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-C-
16 PLACES

C	PART #24A4306A	TUBE #1 — 33.620±.002
C	PART #24A4316A	TUBE #2 — 33.605±.002
C	PART #24A4326A	TUBE #3 — 32.761±.002
C	PART #24A4336A	TUBE #4 — 31.917±.002
C	PART #24A4346A	TUBE #5 — 31.073
C	PART #24A4356A	TUBE #6 — 30.229±.002
C	PART #24A4366A	TUBE #7 — 29.385±.002
C	PART #24A4374A	TUBE #8 — 28.541±.002
C	PART #24A4384A	TUBE #9 — 27.697±.002
C	PART #24A4394A	TUBE #10 — 26.853±.002
C	PART #24A4404A	TUBE #11 — 26.009±.002
C	PART #24A4414A	TUBE #12 — 25.165±.002
C	PART #24A4424A	TUBE #13 — 24.321±.002
C	PART #24A4434A	TUBE #14 — 23.478±.002
C	PART #24A4444A	TUBE #15 — 22.634±.002
C	PART #24A4454A	TUBE #16 — 21.790±.002

SEE DETAIL 1

4 x .15 x45°
.052±.002
15.0°±.5°
.533±.002
500
.257±.002
1.0
R.25
4 x .06 x45°
1 PLACE AS SHOWN
1 PLACE MIRROR IMAGE
.670±.001
TUBE -16 ONLY
SEE OTHER END OF TUBE FOR DIMENSIONAL INFORMATION

4 x .015 x45°
4 x .06 x45°
-A-
-B-
LENGTH
.500 REF
.052±.002
15.0°±.5°
.703 REF
.674±.002
.215±.002
24A4096C

DETAIL 1 (A)

SCALE 2:1
15 PLACES AS SHOWN
15 PLACES MIRROR IMAGE

NOTES:

1. DEGREASE PARTS AFTER MACHINING
2. AFTER PARTS HAVE BEEN MANUFACTURED AND INSPECTED
   A. CLEAN PARTS BY THE PHOSPORIC ACID ANODIZING METHOD (ASTM D3933-80)
   B. COAT WITHIN 4 hrs WITH DEXTER-HYSOL PRIMER #EA 9210 H

REV.	DWG	CHK	ZONE	DATE	CHANGES
C	JB			940020	REV PART No FOR EACH TUBE PER AS-BUILT
B	JB			940309	REVISED DETAIL 1 DIMENSIONING SCHEME
A	JB			940309	REVISED DETAIL 1 DIMENSIONING SCHEME

REQD	ITEM	PART NO.	DESCRIPTION
A/R	1	24A0801B	COOLING TUBE EXTRUSION

UNLESS OTHERWISE SPECIFIED
TOLERANCES: .X ± .1 | FRAC. ±1/64 | .XX ± .02 | ANGLES ± 1° | .XXX ± .005 | FINISH 125
THREADS ARE CLASS 2
CHAMFER ENDS OF ALL SCREW THREADS 30°.
CUT 1.5 PITCH THRD RELIEF WITH ROUND NOSE TOOL ON MACHINE CUT THREADS.
BREAK EDGES .016 MAX. ON MACHINED WORK.
REMOVE BURRS WELD SPLATTER & LOOSE SCALE
REFERENCES: ANSI Y14.5 & B46.1.

SHOP ORDERS
ACCT. NO.
SERIAL NO.
DATE ISSD
DATE REQD.
NO. REQD.
DELIVER TO
SURFACE TREATMENT: SEE NOTES
IDENT. METH.: TAG
DWG. BY: J. BOEHM — DATE: 94-03-01
CHK. BY: J.BERCOVITZ — DATE: 94-03-01

LAWRENCE BERKELEY LABORATORY
UNIVERSITY OF CALIFORNIA-BERKELEY
RHIC-STAR-TPC
OUTER SECTOR COOLING MANIFOLD
COOLING TUBE MACHINING

PATENT CLEAR	DWG. TYPE	SHOWN ON	SCALE	DO NOT SCALE PRINTS
	DETAIL	00X0000	FULL	

MICROFILMED	DESIGN ACCT. NO.	CATEGORY CODE	DWG. NO.	SIZE	REV.
	8052-24	SR0204	24A4096	C	

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