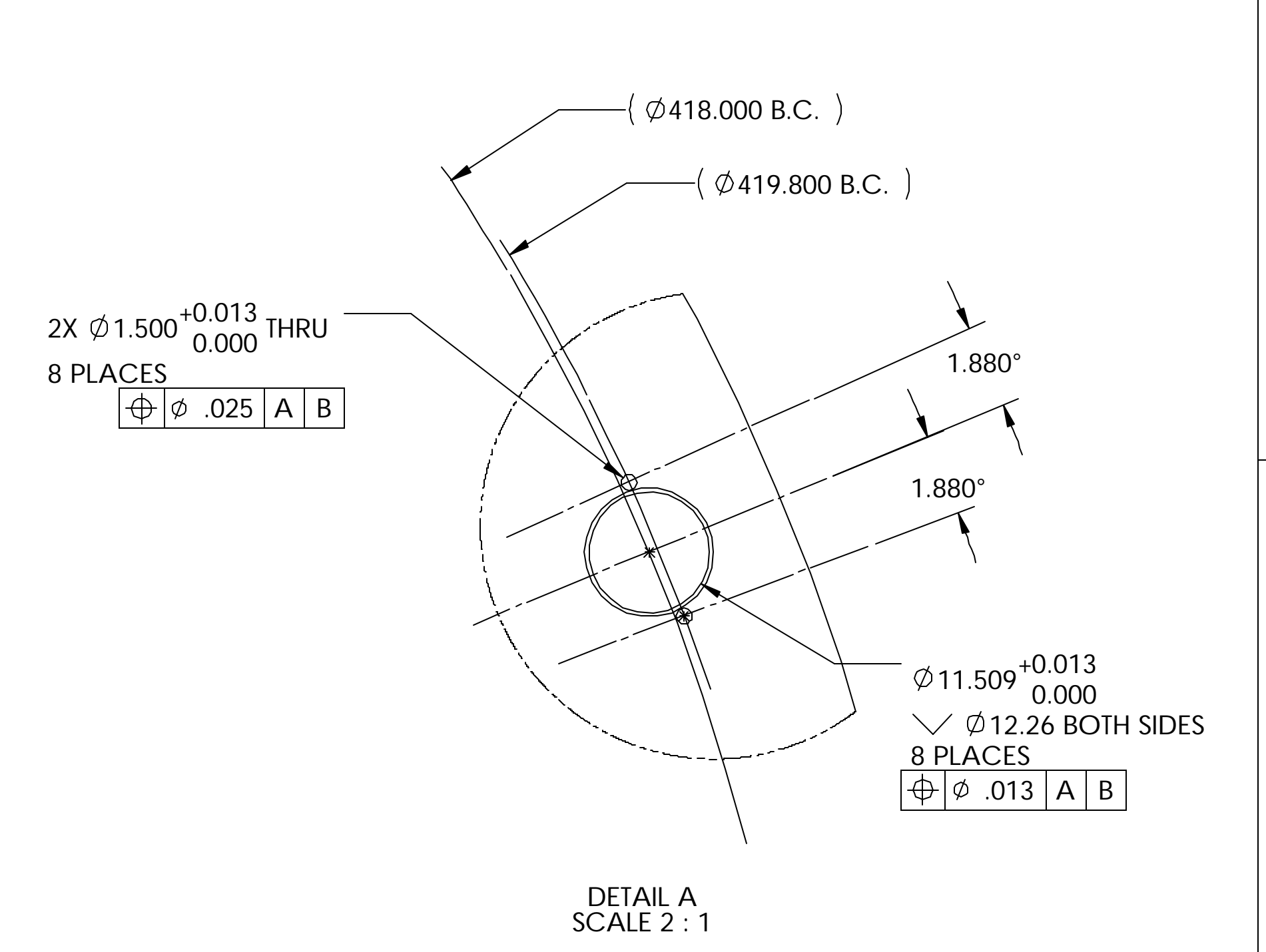
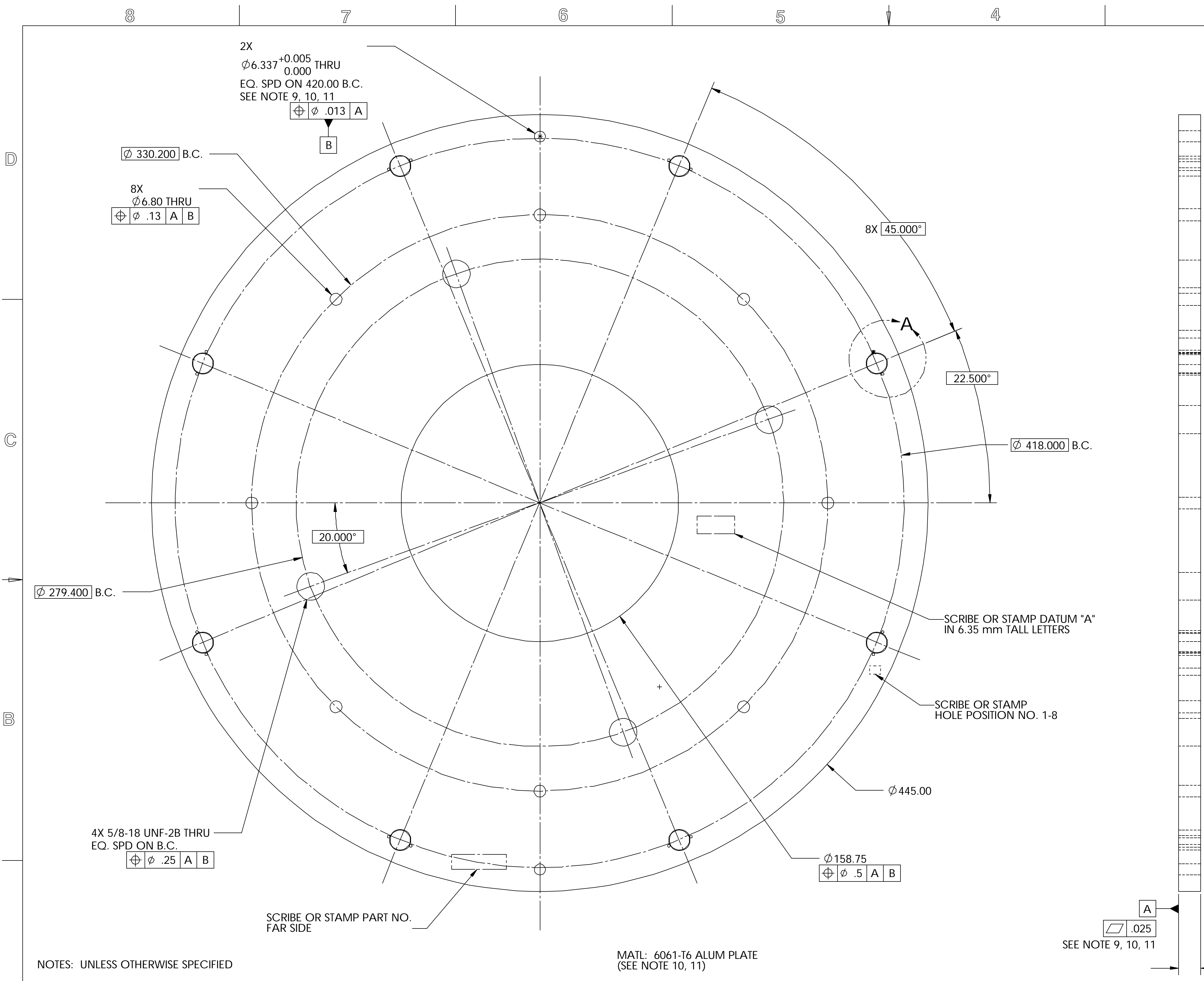


DWG. NO.	SIZE	REV.	SHEET
21F692 4		1	1
DESCRIPTION		MATERIAL	MNT. LOCATION



- 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
 - REMOVE ALL BURRS AND BREAK SHARP EDGES TO A MAXIMUM OF .038
 - ALL INSIDE CORNERS TO BE .038 RADIUS MAX
 - COUNTERSINK 82 DEGREES ALL TAPPED HOLES TO MAJOR DIAMETER
 - COUNTERSINK 82 DEGREES APPROXIMATELY .038 DEEP ALL DRILLED HOLES
 - PARTS TO BE THOROUGHLY CLEANED TO REMOVE ALL OIL, GREASE, DIRT AND CHIPS
 - HOLES USED FOR TEMPORARY 1/2" DIA. TOOLING BALLS
 - STRESS RELIEVE PLATE @ 350 F FOR 6 HOURS TO ACHIEVE DIMENSIONAL STABILITY
 - CMM INSPECTION REQUIRED. INSPECTION REPORTS PROVIDED TO HYTEC FOR REVIEW AND APPROVAL. INSPECTION REPORTS TO INDICATE INSPECTION TEMPERATURE.

UNLESS OTHERWISE SPECIFIED		SHOP ORDERS		SER. NO.		ERNEST ORLANDO LAWRENCE	
TOLERANCES	X.X ± 0.5	FRAC. ± 1/64	NO. REQD.	DATE ISSD	BERKELEY NATIONAL LABORATORY		
	X.XX ± 0.25	ANGLES ± 30°	DATE REQD.	UNIVERSITY OF CALIFORNIA - BERKELEY #			
	X.XXX ± 0.013	FINISH 1.6	SURFACE TREATMENT		ATLAS PIXEL DETECTOR		
DO NOT SCALE PRINT		PROJECT NUMBER		SPACEFRAME BOND FIXTURE			
THREADS ARE CLASS 2		PROJECT NAME		VERTEX CORNER JOINT ALIGNMENT PLATE			
CHAMFER ENDS OF ALL SCREW THREADS 30°		PROJECT US ATLAS SILICON SUBSYSTEM		MICROFILMED:		DWG. TYPE	
CUT ROUNDS, 1.5 THREAD RELIEF ON MACHINED THREADS		DWG. W. K. MILLER		DATE 4/16/2002		SHOWS ON	
BREAK EDGES .016 MAX. ON MACHINED WORK		CHK BILL WILDS		DATE 4/16/2002		PART	
REMOVE BURRS, WELD SPLATTER & LOOSE SCALE		APR E ANDERSSSEN		DATE 4/16/2002		21F690	
IN ACCORDANCE WITH ASME Y14.5m & B46.1				PATENT CLEAR:		DESIGN ACCT. NO.	
				P1AP-11		AP6250	
				SCALE: 1:1.25		DO NOT SCALE PRINTS	
				SHEET 1 OF 1		SIZE	
				21F692 4		REV.	

REV	DWG	CHK	ZONE	DATE	CHANGES