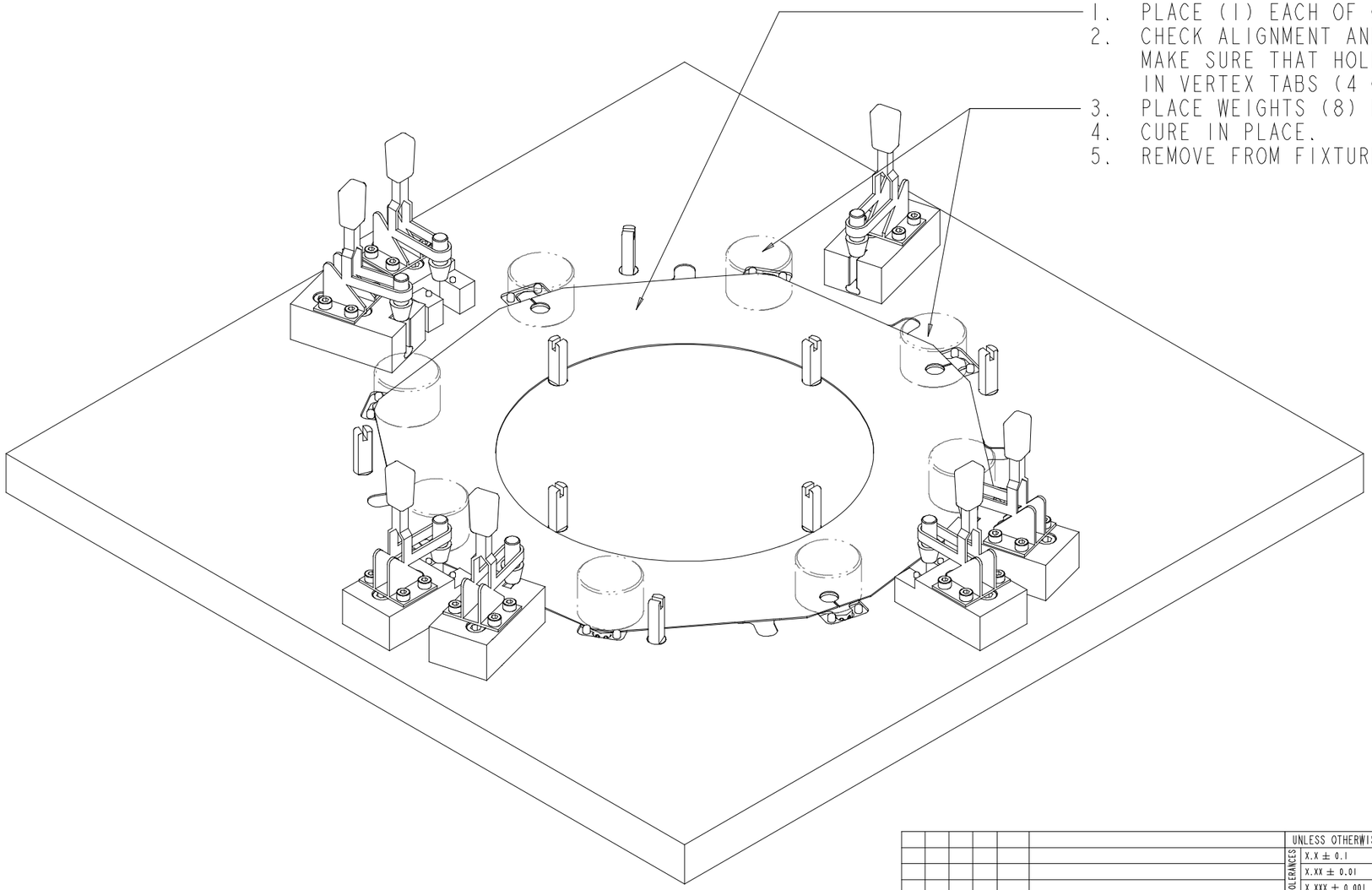
FORWARD CRUCIFORM SUPPORT (250154.ASM) FABRICATION

STEP TWO: VERTEX TAB BONDING

1. PLACE (1) EACH OF CRUCIFORM PLATE (250162.PRT) AS SHOWN.
2. CHECK ALIGNMENT AND CONTACT WITH ALL VERTEX TABS; MAKE SURE THAT HOLES IN PLATE ARE LOCATED OVER HOLES IN VERTEX TABS (4 OF 250170.PRT).
3. PLACE WEIGHTS (8) EACH AS SHOWN.
4. CURE IN PLACE.
5. REMOVE FROM FIXTURE.



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 √(max)

DO NOT SCALE PRINT

THREADS ARE CLASS 2
CHAMFER ENDS OF ALL SCREW TREADS 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.	-
REL TO	E Anderssen	DATE ISSD	-
SURFACE TREATMT		DATE REQD	-
IDENT METHOD	TAG		
PROJECT NUMBER			
PROJECT NAME			
DWG BY	D Uken	DATE	14-Oct-03
CHK BY	N Hartman	DATE	
APR BY	E Anderssen	DATE	

ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY
UNIVERSITY OF CALIFORNIA - BERKELEY

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

MICROFILMED:	DWG. TYPE	SHOWN ON	SCALE: 0.750	DO NOT SCALE PRINTS
	ASSEM		SHEET 11 OF 14	
PATENT CLEAR:	DESIGN ACCT. NO.	CATEGORY CODE	DWG. NO.	SIZE / REV.
	See WebJO	API000	2501974	1

Dwg. File: 2501974 Mod# 1 File: 2501974.1SZPROCESS