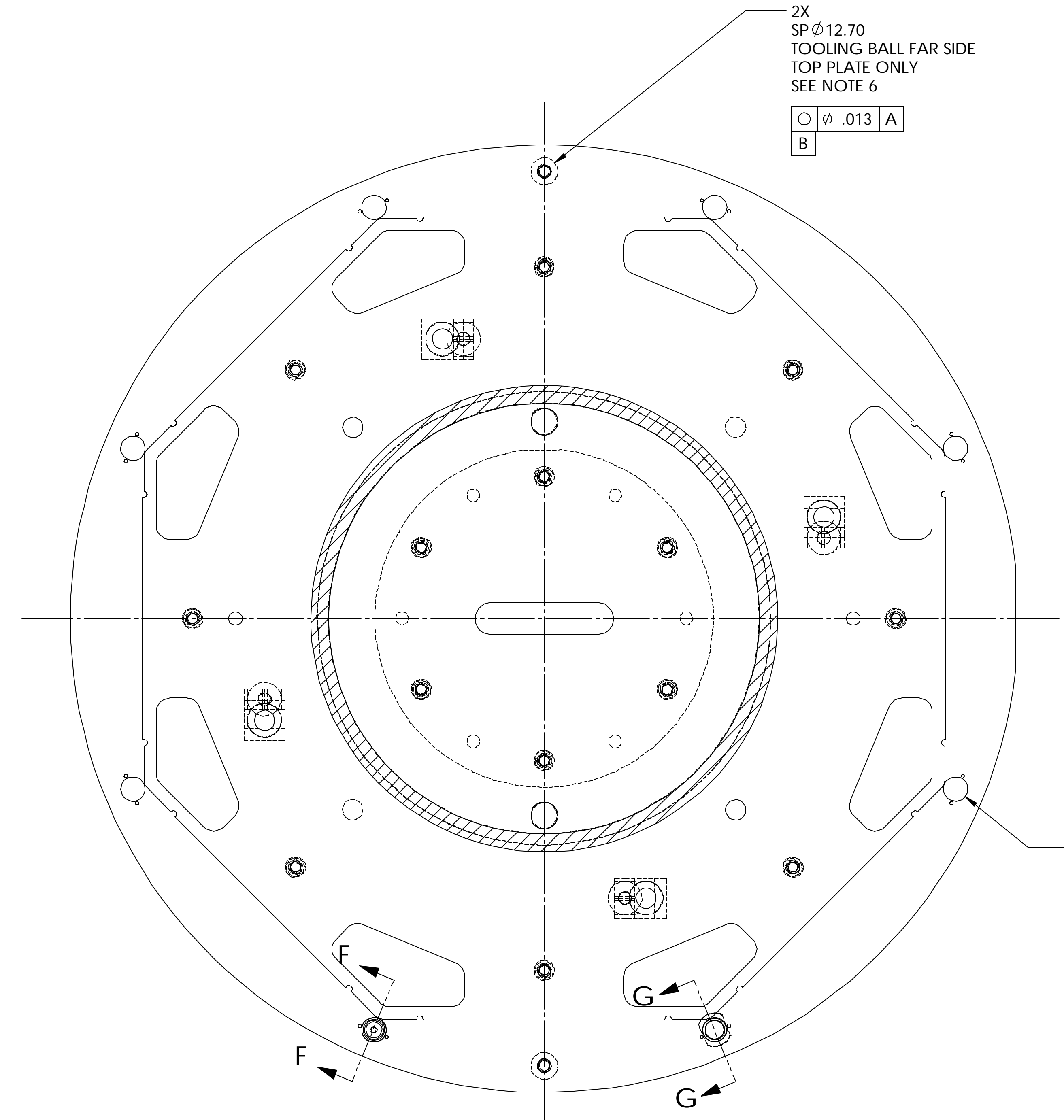


DWG. NO.	21F687 4	SIZE	REV.	SER.	1
ITEM	PART NO.	REQD	DESCRIPTION		MATERIAL



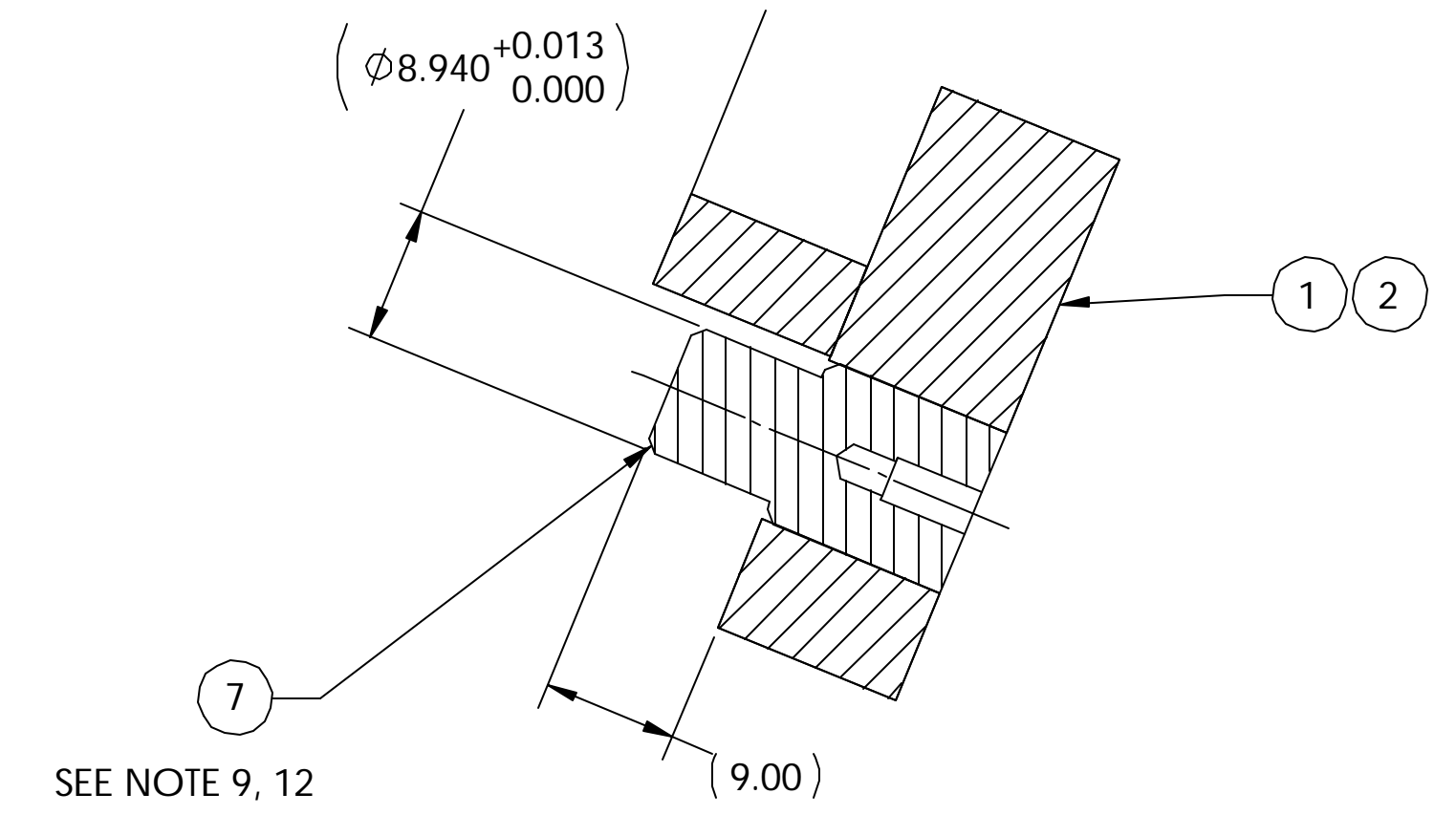
2X
SP Ø12.70
TOOLING BALL FAR SIDE
TOP PLATE ONLY
SEE NOTE 6

⊕	Ø .013	A
		B

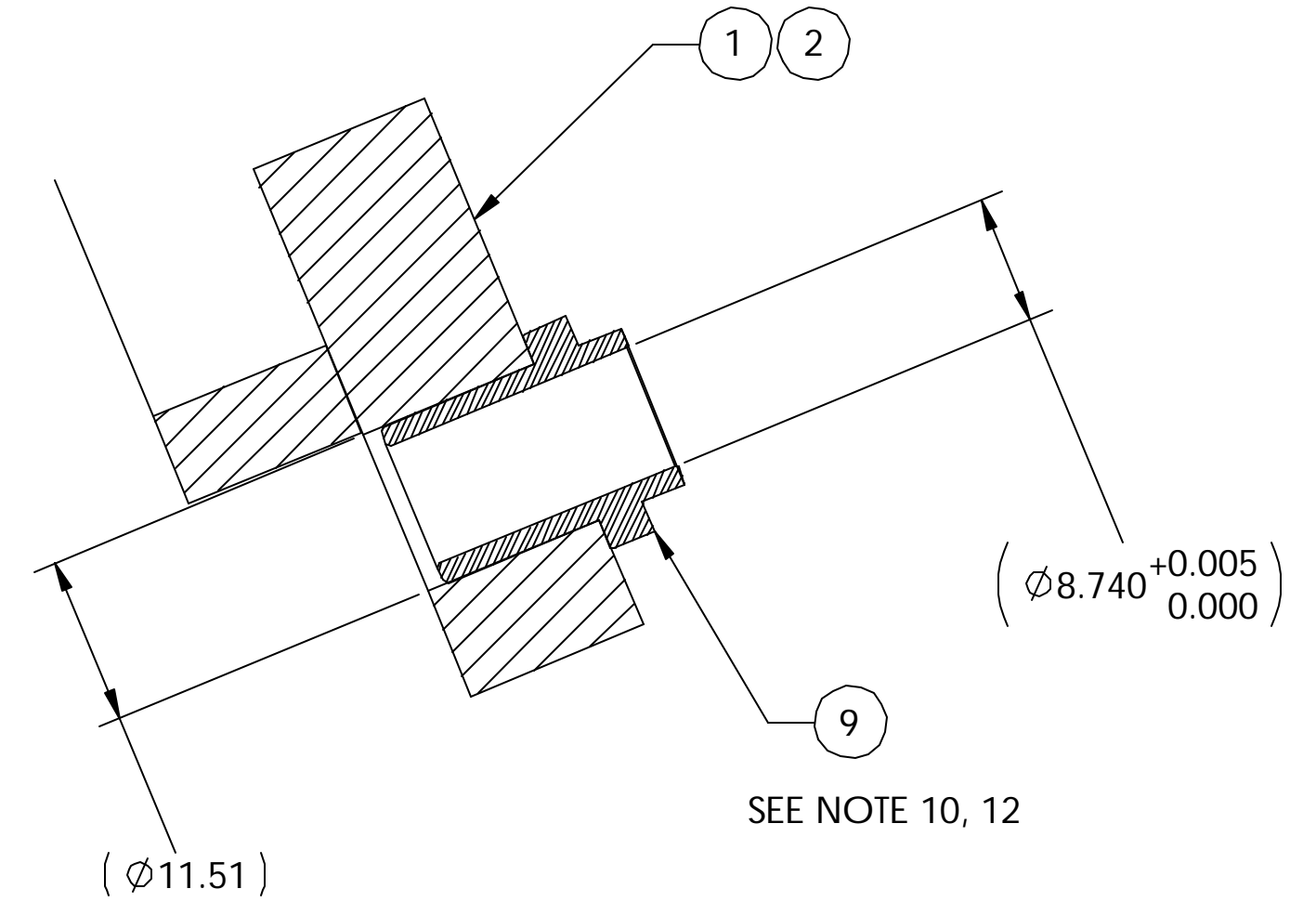
16X Ø11.509^{+0.013}/_{0.000}
TOP AND BOTTOM PLATE
SEE NOTE 6

⊕	Ø .05	A	B
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SECTION D-D
SCALE 1 : 1.5



SECTION F-F
SCALE 2 : 1



SEE NOTE 10, 12

NOTES: UNLESS OTHERWISE SPECIFIED

- ALL DIMENSIONS IN MILLIMETERS
- DIMENSIONS AND TOLERANCING PER ASME Y14.5M-1994
- SURFACE TEXTURE PER ANI/ASME B 46.1-1985
- PARTS TO BE THOROUGHLY CLEANED TO REMOVE ALL OIL, GREASE, DIRT AND CHIPS
- TORQUE SOCKET HEAD CAP SCREWS TO 24.3 in-Lbs (2.0 ft-Lbs.) MAX
- DIMENSIONS AND TOLERANCES ARE BASED UPON INDIVIDUAL PART TOLERANCES; AND ARE REFERENCE
- SCREWS ARE REMOVED; TOGGLE CLAMPS ARE USED TO LEVER TOP PLATE OFF FOR ASSEMBLY REMOVAL AFTER BONDING
- 1.5mm DIA. PINS ARE USED TO ALIGN ASSEMBLY PANELS IN POSITION
- CAPTIVE PIN IS USED TO CRITICALLY POSITION VERTEX JOINT ASSEMBLY (21F676) DURING BONDING
- JOINING PIN CENTERING BUSHING IS USED TO BOND FRAME JOINING PIN (21F660) DURING A SECONDARY BONDING PROCESS
- SEE DWG 21F650 AND 21F665 FOR BONDING ADHESIVE SPECIFICATIONS
- THE POSITION OF BONDING PINS AND BUSHINGS (ITEM 7 AND 9) IN THE FIXTURES TOP AND BOTTOM PLATES (21F692) DURING THE BONDING PROCESS MUST BE RECORDED AND REPEATED FOR ALL BONDING PROCESSES

UNLESS OTHERWISE SPECIFIED		SHOP ORDERS		SER. NO.		ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY	
TOLERANCES	X.X ± 0.5	FRAC. ± 1/64	ACCT. NO.	NO. REQD	DATE ISSD	UNIVERSITY OF CALIFORNIA - BERKELEY #	
	X.XX ± 0.25	ANGLES ± 30°	DEL. TO	DATE REQD	ATLAS PIXEL DETECTOR SPACEFRAME END AND CENTRAL SECTION BONDING FIXTURE ASSEMBLY		
	X.XXX ± 0.013	FINISH 1.6	SURFACE TREATMENT		MICROFILMED: DWG. TYPE ASSEM		
DO NOT SCALE PRINT			PROJECT NAME		SCALE: 1:1.5		
THREADS ARE CLASS 2			PROJECT NO. ATL-IP-ED-XXXX		SHEET 2 OF 2		
CHAMFER ENDS OF ALL SCREW THREADS 30°			DWG. W. K. MILLER		DATE 4/16/2002		
CUT ROUNDS, 1.5 THREAD RELIEF ON MACHINED THREADS			CHK. BILL WILDS		DATE 4/16/2002		
BREAK EDGES .016 MAX. ON MACHINED WORK			APR. E. ANDERSSSEN		DATE 4/16/2002		
REMOVE BURS, WELD SPLATTER & LOOSE SCALE			PATENT CLEAR:		DESIGN ACCT. NO. P1AP-11		
IN ACCORDANCE WITH ASME Y14.5m & B46.1			CATEGORY CIDE		DWG. NO. 21F687 4		
REV	DWG	CHK	ZONE	DATE	CHANGES		

AP6250
21F687 4