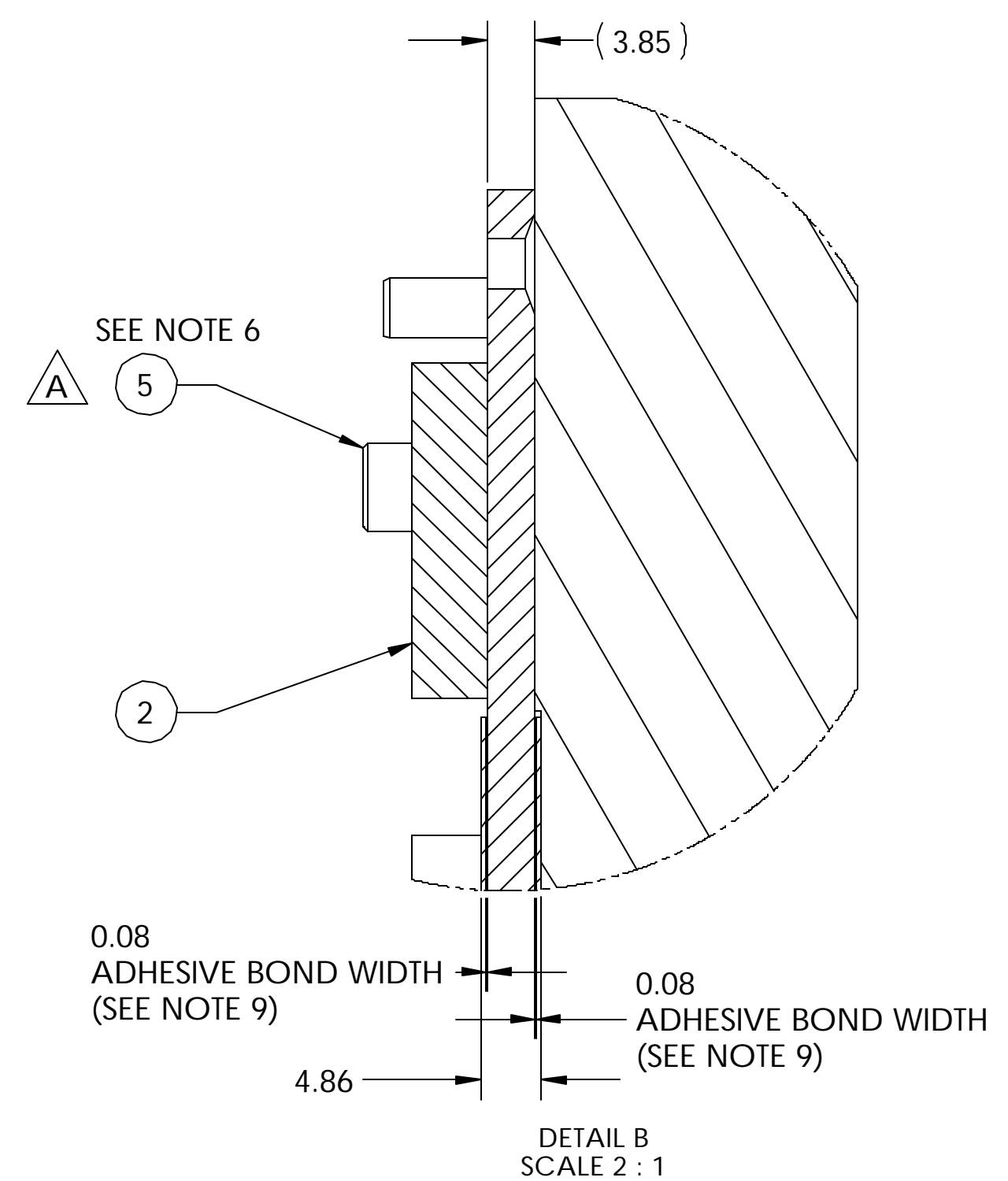
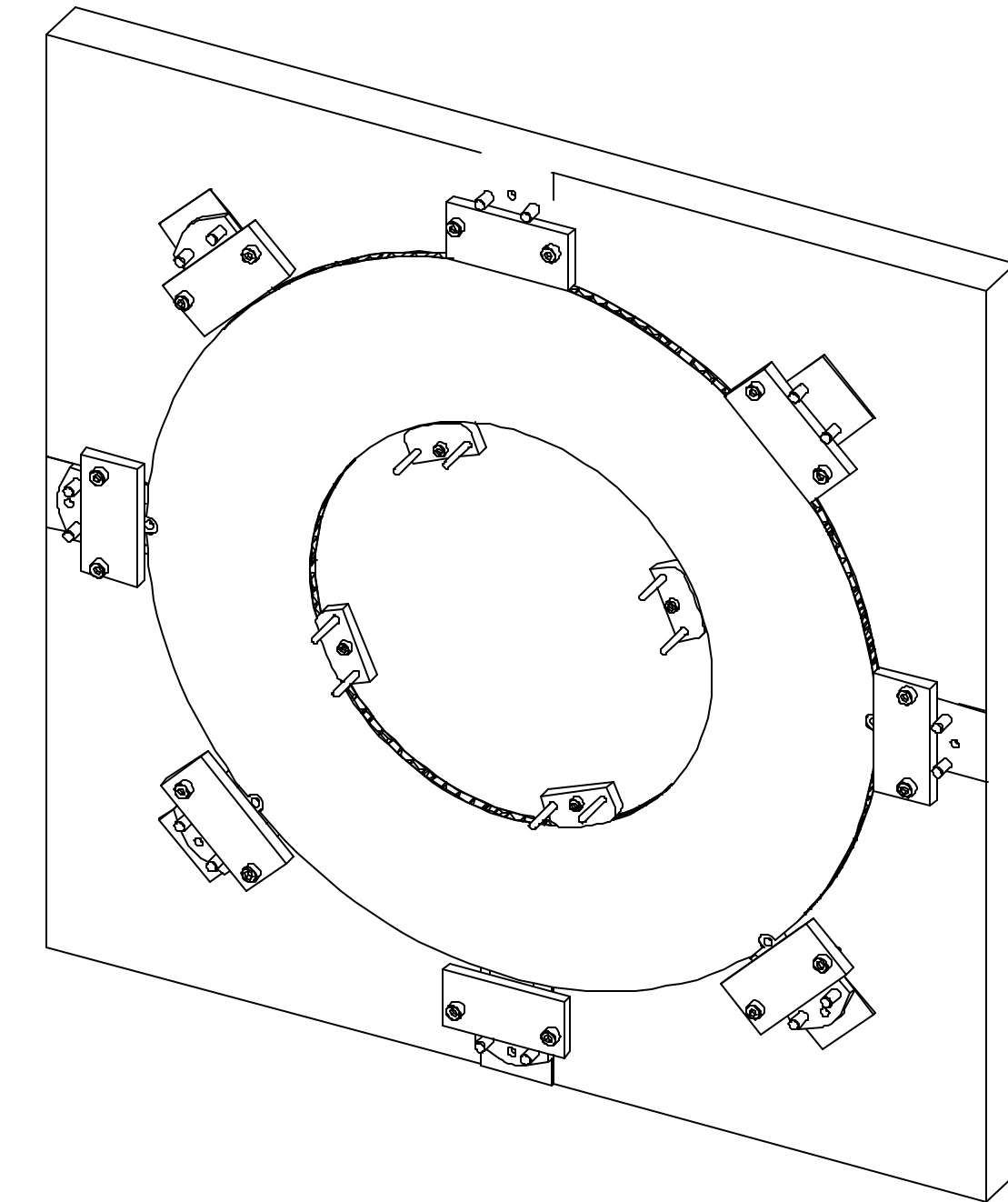
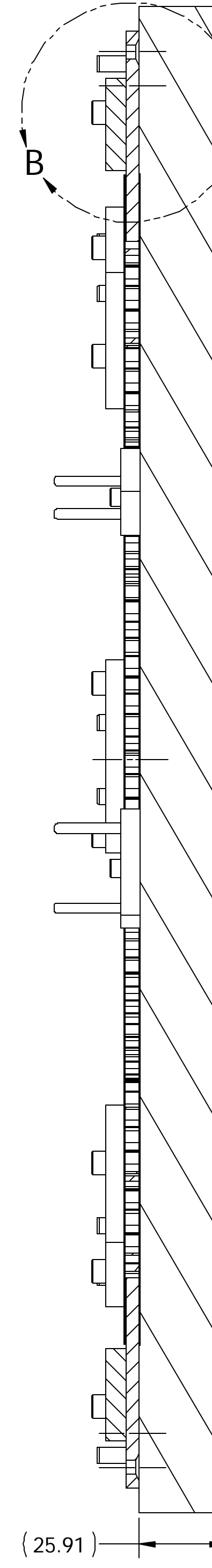
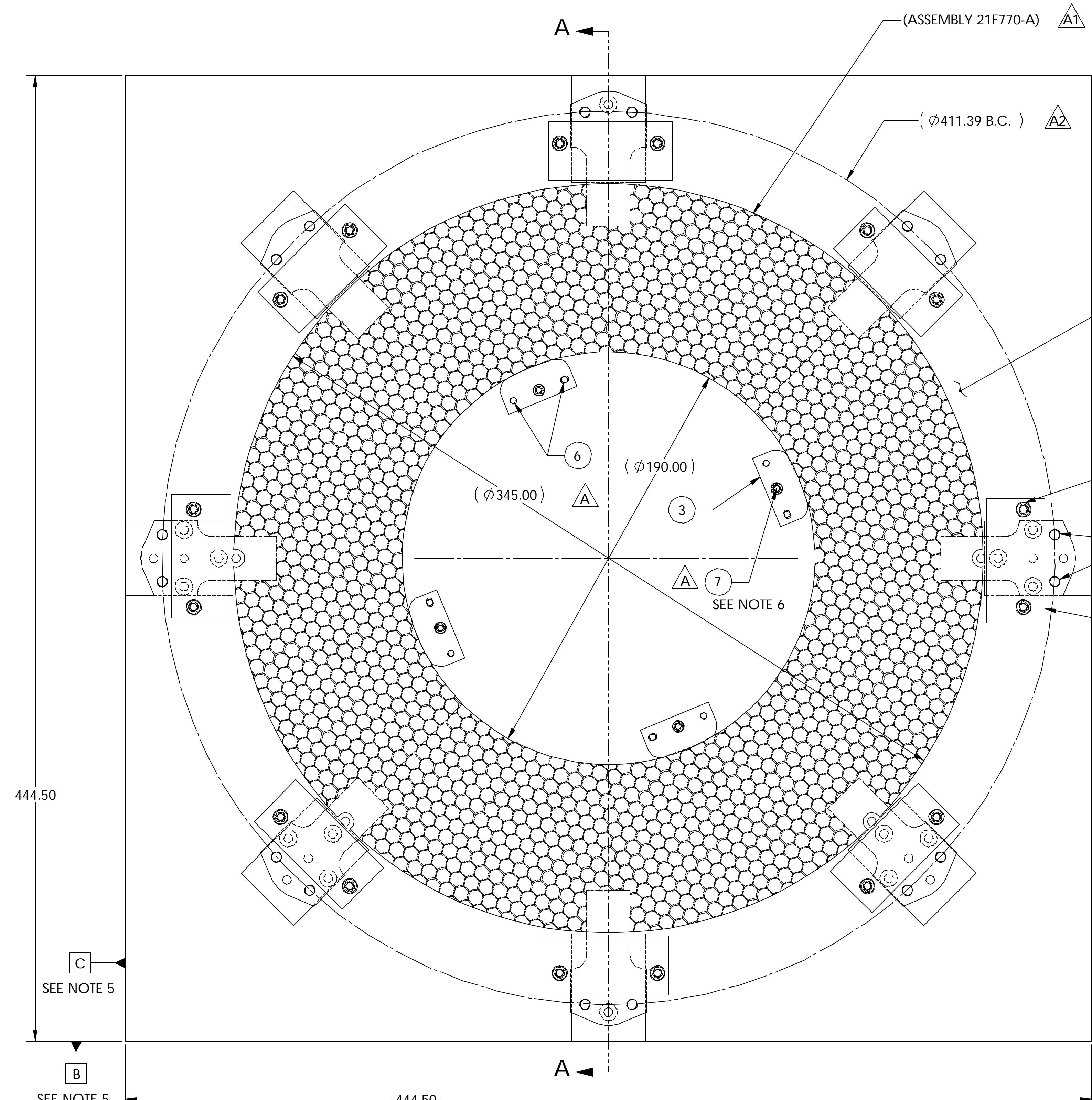


ITEM	PART NO.	REQD	DESCRIPTION	MATERIAL
8		16	4.80 DIA. GAGE PIN	STEEL
7		4	M3 X .50 SOCKET HEAD CAP SCREW X 12.7	STEEL
6		8	3.00 DIA. GAGE PIN	STEEL
5		32	M4 X .7 SOCKET HEAD CAP X 12.7 LONG	STEEL
4	21F778	1	END STIFFENER CAUL PLATE (NOT SHOWN)	ALUM
3	21F777	4	END STIFFENER FACESHEET ALIGNMENT BLOCK	ALUM
2	21F777	8	END STIFFENER VERTEX PLATE CLAMP	ALUM
1	21F776	1	END STIFFENER BOND FIXTURE PLATE	GRAPHITE



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
- SEE FABRICATION PROCEDURE DOCUMENT FOR EXACT SPECIFICATIONS

UNLESS OTHERWISE SPECIFIED		SHOP ORDERS		SER	
TOLERANCES		NO. REQD	DATE ISSD	NO.	DATE
X.X ± 0.5	FRAC. ± 1/64				
X.XX ± 0.25	ANGLES ± 30'				
X.XXX ± 0.013	FINISH 1.6				
		SURFACE TREATMENT			
		DO NOT SCALE PRINT			
		THREADS ARE CLASS 2			
		CHAMFER ENDS OF ALL SCREW THREADS 30°			
		CUT ROUND, 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			

REV	DWG	CHK	ZONE	DATE	CHANGES
A		WKM		9-3-02	DELETED ITEM 5, ASSY NO. REVISED

PROJECT NAME	PROJECT NUMBER	DATE	DATE	DATE
US ATLAS SILICON SUBSYSTEM	ATL-IP-ED-XXXX	4/16/2002	4/16/2002	4/16/2002

DWG. NO.	TYPE	SHOWS ON	SCALE	DO NOT SCALE PRINTS
21F7754	ASSEM	N/A	1:1.25	

PATENT CLEAR.	DESIGN ACCT. NO.	CATEGORY CODE	DWG. NO.	SIZE	REV.
	PIAP-11	AP6250	21F7754	A	

ERNEST ORLANDO LAWRENCE
 BERKELEY NATIONAL LABORATORY
 UNIVERSITY OF CALIFORNIA - BERKELEY #
 ATLAS PIXEL DETECTOR
 SPACEFRAME END STIFFENER
 BOND FIXTURE ASSEMBLY
 SHEET 1 OF 1