



DWG. NO.		SIZE	REV.	SH.		
2501844		1	1		1	
ITEM	PART NO	REQD	DESCRIPTION		MATERIAL	
19	250192	1	Longeron Assy Fixture Sleeve Holder		Al 6061-T6	
18	250191	1	Longeron Assy Fixture Riser for Sleeve and Strut End		Al 6061-T6	
17	250189	1	Longeron Assy Fixture Riser for Forward Attachment		Al 6061-T6	
16	250188	1	Longeron Assy Fixture Riser for Strut Longeron Brace		Al 6061-T6	
15	250187	1	Longeron Assy Fixture Riser for Middle Attachment		Al 6061-T6	
14	250186	1	Longeron Assy Fixture Riser for End Attachment		Al 6061-T6	
13	250185	1	Longeron Support Assy Fixture Baseplate		Al 6061-T6	
12	250155	1	Beampipe Support Longeron Assembly			
11		10	Socket Head Cap Screw M8-1 by 30MM LG		Steel	
10		1	Socket Head Cap Screw M6-1 by 16MM LG		Steel	
9		20	Socket Head Cap Screw M4-.7 by 10MM LG		Steel	
8		1	SHCS M6 by 1		Steel	
7		1	Flat Washer M6		Steel	
6		2	Dowel Pin 8MM DIA x 10MM LG		Steel	
5		10	Dowel Pin 6MM DIA x 20MM LG		Steel	
4		2	Dowel Pin 3MM DIA x 6MM LG		Steel	
3		5	Dowel Pin 3MM DIA x 10MM LG		Steel	
2		5	Destaco 201U Vertical Handle Clamp			
1		5	De Staco Stock Plunger for Vertical Clamp 201-U			

					UNLESS OTHERWISE SPECIFIED		SHOP ORDERS		SER NO. - DATE ISSD - DATE REQD -		ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY UNIVERSITY OF CALIFORNIA - BERKELEY					
					X.X ± 0.1		FRAC. ± 1/64		ACCT NO. NO. REQD 1							
					X.XX ± 0.01		Angles ± 0.50°		DEL TO E Anderssen							
					X.XXX ± 0.001		FINISH 125/32		SURFACE TREATMT							
					DO NOT SCALE PRINT				IDENT METHOD TAG							
					THREADS ARE CLASS 2				PROJECT NUMBER							
					CHAMFER ENDS OF ALL SCREW THREADS 30°				PROJECT NAME							
					BREAK EDGES .016 MAX. ON MACHINED WORK				DWG BY D Uken		DATE 05-Sep-03					
					REMOVE BURRS, WELD SPLATTER & LOOSE SCALE				CHK BY N Hariman		DATE					
					IN ACCORDANCE WITH ASME Y14.3M & B46.1				APP BY E Anderssen		DATE					