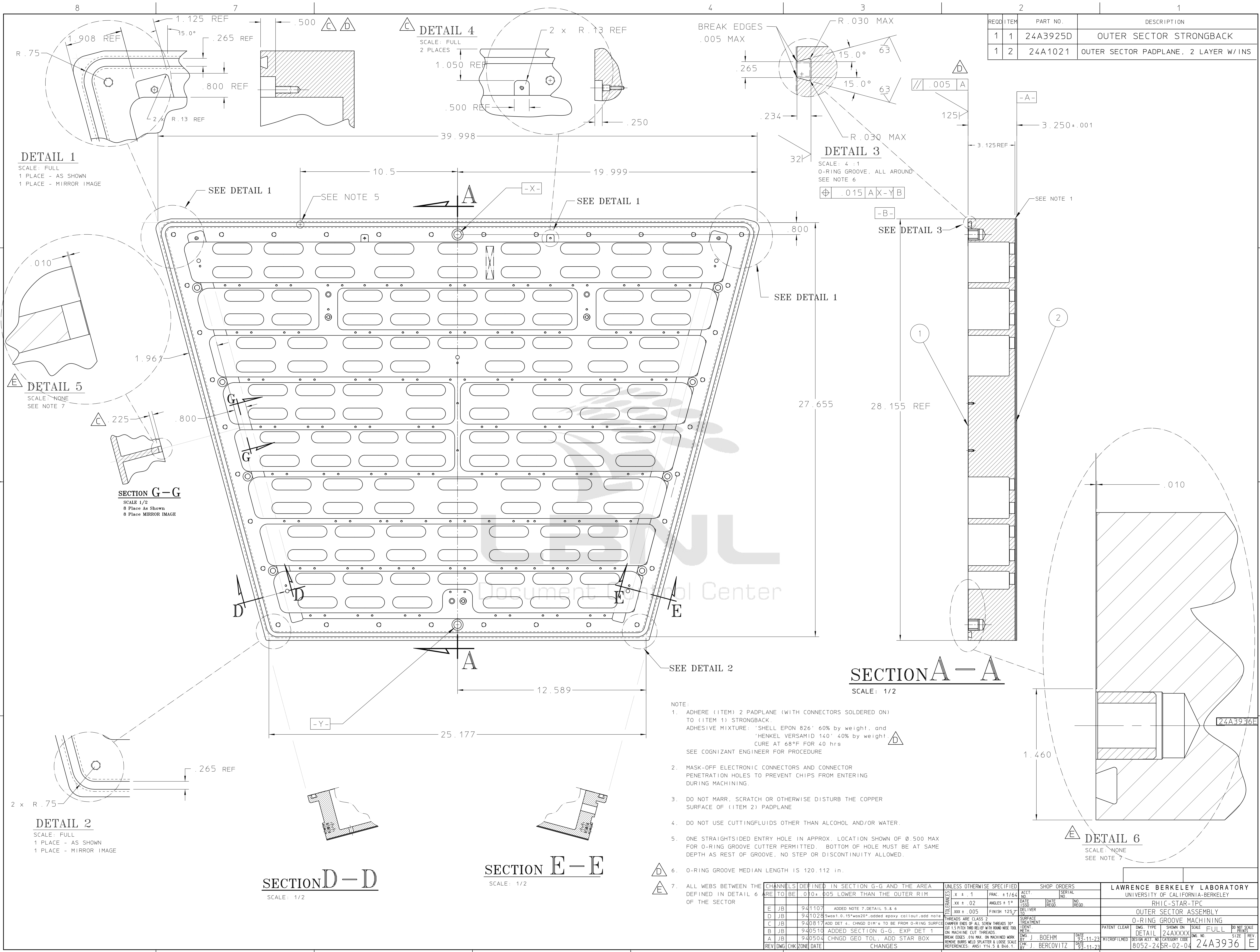


RECD	ITEM	PART NO.	DESCRIPTION
1	1	24A3925D	OUTER SECTOR STRONGBACK
1	2	24A1021	OUTER SECTOR PADPLANE, 2 LAYER W/INS



DETAIL 1
SCALE: FULL
1 PLACE - AS SHOWN
1 PLACE - MIRROR IMAGE

DETAIL 5
SCALE: NONE
SEE NOTE 7

DETAIL 2
SCALE: FULL
1 PLACE - AS SHOWN
1 PLACE - MIRROR IMAGE

DETAIL 4
SCALE: FULL
2 PLACES

DETAIL 3
SCALE: 4 : 1
O-RING GROOVE, ALL AROUND
SEE NOTE 6

SECTION G-G
SCALE: 1/2
8 Place As Shown
8 Place MIRROR IMAGE

SECTION D-D
SCALE: 1/2

SECTION E-E
SCALE: 1/2

SECTION A-A
SCALE: 1/2

DETAIL 6
SCALE: NONE
SEE NOTE 7

- NOTE:
- ADHERE (ITEM 2) PADPLANE (WITH CONNECTORS SOLDERED ON) TO (ITEM 1) STRONGBACK. ADHESIVE MIXTURE: "SHELL EPON 826" 60% by weight, and "HENKEL VERSAMID 140" 40% by weight. CURE AT 68°F FOR 40 hrs. SEE COGNIZANT ENGINEER FOR PROCEDURE.
 - MASK-OFF ELECTRONIC CONNECTORS AND CONNECTOR PENETRATION HOLES TO PREVENT CHIPS FROM ENTERING DURING MACHINING.
 - DO NOT MARR, SCRATCH OR OTHERWISE DISTURB THE COPPER SURFACE OF (ITEM 2) PADPLANE.
 - DO NOT USE CUTTINGFLUIDS OTHER THAN ALCOHOL AND/OR WATER.
 - ONE STRAIGHTSIDED ENTRY HOLE IN APPROX. LOCATION SHOWN OF Ø .500 MAX FOR O-RING GROOVE CUTTER PERMITTED. BOTTOM OF HOLE MUST BE AT SAME DEPTH AS REST OF GROOVE, NO STEP OR DISCONTINUITY ALLOWED.
 - O-RING GROOVE MEDIAN LENGTH IS 120.112 in.
 - ALL WEBS BETWEEN THE CHANNELS DEFINED IN SECTION G-G AND THE AREA ARE TO BE .010 ± .005 LOWER THAN THE OUTER RIM OF THE SECTOR.

REV	DATE	CHK	ZONE	CHANGES	UNLESS OTHERWISE SPECIFIED	SHOP ORDERS	LAWRENCE BERKELEY LABORATORY
E	941107			ADDED NOTE 7, DETAIL 5 & 6	CO X ± .1	ACCT. NO. 1164	LAWRENCE BERKELEY LABORATORY UNIVERSITY OF CALIFORNIA-BERKELEY RHIC-STAR-TPC OUTER SECTOR ASSEMBLY O-RING GROOVE MACHINING
D	941028			Sheet 0.15" x 0.20" added epoxy callout, add note	FRAC. ± 1/64	DATE ISSUED	
C	940817			ADD DET 4, CHNGD DIM'S TO BE FROM O-RING SURFACE	ANGLES ± 1°	DELIVER TO	
B	940510			ADDED SECTION G-G, EXP DET 1	FINISH 125/7	TREATMENT	
A	940504			CHNGD GEO TOL, ADD STAR BOX	THREADS ARE CLASS 2	PATENT CLEAR	
					CHAMFER ENDS OF ALL SREW THREADS 30°	DWG. TYPE	
					CUT 1/4 PITCH AND RELIEF WITH ROUND NOSE TOOL	SCALE	
					ON MACHINE CUT THREADS	SHOWN ON	
					BREAK EDGES .016 MAX. ON MACHINED WORK	DETAIL	
					REMOVE BURRS WELD SPATTER & LOOSE SCALE	8052-24SR-02-04	