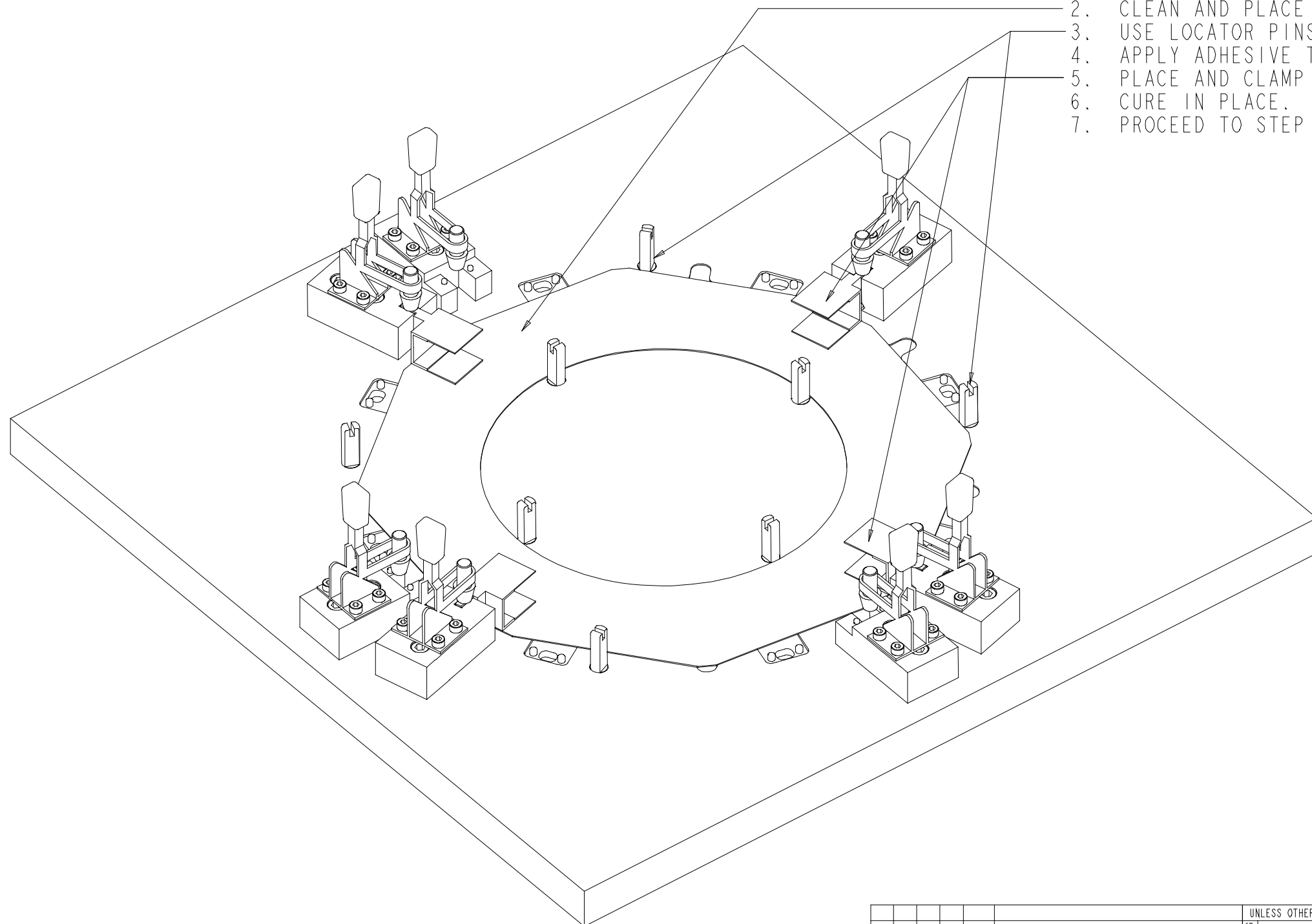



MIDDLE CRUCIFORM SUPPORT (250153.ASM) FABRICATION

STEP ONE: CRUCIFORM INSERT BONDING

1. CLEAN AND MASK INSERTS (4 OF 250167.PRT).
2. CLEAN AND PLACE CRUCIFORM PLATE (250161.PRT) AS SHOWN;
3. USE LOCATOR PINS (27A008.PRT) TO ALIGN PLATE TO FIXTURE.
4. APPLY ADHESIVE TO BONDING AREAS OF INSERTS (250167.PRT).
5. PLACE AND CLAMP (4) INSERTS (250167.PRT) AS SHOWN.
6. CURE IN PLACE.
7. PROCEED TO STEP 2.



					UNLESS OTHERWISE SPECIFIED			SHOP ORDERS			SER. NO. -		ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY UNIVERSITY OF CALIFORNIA - BERKELEY 					
					TOLERANCES			ACCT. NO. 1			DATE ISSD -							
					X.X ± 0.1 FRAC. ± 1/64			DEL. TO E Anderssen			DATE REQ. -							
					X.XX ± 0.01 Angles ± 0.50°													
					X.XXX ± 0.001 FINISH 125/100			SURFACE TREATMT										
					DO NOT SCALE PRINT			IDENT. TAG										
					THREADS ARE CLASS 2			PROJECT NUMBER										
					CHAMFER ENDS OF ALL SCREW THREADS 30°			PROJECT NAME										
					CUT ROUND, 1.5 THREAD RELIEF ON MACHINED THREADS			DWG. NO. D Uken			DATE 14-Oct-03							
					BREAK EDGES .015 MAX. ON MACHINED WORK			CHK BY N Hariman			DATE							
					REMOVE BURRS, WELD SPLATTER & LOOSE SCALE			APP. BY E Anderssen			DATE							
					IN ACCORDANCE WITH ASME Y14.5M & B46.1													
REV	DWG	CHK	ZONE	DATE	CHANGES										PATENT CLEAR: See WebJunction API000			
													DWG. NO. 2501974		SIZE 1		REV. 7	