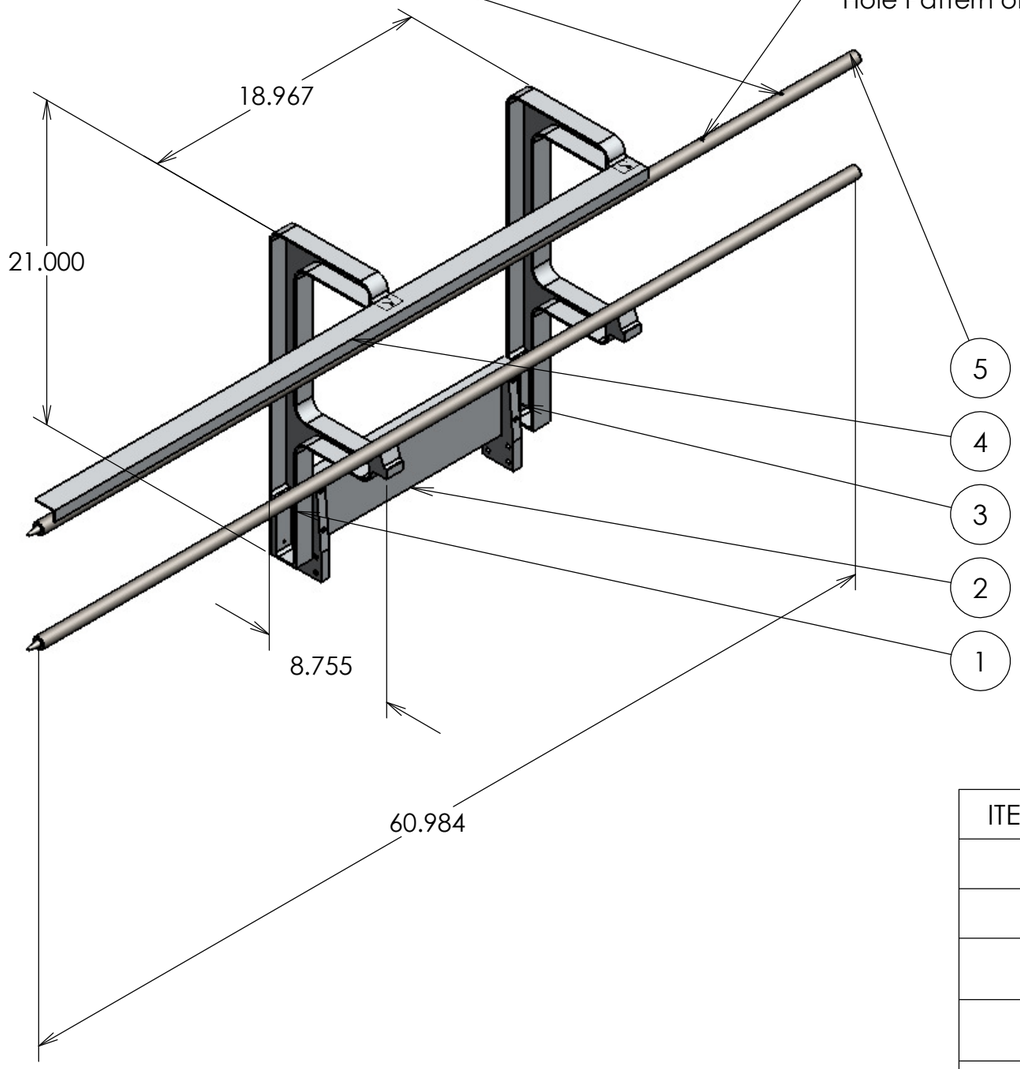
FABRICATION PROCESS	MATERIAL	MATERIAL LOCATION

Item #5 to be machined from Hardened Bearing Rails.
Rail Stock available from Tom Johnson

Hole Pattern on Rails to be referenced to Machined Rail ends +/- 0.50mm



ITEM NO.	PART NUMBER	MATERIAL	QTY.
1	box_rail_CS_v	6061-T6 (SS)	2
2	round_rail_beam	6061-T6 (SS)	1
3	round_rail_angle	6061-T6 (SS)	2
4	angle_cam_guide	6061-T6 (SS)	1
5	box_20mm_rail	AISI 1045 Steel, cold drawn	2

REV	DWG	CHK	ZONE	DATE	CHANGES

UNLESS OTHERWISE SPECIFIED

TOLERANCES

X.X ± 0.5	FRAC. ± 1/64
X.XX ± 0.05	Angles ± 1.00°
X.XXX ± 0.010	FINISH 125√(Uin)

DO NOT SCALE PRINT

THREADS ARE CLASS 2

CHAMFER ENDS OF ALL SCREW THREADS 30°

CUT ROUND, 1.5 THREAD RELIEF ON MACHINED THREADS

BREAK EDGES .016 MAX. ON MACHINED WORK

REMOVE BURRS, WELD SPLATTER & LOOSE SCALE

IN ACCORDANCE WITH ASME Y14.5M & B46.1

SHOP ORDERS

ACCT NO.	NO. REQ'D	SER NO.	–
DEL TO		DATE ISSD	–
SURFACE TREATMT	–	DATE REQ'D	–
IDENT METHOD			
PROJECT NUMBER			
PROJECT NAME			
DWG BY		DATE	
CHK BY		DATE	
APR BY		DATE	

ERNEST ORLANDO LAWRENCE
BERKELEY NATIONAL LABORATORY
UNIVERSITY OF CALIFORNIA - BERKELEY

STEEL RAIL SUPPORT

MICROFILMED:	DWG. TYPE	SHOWN ON	SCALE: 1:16	DO NOT SCALE PRINTS
			SHEET 1 OF 1	
PATENT CLEAR:	DESIGN ACCT. NO.	CATEGORY CODE	DWG. NO.	SIZE / REV.