



DWG. NO.		SIZE		REV.		SH.			
2501974		1		1				1	
ITEM	PART NO	REQD	DESCRIPTION					MATERIAL	
10	27A008	8	Cruciform Fabrication Locator Pin					Free Mach. Brass	
9	250199	3	DeStaco Clamp Base, Cableguide Insert Type					Al 6061-T6	
8	250198	1	Cruciform Support Assy Fixture Baseplate					Al 6061-T6	
7	250190	4	DeStaco Clamp Base, Mid Longeron Attach Insert					Al 6061-T6	
6		14	Socket Head Cap Screw M6-1 by 30MM LG					Steel	
5		28	Socket Head Cap Screw M4-.7 by 10MM Long					Steel	
4		30	Dowel Pin 4MM Diameter by 10MM Long					Steel	
3		16	Dowel Pin 3MM Dia by 10MM Long					Steel	
2		7	Destaco 201U Vertical Handle Clamp						
1		7	De Staco Stock Plunger for Vertical Clamp 201-U						

					UNLESS OTHERWISE SPECIFIED					SHOP ORDERS					ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY UNIVERSITY OF CALIFORNIA - BERKELEY					
					X.X ± 0.1		FRAC. ± 1/64			ACCT NO.		SER NO.		ATLAS PIXEL DETECTOR						
					X.XX ± 0.01		Angles ± 0.50°			DEL TO		DATE		BEAM PIPE AND SERVICES SUPPORT						
					X.XXX ± 0.001		FINISH 125/μm			E Anderssen		REGD		Cruciform Support Assy Fixture						
					DO NOT SCALE PRINT					SURFACE TREATMT		IDENT METHOD		MICROFILMED:						
					THREADS ARE CLASS 2					PROJECT TAG		PROJECT NUMBER		DWG. TYPE		SCALE: 0.750				
					CHAMFER ENDS OF ALL SCREW THREADS 30°					PROJECT NAME		DATE		ASSEMBLY		DO NOT SCALE PRINTS				
					CUT ROUND, 1.5 THREAD RELIEF ON MACHINED THREADS					DWG. BY D Uken		DATE 13-Oct-03		SHOWN ON		SHEET 1 OF 14				
					BREAK EDGES .016 MAX. ON MACHINED WORK					CHK BY N Hariman		DATE		PATENT CLEAR:		DESIGN ACCT. NO. SIZE REV.				
					REMOVE BURRS, WELD SPATTER & LOOSE SCALE					APP BY E Anderssen		DATE		See WebJ		2501974 1				
					14 ACCORDANCE WITH ASME Y14.5M & B46.1															
REV	DWG	CHK	ZONE	DATE	CHANGES															