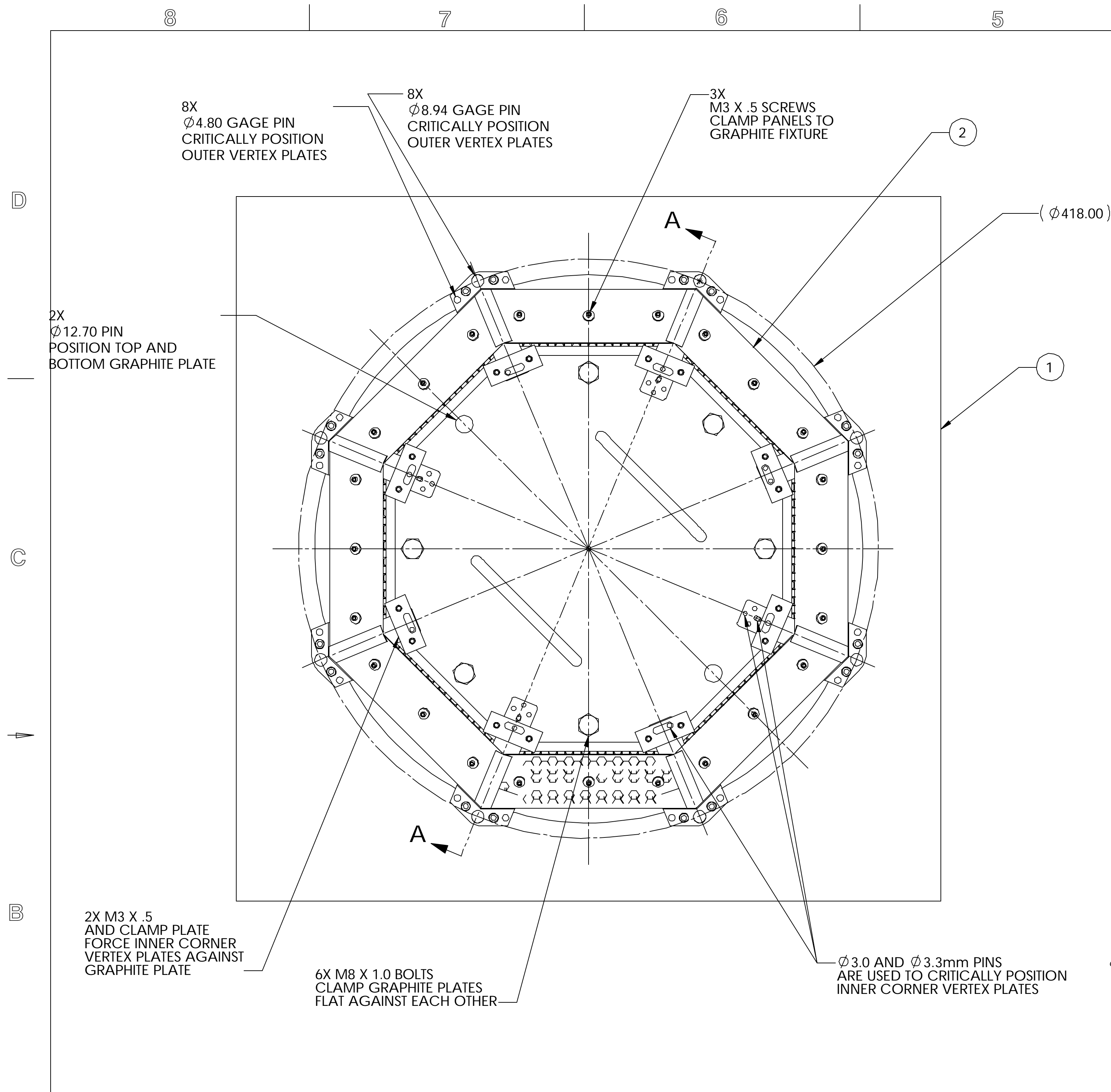
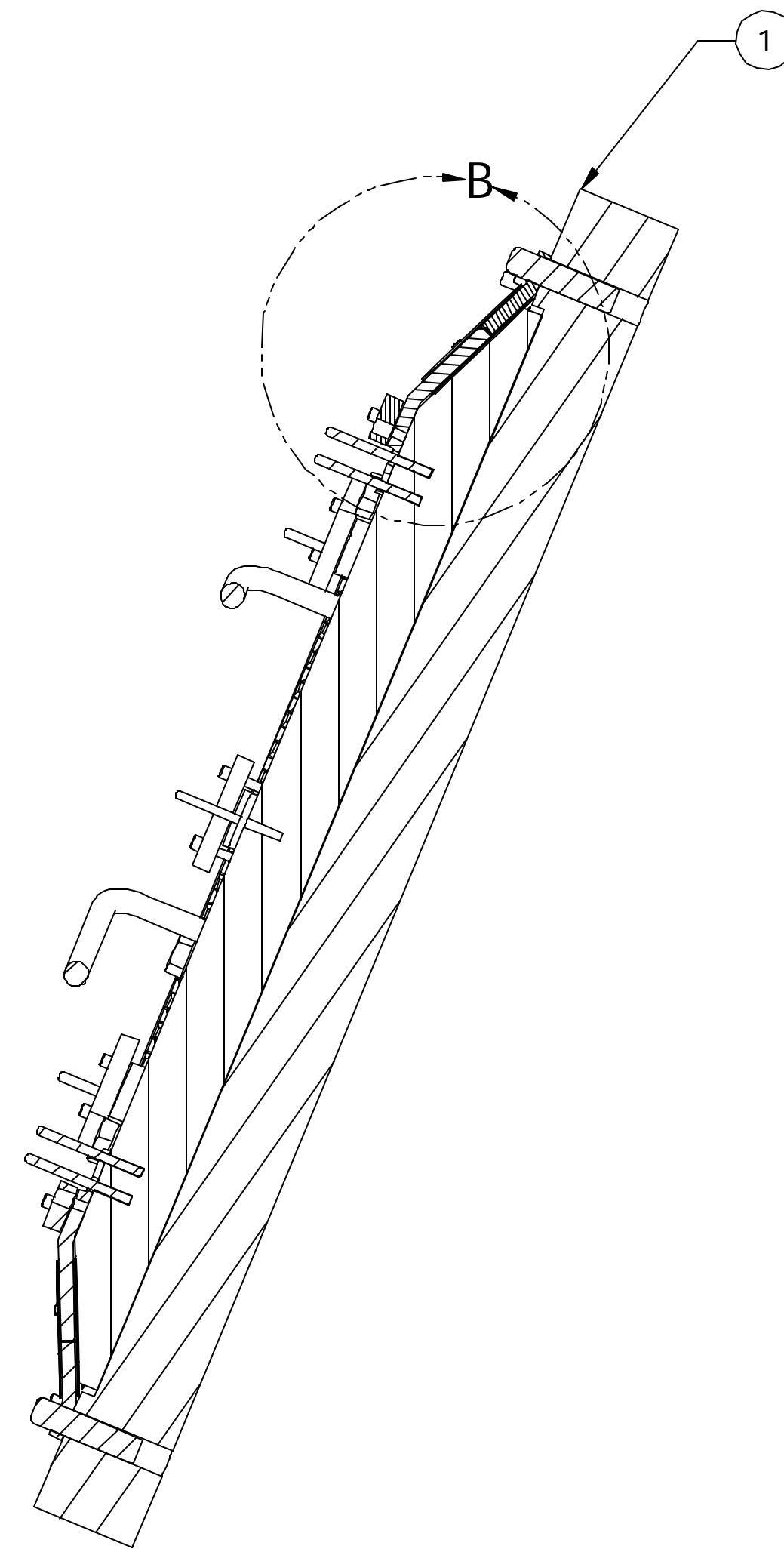


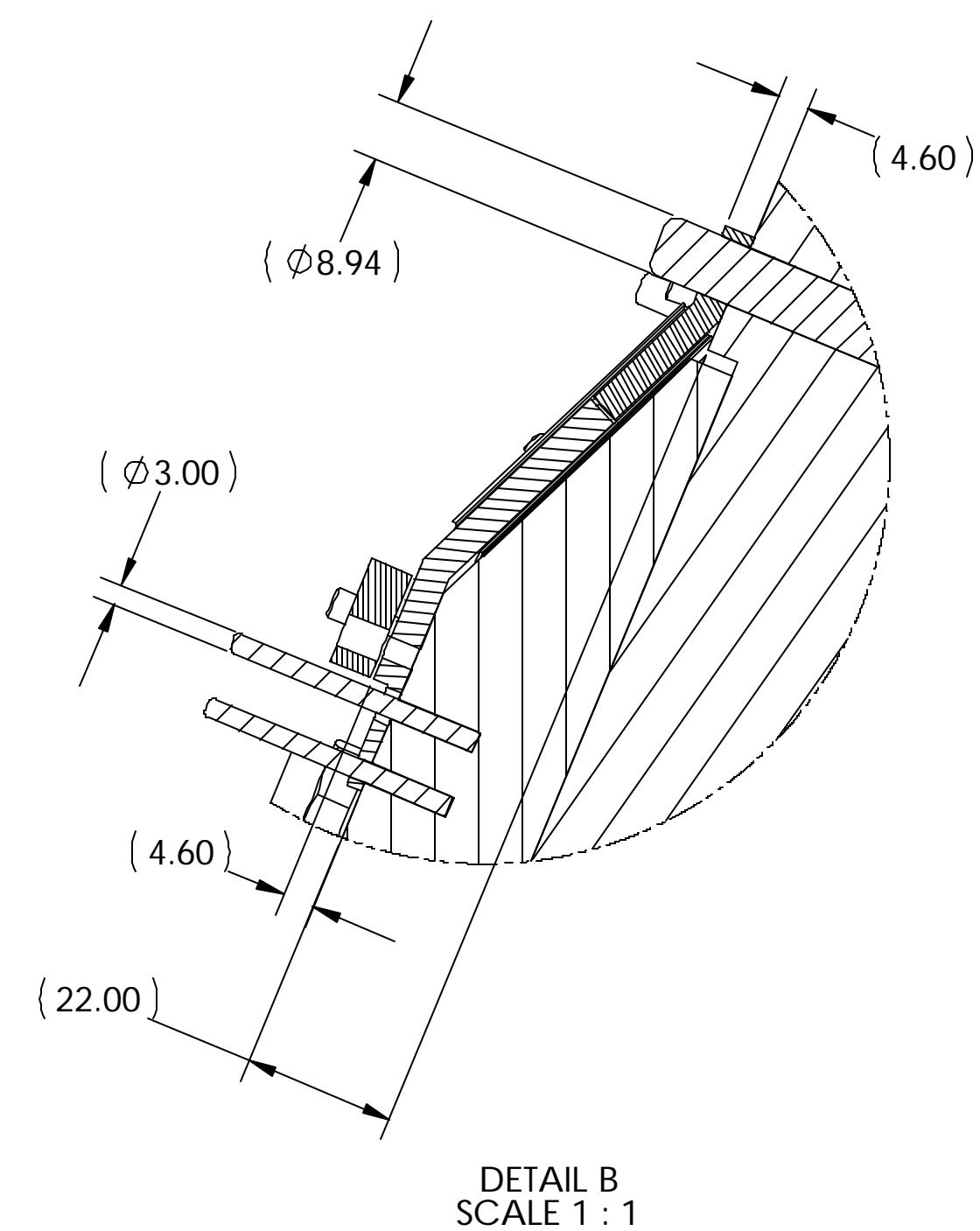
ITEM	PART NO.	REQD	DESCRIPTION	MATERIAL
2	21F720	1	"A" SIDE ENDCONE ASSEMBLY	
1	21F745	1	"A" AND "C" SIDE ENDCONE BOND FIXTURE	



"A" SIDE BOND FABRICATION SHOWN



SECTION A-A SCALE 1:2



DETAIL B SCALE 1:1

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
- PARTS TO BE THOROUGHLY CLEAN FROM OIL, GREASE, DIRT AND CHIPS
- ALL TOLERANCES ARE REFERENCE BASED UPON INDIVIDUAL PART TOLERANCES
- APPLY LESS THAN 1/3 RECOMMENDED TORQUE RATING FOR INDIVIDUAL SCREWS TO PREVENT PULLING HELICOILS OUT OF GRAPHITE
- INSERT PINS INTO HOLES TO 2X DIA. DEPTH ONLY TO ALLOW FOR EASY REMOVAL
- SPRAY MOLD RELEASE ON GRAPHITE PLATE IS ACCEPTABLE, TAPE IS PROHIBITED
- HYSOL 9396 ADHESIVE WITH 3 MIL GLASS BEADS TYP FOR BOND JOINTS, SEE FABRICATION PROCEDURE DOCUMENT FOR EXACT SPECIFICATIONS

REV	DWG	CHK	ZONE	DATE	CHANGES	UNLESS OTHERWISE SPECIFIED	SHOP ORDERS	SER NO.	ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY UNIVERSITY OF CALIFORNIA - BERKELEY #
						TOLERANCES X.X ± 0.5 X.XX ± 0.25 X.XXX ± 0.013	FRAC. ± 1/64 ANGLES ± 30° FINISH 1.6	ACCT NO. DATE ISSD DATE REQD	ATLAS PIXEL DETECTOR "A" SIDE ENDCONE ON BONDING FIXTURE
						DO NOT SCALE PRINT	PROJECT NUMBER PROJECT NAME DWG BY CHK BY APR BY	DATE DATE DATE	SCALE: 1:2 SHEET 1 OF 1 21F745 4
						THREADS ARE CLASS 2 CHAMFER ENDS OF ALL SCREW THREADS 30° CUT ROUNDS, 1.5 THREAD RELIEF ON MACHINED THREADS BREAK EDGES, .016 MAX. ON MACHINED WORK REMOVE BURS, WELD SPLATTER & LOOSE SCALE IN ACCORDANCE WITH ASME Y14.5m & B46.1	PROJECT US ATLAS SILICON SUBSYSTEM DWG W. K. MILLER CHK BILL WILDS APR E. ANDERSSSEN	DATE 4/16/2002 DATE 4/16/2002 DATE 4/16/2002	MICROFILMED: DWG. TYPE ASSEM SHOWS ON N/A CATEGORY CIDE P1AP-11 SCALE: 1:2 SHEET 1 OF 1 21F745 4