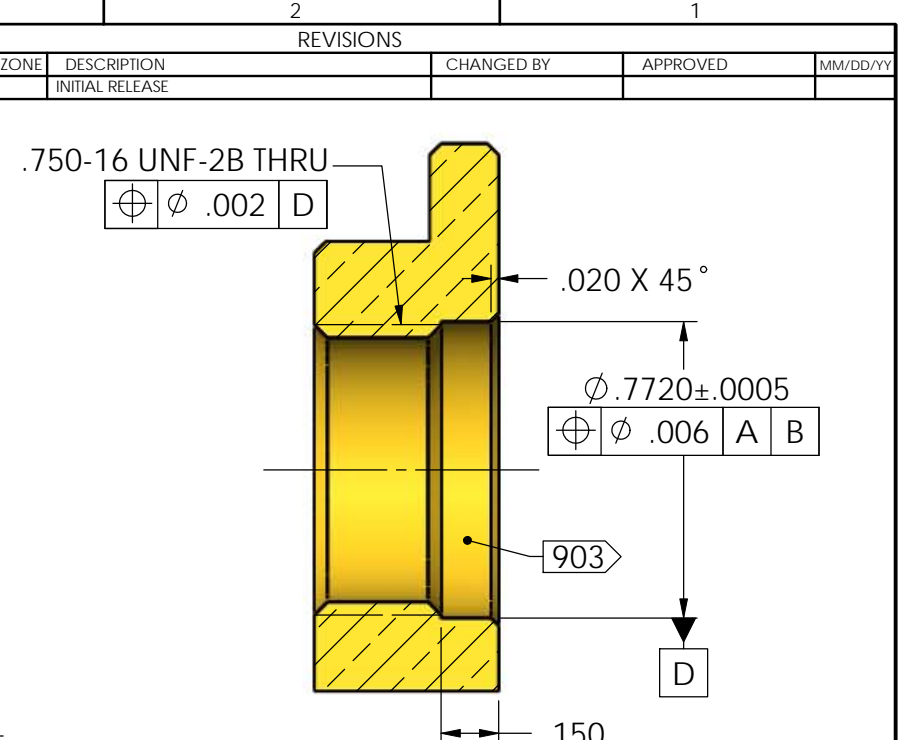
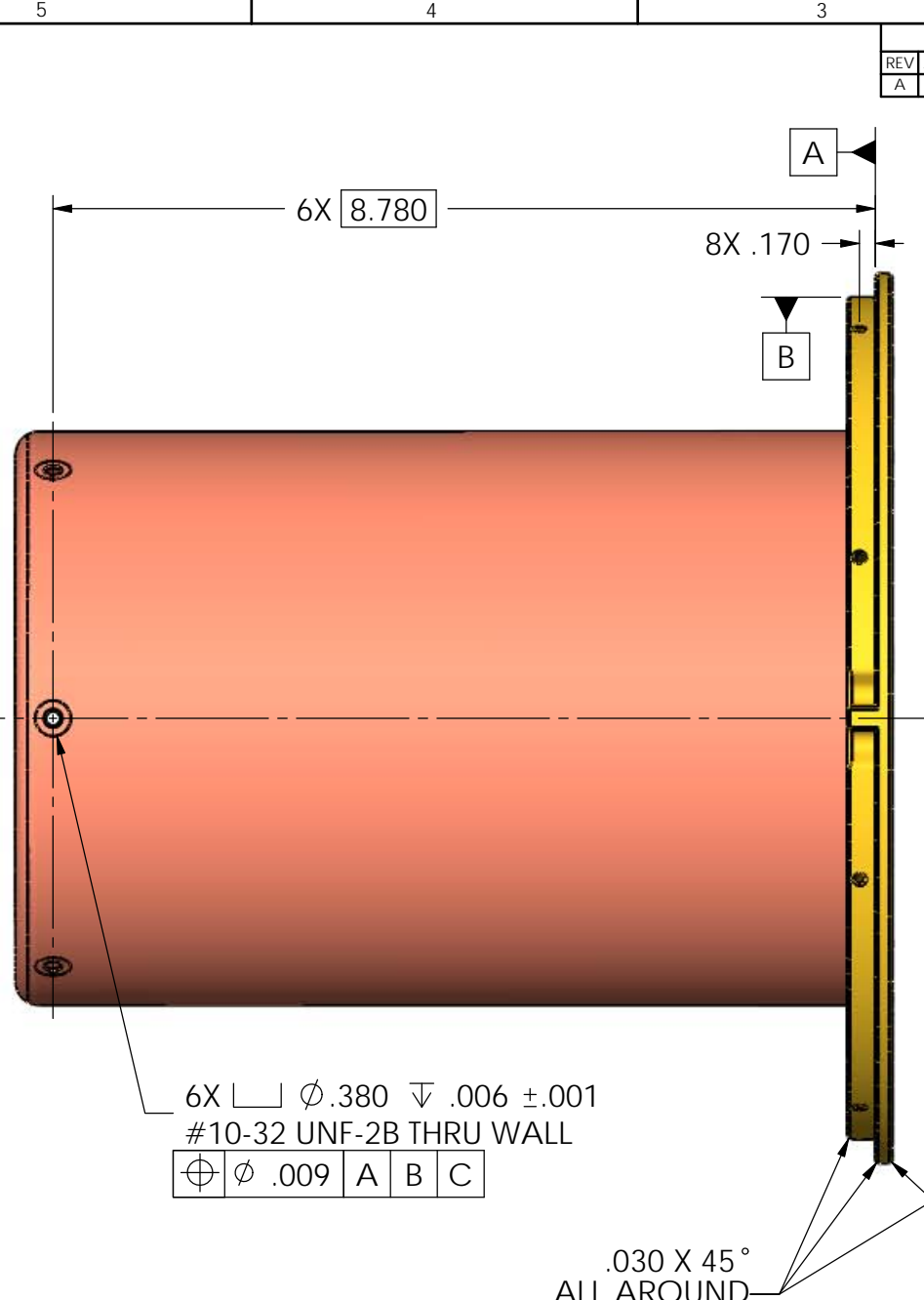
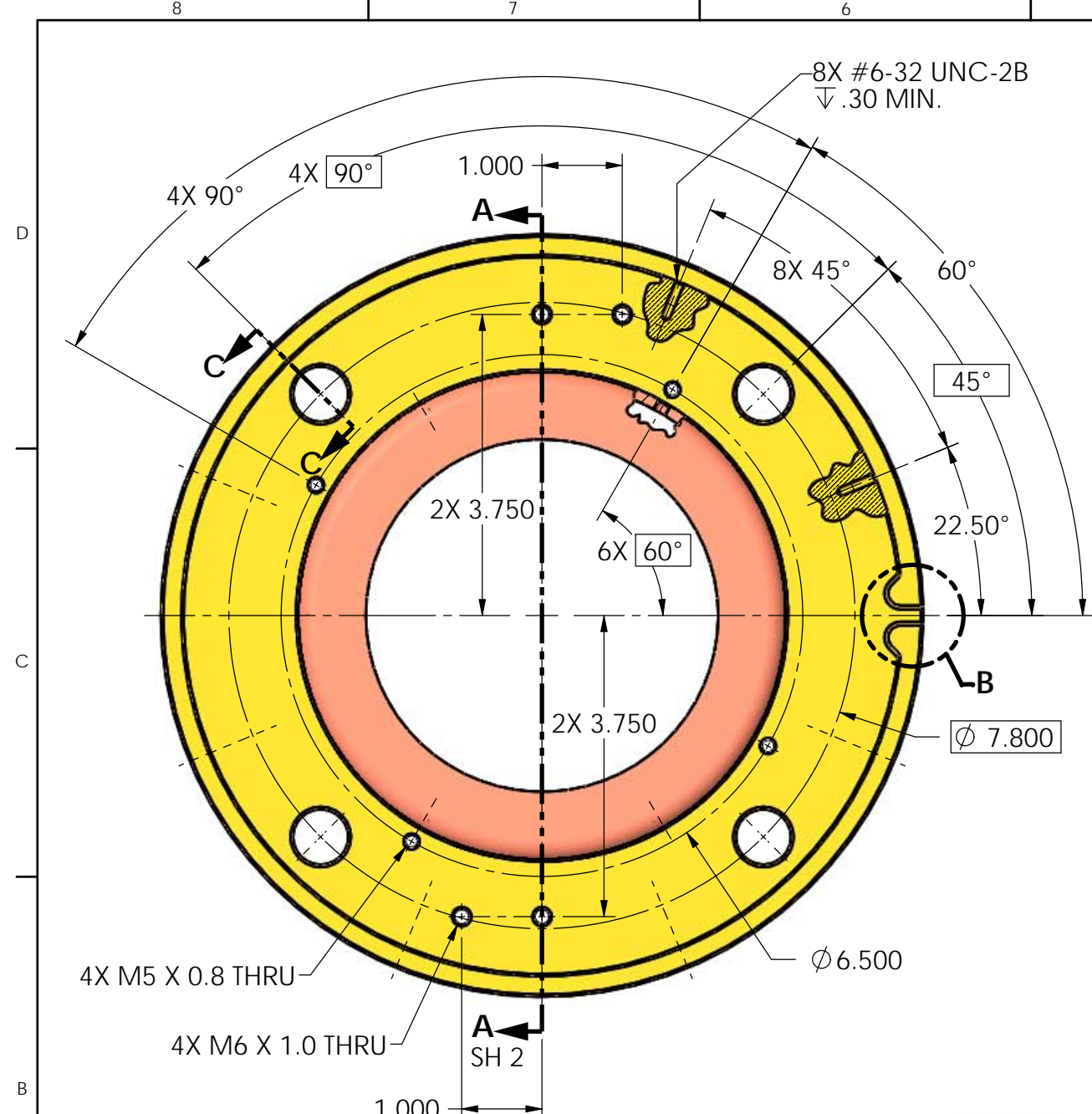
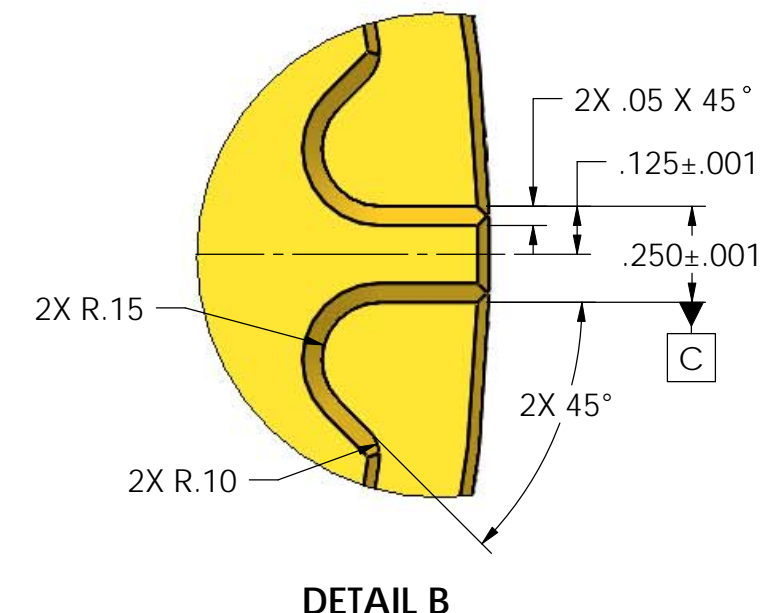
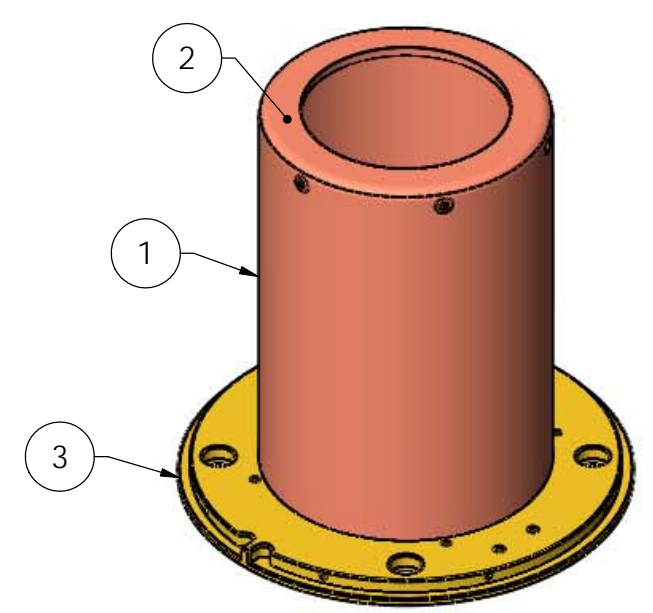


REVISIONS				
REV	ZONE	DESCRIPTION	CHANGED BY	APPROVED
A		INITIAL RELEASE		



SECTION C-C
VIEW ROTATED TO VERTICAL
REPEATED 4 PLACES



DETAIL B

- 903 4X, FOR SILVER PLATING, MASK ENTIRE HOLE (THREADS AND C-BORE) SHOWN IN SECTION C-C
 - 902 SILVER PLATE PER QQ-S-36SD TYPE 2 OR 3, GRADE B .001 ± .0005 MASK ALL TAPPED HOLES.
 - 900 FOR TECHNICAL QUESTIONS, CONTACT: JIM POTTER, 505-661-8155
 - 500 THOROUGHLY CLEAN PARTS TO REMOVE ALL OIL, GREASE, DIRT, CHIPS, ETC.
 - 237 ALL INSIDE CORNERS TO BE R.015 MAX.
 - 233 REMOVE BURRS AND SHARP EDGES TO .015 MIN.
 - 226 COUNTERSINK ALL TAPPED HOLES TO MAJOR DIA.
 - 213 SURFACE TEXTURE IN ACCORDANCE WITH ASME B46.1-1995.
 - 212 SURFACE TEXTURE SYMBOLS IN ACCORDANCE WITH ASME Y14.36M-1996.
 - 200 DIMENSIONING AND TOLERANCING PER ASME Y14.5M-1994.
 - 104 ABBREVIATIONS PER ASME Y14.38-1999.
- NOTES (UNLESS OTHERWISE SPECIFIED)**
CALCULATED WEIGHT: 13.825 LB

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ITEM	QTY	PART NUMBER	DESCRIPTION	MATERIAL
3	1	1J001757	IPA CATHODE END PLATE	BRASS
2	1	1J001756	IPA CATHODE OUTER TUBE END	COPPER
1	1	1J001755	IPA CATHODE OUTER TUBE	COPPER, HARD DRAWN

PARTS LIST / BILL OF MATERIALS

UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES. TOLERANCES ARE:		 ANGULAR = ± 1° MACHINED FINISH = 63/	
.X = ± .030	.XX = ± .010	.XXX = ± .005	

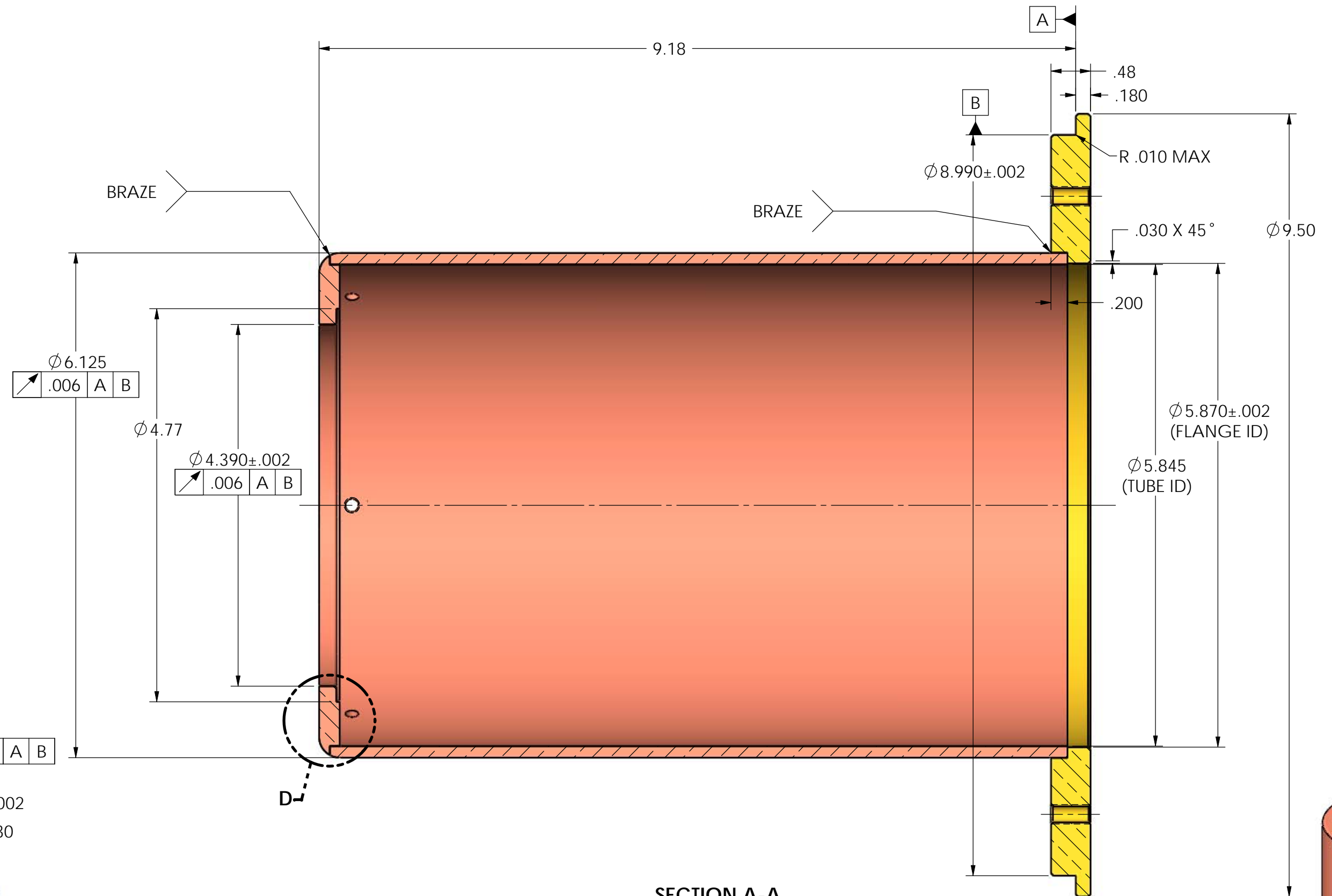
INITIAL RELEASE APPROVALS				MM/DD/YY
DESIGNED	JIM POTTER	JPAW		01/23/10
DRAWN	DANNY GALLANT	GI		01/23/10
CHECKED	JIM POTTER	JPAW		01/23/10
ENGINEERING	JIM POTTER	JPAW		01/23/10

PROJECT: 1209 IPA
 IPA CATHODE OUTER TUBE INSEPARABLE ASSEMBLY
 DRAWING NUMBER: 1J001754
 REV: A

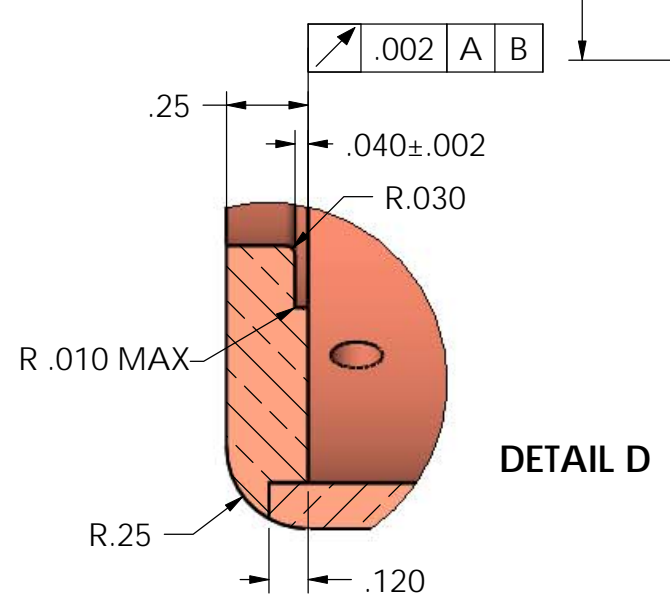
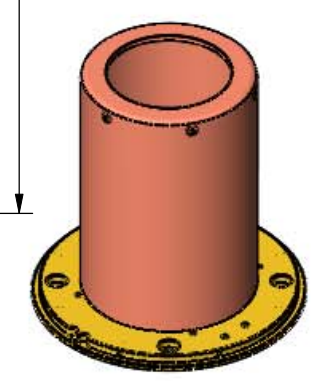
1J001634	NEXT ASSEMBLY	APPROVED	JIM POTTER	JPAW	01/23/10
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SCALE: NONE
DO NOT SCALE DRAWING

SHEET 1 OF 2



SECTION A-A



DETAIL D

JP Accelerator Works, Inc.		
DRAWING NUMBER	REV	
1J001754	A	
SIZE B	SCALE: NONE DO NOT SCALE DRAWING	SHEET 2 OF 2