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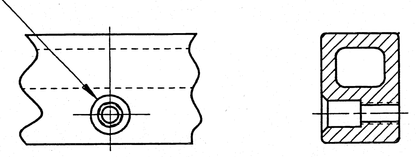
ITEM	ROD	Part Number	Material/Parts Call-Out
		24A0801B	COOLING TUBE EXTRUSION

#6(.138)-32UNF-2C TAP THRU
C'BORE #18(Ø.170/4.32) x .25/6.35 DEEP
C'SINK Ø.25/6.25 x 82°

⌖ Ø.010/.25Ⓢ A B C

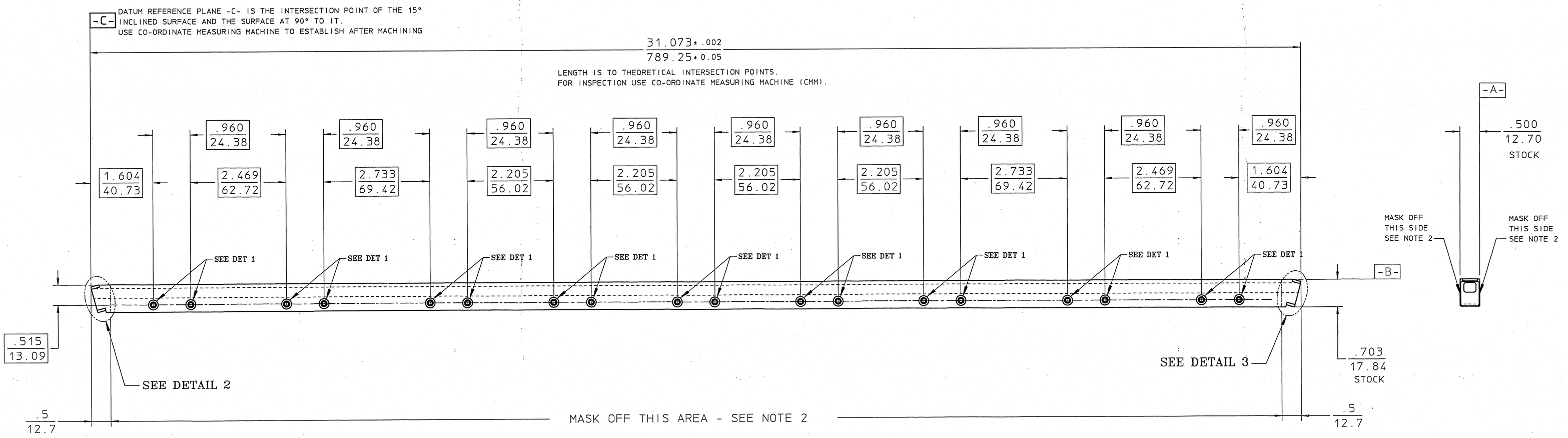


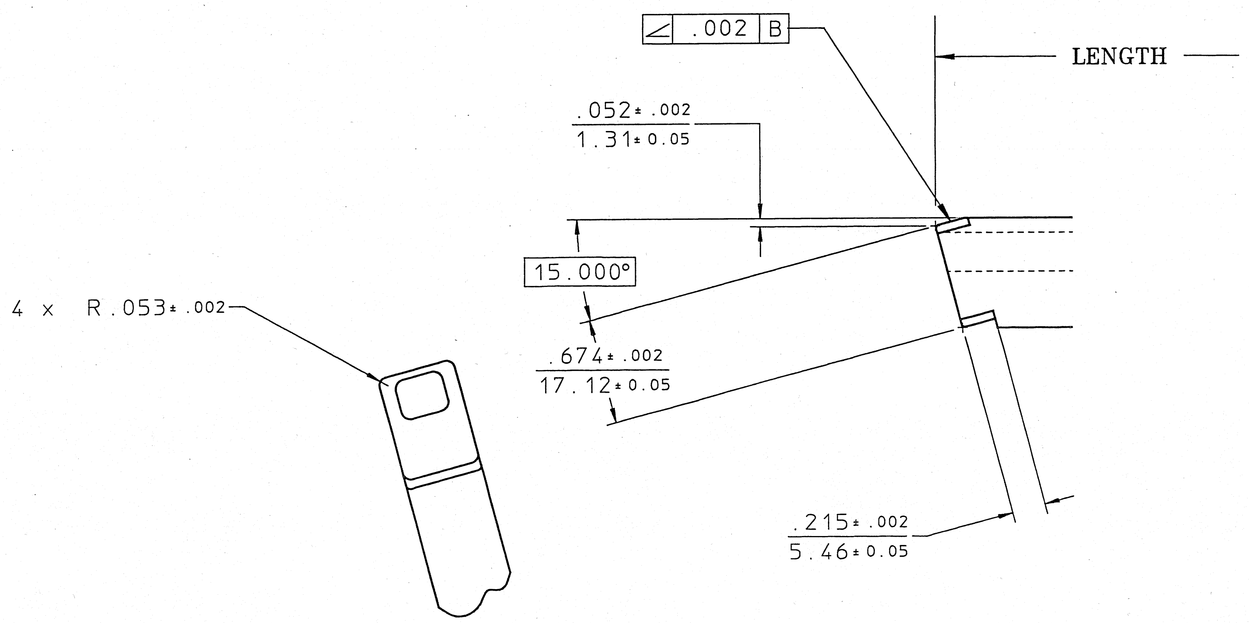
DETAIL 1
SCALE 2:1
18 PLACES

-C- DATUM REFERENCE PLANE -C- IS THE INTERSECTION POINT OF THE 15° INCLINED SURFACE AND THE SURFACE AT 90° TO IT.
USE CO-ORDINATE MEASURING MACHINE TO ESTABLISH AFTER MACHINING

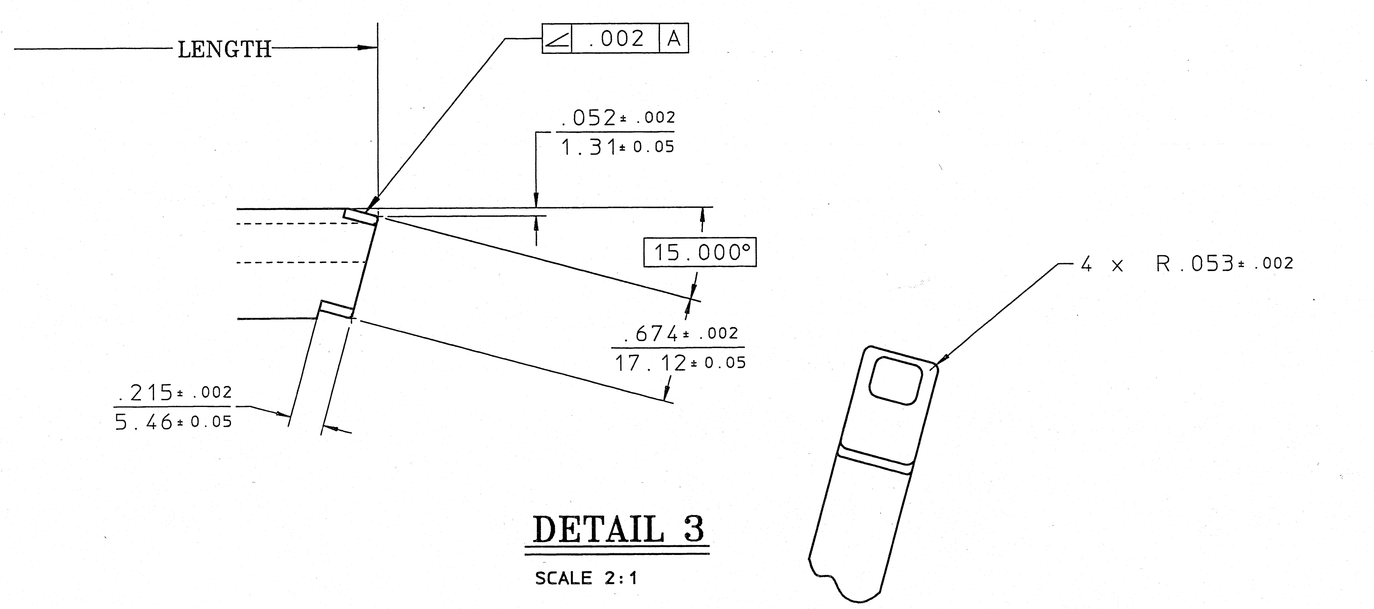
31.073±.002
789.25±0.05

LENGTH IS TO THEORETICAL INTERSECTION POINTS.
FOR INSPECTION USE CO-ORDINATE MEASURING MACHINE (CMM).





DETAIL 2
SCALE 2:1



DETAIL 3
SCALE 2:1

24A4346A

NOTES:

1. DEGREASE PARTS AFTER MACHINING
2. AFTER PARTS HAVE BEEN MANUFACTURED AND INSPECTED:
   A. MASK OFF AREAS INDICATED.
   B. CLEAN PARTS BY THE PHOSPORIC ACID ANODIZING METHOD (ASTM D3933-80) EXCEPT FOR MASKED OFF AREAS
   C. COAT WITHIN 4 hrs WITH DEXTER-HYSOL PRIMER #EA 9210 B EXCEPT FOR MASKED OFF AREAS

REV.	DWN.	CHK.	ZONE	DATE	CHANGES
A	JB			95-04-14	NEW LOGO, METRIC DIMS, CORR. DETAIL 2 DIMS

UNLESS OTHERWISE SPECIFIED
ALL DIMENSIONS ARE INCHES / CENTIMETERS
TOLERANCES: X/.X = ±.06/.15 ANGLES ±5° | .XX/.X = ±0.02/0.05 FINISH | 0.XXX/.XX=±.005/.01 125/32
SAWED, FLAMECUT, SHEARED OR STOCK FINISH
ALL SCREW THREADS ARE ISO METRIC CLASS 6
BREAK EDGES .020/.05 MAX ON MACHINE WORK
REFERENCE - ANSI Y14.5 & B46.1

SHOP ORDERS
ACCT. NO.
SEA. NO.
DATE REQ'D.
DATE REQ'D.
NO. REQ'D.
DELIVER TO
SURFACE TREATMENT: DEGREASE
IDENTIFICATION METHOD: TAG
DRAWN BY: J. BOEHM — DATE: 94/04/04
CHECK BY — DATE

STAR | WBS # 0.00.0 | Production Approval: Cognizant Engineer: J. BERCOVITZ

STAR DRAWING NUMBER	REV.	RHIC DRAWING NUMBER	REV.
TPC410-E-1	A	XXXXXXXXXX	-

LAWRENCE BERKELEY LABORATORY
UNIVERSITY OF CALIFORNIA - BERKELEY

RHIC-STAR-TPC
OUTER SECTOR COOLING MANIFOLD
TUBE #05 MACHINING

PATENT CLEAR	DRAWING TYPE	SHOWN ON	SCALE: FULL	DO NOT SCALE PRINTS
	DETAIL	24A4296		
MICROFILMED	DESIGN ACCOUNT	CATEGORY CODE	LBL DRAWING NUMBER	REV.
MA 7/95	8052-24	SR-02-04	24A4346	A