



DWG. NO.		SIZE	REV.	SH.		
2501844		1	1		1	
ITEM	PART NO	REQD	DESCRIPTION		MATERIAL	
19	250192	1	Longeron Assy Fixture Sleeve Holder		Al 6061-T6	
18	250191	1	Longeron Assy Fixture Riser for Sleeve and Strut End		Al 6061-T6	
17	250189	1	Longeron Assy Fixture Riser for Forward Attachment		Al 6061-T6	
16	250188	1	Longeron Assy Fixture Riser for Strut Longeron Brace		Al 6061-T6	
15	250187	1	Longeron Assy Fixture Riser for Middle Attachment		Al 6061-T6	
14	250186	1	Longeron Assy Fixture Riser for End Attachment		Al 6061-T6	
13	250185	1	Longeron Support Assy Fixture Baseplate		Al 6061-T6	
12	250155	1	Beampipe Support Longeron Assembly			
11		10	Socket Head Cap Screw M8-1 by 30MM LG		Steel	
10		1	Socket Head Cap Screw M6-1 by 16MM LG		Steel	
9		20	Socket Head Cap Screw M4-.7 by 10MM Long		Steel	
8		1	SHCS M6 by 1		Steel	
7		1	Flat Washer M6		Steel	
6		2	Dowel Pin 8MM DIA x 10MM LG		Steel	
5		10	Dowel Pin 6MM DIA x 20MM LG		Steel	
4		2	Dowel Pin 3MM DIA x 6MM LG		Steel	
3		5	Dowel Pin 3MM DIA x 10MM LG		Steel	
2		5	Destaco 201U Vertical Handle Clamp			
1		5	De Staco Stock Plunger for Vertical Clamp 201-U			

					UNLESS OTHERWISE SPECIFIED		SHOP ORDERS		SER NO. -	<div>ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY</div> <div>UNIVERSITY OF CALIFORNIA - BERKELEY</div> <div>ATLAS PIXEL DETECTOR BEAM PIPE AND SERVICES SUPPORT Beampipe Longeron Support Assembly Fixture</div>									
					X.X ± 0.1	FRAC. ± 1/64	ACCT NO. NO. REQD 1	DATE ISSD -											
					X.XX ± 0.01	Angles ± 0.50°	DEL TO E Anderssen	DATE REQD -											
					X.XXX ± 0.001	FINISH 125 \sqrt{Ra}	SURFACE TREATMT IDENT METHOD TAG												
					DO NOT SCALE PRINT		PROJECT NUMBER												
					THREADS ARE CLASS 2		PROJECT NAME												
					CHAMFER ENDS OF ALL SCREW THREADS 30°		DWG BY D Uken		DATE 05-Sep-03										
					CUT ROUND, 1.5 THREAD RELIEF ON MACHINED THREADS		CHK BY N Hariman		DATE										
					BREAK EDGES .015 MAX. ON MACHINED WORK		APR BY E Anderssen		DATE										
					REMOVE BURRS, WELD SPLATTER & LOOSE SCALE														
					IN ACCORDANCE WITH ASME Y14.5M & B46.1														
REV	DWG	CHK	ZONE	DATE	CHANGES														
										MICROFILMED:		DWG. TYPE		SHOWN ON		SCALE: 0.200		DO NOT SCALE PRINTS	
												ASSEM						SHEET 1 OF 2	
										PATENT CLEAR:		DESIGN ACCT. NO. See WebJO		CATEGORY CODE API000		DWG. NO. 2501844		SIZE 1	