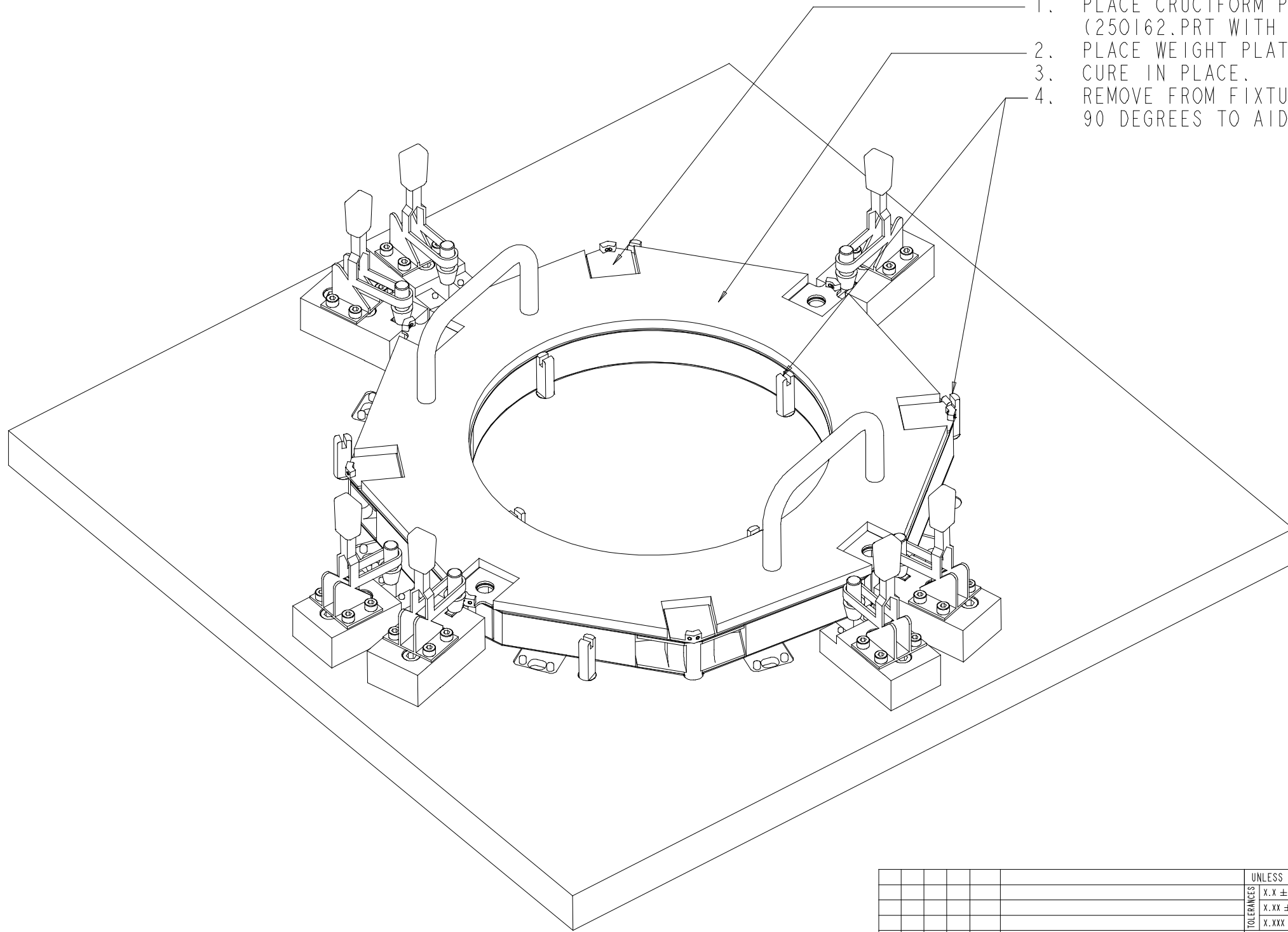


FORWARD CRUCIFORM SUPPORT (250154.ASM) FABRICATION

STEP FIVE: CRUCIFORM PLATE FINAL BONDING

1. PLACE CRUCIFORM PLATE WITH VERTEX TABS FROM STEP TWO (250162.PRT WITH (4) EACH OF 250170.PRT & 250171.PRT) AS SHOWN.
2. PLACE WEIGHT PLATE (250148.PRT) WITH HANDLES AS SHOWN.
3. CURE IN PLACE.
4. REMOVE FROM FIXTURE. TWIST LOCATOR PINS (27A008.PRT 90 DEGREES TO AID IN RELEASE FROM FIXTURE.



					UNLESS OTHERWISE SPECIFIED		SHOP ORDERS		REV. NO. -	ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY UNIVERSITY OF CALIFORNIA - BERKELEY			
					TOLERANCES	X.X ± 0.1	FRAC. ± 1/64	ACCT. NO. 1	REQD. 1				
						X.XX ± 0.01	Angles ± 0.50°	DEL. TO E Anderssen	DATE REQD. -	ATLAS PIXEL DETECTOR BEAM PIPE AND SERVICES SUPPORT Cruciform Support Assy Fixture, Fabrication Process			
						X.XXX ± 0.001	FINISH 125/100	SURFACE TREATMT	DATE REQD. -				
					DO NOT SCALE PRINT		IDENT. TAG		(Stamp)		SCALE: 0.750 DO NOT SCALE PRINTS		
					THREADS ARE CLASS 2		PROJECT METHOD						
					CHAMFER ENDS OF ALL SCREW THREADS 30°		PROJECT NUMBER		PATENT CLEAR: DESIGN ACCT. NO. CATEGORY CODE		DWG. NO. 2501974 SIZE REV. 1		
					CUT ROUND, 1.5 THREAD RELIEF ON MACHINED THREADS		PROJECT NAME						
					BREAK EDGES .015 MAX. ON MACHINED WORK		DWG. D Uken		DATE 14-Oct-03		SHEET 14 OF 14		
					REMOVE BURRS, WELD SPLATTER & LOOSE SCALE		CHK BY N Harrison		DATE				
					IN ACCORDANCE WITH ASME Y14.5M & B46.1		APR BY E Anderssen		DATE		\$ee WebJO API000		
REV	DWG	CHK	ZONE	DATE	CHANGES								