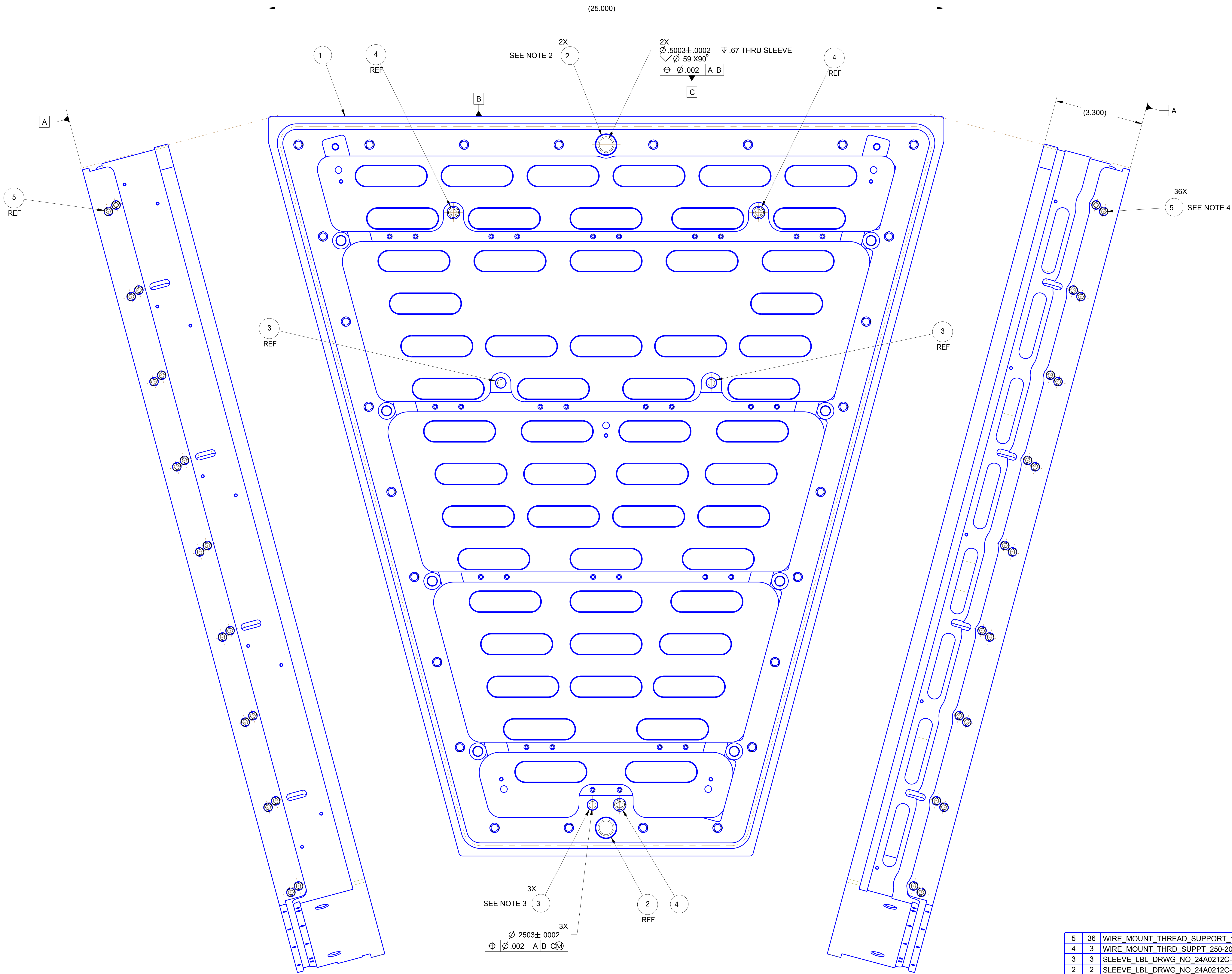



NOTES:  
1.DO NOT USE CUTTING FLUIDS OTHER THAN ALCOHOL AND/OR WATER.  
2.PRESS FIT ITEM (2) SLEEVE .025 TO .045 BELOW SURFACE  
(to accommodate .015 cleanup cut at next operation)  
3.PRESS FIT ITEM (3) SLEEVE .025 TO .045 BELOW SURFACE  
(to accommodate .015 cleanup cut at next operation)  
4.INSTALL ITEM (4) THREAD SUPPORT .025 TO .045 BELOW SURFACE.  
EPOXY IN PLACE.

REVISIONS						
REV	EON NO	DESCRIPTION	BY	DATE	CKR	APP
E		RECONSTRUCTED MODEL & DRAWING USING PTC CREO 2.0 PARAMETRIC. REVISED DIMENSIONING SCHEME TO ASME Y14.5-2009. THIS DRAWING SUPERSEDES SLEEVE INSERTION/BORING & WIRE MOUNT THREAD SUPPORT INSERTION PART OF LBL DRAWING NUMBER 24A3816.	JF	2/29/2016	RS	



5	36	WIRE MOUNT THREAD SUPPORT 10-32	PART	SIBRONZE	0.006	LBL DRWG 24A4242A	
4	3	WIRE MOUNT THRD SUPPT 250-20UNC	PART	SIBRONZE	0.013	LBL DRWG 24A4252A	
3	3	SLEEVE LBL DRWG NO 24A0212C-2	PART	SIBRONZE	0.014	LBL DRWG 24A0212C-2	
2	2	SLEEVE LBL DRWG NO 24A0212C-1	PART	SIBRONZE	0.058	LBL DRWG 24A0212C-1	
1	1	INNER SECTOR STRONGBACK	PART	ALUM 6061-T6	48.174	LBL DRWG 24A3685	
ITEM QTY	PART NAME / DESCRIPTION			TYPE	MATERIAL	MASS [lbs]	DRAWING / PART NUMBER
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES DIMENSIONS IN BRACKETS [x.xx] ARE IN MILLIMETERS AND ARE FOR REFERENCE ONLY				STAR DRAWING NUMBER:		TPC428-E-1	
BROOKHAVEN NATIONAL LABORATORY				DRAWN BY J. FARRELL Feb-22-16		RHC-STAR-TPC INNER SECTOR INNER SECTOR STRONGBACK ASSY	
INTERPRET IN GENERAL ACCORDANCE WITH ASME Y14.5-2009				CHECKED BY R. SOJA			
DECIMAL TOLERANCES: X .XX X .XXX X .XXX ± .015 X .XXX ± .005				ENGINEER R. SHARMA			
ANGULAR TOLERANCES X .X X .X ± .015 X .X ± .005				ENGR MGR			
FINISH: 125				CHIEF M.E.			
THIRD ANGLE PROJECTION				Q.A.		SIZE E	
WSP#				LBL DRAWING NUMBER: LBL DRWG 24A3816		REV E	
24A3685_ASSY_REV_E 40				LEVELOP NO. LEVEL		A-3	
Do Not Scale Drawing				SCALE:		3/4	
				WEIGHT:		3/4	
				SHEET:		1/1	