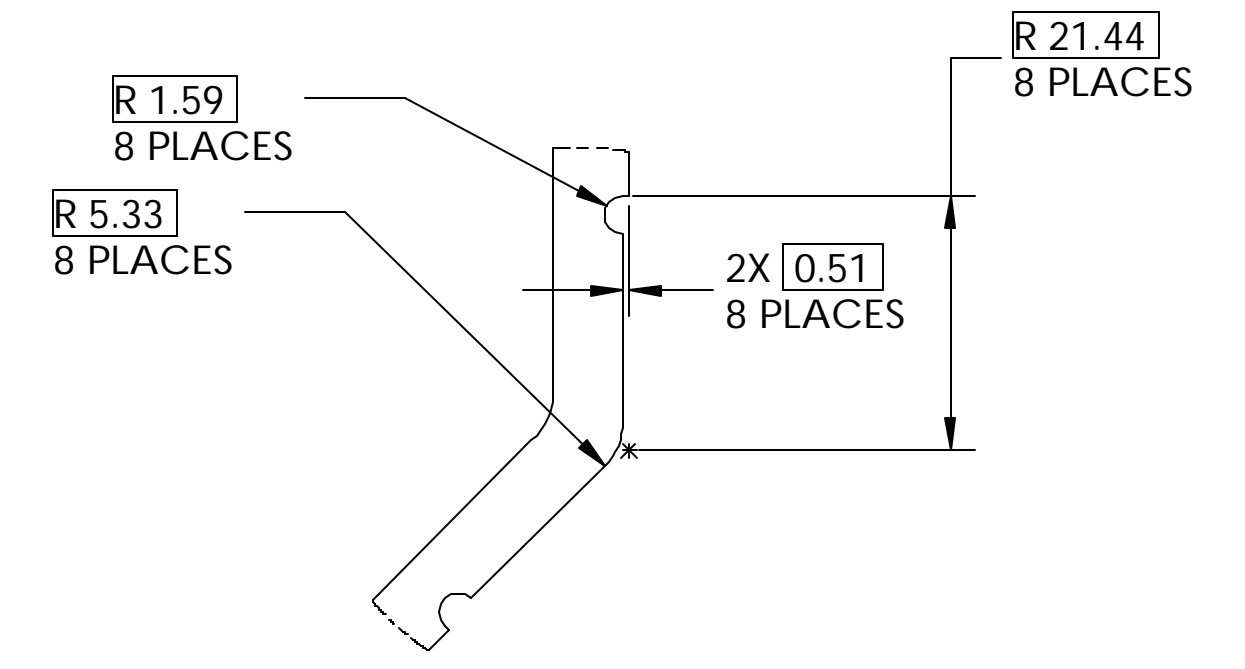
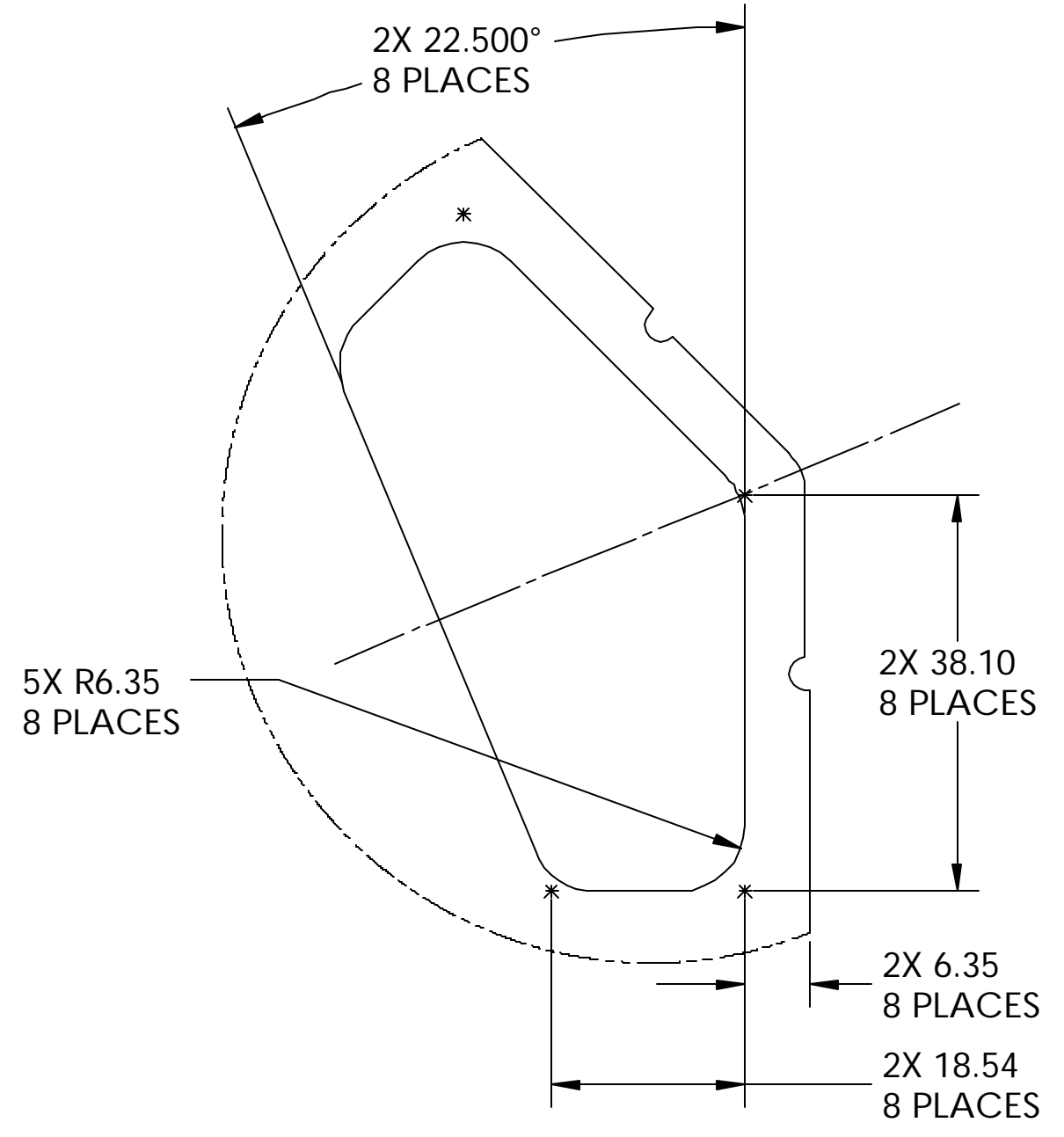
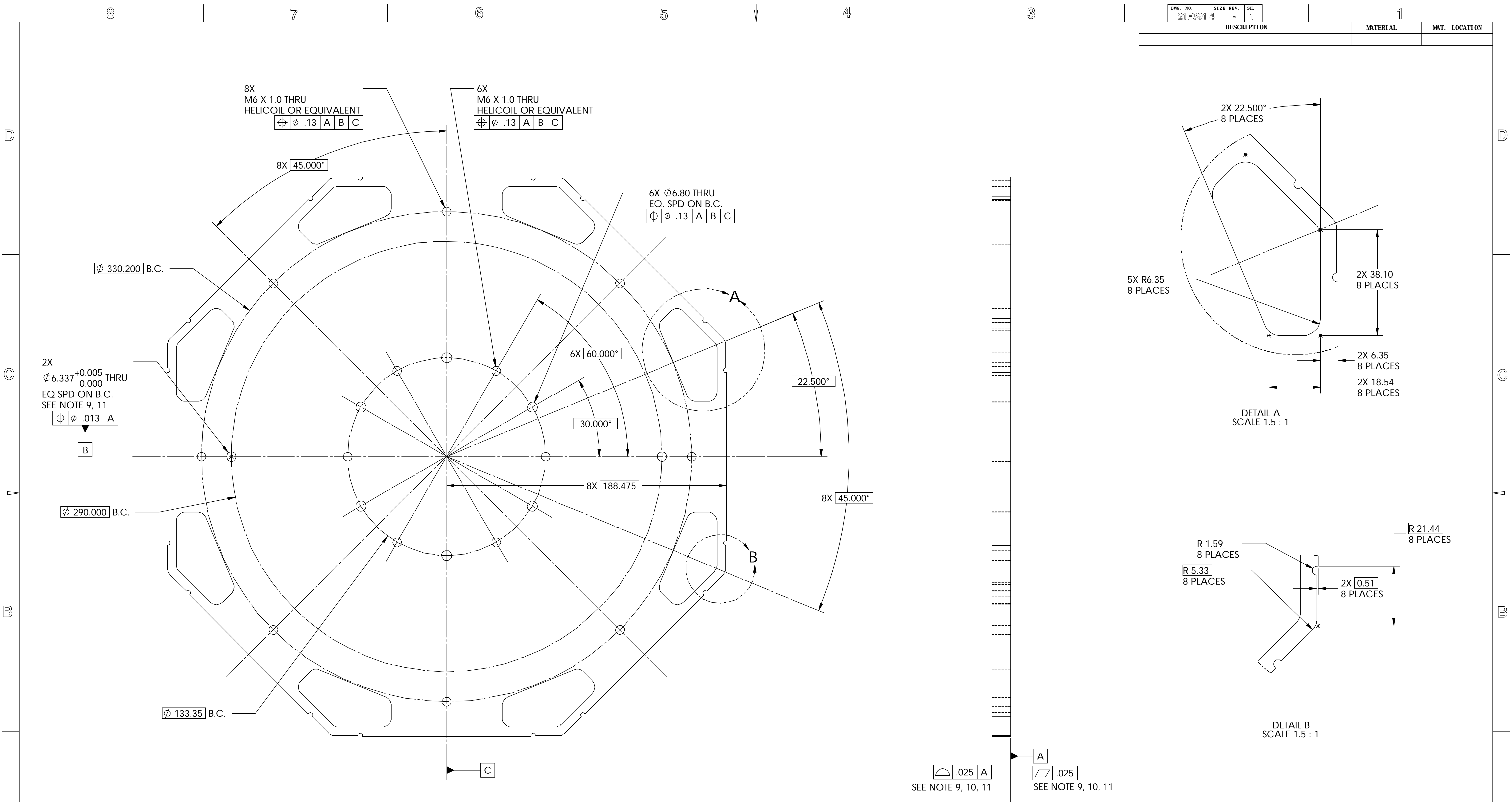


DWG. NO.	SIZE	REV.	SER.
21F691 4		1	
DESCRIPTION		MATERIAL	MNT. LOCATION



NOTES: UNLESS OTHERWISE SPECIFIED

1. ALL DIMENSIONS IN MILLIMETERS
2. DIMENSIONS AND TOLERANCING PER ASME Y14.5M-1994
3. SURFACE TEXTURE PER ANI/ASME B 46.1-1985
4. REMOVE ALL BURRS AND BREAK SHARP EDGES TO A MAXIMUM OF .38
5. ALL INSIDE CORNERS TO BE .38 RADIUS MAX
6. COUNTERSINK 82 DEGREES ALL TAPPED HOLES TO MAJOR DIAMETER
7. COUNTERSINK 82 DEGREES APPROXIMATELY .38 DEEP ALL DRILLED HOLES
8. PARTS TO BE THOROUGHLY CLEANED TO REMOVE ALL OIL, GREASE, DIRT AND CHIPS
9. HOLES FOR 1/2" DIA. PERMANENT TOOLING BALLS
10. STRESS RELIEVE PLATE @ 350 F FOR 6 HOURS TO ACHIEVE DIMENSIONAL STABILITY
11. CMM INSPECTION REQUIRED. CMM REPORT TO BE PROVIDED TO HYTEC FOR REVIEW AND APPROVAL. INSPECTION TEMPERATURE TO BE INDICATED ON REPORT.

MATL: 6061-T6 ALUM
(SEE NOTE 10)

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.		
	X.XXX ± 0.013	FINISH	1.6	SURFACE TREATMENT			
DO NOT SCALE PRINT				IDEN. METHOD TAG	ATLAS PIXEL DETECTOR SPACEFRAME BOND FIXTURE SUB-PANEL ORIENTATION PLATE		
THREADS ARE CLASS 2				PROJECT NAME	MICROFILMED:		
CHAMFER ENDS OF ALL SCREW THREADS 30°				PROJECT NO.	DWG. TYPE		
CUT ROUND. 1.5 THREAD RELIEF ON MACHINED THREADS				PROJECT US ATLAS SILICON SUBSYSTEM	PART		
BREAK EDGES .016 MAX. ON MACHINED WORK				DWG. BY W. K. MILLER	DATE	4/16/2002	SHOWS ON
REMOVE BURRS, WELD SPLATTER & LOOSE SCALE				CHK BY BILL WILDS	DATE	4/16/2002	21F690
IN ACCORDANCE WITH ASME Y14.5m & B46.1				APR BY E. ANDERSSSEN	DATE	4/16/2002	SCALE: 1:1.25
REV	DWG	CHK	ZONE	DATE	CHANGES		DO NOT SCALE PRINTS

SCALE: 1:1.25
SHEET 1 OF 1
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