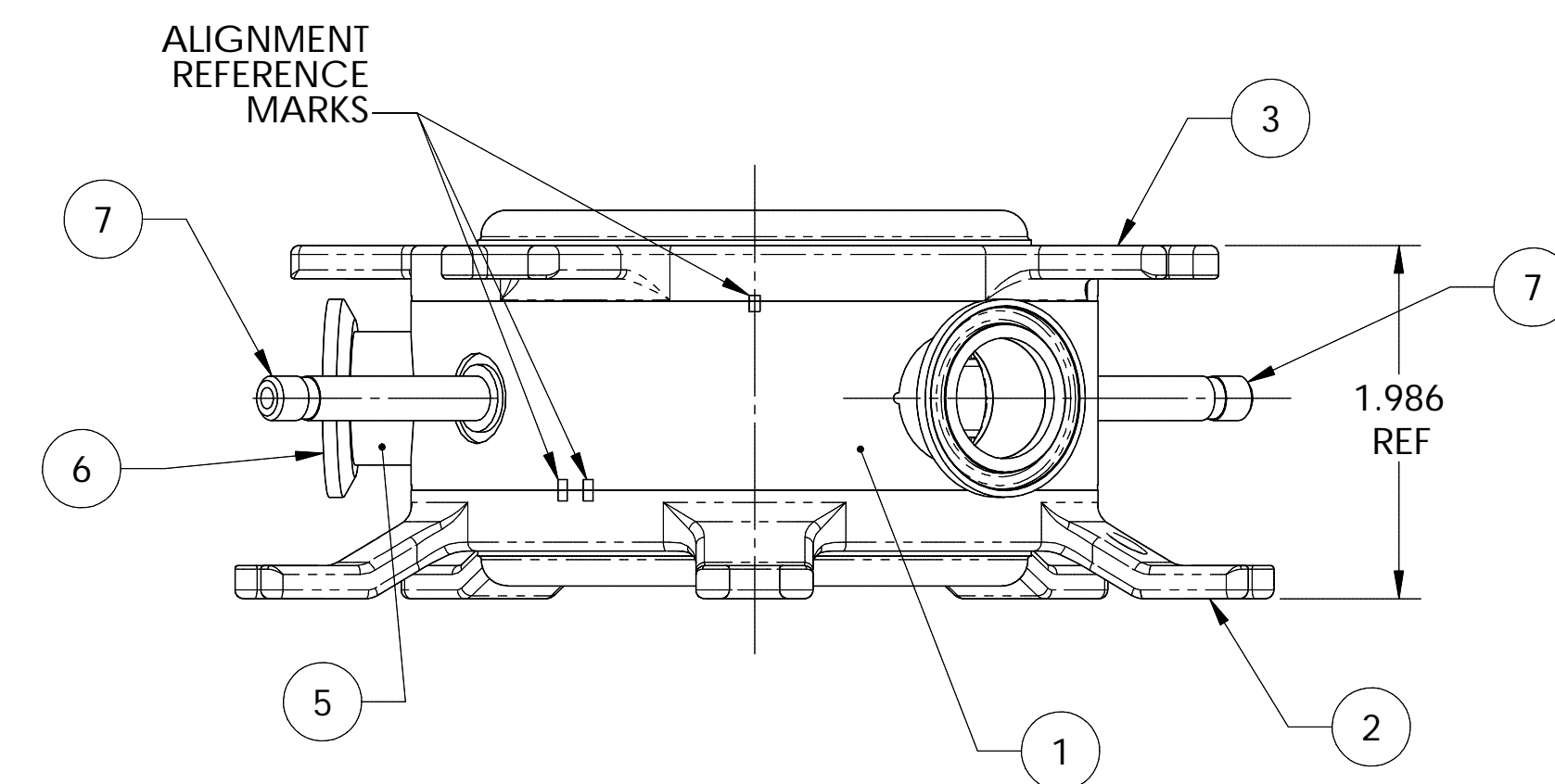
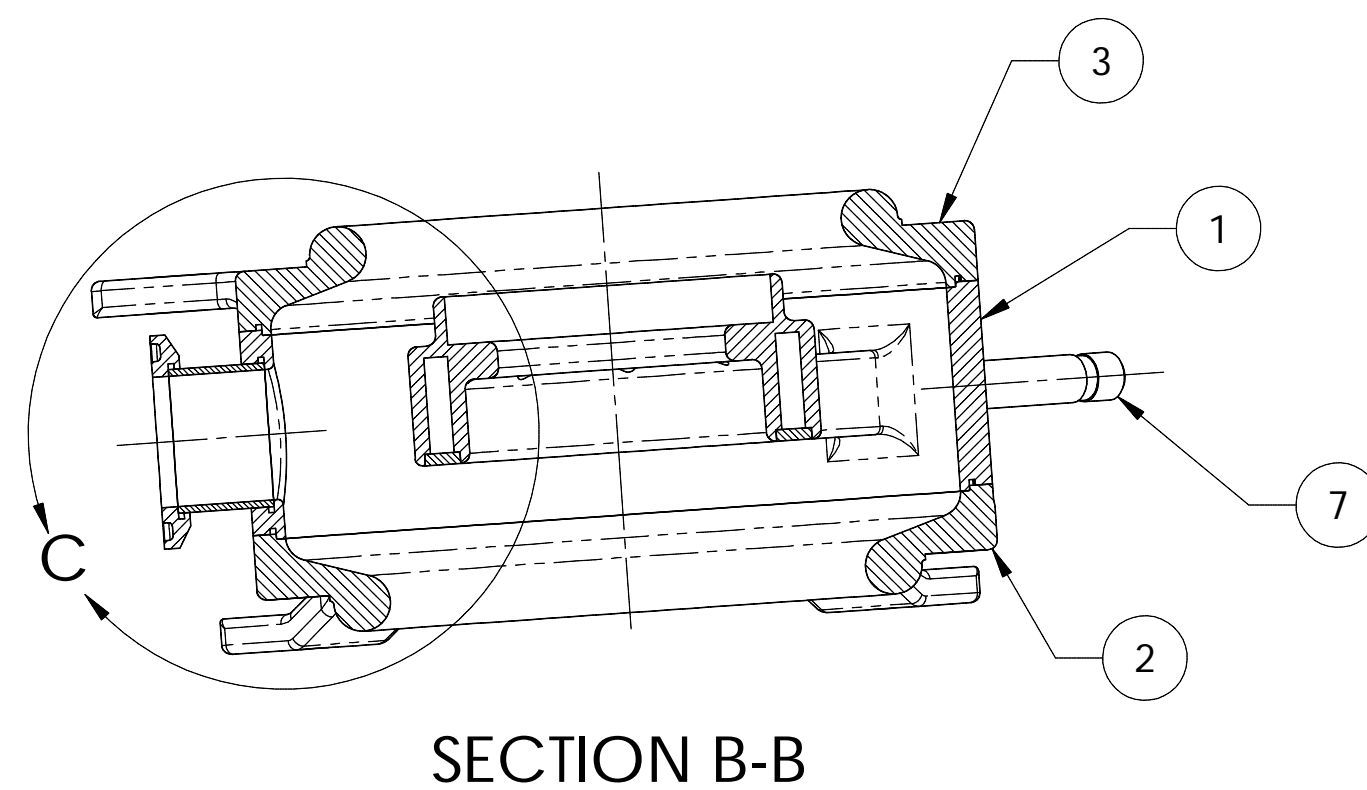
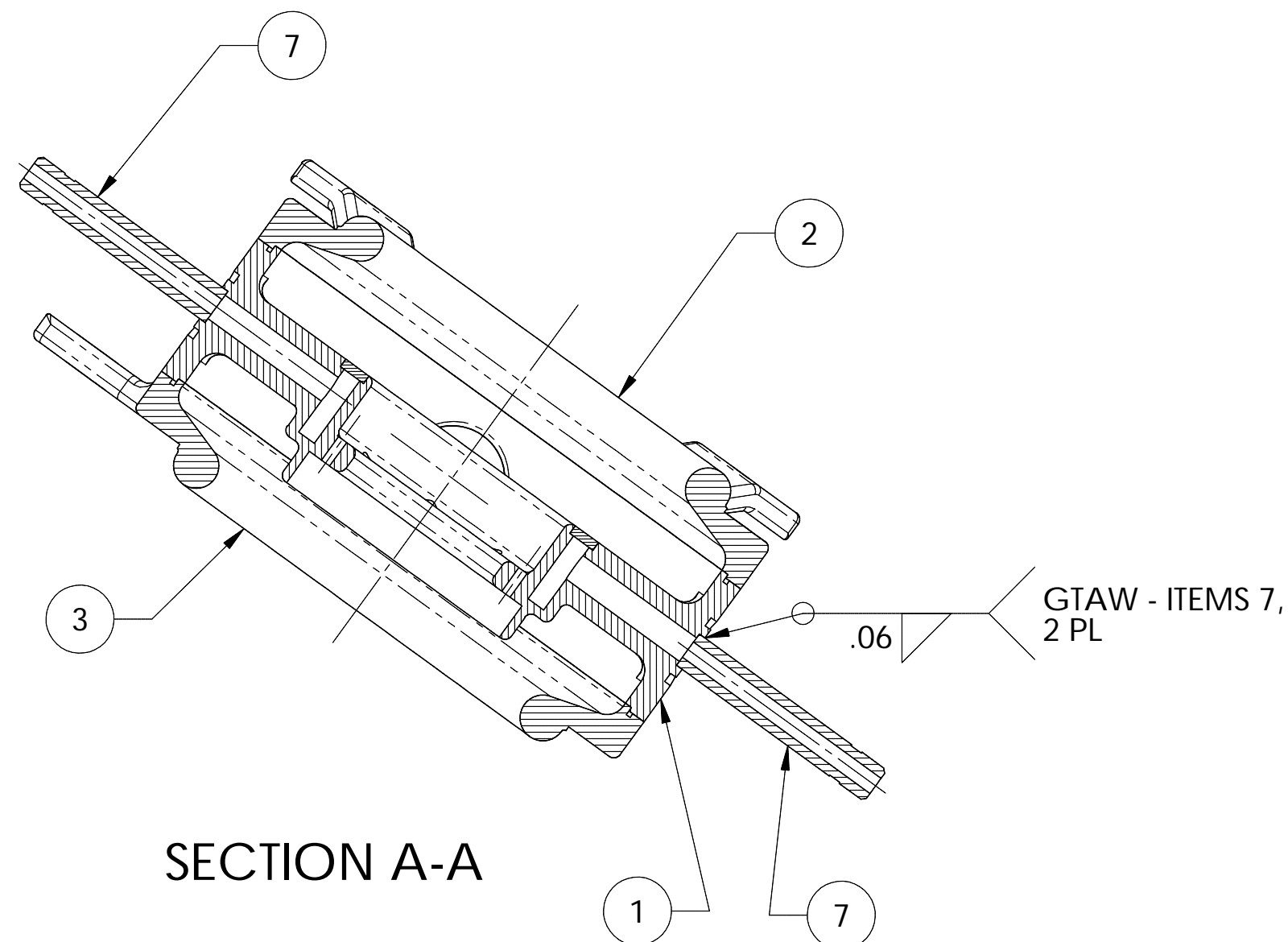
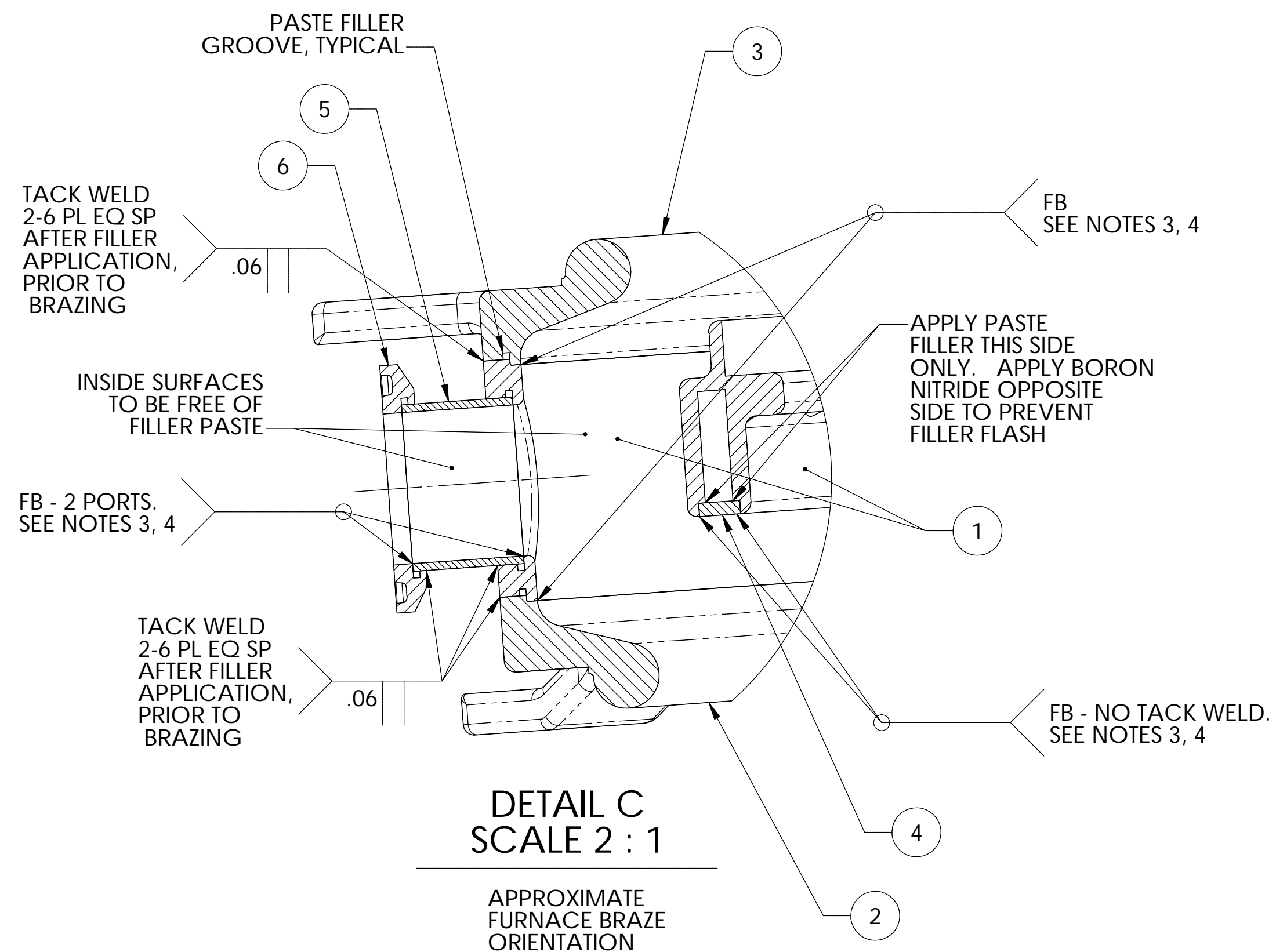


NOTES:

- 1) WELDED AND BRAZED JOINTS TO BE 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. POST-GRIND AS REQUIRED TO ACHIEVE 32 MICRO-INCH FINISH BLEND OR BETTER.



ITEM	QTY	PART NO.	DESCRIPTION
7	2	27A335	TUBE, WATER
6	2	27A349	FLANGE, VACUUM, EXTRACTOR
5	2	27A348	TUBE, VACUUM, EXTRACTOR
4	1	27A345	COVER, WATER, EXTRACTOR
3	1	27A346	FLANGE, EXTRACTOR / CATHODE
2	1	27A347	FLANGE EXTRACTOR / OUTLET
1	1	27A344	EXTRACTOR CORE MACHINING

REV	DRAWN BY	APPVD.	DATE	DESCRIPTION
B	PAL	R. KELLER	12/11/03	BRAZE JOINT DESIGN WAS EBW. ADDED SECTION C-C AND DETAIL D.
A	PAL	R. KELLER	11/25/03	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.	2.3 LB.
MACH. SURFS.: 125 MICRO-INCH ✓		SCALE:	1:1
DO NOT SCALE DRAWING. INTERPRET PER ASME Y14.5M-1994. THREADS ARE GLASS. BREAK MACHINED EDGES .016 MAX. REMOVE BURRS, WELD SPLATTER & LOOSE SCALE.		THIRD ANGLE PROJECTION	WELDMENT, EXTRACTOR

HYBRID ION SOURCE (HYBRIS)		SHEET 1 OF 1	
WELDMENT, EXTRACTOR		SIZE: D	DWG NO: 27A343
		REV: B	