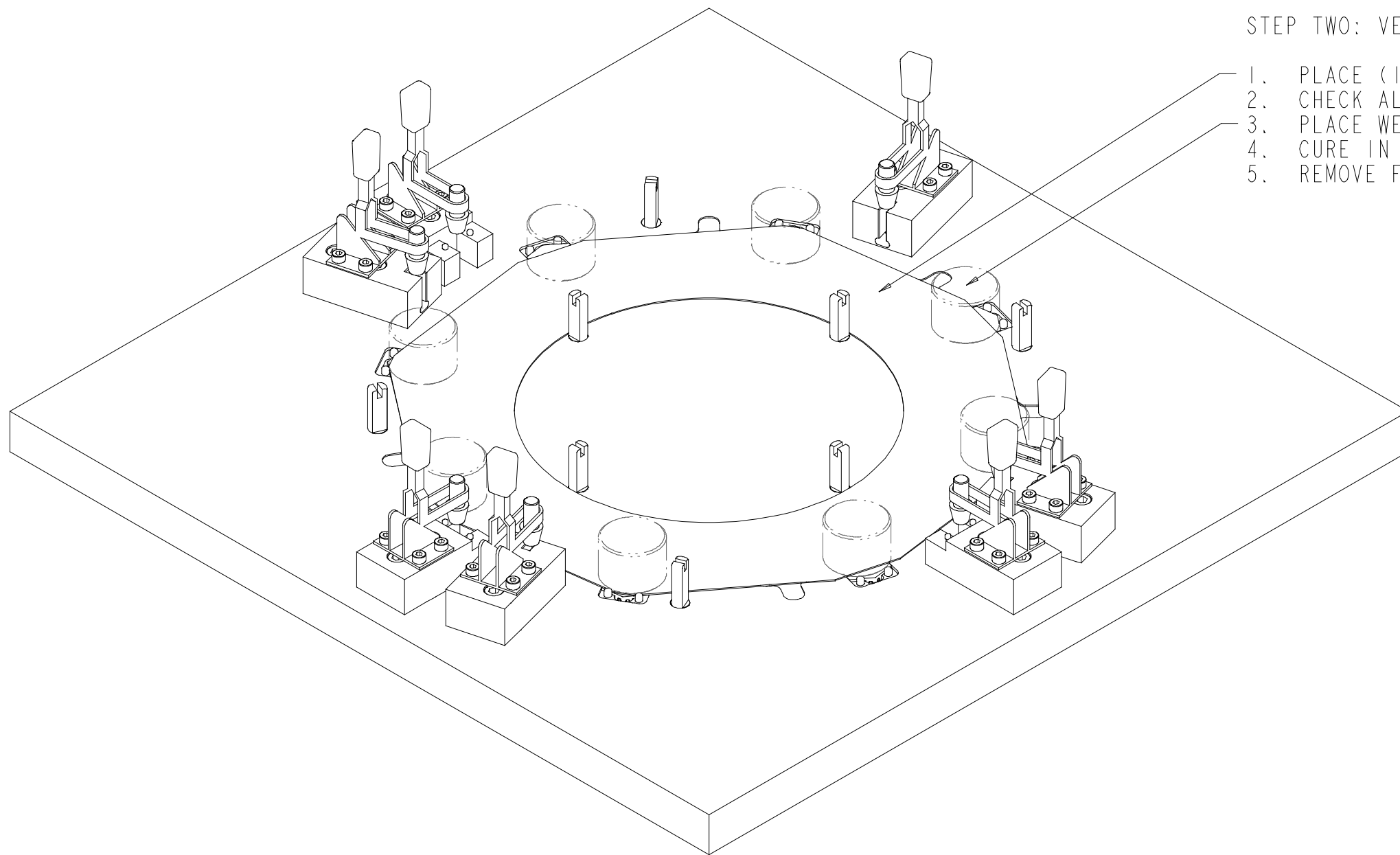


BARREL END CRUCIFORM SUPPORT (250152.ASM) FABRICATION

STEP TWO: VERTEX TAB BONDING

1. PLACE (1) EACH CRUCIFORM PLATE (250161.PRT)
2. CHECK ALIGNMENT AND CONTACT WITH ALL VERTEX TABS
3. PLACE WEIGHTS (8) EACH AS SHOWN.
4. CURE IN PLACE
5. REMOVE FROM FIXTURE



					UNLESS OTHERWISE SPECIFIED		SHOP ORDERS		SER NO. -		<div>ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY UNIVERSITY OF CALIFORNIA - BERKELEY</div> <div>ATLAS PIXEL DETECTOR BEAM PIPE AND SERVICES SUPPORT Cruciform Support Assy Fixture, Fabrication Process</div> <div>MICROFILMED: DWG. TYPE ASSEM SHOWN ON SHEET 3 OF 14</div> <div>PATENT CLEAR: DESIGN ACCT. NO. CATEGORY CODE DWG. NO. 2501974 SIZE REV. 1</div>					
					TOLERANCES		ACCT NO.		NO. REQD 1						DATE ISSD	
					X.X ± 0.1 FRAC. ± 1/64		DEL TO		E Anderssen						DATE REQD	
					X.XX ± 0.01 Angles ± 0.50°		SURFACE TREATMT									
					X.XXX ± 0.001 FINISH 125/1000		IDENT METHOD TAG									
					DO NOT SCALE PRINT		PROJECT NUMBER									
					THREADS ARE CLASS 2		PROJECT NAME									
					CHAMFER ENDS OF ALL SCREW THREADS 30°		DWG D Uken		DATE 13-Oct-03							
					CUT ROUND, 1.5 THREAD RELIEF ON MACHINED THREADS		CHK BY N Hartman		DATE							
					BREAK EDGES .015 MAX. ON MACHINED WORK		APP BY E Anderssen		DATE							
					REMOVE BURRS, WELD SPLATTER & LOOSE SCALE		BY		DATE							
					IN ACCORDANCE WITH ASME Y14.5M & B46.1											
REV	DWG	CHK	ZONE	DATE	CHANGES											