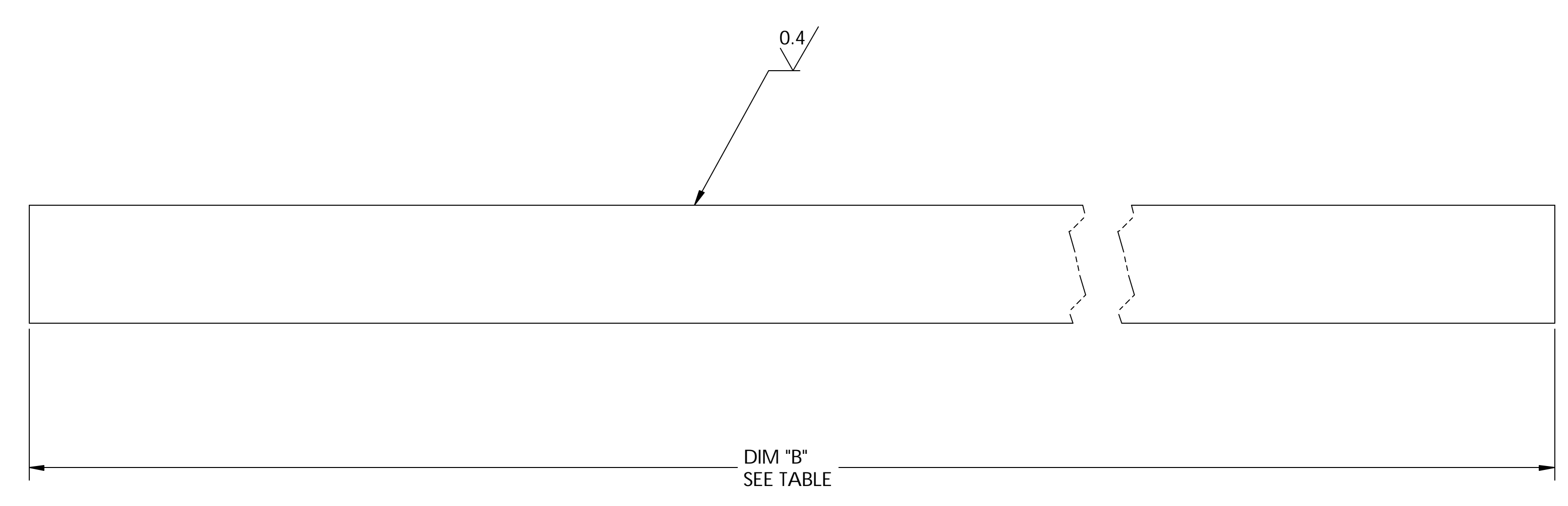
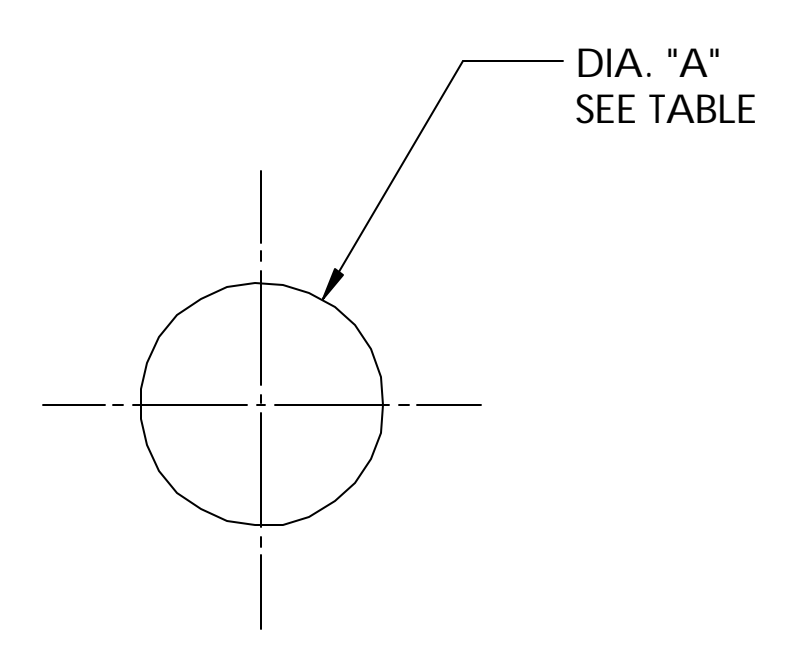


DWG. NO.	SIZE	REV.	SHEET
21F7154		1	1
DESCRIPTION		MATERIAL	MNT. LOCATION



MATL: STEEL GROUND ROUNDSTOCK

Part	Quantity
21F715-1	2
21F715-3	2
21F715-5	2
21F715-7	4
21F715-9	2

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 NAME	ATL-IP-ED-XXXX		
	CHAMFER ENDS OF ALL SCREW THREADS 30°		PROJECT NO.	US ATLAS SILICON SUBSYSTEM		
	CUT ROUNDS, 1.5 THREAD RELIEF ON MACHINED THREADS		DWG. BY	W. K. MILLER	DATE	4/16/2002
	BREAK EDGES, .016 MAX. ON MACHINED WORK		CHK. BY	BILL WILDS	DATE	4/16/2002
	REMOVE BURRS, WELD SPLATTER & LOOSE SCALE		APR. BY	E. ANDERSSSEN	DATE	4/16/2002
	IN ACCORDANCE WITH ASME Y14.5m & B46.1					
REV	DWG	CHK	ZONE	DATE	CHANGES	

Charge account number P1AP13