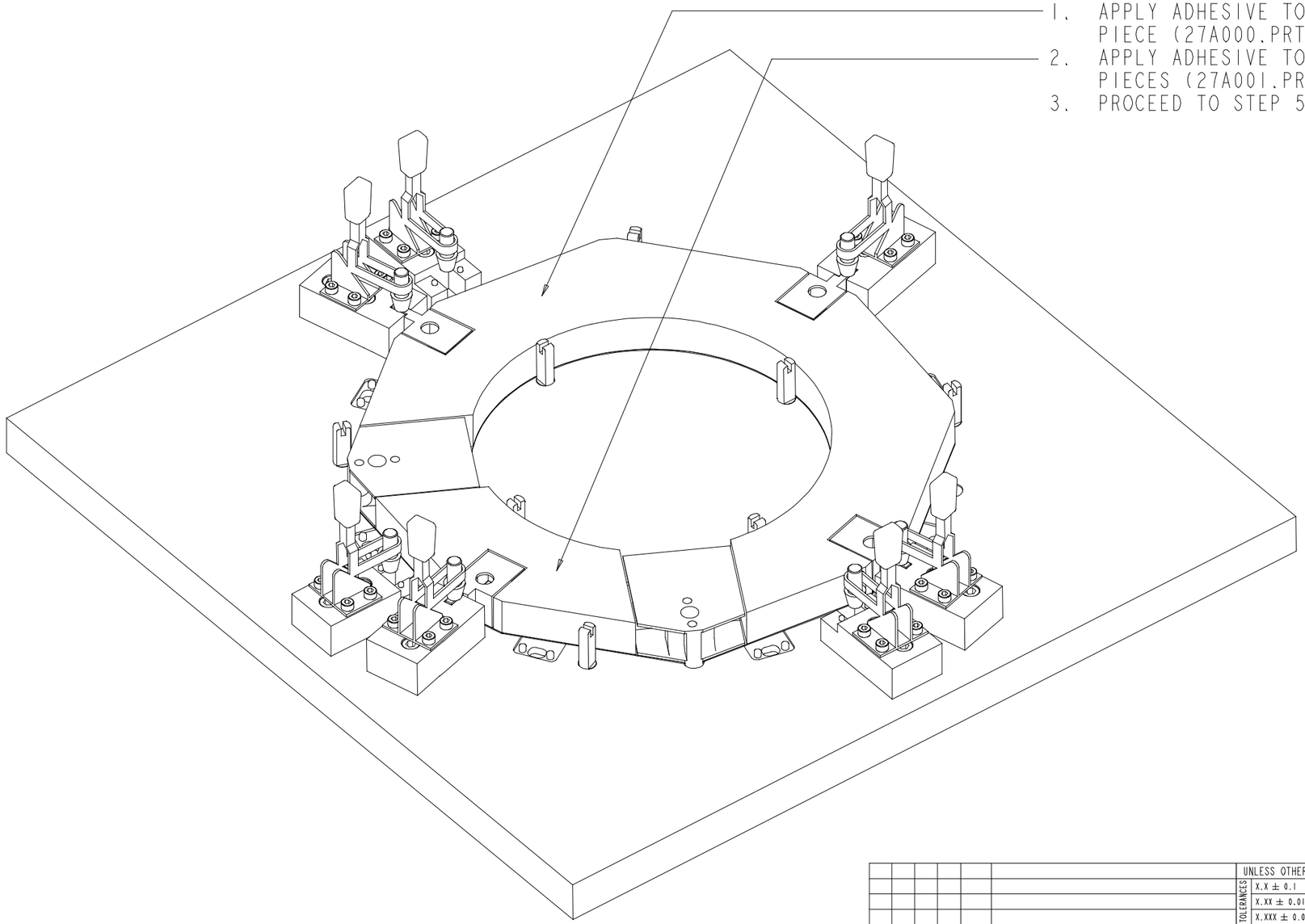
FORWARD CRUCIFORM SUPPORT (250154.ASM) FABRICATION

STEP FOUR: CRUCIFORM CORE BONDING

1. APPLY ADHESIVE TO BOTH SIDES OF CRUCIFORM CORE PIECE (27A000.PRT) AND PLACE AS SHOWN.
2. APPLY ADHESIVE TO BOTH SIDES OF (2) CRUCIFORM CORE PIECES (27A001.PRT) AND PLACE AS SHOWN.
3. PROCEED TO STEP 5.



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 √(RMS)

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
REL TO E Anderssen
SURFACE TREATMT
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

SER NO. -
DATE ISSD -
DATE REQD -

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: ASSEM
SHOWN ON
SCALE: 0.750
DO NOT SCALE PRINTS
SHEET 13 OF 14
PATENT CLEAR:
DESIGN ACCT. NO.: See WebJO
CATEGORY CODE: API000
DWG. NO.: 2501974
SIZE
REV.: 1