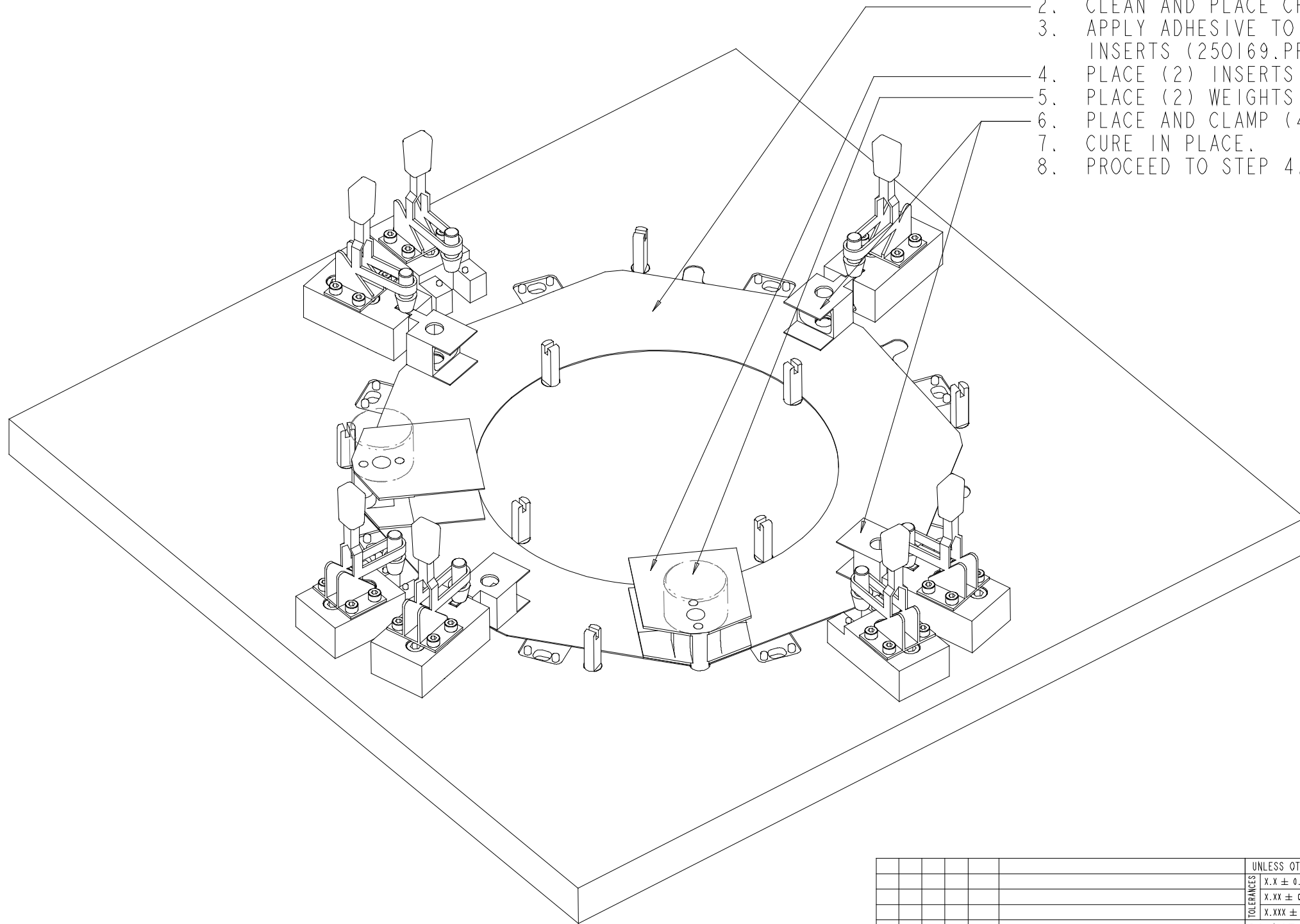


FORWARD CRUCIFORM SUPPORT (250154.ASM) FABRICATION

STEP THREE: CRUCIFORM INSERT BONDING

1. CLEAN AND MASK INSERTS (4 OF 250169.PRT, 2 OF 250166.PRT).
2. CLEAN AND PLACE CRUCIFORM PLATE (250163.PRT) AS SHOWN.
3. APPLY ADHESIVE TO BONDING AREAS OF INSERTS (250169.PRT, 250166.PRT).
4. PLACE (2) INSERTS (250166.PRT) AS SHOWN.
5. PLACE (2) WEIGHTS AS SHOWN.
6. PLACE AND CLAMP (4) INSERTS (250169.PRT) AS SHOWN.
7. CURE IN PLACE.
8. PROCEED TO STEP 4.



					UNLESS OTHERWISE SPECIFIED		SHOP ORDERS		REV. NO. -	ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY UNIVERSITY OF CALIFORNIA - BERKELEY							
					TOLERANCES		ACCT. NO.	NO. REQ. 1	DATE ISSD								
							DEL. TO	E Anderssen	DATE REQ.	ATLAS PIXEL DETECTOR BEAM PIPE AND SERVICES SUPPORT Cruciform Support Assy Fixture, Fabrication Process							
							TOLERANCES										
							PROJECT NUMBER			SCALE: 0.750							
							PROJECT NAME										
							BY	D Uken	DATE 14-Oct-03	SHEET 12 OF 14							
							CHK	N Hariman	DATE								
							APP	E Anderssen	DATE	DWG. NO. 2501974 SIZE 1							
							PATENT CLEAR: See WebJØ API000										
							DESIGN ACCT. NO. CATEGORY CODE										
							IN ACCORDANCE WITH ASME Y14.5M & B46.1										
							</										