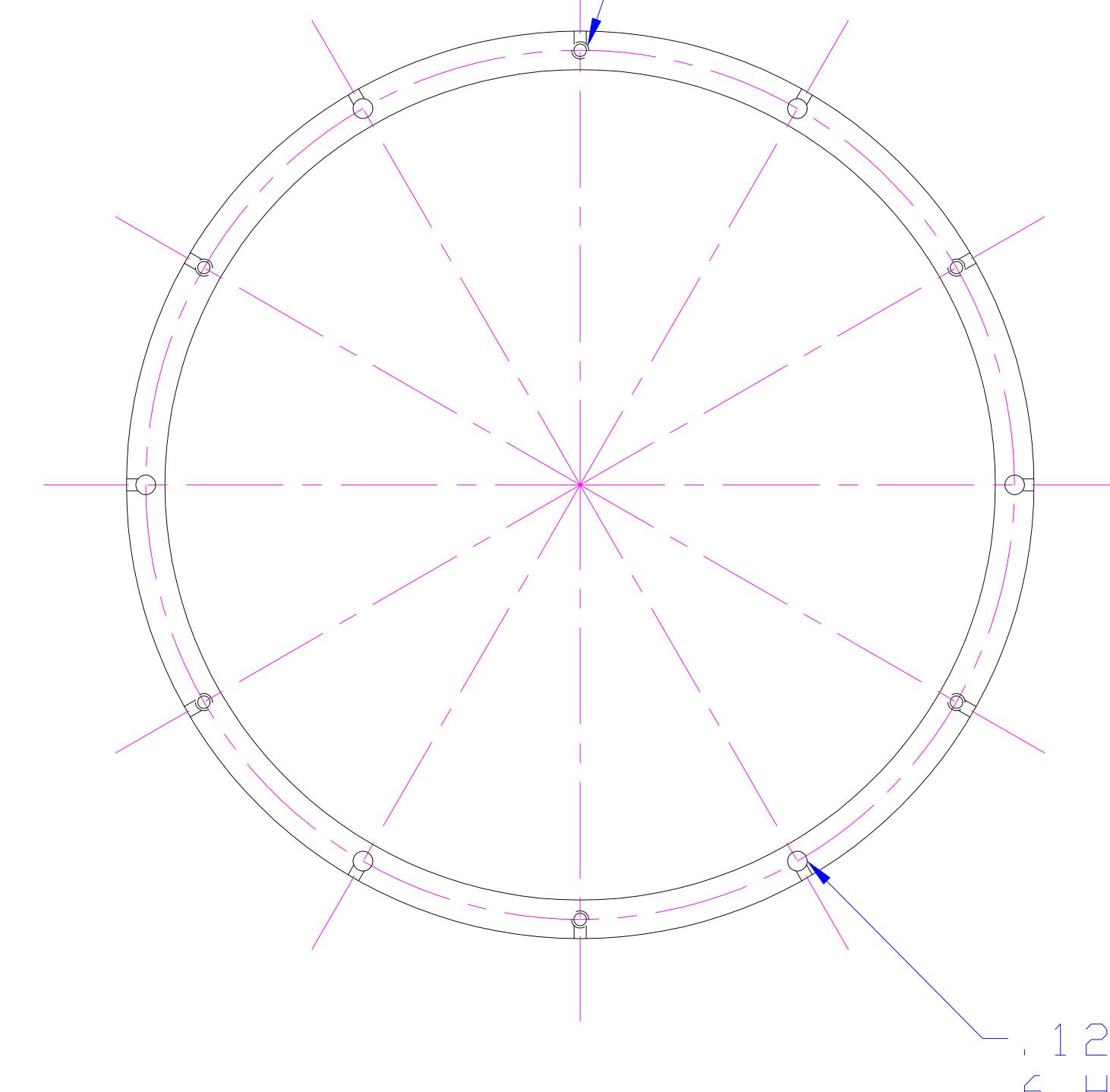
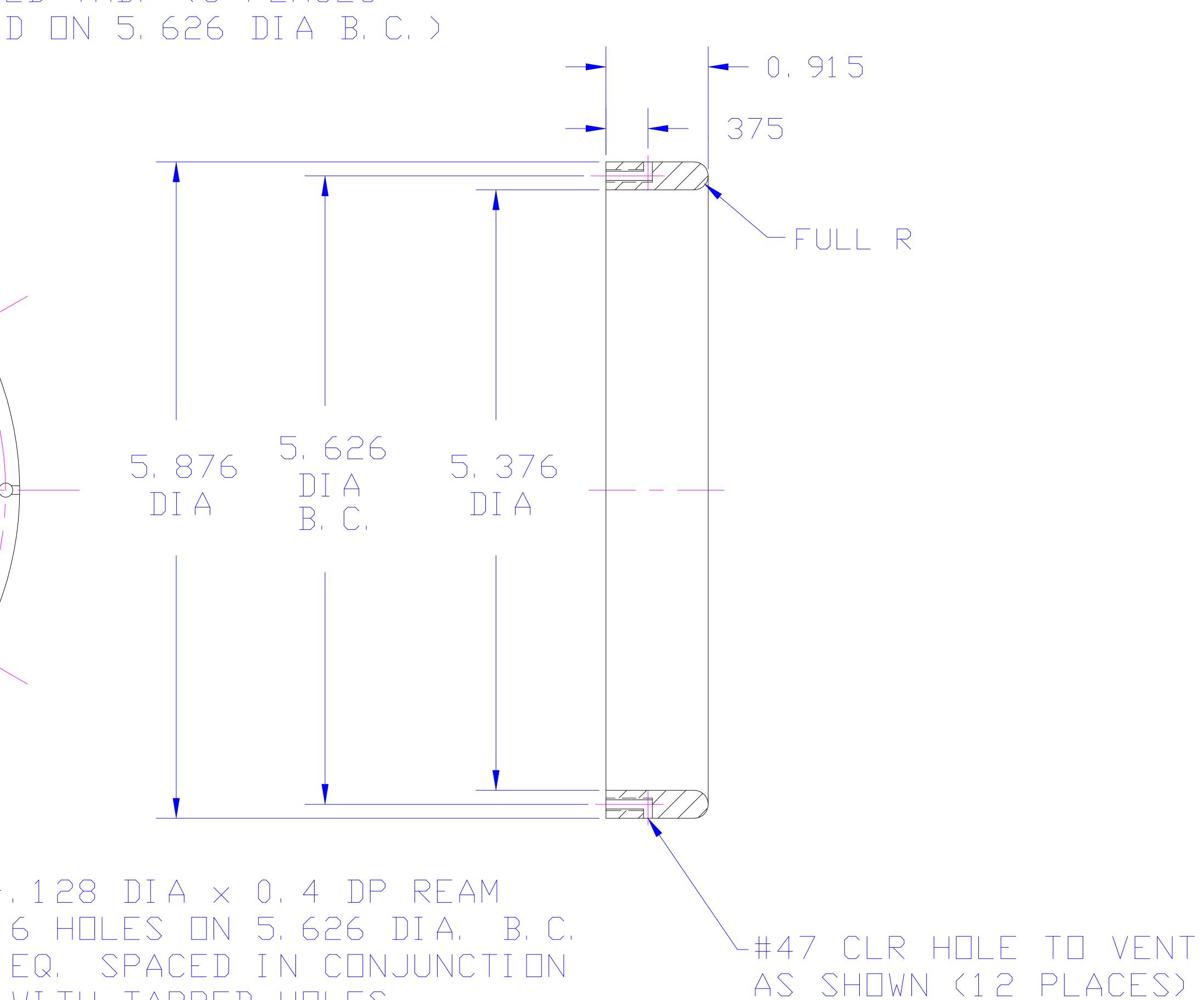
- 7, USE IN PLACE OF 2709-54 FOR LOWER GRADIENTS AT CATHODE ELECTRODE,
- SMOOTHLY ¹/₅ FINISH OR BETTER
- 4, MACHINE TO ¹⁶ FINSH THEN ELCTROPOLISH.
- FURNACE COOL AT A UNIFORM RATE, 3. ALL RADII AND STRAIGHT SECTIONS MUST BLEND
- 2, STRESS RELIEVE BEFORE FINISH MACHINING, (ALLOW 1/16 PER SURFACE FOR FINISH MACHINING STRESS RELIEVE IN DRY HYDROGEN FURNACE BY INCREASING HEAT UNIFORMLY TO 1500°-1600° AND HOLDING AT THAT TEMP, FOR 15 MINUTES; THEN
- 1, MAT'L: 6" DD 0,5 THK WALL TYPE 304 STAINLESS STEEL SEAMLESS TUBE

NDTES



$-FLAT BOTTOM TAP \times 0.4 DP$ 4-40 UNC-2B THD, (6 PLACES EQ. SPACED ON 5,626 DIA B.C.)



-128 DIA \times 0, 4 DP REAM WITH TAPPED HOLES,

5, DO NOT USE EMERY TO ACHIEVE MACHINE FINISH,

6. ALL MACHINING TO BE DONE WITH SULFUR-FREE DIL.

DRAWN BY URI BE CHECKED BY APPROVED BY

NUCLEAR PHYSICS LABORATORY	ALTERNATE SHIFLD RI		
UNIVERSITY OF ILLINDIS AT URBANA-CHAMPAIGN	ALIERNAIE SHIELD RI	NU FUR UE.	DAF SLURUE
UNLESS OTHERWISE SPECIFIED	PART NO.	SCALE	FILE
DIMENSIONS IN INCHES 2 PLACE DEC. ±, 01	ND, REQ'D.	11 = 1	15
BREAK SHARP CORNERS 3 PLACES DEC. ±,003	CHASSIS NO, OR MATERIAL	DATE	DWG, ND,
FRACTIONAL±1/32″ ANGULAR±0°30′	LISTED	8/31/94	C-2709-54A

DESCRI PTI ON	BY	APP'D