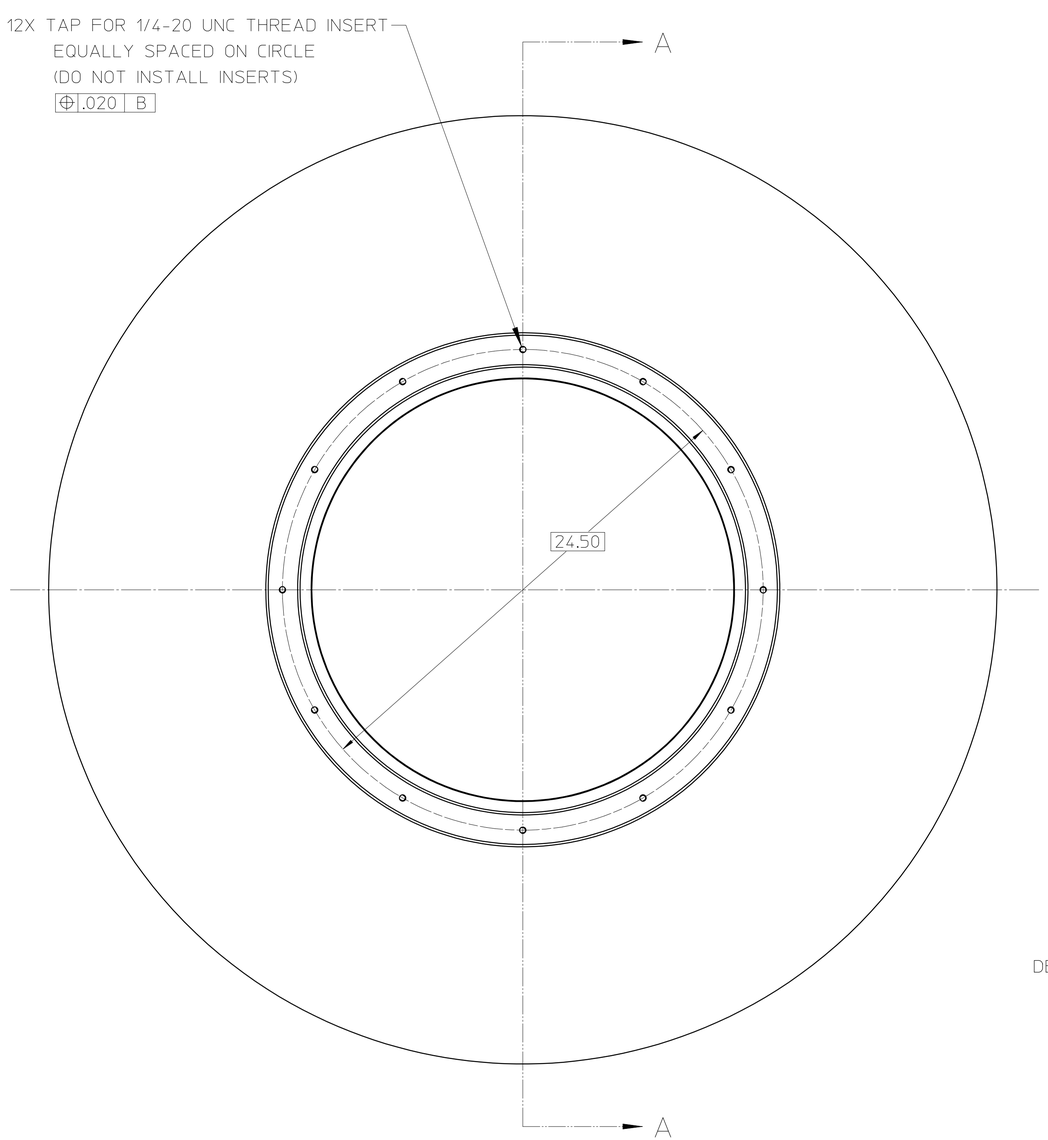
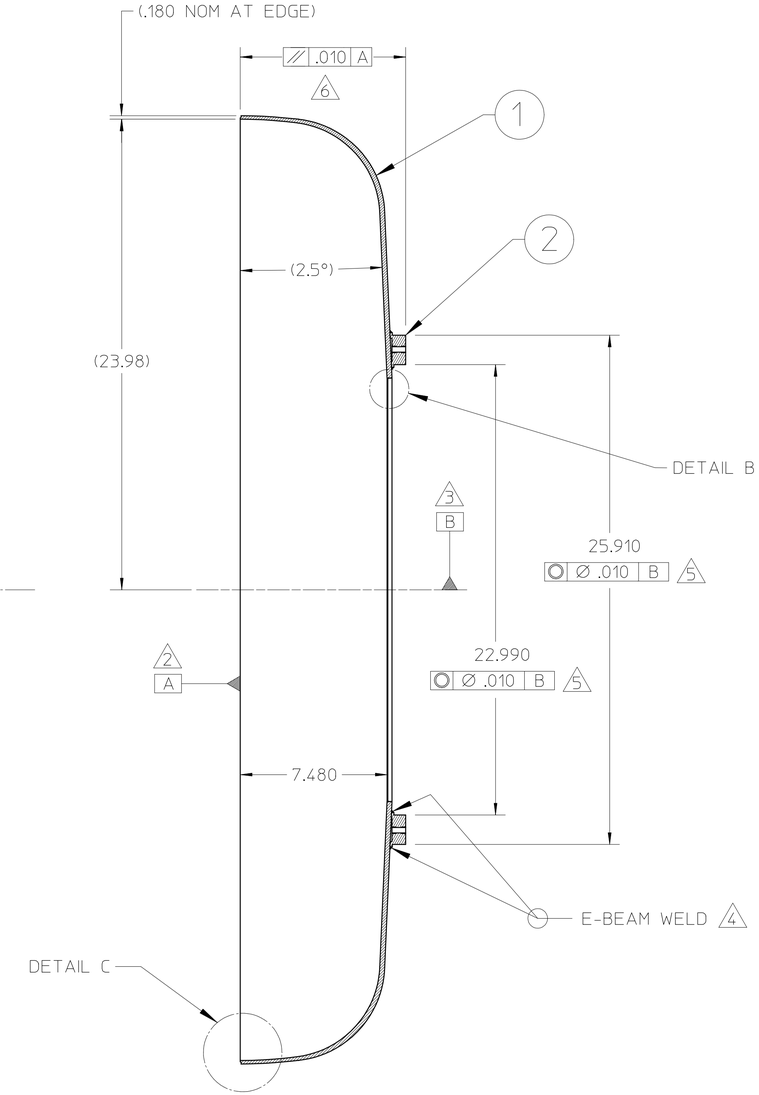
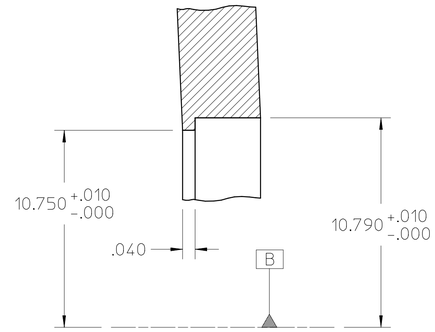
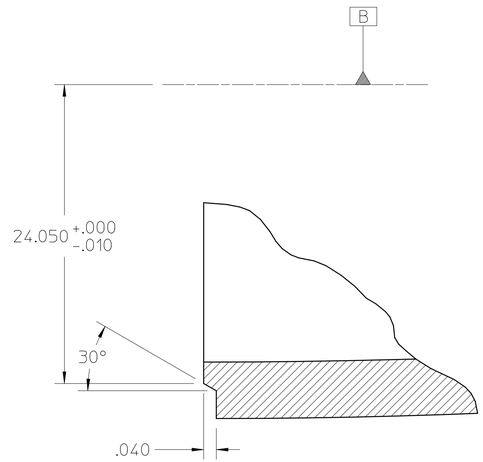




SECTION A-A



DETAIL B
SCALE 4:1



DETAIL C
SCALE 4:1

2506374A

1. ALL DIMENSIONS ARE INCHES.
2. DATUM A TO BE ESTABLISHED BASED ON EXISTING EDGE OF CAVITY HALF-SHELL.
3. DATUM B AXIS TO BE ESTABLISHED BY MINIMIZING CIRCULAR RUNOUT NEAR OUTER EDGE OF HALF-SHELL.
4. STIFFENER RING TO BE POSITIONED AND HELD IN PLACE DURING WELDING BY FIXTURING PROVIDED.
5. THESE SURFACES TO BE MACHINED AFTER WELDING.
6. MINIMUM CLEAN-UP ON THIS SURFACE.

REV	DWG	CHK	ZONE	DATE	CHANGES
A	SPV		C-3	12/4/03	DIMS ADDED TO STIFFENER RING ID AND OD CLEAN-UP CUTS

REQD	ITEM	PART NO.	DESCRIPTION
1	2	2506504	STIFFENER RING
1	1	2506364	CAVITY HALF-SHELL SPINNING

UNLESS OTHERWISE SPECIFIED
TOLERANCES: .X ± .1 | FRAC. ± 1/64 | .XX ± .02 | ANGLES ± .5° | .XXX ± .010 | FINISH 125
THREADS ARE CLASS 2
CHAMFER ENDS OF ALL SCREW THREADS 30°.
CUT 1.5 PITCH THRD RELIEF WITH ROUND NOSE TOOL ON MACHINE CUT THREADS.
BREAK EDGES .016 MAX. ON MACHINED WORK
REMOVE BURRS WELD SPLATTER & LOOSE SCALE
REFERENCES: ANSI Y14.5 & B46.1.

SHOP ORDERS
ACCT. NO. | SERIAL NO.
DATE ISSD | DATE REQD. | NO. REQD.
DELIVER TO
SURFACE TREATMENT: DEGREASE
IDENT. METH.: -
DWG. BY: S. VIROSTEK | DATE: 07-24-03
CHK. BY: S. VIROSTEK | DATE: 07-24-03

LAWRENCE BERKELEY LABORATORY
UNIVERSITY OF CALIFORNIA-BERKELEY
201 MHZ MUON CAVITY PROTOTYPE
CAVITY BODY COMPONENTS
CAVITY HALF-SHELL MACHINING SIDE A

PATENT CLEAR	DWG. TYPE	SHOWN ON	SCALE	DO NOT SCALE PRINTS
	PART		1/4	
MICROFILMED	DESIGN ACCT. NO.	CATEGORY CODE	DWG. NO.	SIZE / REV.
	72MC-C5	---	2506374	A