

LONGERON SUPPORT ASSY (250I55.ASM) FABRICATION

BONDING STEP: ALL COMPONENTS}

1. CLEAN AND MASK ALL COMPONENTS.

2. APPLY ADHESIVE AND CLAMP END ATTACHMENT (250I76.PRT) TO RISER ONE AS SHOWN.)

3. APPLY ADHESIVE AND INSERT END PIECES (25I80.PRT & 250I81.PRT) INTO STRUT LONGERON (250I79). CLAMP THIS COMPONENT GROUP (250I80 INTO RISER THREE, 250I81 INTO RISER FIVE) AS SHOWN.

4. APPLY ADHESIVE AND SCREW STRUT STABILIZER (250I78.PRT) TO RISER FOUR AS SHOWN.)

5. APPLY ADHESIVE AND PLACE MID ATTACHMENTS (250I42.PRT) ON RISERS TWO AND THREE AS SHOWN.

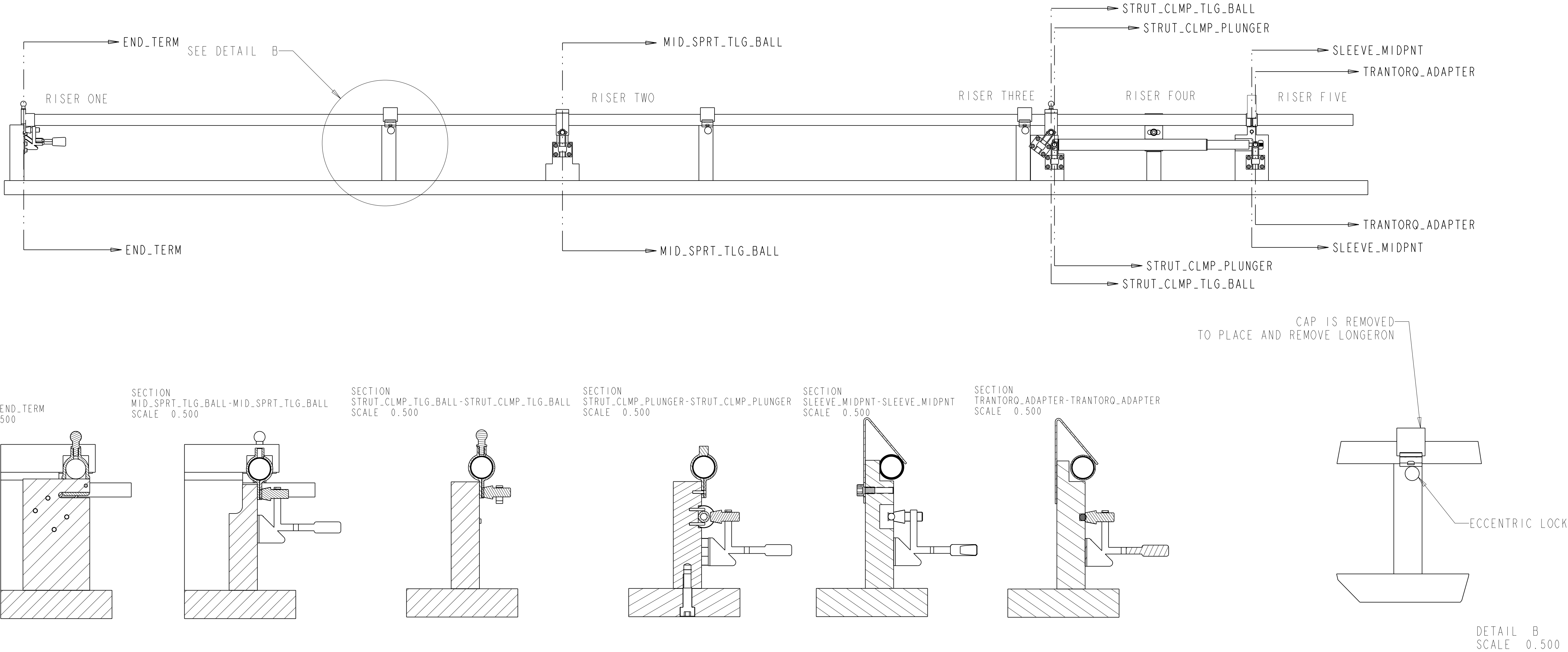
6. APPLY ADHESIVE AND CLAMP MID ATTACHMENT KEEPERS (250I41.PRT) TO RISERS TWO AND THREE AS SHOWN.
7. APPLY ADHESIVE AND POSITION SLEEVE (250I82.PRT) ON MAIN LONGERON (250I75.PRT) IN APPROXIMATE POSITION, 86 MM FROM ONE END. INSERT THE OTHER END OF THIS COMPONENT GROUP INTO END ATTACHMENT (250I76.PRT) ON RISER ONE AND LOCATE THE SLEEVE INTO POSITION ON RISER FIVE AS SHOWN. HOLD SLEEVE IN PLACE WITH SPRING CLAMP (250I92.PRT) AND M6 SCREW AS SHOWN.

8. APPLY ADHESIVE AND CLAMP MID ATTACHMENT KEEPERS (250I41.PRT) TO RISERS TWO AND THREE AS SHOWN.

9. CURE IN PLACE.

10. PLACE (3) TOOLING BALLS, ONE IN EACH LONGERON ATTACHMENT AT RISERS 1-3.

11. REMOVE FROM FIXTURE.



				UNLESS OTHERWISE SPECIFIED				SHOP ORDERS				ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY UNIVERSITY OF CALIFORNIA - BERKELEY			
				TOLERANCES				ACCT NO. REQD				ATLAS PIXEL DETECTOR BEAM PIPE AND SERVICES SUPPORT Beampipe Longeron Support Assembly Fixture			
				X.X ± 0.1				FAC. ± 1/64				DO NOT SCALE PRINTS			
				X.XX ± 0.01				Angles ± 0.50°				SCALE: 0.250			
				X.XXX ± 0.001				FINISH 125 $\sqrt{\mu\text{in}}$				SHEET 2 OF 2			
				DO NOT SCALE PRINT				SURFACE TREATMT				DWG. NO. 250I844			
				THREADS ARE CLASS 2				IDENT. METHOD TAG				REV. 2			
				CHAMFER ENDS OF ALL SCREW THREADS 30°				PROJECT NUMBER				DWG. TYPE ASSEM			
				CUT ROUND, 1.5 THREAD RELIEF ON MACHINED THREADS				PROJECT NAME				SHOWN ON			
				BREAK EDGES .016 MAX. ON MACHINED WORK				DWG. BY D Uken				PATENT CLEAR: See WebJ			
				REMOVE BURRS, WELD SPLATTER & LOOSE SCALE				CHK BY N Hartman				CATEGORY CODE API000			
				IN ACCORDANCE WITH ASME Y14.5M & B46.1				APR BY E Anderssen				DATE 17-Sep-03			
REV				DWG	CHK	ZONE	DATE	CHANGES				DWG. NO. 250I844			