



DWG. NO.		SIZE	REV.	SH.		
2501504		1	1		1	
ITEM	PART NO	REQD	DESCRIPTION		MATERIAL	
9	250155	4	Beampipe Support Longeron Assembly			
8	250154	1	Beampipe Support Cruciform, Forward Position			
7	250153	1	Beampipe Support Cruciform, Middle Position			
6	250152	1	Beampipe Support Cruciform, Barrel End			
5	250051	2	Position Mechanism			
4	250040	2	Tension Mechanism			
3		4	Socket Head Cap Screw M6-1 by 30MM LG		Steel	
2		24	Socket Head Cap Screw M3-.5 X 8MM LG		Steel	
1		4	Flat Washer M6		Steel	

ASSEMBLY NOTE:

1. EACH LONGERON ASSY (ITEM 9) IS ATTACHED BY A PAIR OF M3-.5 X 8MM LG SCREWS TO EACH CRUCIFORM SUPPORT (ITEMS 6-8)
2. AS SHOWN IN DETAIL A, AN ADDITIONAL ATTACHMENT IS MADE WITH AN M6-1 X 30 MM LG SCREW AND M6 WASHER (ITEMS 1 AND 3) THRU THE FORWARD CRUCIFORM TO THE STRUT LONGERON MOUNT BUSHING (250180.PRT)

DETAIL A  
SCALE 2.000

					UNLESS OTHERWISE SPECIFIED		SHOP ORDERS		SER -		ERNEST ORLANDO LAWRENCE	
					X.X ± 0.1		ACCT NO.		NO.		BERKELEY NATIONAL LABORATORY	
					FRAC. ± 1/64		REQD 1		DATE		UNIVERSITY OF CALIFORNIA - BERKELEY	
					X.XX ± 0.01		DEL TO E Anderssen		ISSD		ATLAS PIXEL DETECTOR	
					Angles ± 0.50°		DATE REQD		-		BEAM PIPE AND SERVICES SUPPORT	
					X.XXX ± 0.001		FINISH 125/32		-		Main Assembly Side A	
					FINISH 125/32		SURFACE TREATMT		-		SCALE: 0.250	
					DO NOT SCALE PRINT		PROJECT TAG		-		DO NOT SCALE PRINTS	
					THREADS ARE CLASS 2		PROJECT NUMBER		-		SHEET 1 OF 2	
					CHAMFER ENDS OF ALL SCREW THREADS 30°		PROJECT NAME		-		DWG. NO.	
					CUT ROUND, 1.5 THREAD RELIEF ON MACHINED THREADS		DWG D Uken		DATE 05-Sep-03		SIZE	
					BREAK EDGES .010 MAX. ON MACHINED WORK		CHK BY N Hariman		DATE		REV.	
					REMOVE BURRS, WELD SPATTER & LOOSE SCALE		APR BY E Anderssen		DATE		2501504	
					IN ACCORDANCE WITH ASME Y14.5M & B46.1						1	
REV	DWG	CHK	ZONE	DATE	CHANGES							