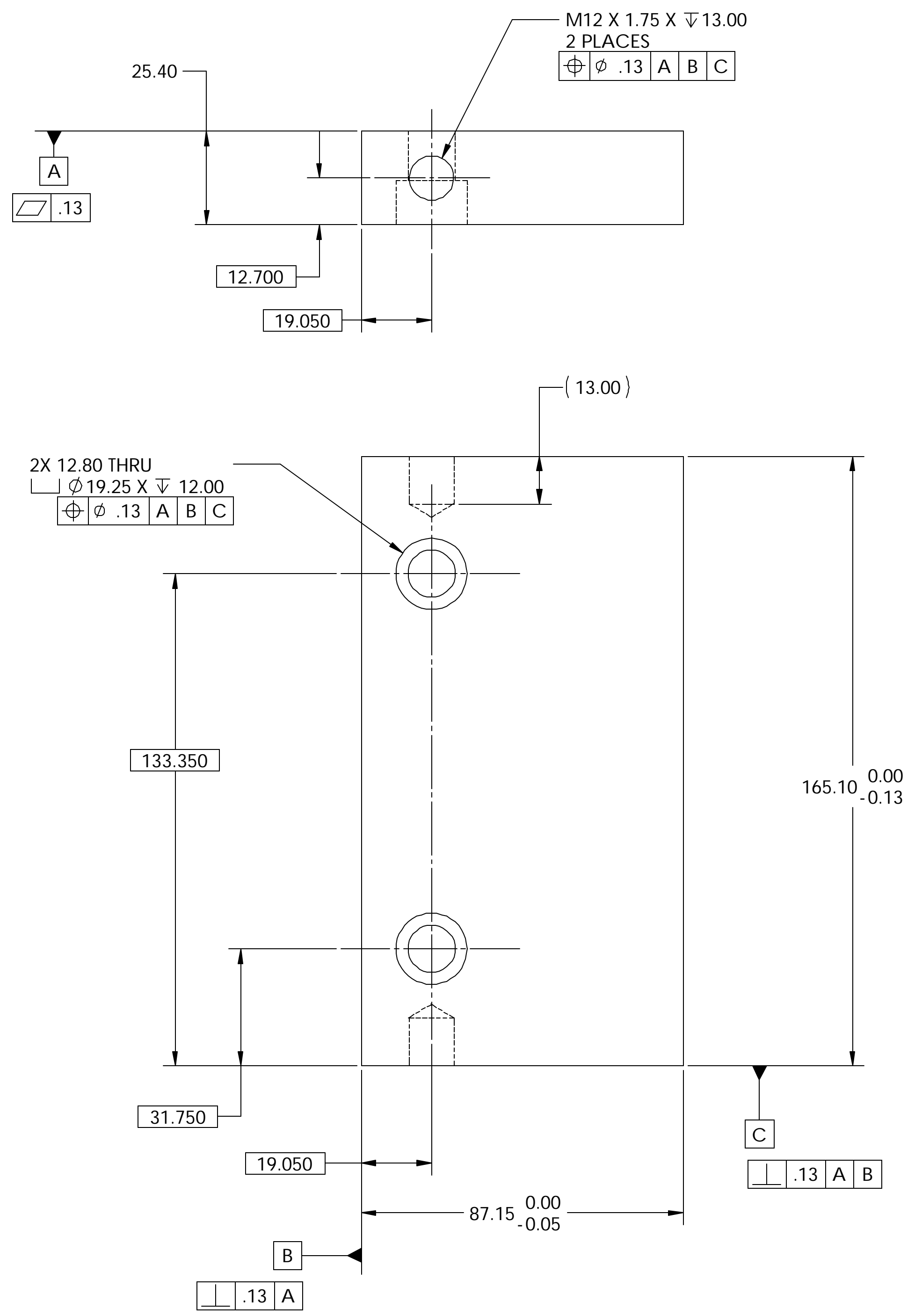


DWG. NO.	SIZE	REV.	SHEET
21F7624		1	1
DESCRIPTION		MATERIAL	MNT. LOCATION



MATL: 4340 ALLOY STEEL (SEE NOTE 9)

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
- 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
- 4340 MATERIAL TO BE CARBORIZED AND OIL QUENCHED TO ACHIEVE Rc50 (HB 475) MINIMUM HARDNESS

UNLESS OTHERWISE SPECIFIED		SHOP ORDERS		SER. NO.		ERNEST ORLANDO LAWRENCE	
TOLERANCES		ACCT. NO.		DATE ISSD		BERKELEY NATIONAL LABORATORY	
X.X ± 0.5	FRAC. ± 1/64	NO. REQD.		DATE REQD.		UNIVERSITY OF CALIFORNIA - BERKELEY #	
X.XX ± 0.25	ANGLES ± 30°	DEL. TO		SURFACE TREATMENT		ATLAS PIXEL DETECTOR	
X.XXX ± 0.013	FINISH 1.6	INDEX METHOD TAG		PROJECT NUMBER		ENDCONE VERTEX PLATE	
DO NOT SCALE PRINT				PROJECT NAME		MOLD SIDE PLATE	
THREADS ARE CLASS 2				PROJECT US ATLAS SILICON SUBSYSTEM		MICROFILMED:	
CHAMFER ENDS OF ALL SCREW THREADS 30°				DWE W. K. MILLER		DWG. TYPE	
CUT ROUND, 1.5 THREAD RELIEF ON MACHINED THREADS				DATE 4/16/2002		PART	
BREAK EDGES .016 MAX. ON MACHINED WORK				CHK BILL WILDS		SHOWS ON	
REMOVE BURRS, WELD SPLATTER & LOOSE SCALE				DATE 4/16/2002		21F759	
IN ACCORDANCE WITH ASME Y14.5m & B46.1				APR BY E ANDERSSSEN		SCALE: 1:1	
REV DWG		CHK ZONE		DATE		DO NOT SCALE PRINTS	
						SHEET 1 OF 1	
						SIZE REV.	
						21F7624	

REV	DWG	CHK	ZONE	DATE	CHANGES