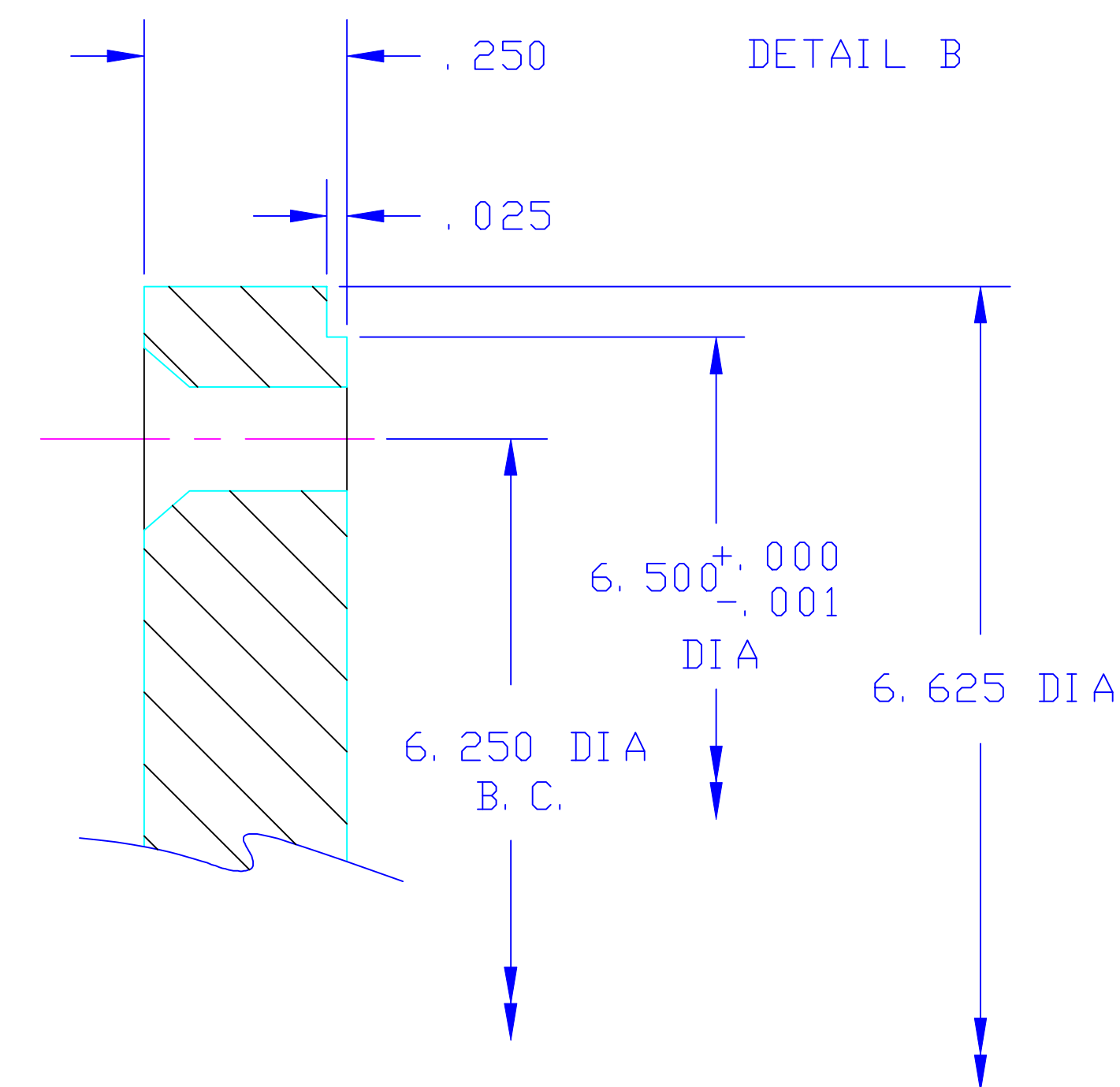
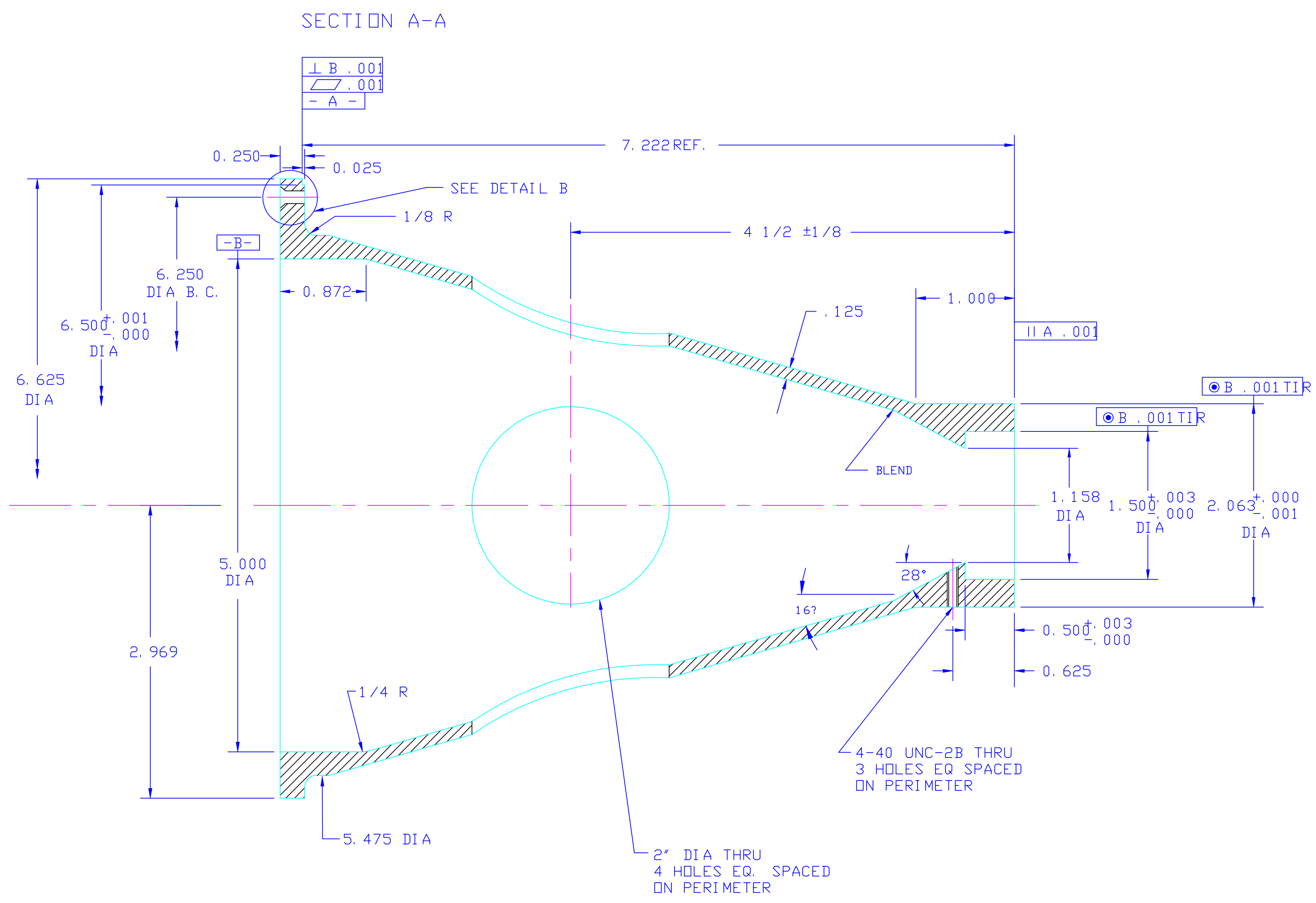
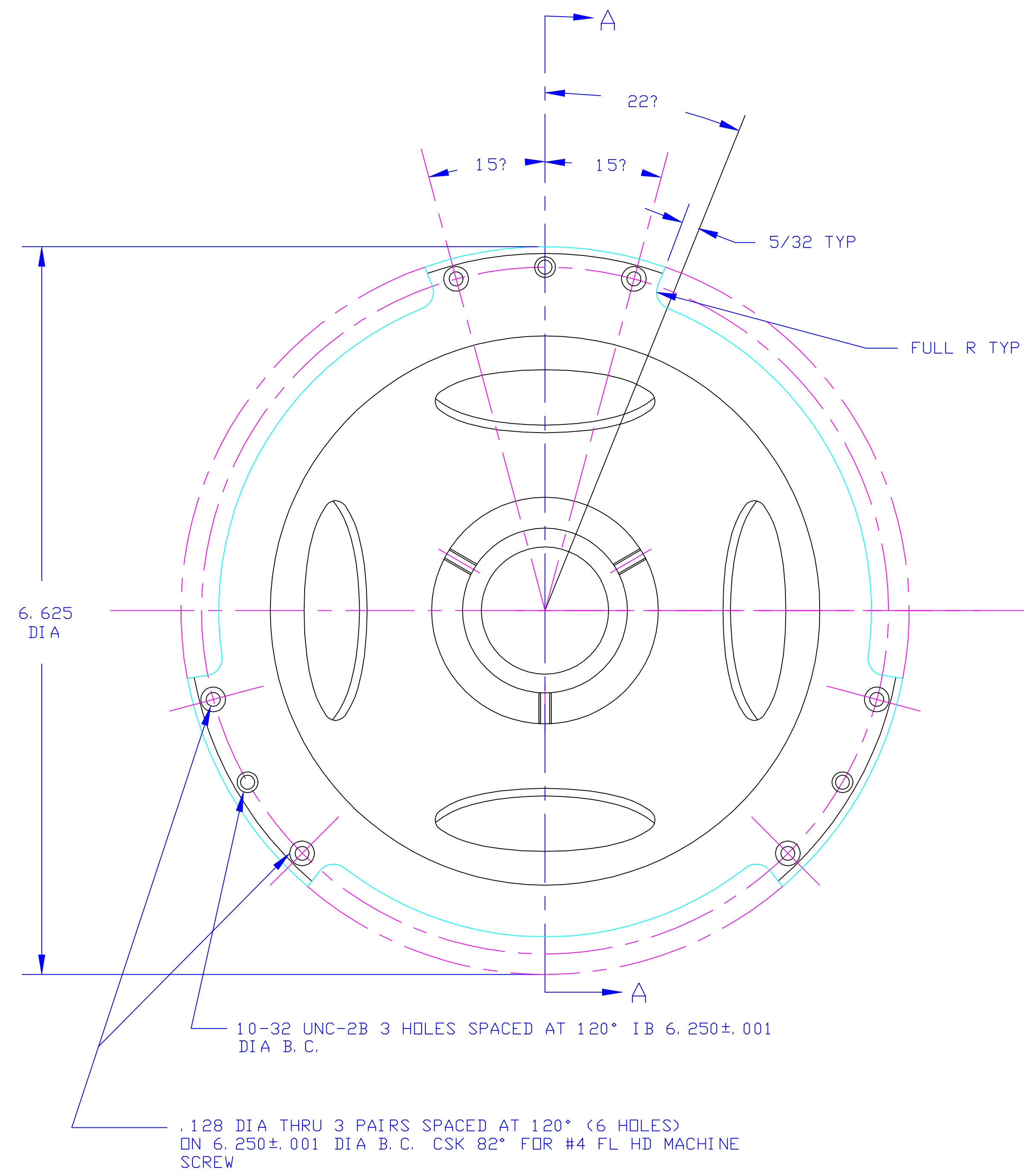


REV.	DATE	DESCRIPTION	BY	APP'D
1	3-91	CHANGED DIA FROM 1.18 TO 1.158	URIBE	



NOTES

1. MAT'L: 304 SST 7" DIA CONE
2. STRESS RELIEVE BEFORE FINISH MACH'G. (ALLOW 1/16 PER SURFACE FOR FINISH MACH'G). STRESS RELIEVE IN DRY HYDROGEN FURNACE BY INCREASING HEAT UNIFORMLY TO 1500°-1600°F & HOLDING AT THAT TEMP. FOR 15 MINUTES; THEN FURNACE COOL AT A UNIFORM RATE.
3. FINISH CONICAL SURFACE AND "NOSE" TO OR BETTER, THEN ELECTROPOLISH PART.
4. DO NOT USE EMERY TO ACHIEVE FINAL FINISH
5. ALL MACHINING TO BE DONE WITH SULFUR-FREE CUTTING OIL.

DRAWN BY URIBE	NUCLEAR PHYSICS LABORATORY UNIVERSITY OF ILLINOIS AT URBANA-CHAMPAIGN	CATHODE SUPPORT CONE		
CHECKED BY	UNLESS OTHERWISE SPECIFIED	PART NO.	SCALE 1=1	FILE 12
APPROVED BY	DIMENSIONS IN INCHES 2 PLACE DEC. ±.01 BREAK SHARP CORNERS 3 PLACES DEC. ±.003 FRACTIONAL 1/32" ANGULAR ±0°30'	CHASSIS NO. OR MATERIAL LISTED	DATE 7-10-88	DWG. NO. D-2709-45A