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DWG. NO.	21F699 4	SIZE	REV.	SR.
ITEM	PART NO.	REQD	DESCRIPTION	MATERIAL

D

C

B

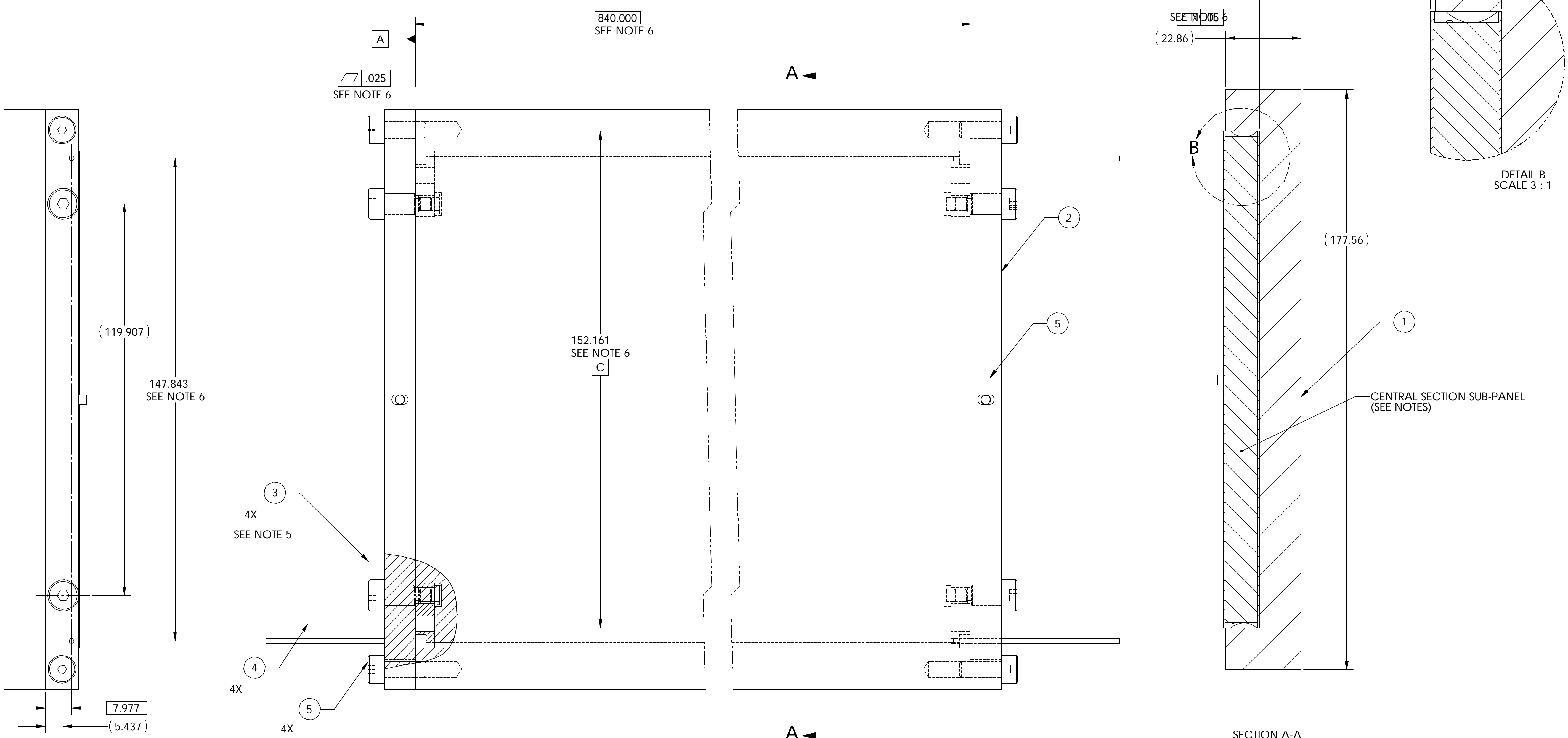
A

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NOTES: UNLESS OTHERWISE SPECIFIED

- DIMENSIONS IN MILLIMETERS
- FIXTURE USED TO FABRICATE SUB-PANEL 1 AND SUB-PANEL 2 (PART 21F666)
- SUB-PANEL ASSEMBLIES SHOWN IN THEIR PRE-MACHINED STATE; POST BONDING MACHINED POCKETS IN PANEL 21F668 ARE SHOWN ON 21F666 AND 21F667
- SEE PANEL DRAWINGS FOR ADHESIVE REQUIREMENTS
- TORQUE SCREW TO 11 in-Lbs. MAX.
- DIMENSIONS, TOLERANCES, AND DATUMS ARE BASED UPON INDIVIDUAL PARTS; SOME ARE REFERENCE
- INSERT 21F676 IS PRE-BONDED INTO PART 21F675 PRIOR TO BONDING INTO PANEL ASSEMBLY
- ITEM 4 AND 1.50 DIA. HOLE IN ITEM 2 CRITICALLY POSITION CORNER BLOCK ASSEMBLY
- TORQUE ON ITEM 3 DRAWS CORNERBLOCK ASSEMBLY FLAT AGAINST ITEM 2
- NOTE RELATIVE POSITION OF CORNERBLOCK ASSEMBLY -1 AND -2 AS DEFINED IN PANEL DRAWING 21F666 AND 21F667

UNLESS OTHERWISE SPECIFIED		SHOP ORDERS		SER. NO.		ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY	
TOLERANCES	X.X ± 0.5	FRAC.	± 1/64	ACCT. NO.	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			ATLAS PIXEL DETECTOR SPACEFRAME CENTRAL SECTION SUB-PANEL BOND FIXTURE
DO NOT SCALE PRINT				IDEN. METHOD TAG			
THREADS ARE CLASS 2				PROJECT NO.	ATL-IP-ED-XXXX		MICROFILMED: DWG. TYPE ASSEM N/A SHOWS ON N/A SCALE: 1.5:1 DO NOT SCALE PRINTS
CHAMFER ENDS OF ALL SCREW THREADS 30°				PROJECT NAME	US ATLAS SILICON SUBSYSTEM		
CUT ROUND, 1.5 THREAD RELIEF ON MACHINED THREADS				DWG. BY	W. K. MILLER		PATENT CLEAR: DESIGN ACCT. NO. P1AP-11 CATEGORY CIDE AP6250 DWG. NO. 21F699 4 SIZE REV.
BREAK EDGES .016 MAX. ON MACHINED WORK				CHK BY	BILL WILDS		
REMOVE BURS, WELD SPLATTER & LOOSE SCALE				APR BY	E. ANDERSSSEN		
IN ACCORDANCE WITH ASME Y14.5m & B46.1				DATE	4/16/2002		
REV	DWG	CHK	ZONE	DATE	CHANGES		

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