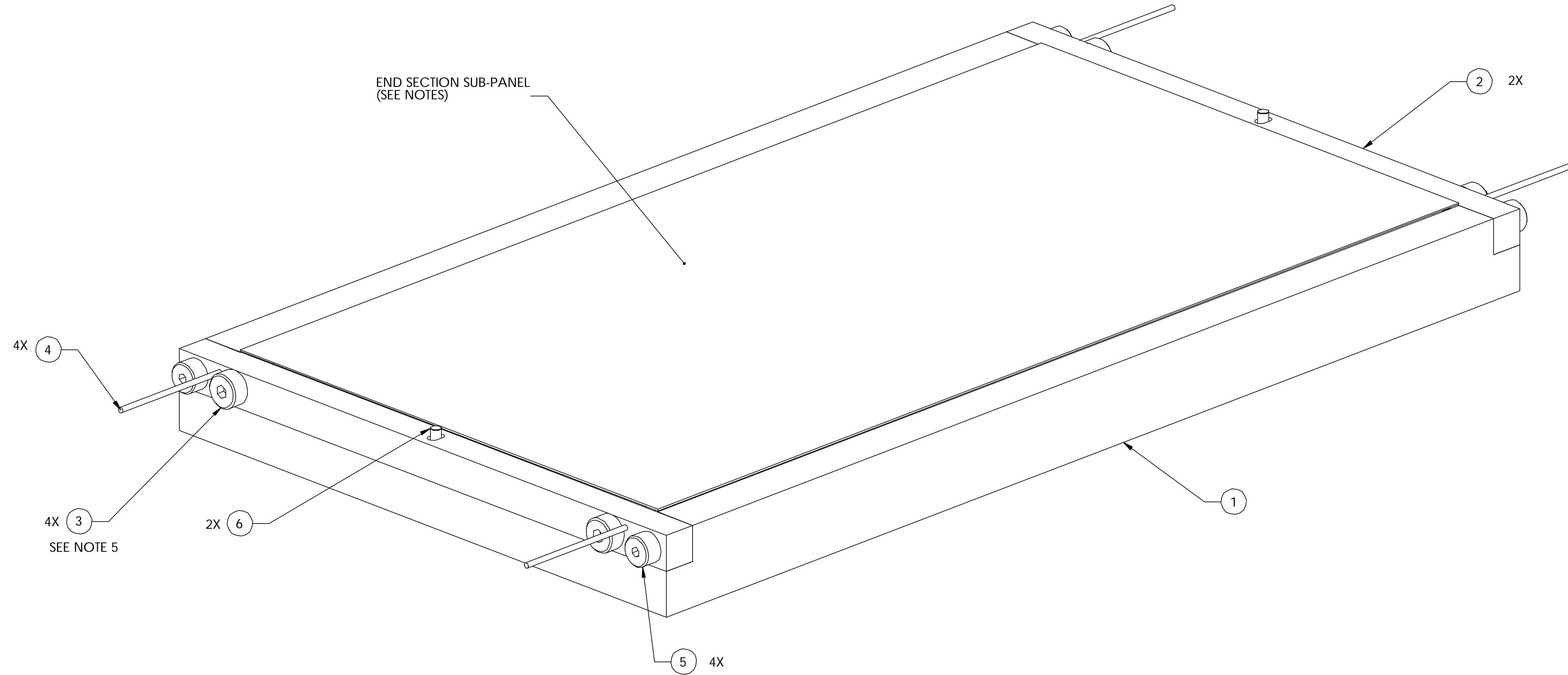


ITEM	PART NO.	REQD	DESCRIPTION	MATERIAL
6		4	3.0mm DIA. GAGE PIN	STEEL
5		4	M5 X .8 SOCKET HD CAP SCREW X 15 LONG	STEEL
4		4	1.50mm DIA. GAGE PIN	STEEL
3	21F704	4	PANEL BOND FIXTURE MODIFIED SCREW	
2	21F703	1	END SECTION PANEL BOND FIXTURE END PLATE	
1	21F701-1	1	END SECTION PANEL BOND FIXTURE BASEPLATE	



NOTES: UNLESS OTHERWISE SPECIFIED

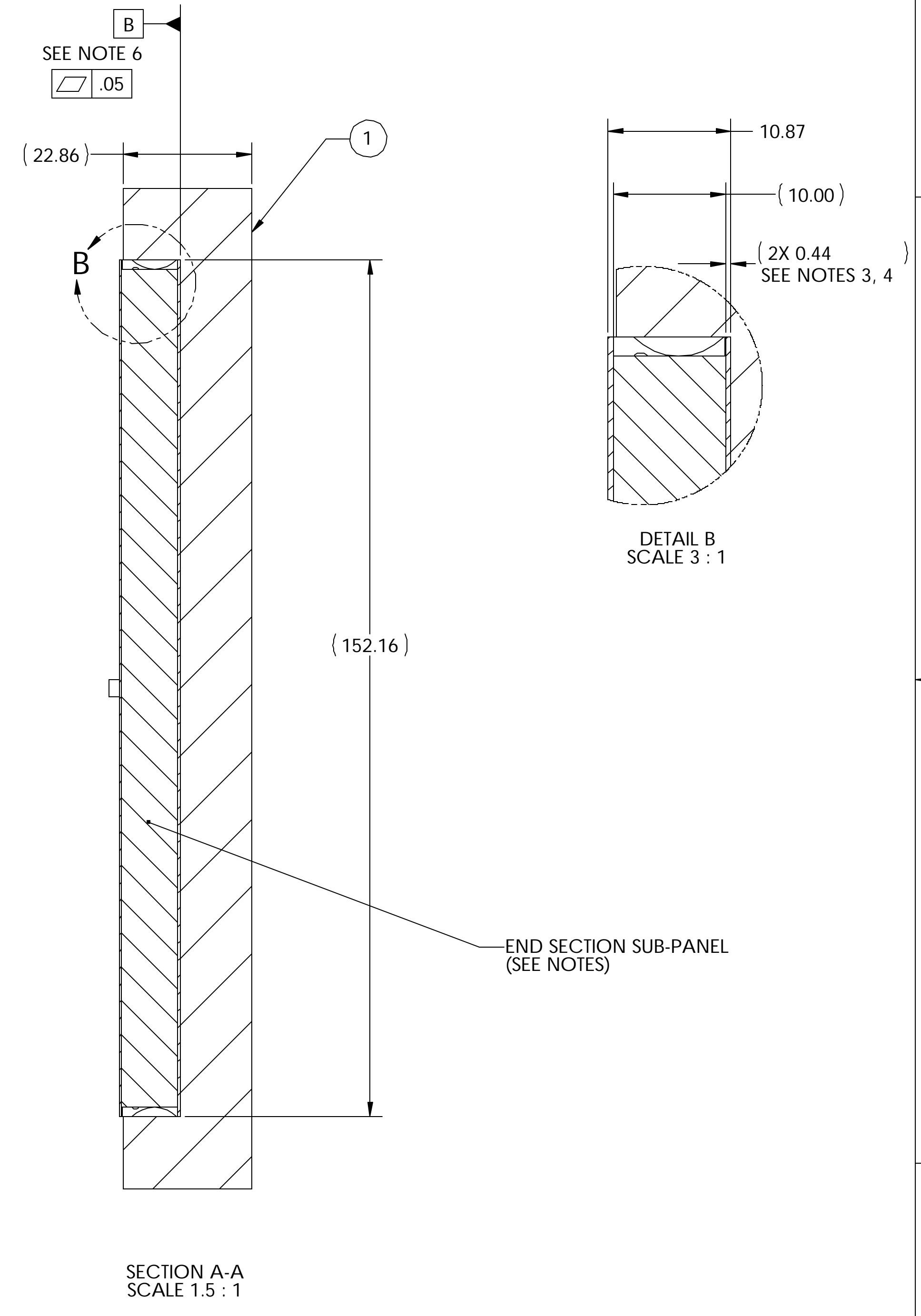
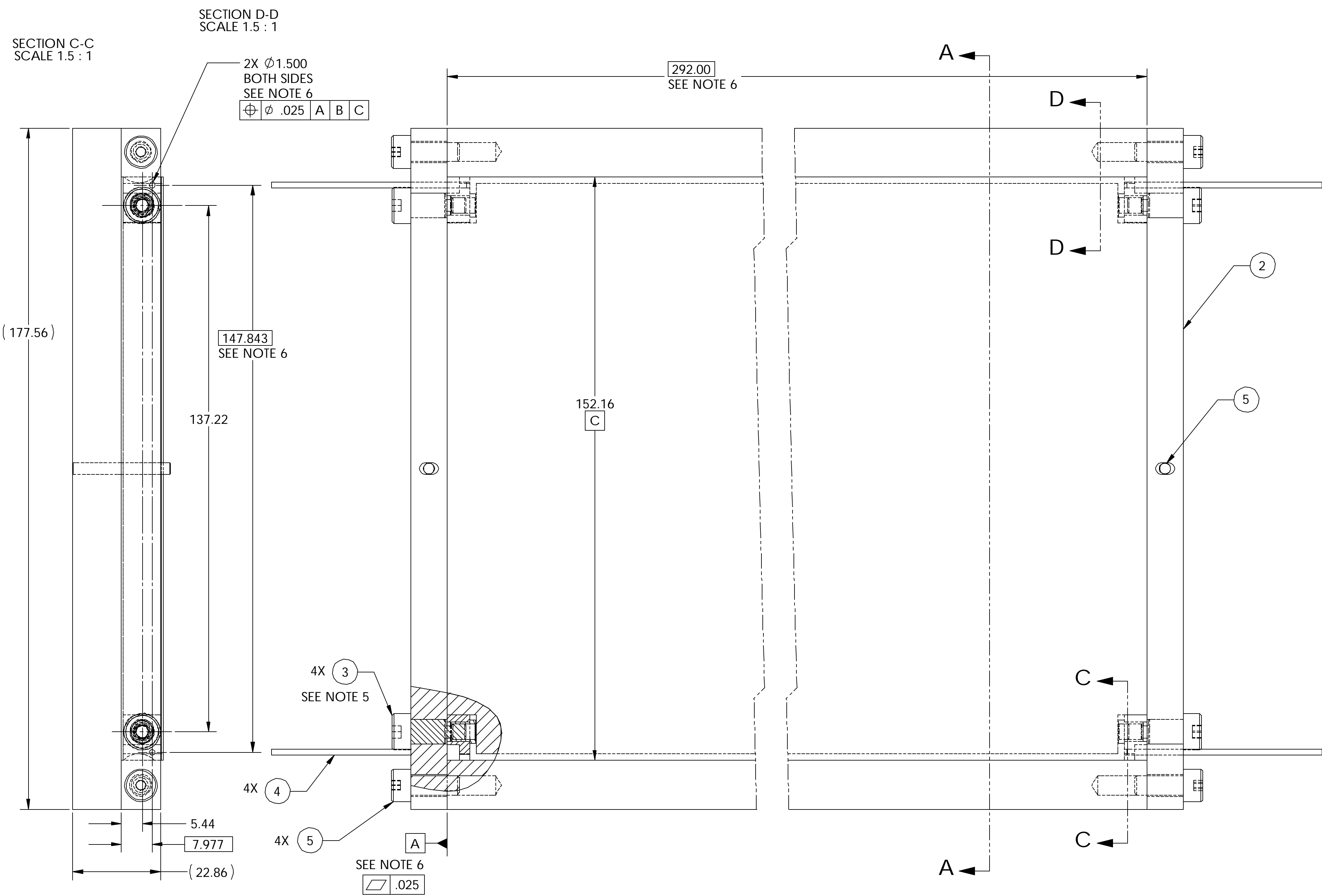
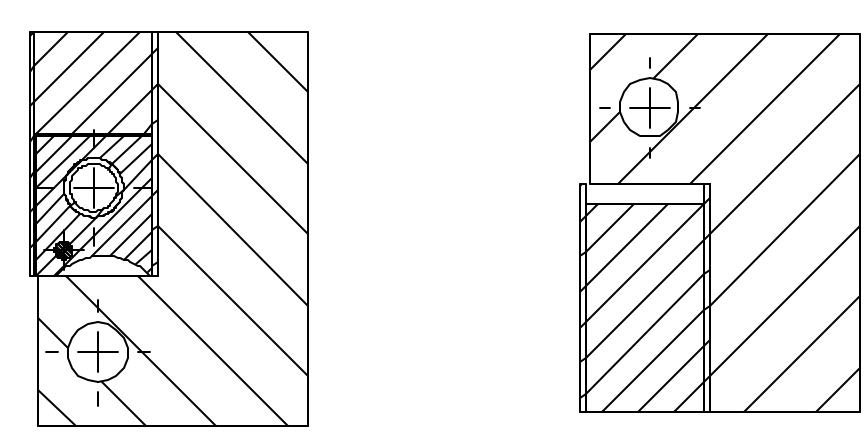
- DIMENSIONS IN MILLIMETERS
- FIXTURE USED TO FABRICATE SUB-PANEL 1 AND SUB-PANEL 2 (PART 21F666)
- SUB-PANEL ASSEMBLIES SHOWN IN THEIR PRE-MACHINED STATE; POST BONDING MACHINED POCKETS IN PANEL 21F668 ARE SHOWN ON 21F666 AND 21F667
- SEE PANEL DRAWINGS FOR ADHESIVE REQUIREMENTS
- TORQUE SCREW TO 11 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

REV	DWG	CHK	ZONE	DATE	CHANGES

UNLESS OTHERWISE SPECIFIED		SHOP ORDERS		SER. NO.
TOLERANCES	X.X ± 0.5	FRAC. ± 1/64	ACCT. NO.	NO. REQD.
	X.XX ± 0.25	ANGLES ± 30°	DATE ISSD	DATE REQD.
	X.XXX ± 0.013	FINISH 1.6	SURFACE TREATMENT	
<b>DO NOT SCALE PRINT</b>		IDEN. METHOD TAG		
THREADS ARE CLASS 2		PROJECT NUMBER	ATL-IP-ED-XXXX	
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	
BREAK EDGES .016 MAX. ON MACHINED WORK		CHK. BY	BILL WILDS	
REMOVE BURS, WELD SPLATTER & LOOSE SCALE		DATE	4/16/2002	
IN ACCORDANCE WITH ASME Y14.5m & B46.1		APR. BY	E. ANDERSSON	
		DATE	4/16/2002	

ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY				
UNIVERSITY OF CALIFORNIA - BERKELEY #				
ATLAS PIXEL DETECTOR SPACEFRAME END SECTION SUB-PANEL BOND FIXTURE				
MICROFILMED:	DWG. TYPE	SHOWS ON	SCALE:	DO NOT SCALE PRINTS
	ASSEM	N/A	1.5:1	
PATENT CLEAR:	DESIGN ACCT. NO.	CATEGORY CIDE	DWG. NO.	SIZE
	P1AP-11	AP6250	21F7004	REV.
			SHEET 1 OF 2	

DWG. NO. 21F700 4		SIZE -	REV. 2	SR. 2
ITEM	PART NO.	REQD	DESCRIPTION	MATERIAL



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	
TOLERANCES	X.XX ± 0.5	FRAC. ± 1/64	ACCT. NO.	NO. REQD	DATE ISSD	BERKELEY NATIONAL LABORATORY
	X.XX ± 0.25	ANGLES ± 30°	DEL. TO	DATE REQD		UNIVERSITY OF CALIFORNIA - BERKELEY #
	X.XXX ± 0.013	FINISH 1.6	SURFACE TREATMENT			ATLAS PIXEL DETECTOR SPACEFRAME END SECTION SUB-PANEL BOND FIXTURE
DO NOT SCALE PRINT			INDEX METHOD TAG			
THREADS ARE CLASS 2			PROJECT NUMBER			
CHAMFER ENDS OF ALL SCREW THREADS 30°			PROJECT NAME			
CUT ROUNDS, 1.5 THREAD RELIEF ON MACHINED THREADS			DWG. BY	DATE		
BREAK EDGES, .016 MAX. ON MACHINED WORK			CHK BY	DATE		
REMOVE BURS, WELD SPLATTER & LOOSE SCALE			APR BY	DATE		
IN ACCORDANCE WITH ASME Y14.5m & B46.1						
REV	DWG	CHK	ZONE	DATE	CHANGES	

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1

SCALE: 1.5 : 1

DO NOT SCALE PRINTS

ASSEM N/A

SHOWS ON N/A

DESIGN ACCT. NO. P1AP-11

CATEGORY CODE AP6250

DWG. NO. 21F700 4

SIZE

REV.

SHEET 2 OF 2