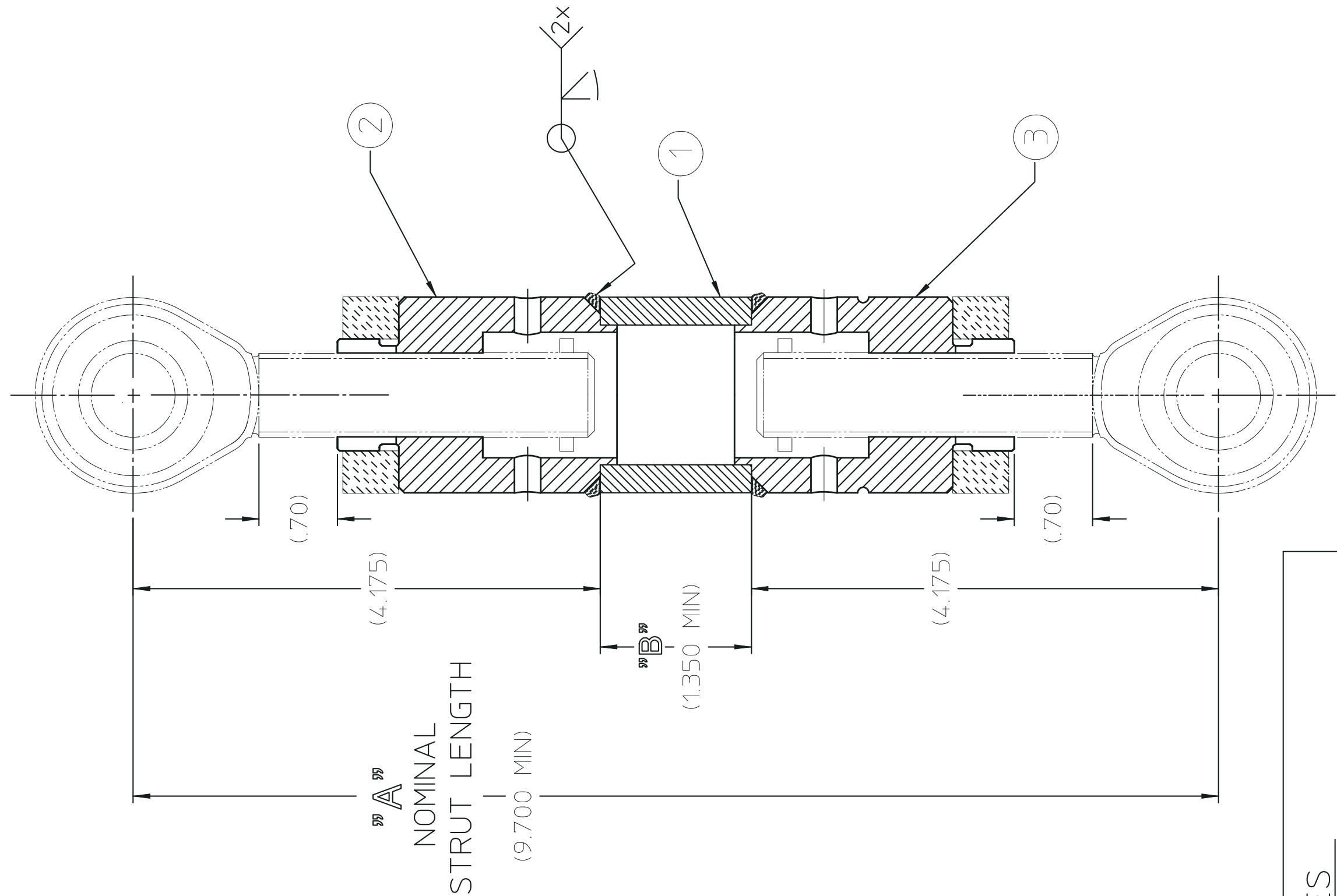


## STEP 1

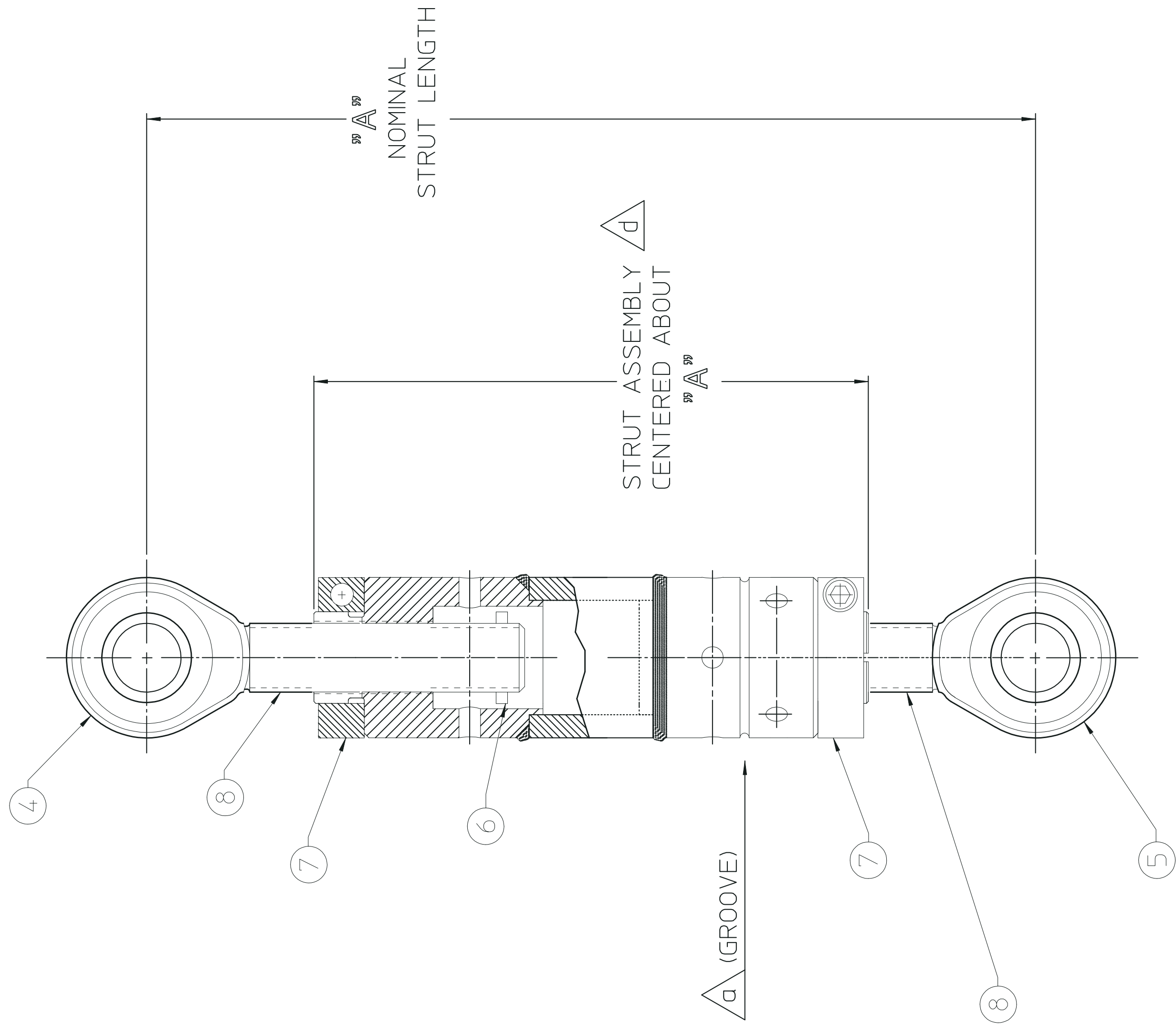
NOTÉ:

1. ENTER DESIRED NOMINAL STRUT LENGTH IN COLUMN "A",  
SUBTRACT 8.350 FROM "A", AND ENTER REMAINDER IN  
COLUMN "B". THIS IS THE LENGTH OF THE TUBE (ITEM 1).
2. CUT THE TUBE (ITEM 1) TO LENGTH "B" AS DETERMINED IN  
STEP 1, NOTE 1.
3. WELD STRUT TUBE ENDS (ITEMS 2 & 3) TO TUBE (ITEM 1).
4. ELECTROLESS NICKEL PLATE ENTIRE WELDMENT TO A  
PLATING THICKNESS OF .0003" MIN / .0008" MAX.



| Part Number | (Nominal Strut Length)<br>"A" | [*A" minus 8.350 =]<br>"B" ± .025 | NOTES                                       |
|-------------|-------------------------------|-----------------------------------|---------------------------------------------|
| 25D08986-1  | 9.700                         | 1.350                             | ABSOLUTE MINIMUM LENGTH                     |
| 25D08986-2  | 15.500                        | 7.150                             | ADJUSTABLE SUPPORT STAND (25F0694)          |
| 25D08986-3  | 14.250                        | 5.900                             | SUPERBEND PS & PSS TABLE TOP                |
| 25D08986-4  | 32.250                        | 23.900                            | SUPERBEND PS TABLE TOP                      |
| 25D08986-5  | 35.250                        | 26.900                            | SUPERBEND PS TABLE TOP                      |
| 25D08986-6  | 43.750                        | 35.400                            | SUPERBEND PSS TABLE TOP                     |
| 25D08986-7  | 14.500                        | 6.150                             | BL 5.31 MIRROR TANK STRUTS                  |
| 25D08986-8  | 26.250                        | 17.900                            | BL 5.31 MIRROR TANK STRUTS                  |
| 25D08986-9  | 26.000                        | 17.650                            | BL 5.31 MIRROR TANK STRUTS                  |
| 25D08986-10 | 36.750                        | 28.400                            | BL 5.01 MIRROR TANK STRUTS                  |
| 25D08986-11 | 32.625                        | 24.275                            | BL 5.01 MIRROR TANK STRUTS                  |
| 25D08986-12 | 10.000                        | 1.650                             | BL 5.01 & 5.03 MONOCHROMATOR TANK STRUTS    |
| 25D08986-13 | 15.000                        | 6.650                             | BL 5.01 & 5.03 MONOCHROMATOR TANK STRUTS    |
| 25D08986-14 | 14.200                        | 5.850                             | BL 8.2 MI TANK HORIZONTAL STRUTS            |
| 25D08986-15 | 16.850                        | 8.500                             | BL 8.2 MI TANK VERTICAL STRUTS              |
| 25D08986-16 | 24.000                        | 15.650                            | FRAME SUPPORT                               |
| 25D08986-17 | 12.000                        | 3.650                             | SPECIAL SUPERBEND PS TABLE TOP              |
| 25D08986-18 | 64.375                        | 56.025                            | BL 5.03 END STATION SUPPORT                 |
| 25D08986-19 | 13.000                        | 4.650                             | BL 12.3 PS TABLE                            |
| 25D08986-20 | 41.300                        | 32.950                            | SUPERBEND PS TABLE TOP                      |
| 25D08986-21 | 44.270                        | 35.920                            | SUPERBEND PSS TABLE TOP                     |
| 25D08986-22 | 48.000                        | 39.650                            | BL1102 END STATION SPECTROGRAPH SUPPORT     |
| 25D08986-23 | 24.500                        | 16.150                            | BL1102 END STATION XES SPECTROM. SUPPORT    |
| 25D08986-24 | 19.500                        | 11.150                            | BL1102 END STATION SALMERON CHAMBER SUPPORT |
| 25D08986-25 | 43.000                        | 34.650                            | BL1102 SALMERON SPECTROMETER SUPPORT        |
| 25D08986-26 | 22.000                        | 13.650                            | BL12.31 ENDSTATION SUPPORT                  |
| 25D08986-27 | 11.530                        | 3.180                             | BL12.31 M2 MIRROR TANK HORIZONTAL STRUTS    |
| 25D08986-28 | 13.530                        | 5.180                             | BL12.31 M2 MIRROR TANK VERTICAL STRUTS      |
| 25D08986-29 | 16.150                        | 7.800                             | BL12.22 DIAGNOSTIC SUPPORT                  |
| 25D08986-30 | 15.150                        | 6.800                             | BL12.22 KB MIRROR TANK SUPPORT              |
| 25D08986-31 | 25.000                        | 16.650                            | BL-4.0 FRONT END PS / PSS ASSY              |
| 25D08986-32 | 41.000                        | 32.650                            | BL-4.0 FRONT END PS / PSS ASSY              |

NOTES



|            |            |            |        |                                         |                                      |
|------------|------------|------------|--------|-----------------------------------------|--------------------------------------|
| O          | 25D8986-25 | 43.000     | 34.650 | BL1102 SALMERON SPECTROMETER SUPPORT    |                                      |
|            | 25D8986-26 | 22.000     | 13.650 | BL1234 ENDSTATION SUPPORT               |                                      |
|            | 25D8986-27 | 11.530     | 3.180  | BL1231 M2 MIRROR TANK HORIZONTAL STRUTS |                                      |
|            | 25D8986-28 | 13.530     | 5.180  | BL1231 M2 MIRROR TANK VERTICAL STRUTS   |                                      |
|            | 25D8986-29 | 16.150     | 7.800  | BL1222 DIAGNOSTIC SUPPORT               |                                      |
|            | 25D8986-30 | 15.150     | 6.800  | BL1222 KB MIRROR TANK SUPPORT           |                                      |
|            | 25D8986-31 | 25.000     | 16.650 | BL-60 FRONT END PS / PSS ASSY           |                                      |
|            | 25D8986-32 | 41.000     | 32.650 | BL-60 FRONT END PS / PSS ASSY           |                                      |
|            | P          | 25D8986-25 | 43.000 | 34.650                                  | BL1102 SALMERON SPECTROMETER SUPPORT |
|            |            | 25D8986-26 | 22.000 | 13.650                                  | BL1234 ENDSTATION SUPPORT            |
| 25D8986-27 |            | 11.530     | 3.180  | BL1231 M2 MIRROR TANK HORIZONTAL STRUTS |                                      |
| 25D8986-28 |            | 13.530     | 5.180  | BL1231 M2 MIRROR TANK VERTICAL STRUTS   |                                      |
| 25D8986-29 |            | 16.150     | 7.800  | BL1222 DIAGNOSTIC SUPPORT               |                                      |
| 25D8986-30 |            | 15.150     | 6.800  | BL1222 KB MIRROR TANK SUPPORT           |                                      |
| 25D8986-31 |            | 25.000     | 16.650 | BL-60 FRONT END PS / PSS ASSY           |                                      |
| 25D8986-32 |            | 41.000     | 32.650 | BL-60 FRONT END PS / PSS ASSY           |                                      |
| R          |            | 25D8986-25 | 43.000 | 34.650                                  | BL1102 SALMERON SPECTROMETER SUPPORT |
|            |            | 25D8986-26 | 22.000 | 13.650                                  | BL1234 ENDSTATION SUPPORT            |
|            | 25D8986-27 | 11.530     | 3.180  | BL1231 M2 MIRROR TANK HORIZONTAL STRUTS |                                      |
|            | 25D8986-28 | 13.530     | 5.180  | BL1231 M2 MIRROR TANK VERTICAL STRUTS   |                                      |
|            | 25D8986-29 | 16.150     | 7.800  | BL1222 DIAGNOSTIC SUPPORT               |                                      |
|            | 25D8986-30 | 15.150     | 6.800  | BL1222 KB MIRROR TANK SUPPORT           |                                      |
|            | 25D8986-31 | 25.000     | 16.650 | BL-60 FRONT END PS / PSS ASSY           |                                      |
|            | 25D8986-32 | 41.000     | 32.650 | BL-60 FRONT END PS / PSS ASSY           |                                      |
|            | S          | 25D8986-25 | 43.000 | 34.650                                  | BL1102 SALMERON SPECTROMETER SUPPORT |
|            |            | 25D8986-26 | 22.000 | 13.650                                  | BL1234 ENDSTATION SUPPORT            |
| 25D8986-27 |            | 11.530     | 3.180  | BL1231 M2 MIRROR TANK HORIZONTAL STRUTS |                                      |
| 25D8986-28 |            | 13.530     | 5.180  | BL1231 M2 MIRROR TANK VERTICAL STRUTS   |                                      |
| 25D8986-29 |            | 16.150     | 7.800  | BL1222 DIAGNOSTIC SUPPORT               |                                      |
| 25D8986-30 |            | 15.150     | 6.800  | BL1222 KB MIRROR TANK SUPPORT           |                                      |
| 25D8986-31 |            | 25.000     | 16.650 | BL-60 FRONT END PS / PSS ASSY           |                                      |
| 25D8986-32 |            | 41.000     | 32.650 | BL-60 FRONT END PS / PSS ASSY           |                                      |
| T          |            | 25D8986-25 | 43.000 | 34.650                                  | BL1102 SALMERON SPECTROMETER SUPPORT |
|            |            | 25D8986-26 | 22.000 | 13.650                                  | BL1234 ENDSTATION SUPPORT            |
|            | 25D8986-27 | 11.530     | 3.180  | BL1231 M2 MIRROR TANK HORIZONTAL STRUTS |                                      |
|            | 25D8986-28 | 13.530     | 5.180  | BL1231 M2 MIRROR TANK VERTICAL STRUTS   |                                      |
|            | 25D8986-29 | 16.150     | 7.800  | BL1222 DIAGNOSTIC SUPPORT               |                                      |
|            | 25D8986-30 | 15.150     | 6.800  | BL1222 KB MIRROR TANK SUPPORT           |                                      |
|            | 25D8986-31 | 25.000     | 16.650 | BL-60 FRONT END PS / PSS ASSY           |                                      |
|            | 25D8986-32 | 41.000     | 32.650 | BL-60 FRONT END PS / PSS ASSY           |                                      |
|            | U          | 25D8986-25 | 43.000 | 34.650                                  | BL1102 SALMERON SPECTROMETER SUPPORT |
|            |            | 25D8986-26 | 22.000 | 13.650                                  | BL1234 ENDSTATION SUPPORT            |
| 25D8986-27 |            | 11.530     | 3.180  | BL1231 M2 MIRROR TANK HORIZONTAL STRUTS |                                      |
| 25D8986-28 |            | 13.530     | 5.180  | BL1231 M2 MIRROR TANK VERTICAL STRUTS   |                                      |
| 25D8986-29 |            | 16.150     | 7.800  | BL1222 DIAGNOSTIC SUPPORT               |                                      |
| 25D8986-30 |            | 15.150     | 6.800  | BL1222 KB MIRROR TANK SUPPORT           |                                      |
| 25D8986-31 |            | 25.000     | 16.650 | BL-60 FRONT END PS / PSS ASSY           |                                      |
| 25D8986-32 |            | 41.000     | 32.650 | BL-60 FRONT END PS / PSS ASSY           |                                      |

|   |   |   |   |   |   |   |   |
|---|---|---|---|---|---|---|---|
| 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 |
|---|---|---|---|---|---|---|---|