



NOTES

1. MAT'L: 6" OD - 0.5 THK WALL TYPE 304
STAINLESS STEEL SEAMLESS TUBE
2. STRESS RELIEVE BEFORE FINISH MACHINING.
(ALLOW 1/16 PER SURFACE FOR FINISH MACHINING
STRESS RELIEVE IN DRY HYDROGEN FURNACE BY
INCREASING HEAT UNIFORMLY TO 1500°-1600° AND
HOLDING AT THAT TEMP. FOR 15 MINUTES; THEN
FURNACE COOL AT A UNIFORM RATE.
3. ALL RADII AND STRAIGHT SECTIONS MUST BLEND
SMOOTHLY $\frac{1}{16}$ FINISH OR BETTER
4. MACHINE TO $\frac{1}{16}$ FINSH THEN ELCTROPOLISH.
5. DO NOT USE EMERY TO ACHIEVE MACHINE FINISH.
6. ALL MACHINING TO BE DONE WITH SULFUR-FREE OIL.
7. USE IN PLACE OF 2709-54 FOR LOWER GRADIENTS AT
CATHODE ELECTRODE.

DRAWN BY URIBE	NUCLEAR PHYSICS LABORATORY UNIVERSITY OF ILLINOIS AT URBANA-CHAMPAIGN	ALTERNATE SHIELD RING FOR CEBAF SOURCE		
CHECKED BY		PART NO. NO. REQ'D.	SCALE 1=1	FILE 15
APPROVED BY	UNLESS OTHERWISE SPECIFIED	CHASSIS NO. OR MATERIAL LISTED	DATE 8/31/94	DWG. NO. C-2709-54A
	DIMENSIONS IN INCHES 2 PLACE DEC. $\pm .01$ BREAK SHARP CORNERS 3 PLACES DEC. $\pm .003$ FRACTIONAL $\pm 1/32"$ ANGULAR $\pm 0^{\circ}30'$			