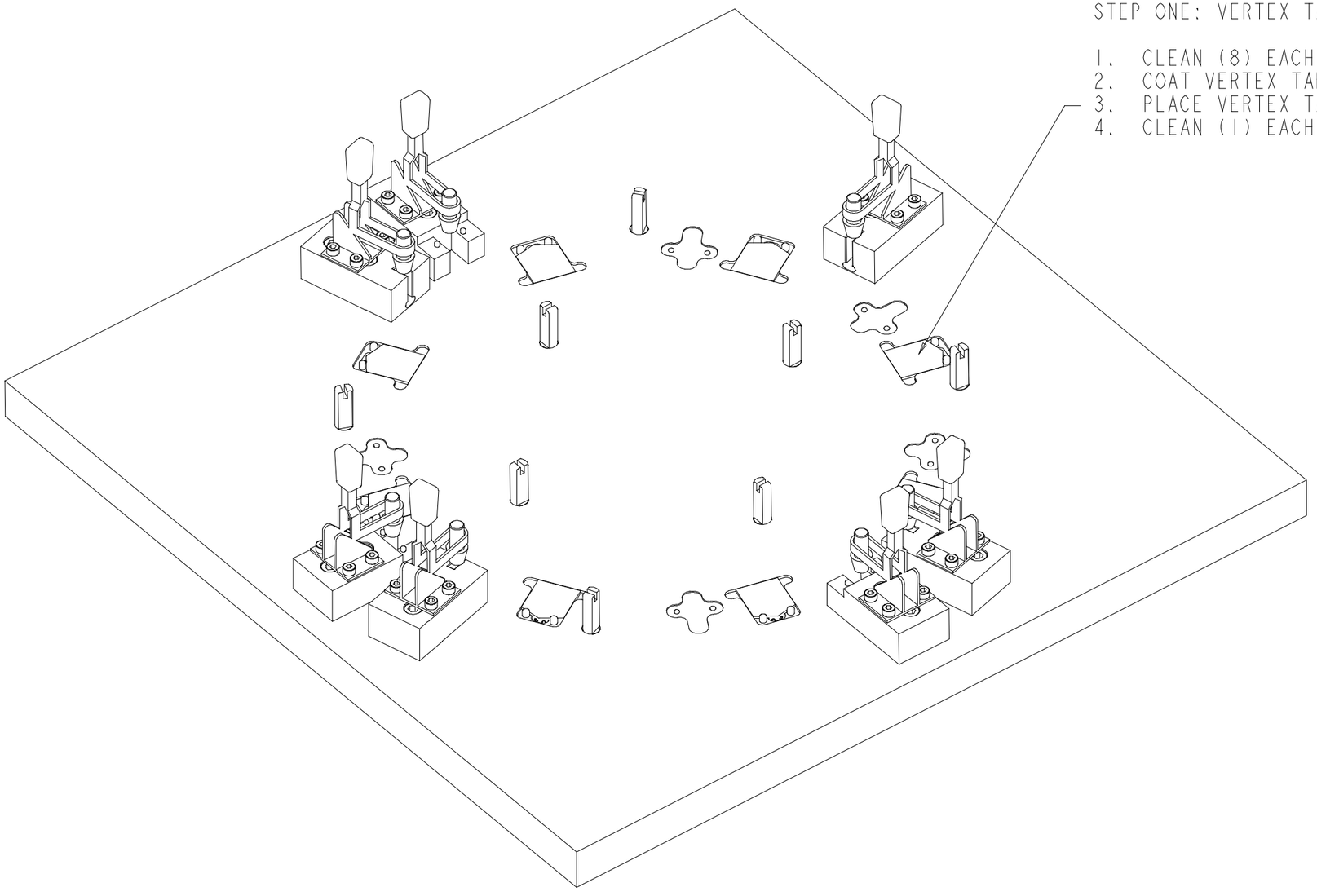
BARREL END CRUCIFORM SUPPORT (250152.ASM) FABRICATION

STEP ONE: VERTEX TAB BONDING PREP

1. CLEAN (8) EACH VERTEXT TABS (250171.PRT).
2. COAT VERTEX TABS WITH ADHESIVE.
3. PLACE VERTEX TABS (250171.PRT) IN POCKETS AS SHOWN.
4. CLEAN (1) EACH CRUCIFORM PLATE (250161.PRT) (NOT SHOWN).



REV	DWG	CHK	ZONE	DATE	CHANGES

UNLESS OTHERWISE SPECIFIED

TOLERANCES		
	X.X ± 0.1	FRAC. ± 1/64
	X.XX ± 0.01	Angles ± 0.50°
	X.XXX ± 0.001	FINISH 125

DO NOT SCALE PRINT

THREADS ARE CLASS 2
CHAMFER ENDS OF ALL SCREW THEADS 30°
CUT ROUND, 1.5 THREAD RELIEF ON MACHINED THREADS
BREAK EDGES .016 MAX. ON MACHINED WORK
REMOVE BURRS, WELD SPLATTER & LOOSE SCALE
IN ACCORDANCE WITH ASME Y14.5M & B46.1

SHOP ORDERS

ACCT NO.	NO. REQD 1	SER NO.	-
DEL TO	E Anderssen	DATE ISSD	-
SURFACE TREATMT		DATE REQD	-
IDENT METHOD	TAG		
PROJECT NUMBER			
PROJECT NAME			
DWG BY	D Uken	DATE	13-Oct-03
CHK BY	N Hartman	DATE	
APR BY	E Andersen	DATE	

ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY
UNIVERSITY OF CALIFORNIA - BERKELEY

ATLAS PIXEL DETECTOR
BEAM PIPE AND SERVICES SUPPORT
Cruciform Support Assy Fixture

MICROFILMED:	DWG. TYPE	SHOWN ON	SCALE: 0.750	DO NOT SCALE PRINTS
	ASSEM		SHEET 2 OF 14	
PATENT CLEAR:	DESIGN ACCT. NO.	CATEGORY CODE	DWG. NO.	SIZE / REV.
	See WebJO	API000	2501974	1