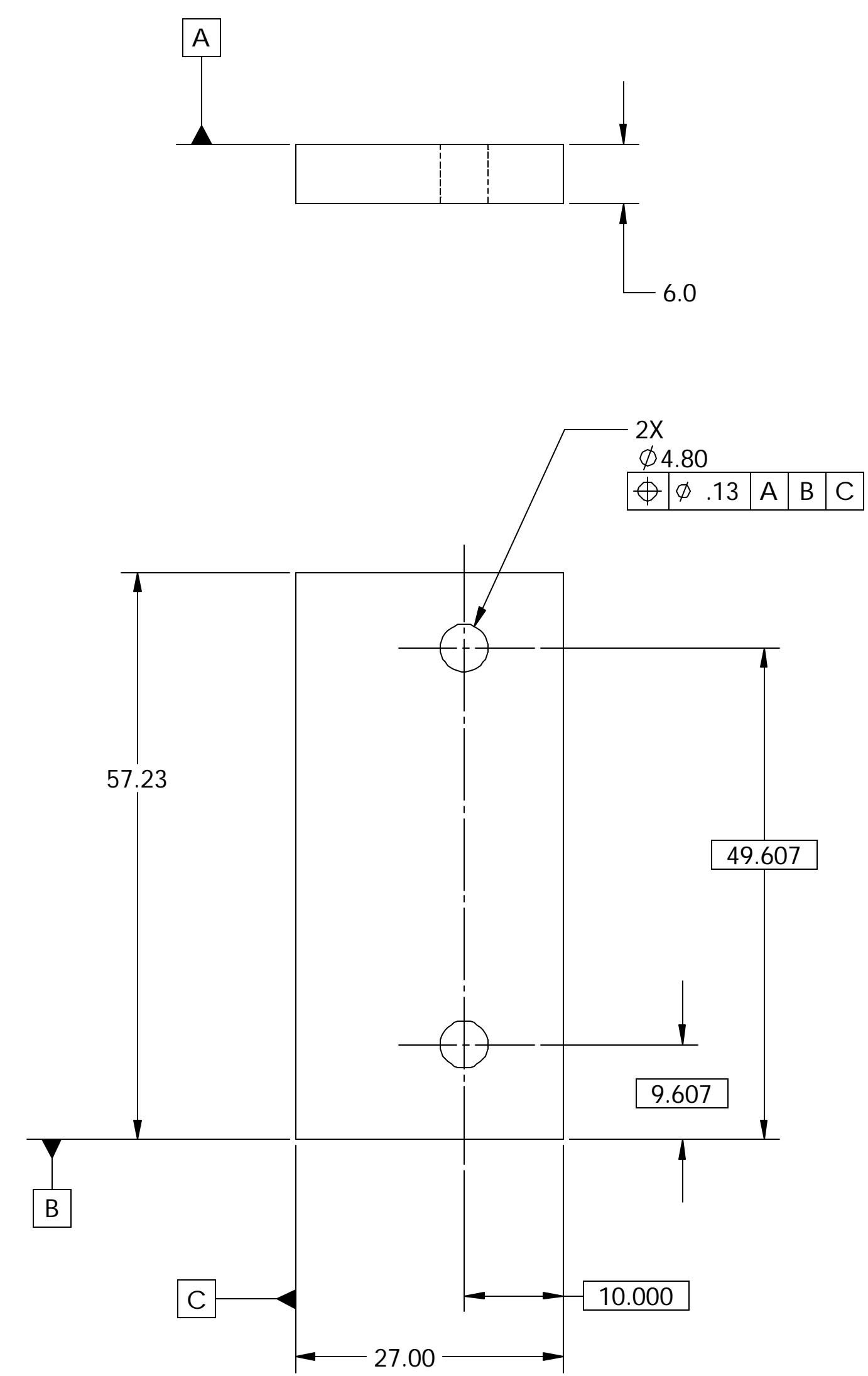
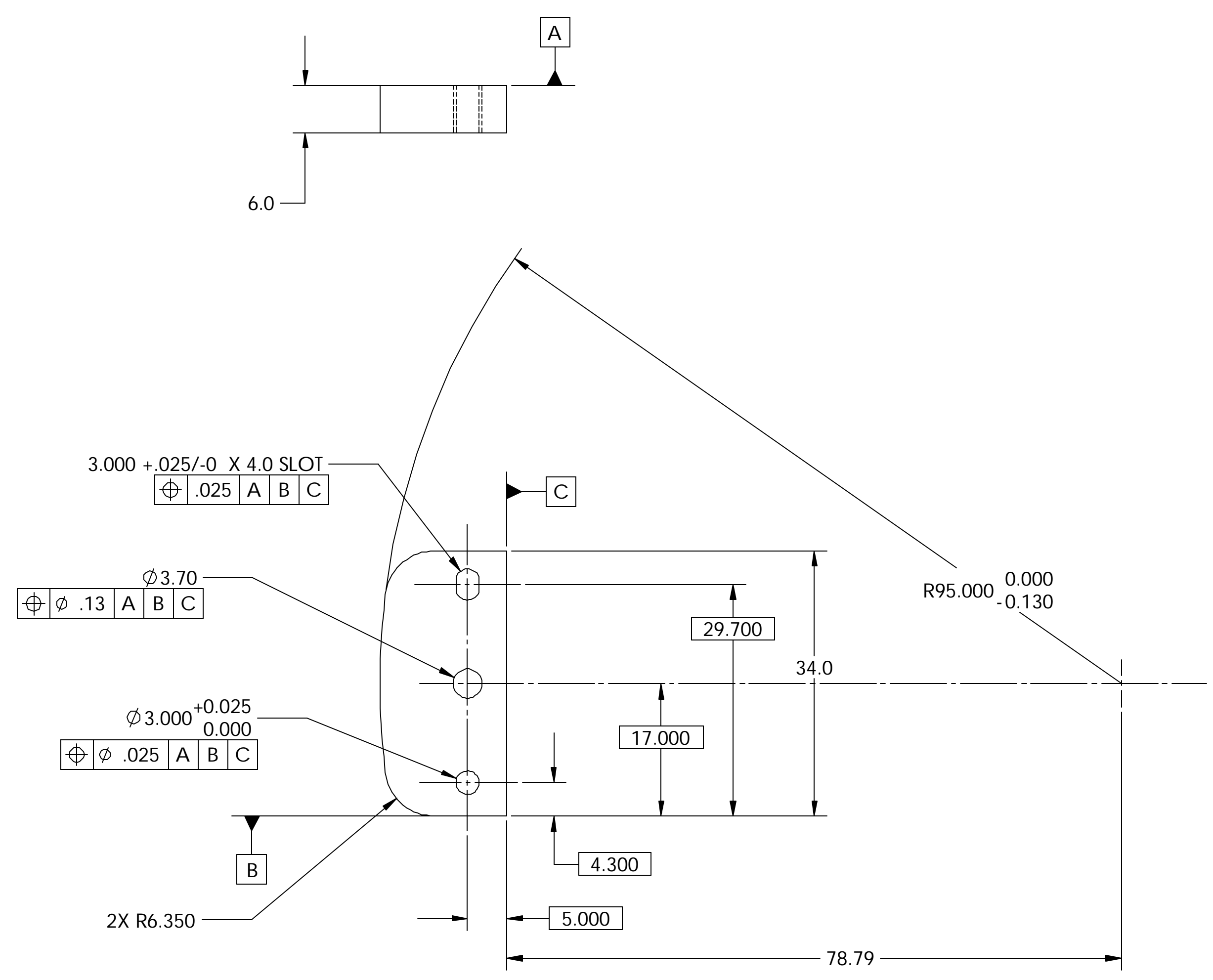


DWG. NO.	SIZE	REV.	SR.		
21F777 4	=	1			
DESCRIPTION		MATERIAL	MT. LOCATION		



STIFFENER VERTEX PLATE CLAMP  
MATL: ALUMINUM



FACESHEET ALIGNMENT BLOCK  
MATL: ALUMINUM

NOTES: UNLESS OTHERWISE SPECIFIED

1. DIMENSIONS IN MILLIMETERS
2. DIMENSIONS AND TOLERANCING PER ASME Y14.5M-1994
3. SURFACE TEXTURE PER ANI/ASME B 46.1-1985
4. REMOVE ALL BURRS AND BREAK SHARP EDGES TO A MAXIMUM OF .38
5. ALL INSIDE CORNERS TO BE .38 RADIUS MAX
6. COUNTERSINK 82 DEGREES ALL TAPPED HOLES TO MAJOR DIAMETER
7. COUNTERSINK 82 DEGREES APPROXIMATELY .38 DEEP ALL DRILLED HOLES
8. PARTS TO BE THOROUGHLY CLEANED TO REMOVE ALL OIL, GREASE, DIRT AND CHIPS

REV		DWG	CHK	ZONE	DATE	UNLESS OTHERWISE SPECIFIED		SHOP ORDERS		SER	ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY UNIVERSITY OF CALIFORNIA - BERKELEY #		
						TOLERANCES	X.X ± 0.5	FRAC. ± 1/64	ACCT NO.	NO. REQD	DATE ISSD	<b>ATLAS PIXEL DETECTOR SPACEFRAME END STIFFENER BONDING FIXTURE CLAMPS</b>	
							X.XX ± 0.25	ANGLES ± 30°	DEL TO	DATE REQD			
							X.XXX ± 0.013	FINISH 3.2	SURFACE TREATMENT				
						<b>DO NOT SCALE PRINT</b>			INDEX METHOD TAG				
						THREADS ARE CLASS 2				PROJECT NUMBER			
						CHAMFER ENDS OF ALL SCREW THREADS 30°				PROJECT NAME			
						CUT ROUND, 1.5 THREAD RELIEF ON MACHINED THREADS				PROJECT US ATLAS SILICON SUBSYSTEM			
						BREAK EDGES .016 MAX. ON MACHINED WORK				DWE W. K. MILLER		DATE 4/16/2002	
						REMOVE BURRS, WELD SPLATTER & LOOSE SCALE				CHK BILL WILDS		DATE 4/16/2002	
						IN ACCORDANCE WITH ASME Y14.5m & B46.1				APR E ANDERSSSEN		DATE 4/16/2002	
						CHANGES						MICROFILMED: DWG. TYPE PART SHOWS ON 21F775 SCALE: 2:1 SHEET 1 OF 1 CATEGORY CIDE P1AP-11 AP6250 DWG. NO. 21F777 4 SIZE REV.	