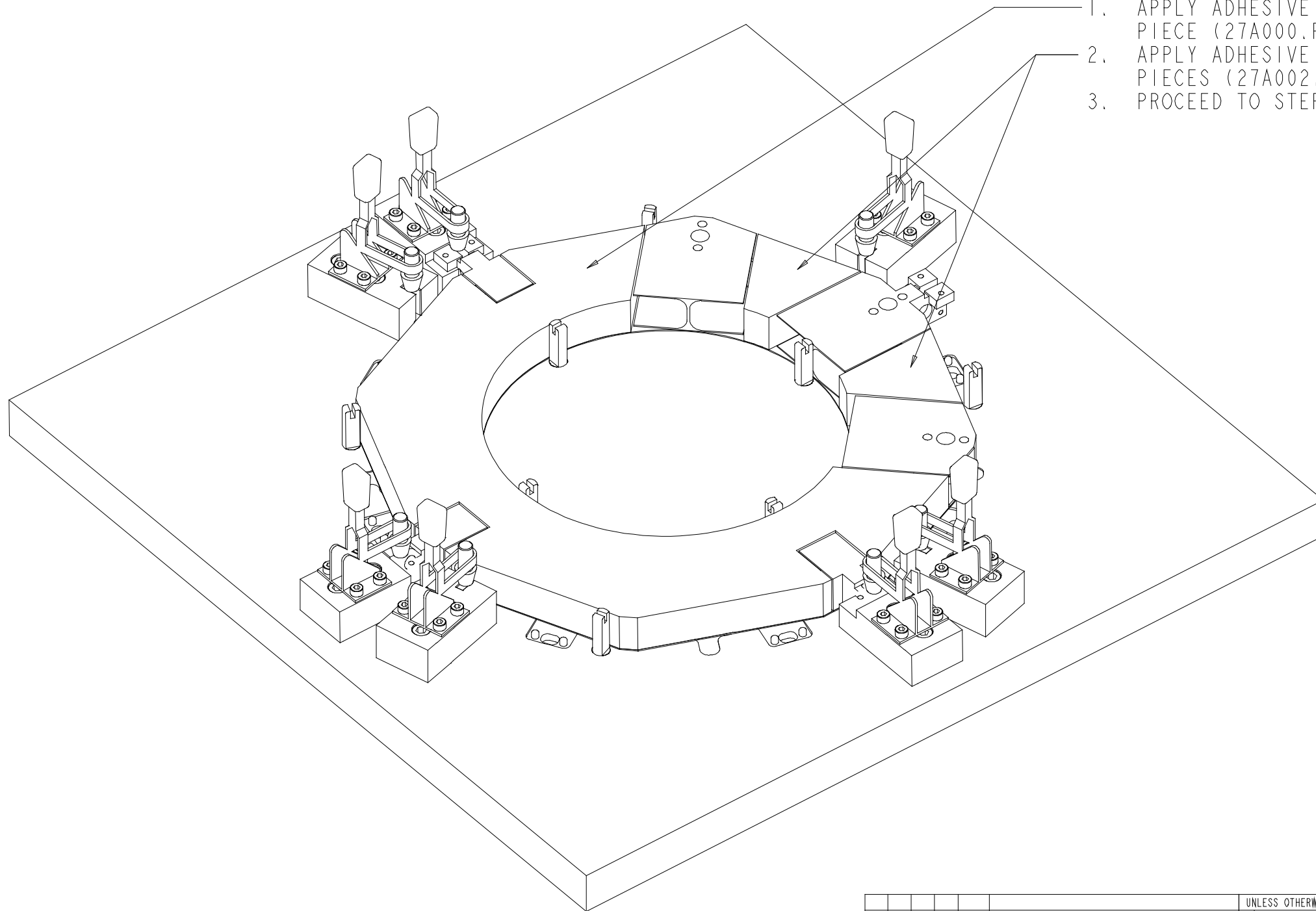



## BARREL END CRUCIFORM SUPPORT (250152.ASM) FABRICATION

## 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 (27A002.PRT) AND PLACE AS SHOWN.
3. PROCEED TO STEP 5.



					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 REQD -		ATLAS PIXEL DETECTOR BEAM PIPE AND SERVICES SUPPORT Cruciform Support Assy Fixture, Fabrication Process				
					X.XX ± 0.01      Angles ± 0.50°			SURFACE TREATMT									
					X.XXX ± 0.001      FINISH 125/100			IDENT. TAG					MICROFILMED:      DWG. TYPE      SHOWN ON      SCALE: 0.750      DO NOT SCALE PRINTS				
					DO NOT SCALE PRINT			PROJECT NUMBER									
					THREADS ARE CLASS 2			PROJECT NAME					SHEET 5 OF 14				
					CHAMFER ENDS OF ALL SCREW THREADS 30°			DWG. NO. D Uken			DATE 13-Oct-03						
					CUT ROUND, 1.5 THREAD RELIEF ON MACHINED THREADS			CHK BY N Hariman			DATE		PATENT CLEAR:      DESIGN ACCT. NO.      CATEGORY CODE      DWG. NO. 2501974      SIZE      REV. 1				
					BREAK EDGES .015 MAX. ON MACHINED WORK			APP. BY E Anderssen			DATE						
					REMOVE BURRS, WELD SPLATTER & LOOSE SCALE								See WebJunction API000				
					IN ACCORDANCE WITH ASME Y14.5M & B46.1												
REV	DWG	CHK	ZONE	DATE	CHANGES												