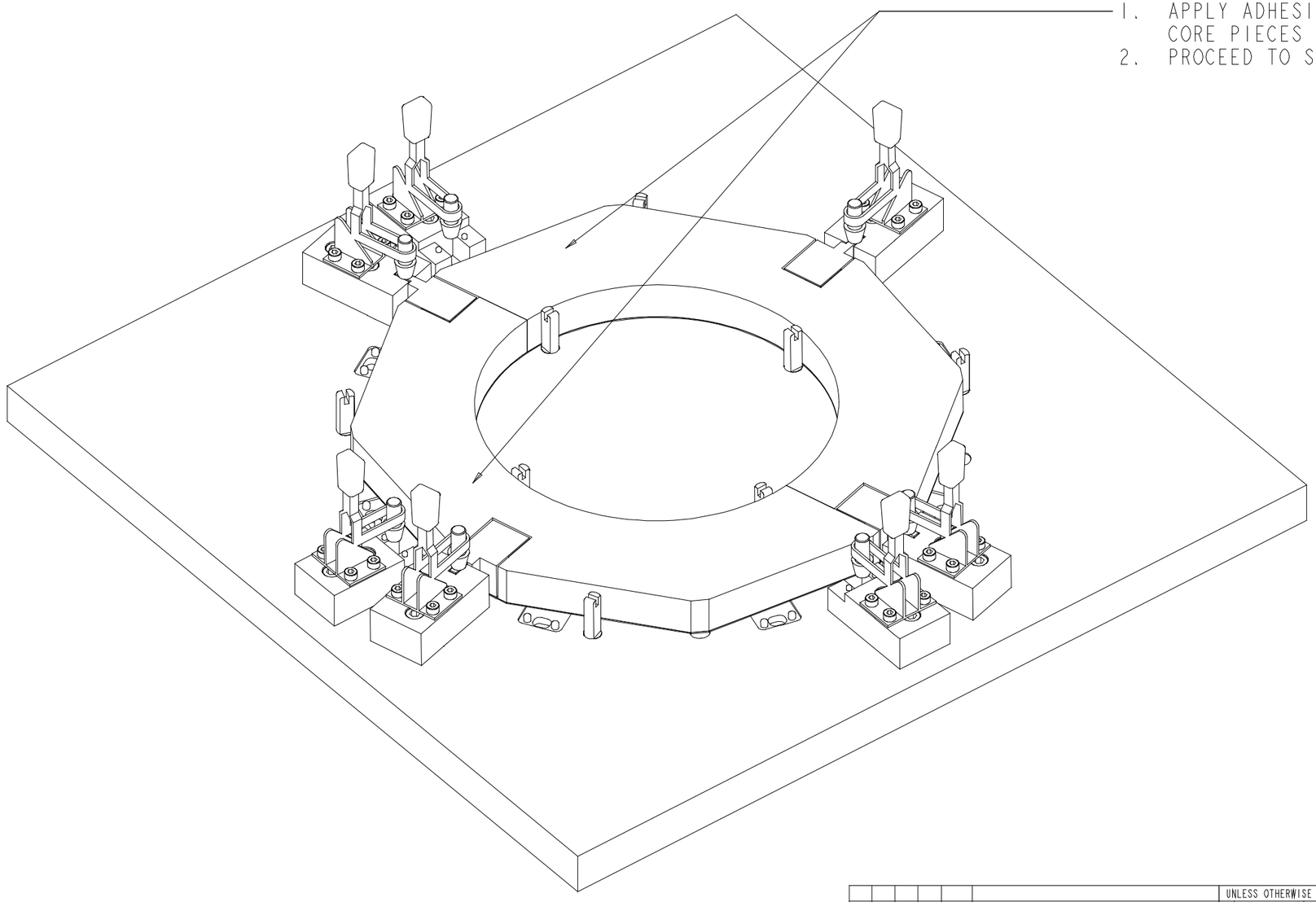
MIDDLE CRUCIFORM SUPPORT (250152.ASM) FABRICATION

STEP TWO: CRUCIFORM CORE BONDING

1. APPLY ADHESIVE TO BOTH SIDES OF (2) CRUCIFORM CORE PIECES (27A003.PRT) AND PLACE AS SHOWN.
2. 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 THEADS 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.	-
DEL TO	E Anderssen	DATE ISSD	-
SURFACE TREAT'MT		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 8 OF 14	
PATENT CLEAR:	DESIGN ACCT. NO.	CATEGORY CODE	DWG. NO.	SIZE / REV.
	See WebJO API000		2501974	1

Dwg. File: 2501974 Mod=1 File: 250152.120PROCESS