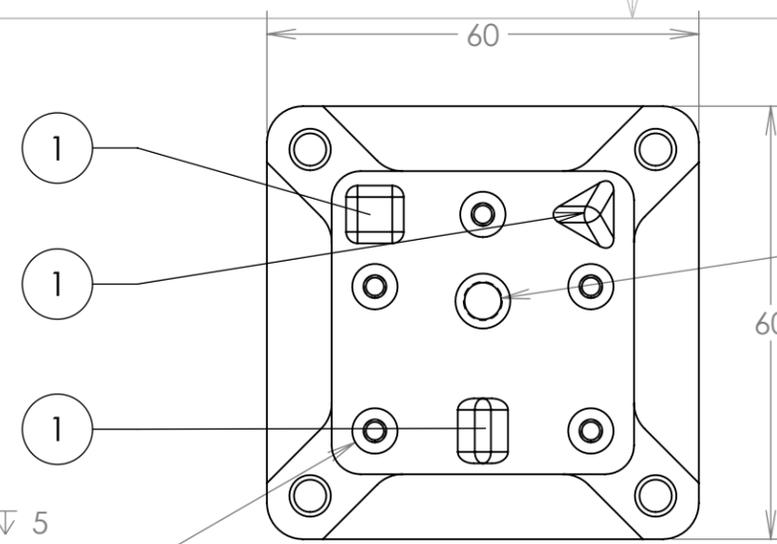


Overall size shown here. Part is to correspond to solid model.

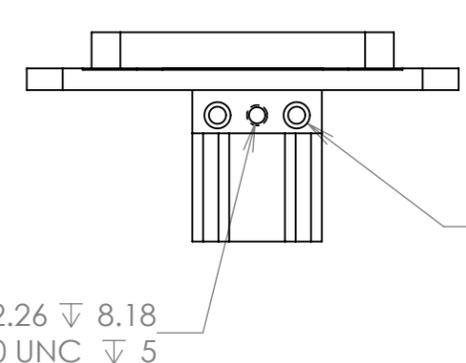
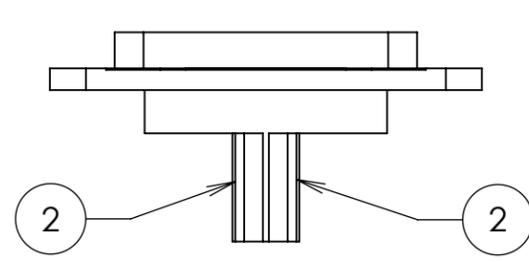
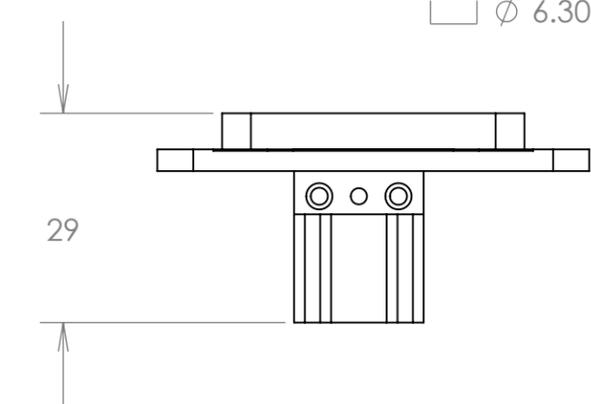
The important feature to reference is the kinematic clamp features (1) with respect to the side walls indicated as (2), within 0.025mm of the solid model definition.

Screw titanium and aluminum stock together with M3x0.5 titanium flatheads 6mm long, prior to machining rest of features.

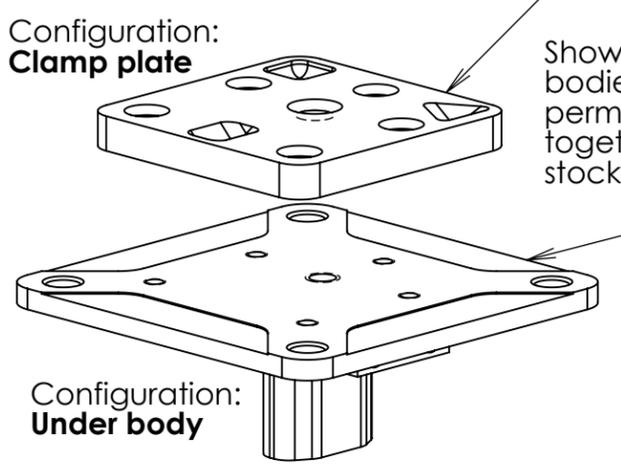
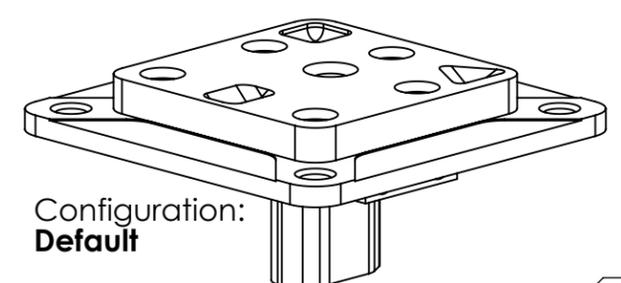
REVISIONS				
REV	DWG	CHK	DATE	DESCRIPTION
1	JHS	JHS	2011-06-10	Initial drawing.
2	JHS	JHS	2011-12-15	Separate into two materials, screwed together permanently



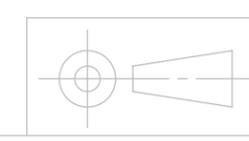
Ø 5.11 ± 11
 10-24 UNC ± 9.65
 √ Ø 7.62 X 90°, NEAR SIDE



2X Ø 2.38 ± 8
 √ Ø 3.65 X 90°, NEAR SIDE
 3/32" dowel pin presses into these holes



Ti 6Al-4V
 Shown as two separate bodies, really one permanently screwed together from 2 pieces of stock
 6061-T6



MATERIAL	Ti 6Al-4V (clamp plate) 6061-T6 (under body)	
SURFACE TREATMENT		
DIMENSIONS IN MM. UNLESS OTHERWISE SPECIFIED:		
TOLERANCES	X.X ± 0.5	FRAC. ± 1/64
	X.XX ± 0.1	ANGLES ± 1.00°
	X.XXX ± 0.05	FINISH $\sqrt[3.2]{\mu\text{m}}$

ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY
 UNIVERSITY OF CALIFORNIA - BERKELEY

Guide_bottom_v2

DWG BY Joe Silber	DATE 2011-06-10
CHK BY Joe Silber	DATE 2011-06-10
APR BY Joe Silber	DATE 2011-06-10

THREADS ARE CLASS 2
 CHAMFER ENDS OF ALL SCREW THREADS 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

SER NO.	SCALE: 1:1	SHEET 1 OF 1			
PROJECT NO.	PROJECT NAME	CATEGORY CODE	DWG NO.	SIZE B	REV. 2