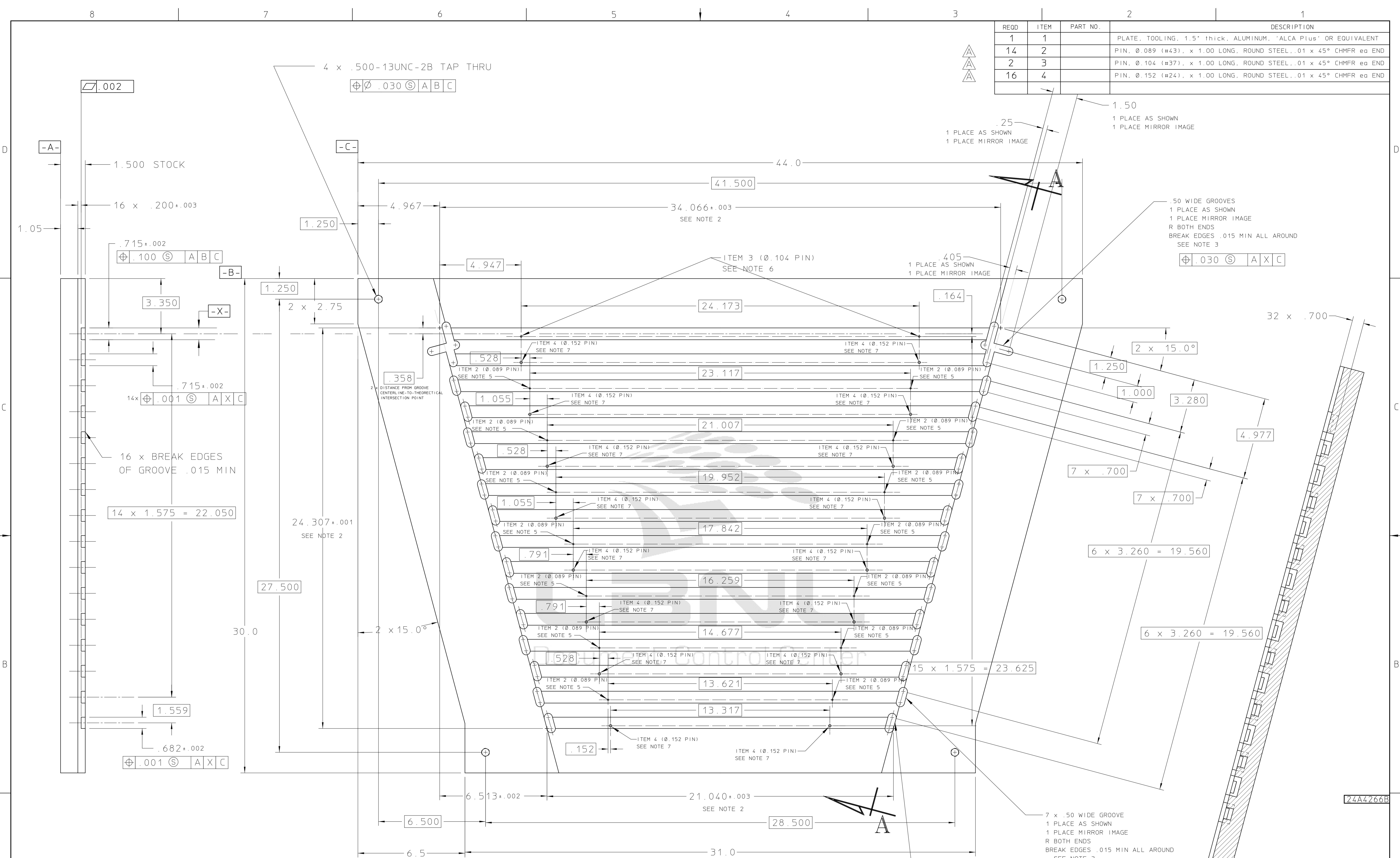


RECD	ITEM	PART NO.	DESCRIPTION
1	1		PLATE, TOOLING, 1.5' thick, ALUMINUM, 'ALCA Plus' OR EQUIVALENT
14	2		PIN, Ø.089 (#43), x 1.00 LONG, ROUND STEEL, .01 x 45° CHMFR ea END
2	3		PIN, Ø.104 (#37), x 1.00 LONG, ROUND STEEL, .01 x 45° CHMFR ea END
16	4		PIN, Ø.152 (#24), x 1.00 LONG, ROUND STEEL, .01 x 45° CHMFR ea END



NOTES:

- .0005/.001(MAX) COAT TOP VIEW SURFACE WITH MOLD RELEASE.
- DIMENSIONS INDICATED ARE TO THEORETICAL INTERSECTION POINTS AND ARE CRITICAL.
- GROOVES INDICATED ARE ADHESIVE DRIP CATCHER AND THEIR LOCATION AND SIZE ARE NOT CRITICAL.
- WEIGHT approx. 180 lbs

- 14 x DRILL & REAM FOR PRESSFIT OF ITEM 2 PIN LOCATED WITHIN .004 OF TRUE POSITION WITH RESPECT TO DATUM SURFACE -A-; -X- DEFINED AS CENTERPLANE OF LONGEST .715+.002 GROOVE; AND DATUM SURFACE -C-, RFS. PIN TO PROTRUDE .45 TO .50 ABOVE SURFACE
- 2 x DRILL & REAM FOR PRESSFIT OF ITEM 3 PIN LOCATED WITHIN .004 OF TRUE POSITION WITH RESPECT TO DATUM SURFACE -A-; -X- DEFINED AS CENTERPLANE OF LONGEST .715+.002 GROOVE; AND DATUM SURFACE -C-, RFS. PIN TO PROTRUDE .45 TO .50 ABOVE SURFACE
- 16 x DRILL & REAM FOR PRESSFIT OF ITEM 4 PIN LOCATED WITHIN .004 OF TRUE POSITION WITH RESPECT TO DATUM SURFACE -A-; -X- DEFINED AS CENTERPLANE OF LONGEST .715+.002 GROOVE; AND DATUM SURFACE -C-, RFS. PIN TO PROTRUDE .45 TO .50 ABOVE SURFACE

SECTION A-A
SCALE 1:2

UNLESS OTHERWISE SPECIFIED		SHOP ORDERS		LAWRENCE BERKELEY LABORATORY	
CO	ACC.	NO.	SERIAL	UNIVERSITY OF CALIFORNIA-BERKELEY	
X ± 1	FRAC. ± 1/64	DATE	NO.	RHIC-STAR-TPC	
XX ± .02	ANGLES ± 1°	ISSD	RECD	OUTER SECTOR COOLING MANIFOLD	
XXX ± .005	FINISH 125/7	DELIVER		BONDING FIXTURE	
THREADS ARE CLASS 2		SURFACE TREATMENT DEGREASE		PATENT CLEAR	
CHAMFER ENDS OF ALL SCREW THREADS 30°		REWORK		DWG. TYPE	
CUT 1.5 PITCH RND RELIEF WITH RND NSE TOO		TAG		SCALE FULL	
ON MACHINING CUT THREADS		DATE		Dwg. NO.	
BREAK EDGES .016 MAX. ON MACHINED WORK		Dwg. J. BOEHM		8052-245R-02-04	
REMOVE BURRS WELD SPATTER & LOOSE SCALE		DATE		24A4266	
REFERENCES: ANG 114.3 & B44.1		Dwg. J. BERCOVITZ		REV. B	