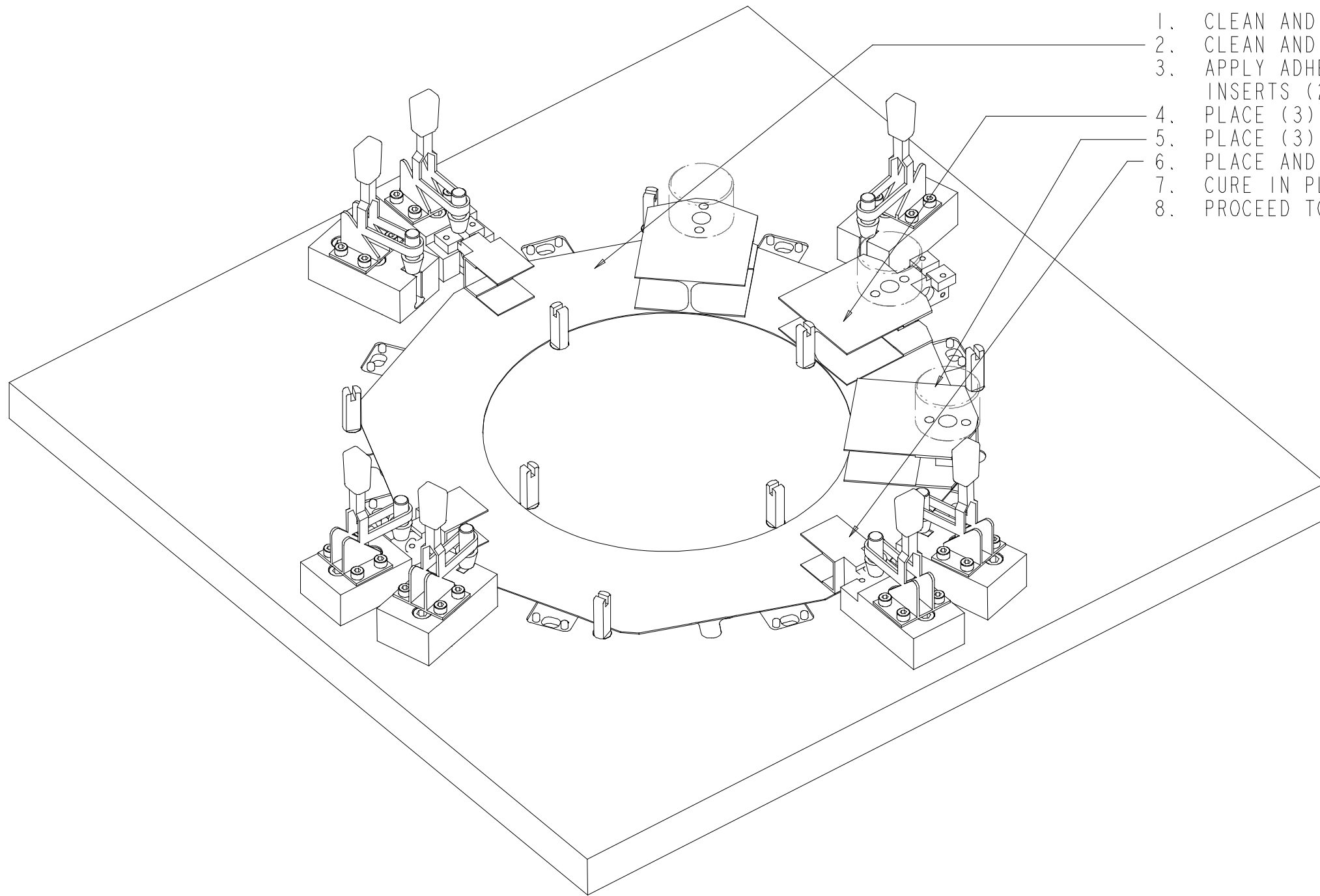



BARREL END CRUCIFORM SUPPORT (250152.ASM) FABRICATION

STEP THREE: CRUCIFORM INSERT BONDING

1. CLEAN AND MASK INSERTS (250164.PRT, 250166.PRT).
2. CLEAN AND PLACE CRUCIFORM PLATE (250160.PRT) AS SHOWN.
3. APPLY ADHESIVE TO BONDING AREAS OF INSERTS (250164.PRT, 250166.PRT).
4. PLACE (3) INSERTS (250166.PRT) AS SHOWN.
5. PLACE (3) WEIGHTS AS SHOWN.
6. PLACE AND CLAMP (3) INSERTS (250164.PRT) AS SHOWN.
7. CURE IN PLACE.
8. PROCEED TO STEP 4.



					UNLESS OTHERWISE SPECIFIED		SHOP ORDERS		REV. -	ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY UNIVERSITY OF CALIFORNIA - BERKELEY 								
					TOLERANCES	X.X ± 0.1	FRAC. ± 1/64	ACCT. NO. 1	REQD. 1					DATE ISSD -				
						X.XX ± 0.01	Angles ± 0.50°	DEL. TO E Anderssen	DATE REQD -									
						X.XXX ± 0.001	FINISH 125/32	SURFACE TREATMT										
					DO NOT SCALE PRINT			IDENT METHOD TAG										
					THREADS ARE CLASS 2			PROJECT NUMBER		ATLAS PIXEL DETECTOR BEAM PIPE AND SERVICES SUPPORT Cruciform Support Assy Fixture, Fabrication Process								
					CHAMFER ENDS OF ALL SCREW THREADS 30°			PROJECT NAME										
					CUT ROUND, 1.5 THREAD RELIEF ON MACHINED THREADS			DWG D Uken	DATE 13-Oct-03									
					BREAK EDGES .019 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			PATENT CLEAR: DESIGN ACCT. NO. CATEGORY CODE See WebJØ API000										
REV	DWG	CHK	ZONE	DATE	CHANGES										MICROFILMED: DWG. TYPE ASSEM SHOWN ON SHEET 4 OF 14 SCALE: 0.750 DO NOT SCALE PRINTS DWG. NO. 2501974 SIZE 1			