4X, Tapped Holes for Hoist Rings
2X, CB's for Ball Alignment Bushings

$\varnothing 20.500$ B.C.

Therefore, 1506# of Pb Shielding & Klystron Box

Klystron Box, and Pb Shield Assy CG
(3006#)
32.95

(1500#)
(den=.211#/in3 in the model)
30.0 Klystron CG

1.000

.75
2.00
3.75

18.500 dia. hole

C. Brooksby, 5/7/02

SCALE 0.200

21.750 Klystron Flange OD
Klystron Box Support

CAB, 5/7/02

Ill # out of Aluminum
NOTES, UNLESS OTHERWISE SPECIFIED:

1. **± XXX ± .005 ± .XX ± .06 TOLERANCE.**

2. PERMANENTLY MARK DRAWING NUMBER APPROPRIATELY WHERE SHOWN ON SIDE OF STAND.

3. REMOVE ALL BURRS AND BREAK SHARP EDGES

4. ALL MACHINED SURFACES WILL BE 125 FINISH OR BETTER. NO PITS, DENTS, SCRATCHES, ETC. PERMITTED.

5. PART WILL BE FREE OF ALL FOREIGN MATERIALS, LOOSE SCALE, CHIPS, GREASE AND OIL.

6. PROTECT FROM DAMAGE THROUGHOUT ALL PHASES OF MANUFACTURING, SHIPMENT AND HANDLING.

7. APPLICABLE STANDARDS/SPECIFICATIONS:
   - ASME Y14.5M-1994, DIMENSIONING AND TOLERANCING
   - ASME B46.1-1995 SURFACE TEXTURE
   - ASME Y14.36M-1999 SURFACE TEXTURE SYMBOLOGY
   - ASME Y14.38-1998 ABBREVIATIONS & ACRONYMS

8. CHECK ALL CONTINUOUS WELDS FOR LEAK FREE CONDITION BY DYE PENETRANT INSPECTION, AND FIX AS NEEDED.

9. 4X .250-20 UNC-2B

10. **8X .500-13 UNC-2B VS .75 BLIND HOLE DO NOT BREAK THRU**

SECTION A-A

NOTE: FOR VITON O-RING

AS-568A-388

3/16 DIAM X 19" I.D.

CLASSIFICATION: UNCLASSIFIED
NOTES, UNLESS OTHERWISE SPECIFIED:

1. APPLICABLE STANDARDS/SPECIFICATIONS:
   - ASME Y14.5M-1994: DIMENSIONING AND TOLERANCING
   - ASME B46.1-1995: SURFACE TEXTURE
   - ASME Y14.36M-1996: SURFACE TEXTURE SYMBOLS
   - AWS AZ-4 WELD SYMBOLS

2. + XXX: 005 ± XX: 06 POSITIONAL TOLERANCE.
   PERMANENTLY MARK DRAWING NUMBER APPROXIMATELY WHERE SHOWN ON SIDE OF STAND.

3. REMOVE ALL BURRS AND BREAK SHARP EDGES.

4. ALL MACHINED SURFACES WILL BE 125 FINISH OR BETTER. NO PITS, DENTS, SCRATCHES, ETC. PERMITTED.

5. PART WILL BE FREE OF ALL FOREIGN MATERIALS, LOOSE SCALE, CHIPS, GREASE AND OIL.

6. PROTECT FROM DAMAGE DURING ALL PHASES OF MACHINING, SHIPPING AND HANDLING.
NOTES, UNLESS OTHERWISE SPECIFIED:
1. ALL DIMENSIONS ARE IN INCHES.
5. ALL MACHINED SURFACES 125 MICROINCHES OR BETTER.
6. BREAK EDGES .030 MAX RADIUS OR CHAMFER.
7. PERMANENTLY MARK DRAWING NUMBER APPROXIMATELY WHERE SHOWN.
8. DYE PENETRANT CHECK ON WELDS.
9. ELECTRO POLISH PER MIL-S-5002 TO A BRIGHT LUSTER FINISH AND WITHOUT ANY VISIBLE CONTACT MARKS.
10. ALL INTERNAL BEND RADIUS TO BE MAXIMUM 2X MATERIAL THICKNESS.
NOTES, UNLESS OTHERWISE SPECIFIED:

1. ALL DIMENSIONS ARE IN INCHES.
   POSITIONAL TOLERANCE:
   ± $X_{0.000} = \pm 0.003$
   ± $X_{0.000} = \pm 0.010$

2. DIMENSIONING AND TOLERANCING PER


4. SURFACE TEXTURE PER ASME B46.1-1995,
   SURFACE TEXTURE SYMBOLS PER ASME
   Y14.38M-1996.

5. ALL MACHINED SURFACES \( \leq 125 \mu \text{inches}
   \text{or better.}

6. BREAK EDGES .030 MAX RADIUS OR CHAMFER.

7. PERMANENTLY MARK DRAWING NUMBER
   APPROXIMATELY WHERE SHOWN.

8. DYE PENETRANT CHECK ON WELDS.

9. ELECTRO POLISH PER MIL-55022 TO A BRIGHT LUSTER FINISH
   AND WITHOUT ANY VISIBLE CONTACT MARKS.

10. ALL INTERNAL BEND RADIUS TO BE MAXIMUM 2X MATERIAL THICKNESS.
SECTION A-A

NOTES, UNLESS OTHERWISE SPECIFIED:

1. ALL DIMENSIONS ARE IN INCHES.
   POSITI0NAL TOLERANCE:
   ± XX = ± 0.01
   ± XXX = ± 0.01


5. ALL MACHINED SURFACES 125 MICROINCHES OR BETTER.

6. BREAK EDGES .030 MAX RADIUS OR CHAMFER.

7. PERMANENTLY MARK DRAWING NUMBER APPROXIMATELY WHERE SHOWN.

8. DYE PENTRANT CHECK ON WELDS.

9. ELECTRO POLISH FOR MIL-S-5002 TO A BRIGHT LUSTER FINISH
   AND WITHOUT ANY VISIBLE CONTACT MARKS.

10. ALL INTERNAL BEND RADIUS TO BE MAXIMUM 2X MATERIAL THICKNESS.
NOTES, UNLESS OTHERWISE SPECIFIED:

1. ALL DIMENSIONS ARE IN INCHES.
   POSITIONAL TOLERANCE:
   ± XXX: ± 0.03
   ± XXX: ± 0.01

2. DIMENSIONING AND TOLERANCING PER
   ASME Y14.5M-1994


4. SURFACE TEXTURE PER ASME B44.1-1995.
   SURFACE TEXTURE SYMBOLS PER ASME

5. ALL MACHINED SURFACES .125 MICROINCHES
   OR BETTER.

6. BREAK EDGES .030 MAX RADIUS OR CHAMFER.

7. PERMANENTLY MARK DRAWING NUMBER
   APPROXIMATELY WHERE SHOWN.

8. DYE PENETRANT CHECK ON WELDS.

9. ELECTRO POLISH PER MIL-S-5002 TO A BRIGHT LUSTER FINISH
   AND WITHOUT ANY VISIBLE CONTACT MARKS.

10. ALL INTERNAL BEND RADIUS TO BE MAXIMUM 2X MATERIAL THICKNESS.