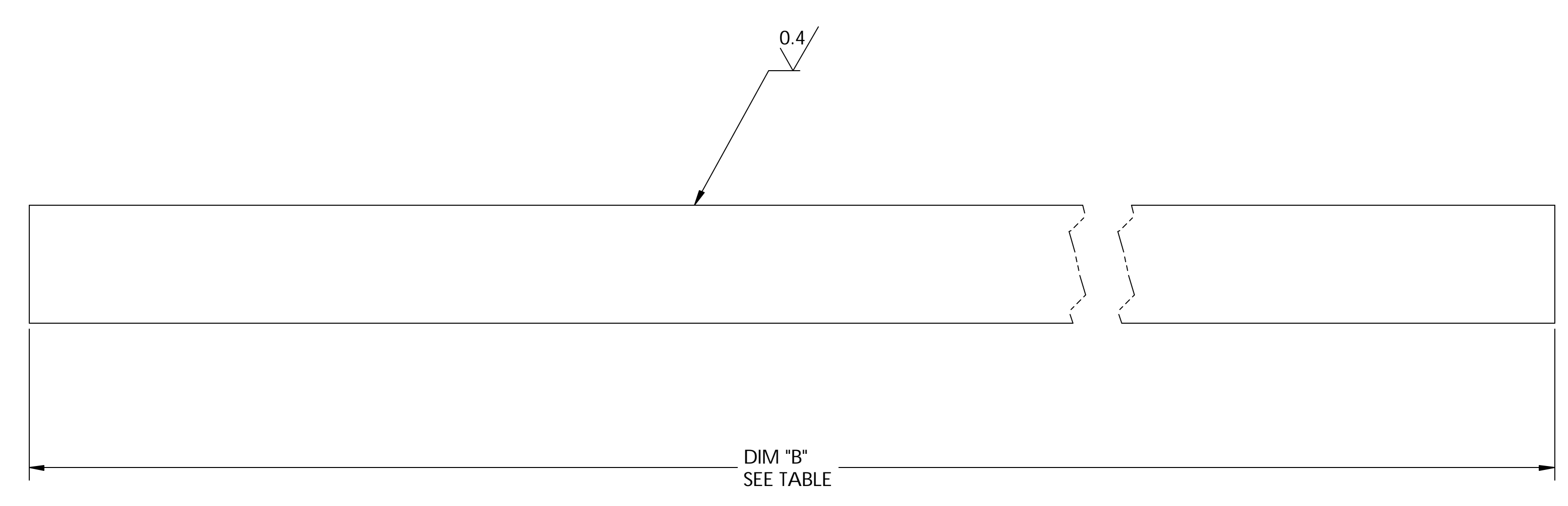
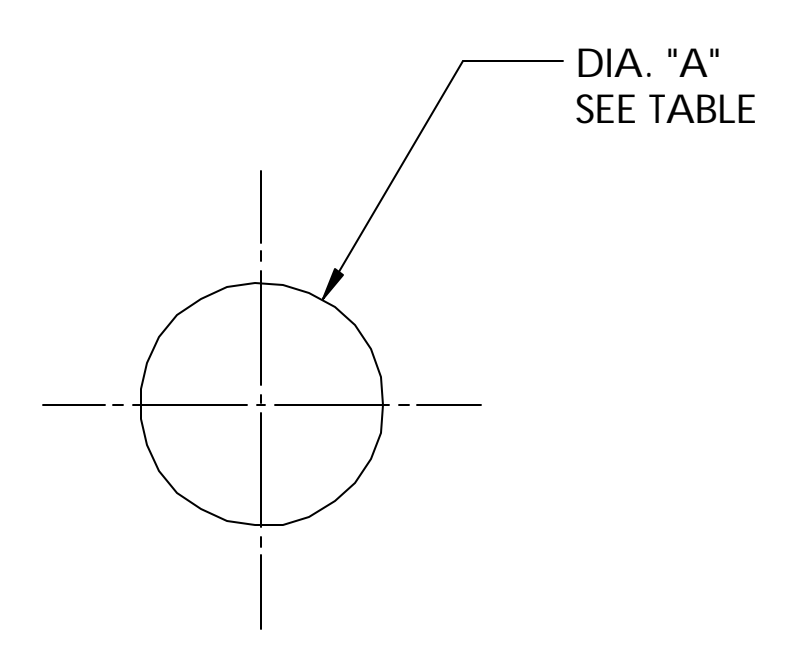


DWG. NO.	SIZE	REV.	SHEET
21F7154		1	1
DESCRIPTION		MATERIAL	MNT. LOCATION



MATL: STEEL GROUND ROUNDSTOCK

PARTNO.	DIM "A"	"A" TOL.	DIM "B"	PART/PURPOSE
21F715-1	8.965	+/-0.025	305.00	JOINT INSERT MANDREL
21F715-3	6.35	+/-0.025	305.00	MOLD ALIGNMENT ROD
21F715-5	7.72	+/-0.025	305.00	JOINING PIN MANDREL
21F715-7	10.11	+/-0.025	857.00	STIFFENING TUBE MANDREL
21F715-9	6.35	+/-0.025	857.00	MOLD ALIGNMENT ROD

- NOTES: UNLESS OTHERWISE SPECIFIED
- 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 .38
 - ALL INSIDE CORNERS TO BE .38 RADIUS MAX
 - COUNTERSINK 82 DEGREES ALL TAPPED HOLES TO MAJOR DIAMETER
 - COUNTERSINK 82 DEGREES APPROXIMATELY .38 DEEP ALL DRILLED HOLES
 - PARTS TO BE THOROUGHLY CLEANED TO REMOVE ALL OIL, GREASE, DIRT AND CHIPS

UNLESS OTHERWISE SPECIFIED		SHOP ORDERS		SER. NO.	ERNEST ORLANDO LAWRENCE	
TOLERANCES	X, X ± 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
DO NOT SCALE PRINT			INDEX METHOD TAG	VERTEX STIFFENER TUBE MOLD MANDREL		
THREADS ARE CLASS 2			PROJECT NUMBER	MICROFILMED:		
CHAMFER ENDS OF ALL SCREW THREADS 30°			PROJECT US ATLAS SILICON SUBSYSTEM	DWG. TYPE	SHOWS ON	SCALE: 4:1
CUT ROUNDS, 1.5 THREAD RELIEF ON MACHINED THREADS			DWG. BY W. K. MILLER	PART	N/A	DO NOT SCALE PRINTS
BREAK EDGES, .016 MAX. ON MACHINED WORK			CHK BY BILL WILDS	DATE 4/16/2002	DESIGN ACCT. NO.	
REMOVE BURRS, WELD SPLATTER & LOOSE SCALE			APR BY E. ANDERSSSEN	DATE 4/16/2002	PATENT CLEAR:	
IN ACCORDANCE WITH ASME Y14.5m & B46.1					CATEGORY CIDE	
REV	DWG	CHK	ZONE	DATE	CHANGES	

DWG. NO.	SIZE	REV.
P1AP-11	AP6250	21F7154
SHEET 1 OF 1		