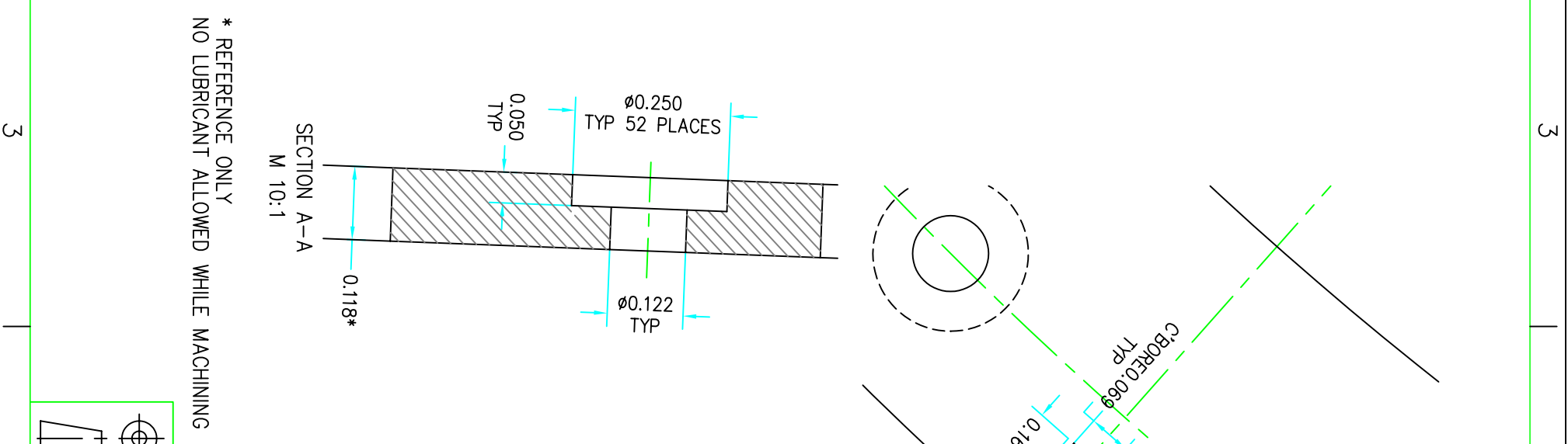
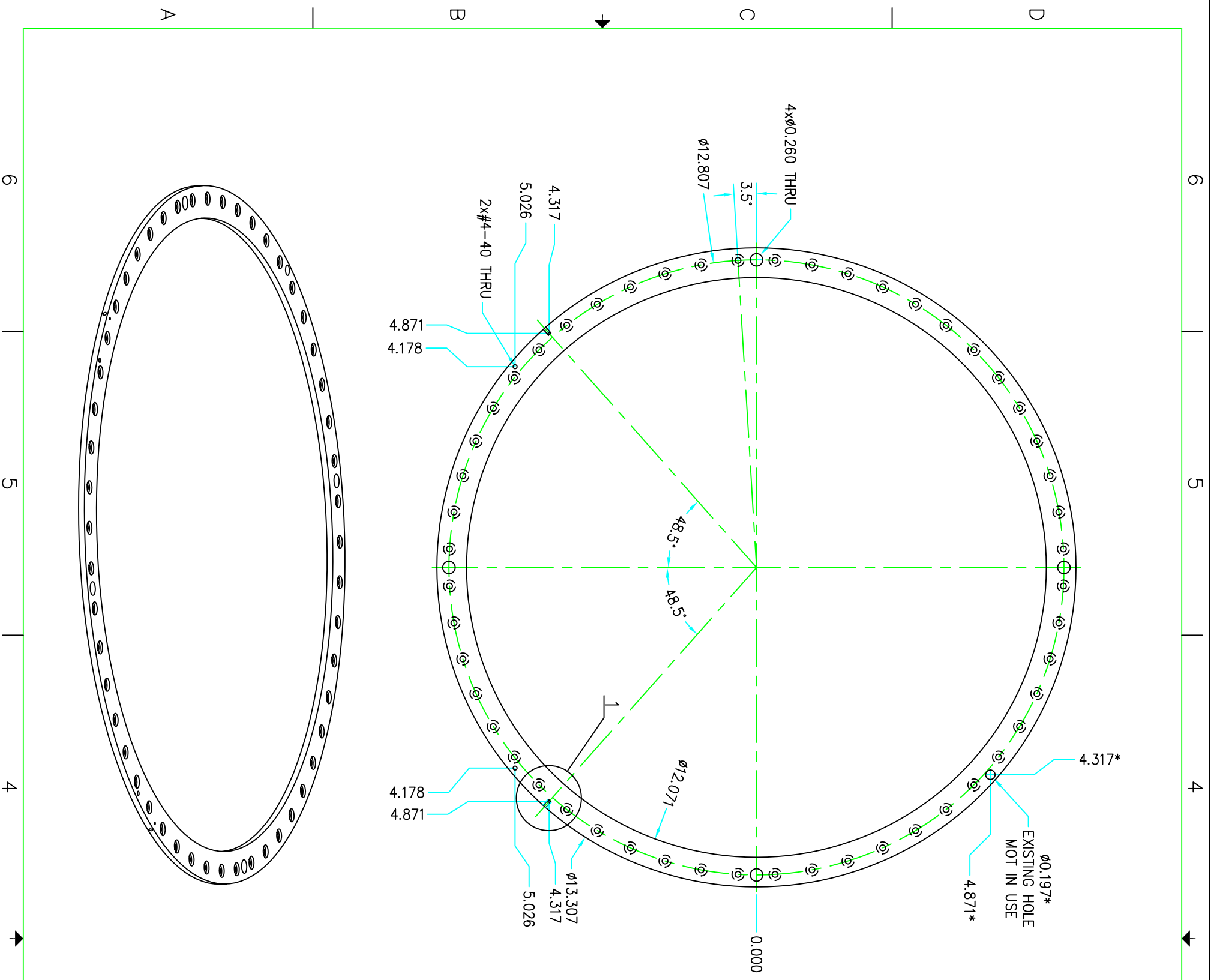


ZONE	REV	DESCRIPTION	DATE	APPROVED



* REFERENCE ONLY
NO LUBRICANT ALLOWED WHILE MACHINING

PNL/REF#	QTY	U/L	PART NAME	MATERIAL	REF. SHEET/DWG.
			RING	COPPER	

PARTS LIST		PERMISSIBLE VARIATION IN MM DIMENSIONS WITHOUT TOLERANCES	
DIMEN	< 3	3-6	6-10
TOLER	± 0.05	± 0.06	± 0.075
DIMEN	120-180	18-30	30-50
TOLER	± 0.105	± 0.125	± 0.150
DIMEN	120-180	18-30	30-50
TOLER	± 0.200	± 0.250	± 0.315
ANGLE	$\pm 1^\circ$	$\pm 30'$	$\pm 20'$
		$\pm 10'$	$\pm 5'$

UNLESS OTHERWISE SPECIFIED:	PERMISSIBLE VARIATION IN MM DIMENSIONS WITHOUT TOLERANCES
1. DIMENSIONS ARE IN MM.	
2. MACHINE SURFACES TO BE FLAT, SQUARE, PARALLEL, & CONCENTRIC.	
3. MARK ALL DETAILS (EXCEPT COMMERCIAL PARTS) WITH DIM.	
4. ITEM NUMBER.	
5. RILEY'S CORNERS: 15° x 45° CHAMFER.	
6. RILEY'S SPARK SHARP TO R40.	
7. TAPPED HOLES: MIN DEPTH 2.0 x DIA.	
8. CHAMK BORED & REAMED HOLES 1.5 x 45°.	
9. DO NOT SCALE DRAWING.	
10. ALL WELDING TO CONFORM TO LATEST A.S.M.S. STANDARDS.	

NAME	DATE	SIZE	SCALE
DRWN: Andrey	10/02/09	D	1:4
CHKD:			
APPRD: HW			

PROJECT NUMBER	DRAWING NUMBER	SHEET	REVISION
100		1 OF 1	A

CYLON BRANDEIS
 THE CYLON CATHODE CLAMP RING
 HIGH ENERGY PHYSICS LABORATORY