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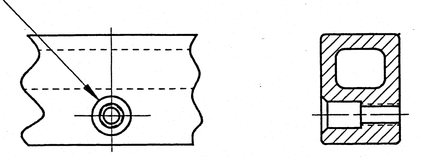
ITEM	RQ'D	Part Number	Material/Parts Call-Out
		24A0801B	COOLING TUBE EXTRUSION

#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°

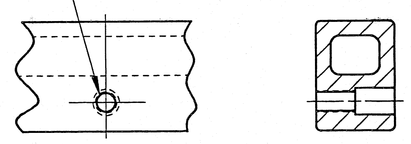
⌖ Ø.010/.25Ⓢ A B C



DETAIL 1
SCALE 2:1
16 PLACES

#31 (Ø.120/3.05) THRU (SPECIAL TAP DRILL SIZE)
#6(.138/3.5)-32UNF-2C TAP THRU
C'BORE #18(Ø.170/4.31) x .25/6.35 DEEP, FAR SIDE

⌖ Ø.010/.25Ⓢ A B C



DETAIL 4
SCALE 2:1
1 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

29.385 ± .002
746.38 ± 0.05

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

1.551 / 39.40	.960 / 24.38	.960 / 24.38	.960 / 24.38	.960 / 24.38	.960 / 24.38	.960 / 24.38	.960 / 24.38	.960 / 24.38	.960 / 24.38	.960 / 24.38
	2.205 / 56.02	2.205 / 56.02	3.260 / 82.82	1.630 / 41.41	1.630 / 41.41	3.260 / 82.82	2.205 / 56.02	2.205 / 56.02	1.551 / 39.40	

SEE DET 1 (×10)

-A-

.500 / 12.70 STOCK

MASK OFF THIS SIDE SEE NOTE 2 (×2)

-B-

.703 STOCK

.515 / 13.09

SEE DETAIL 2

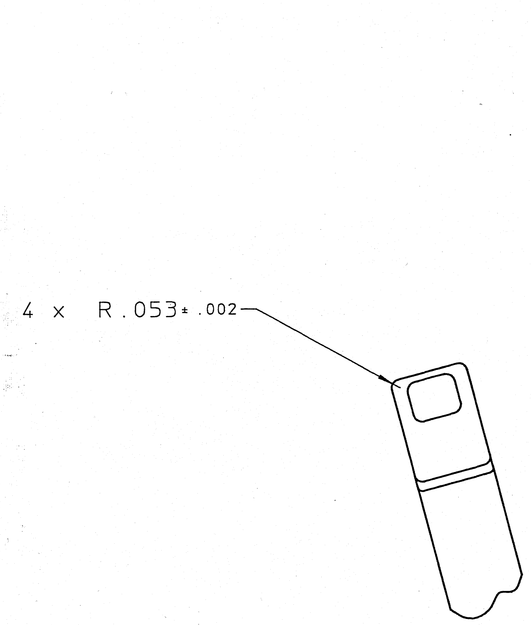
SEE DETAIL 4

SEE DETAIL 3

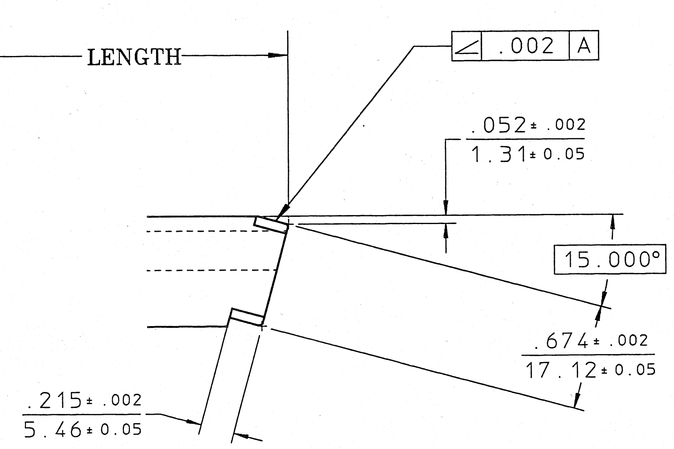
.5 / 12.7

MASK OFF THIS AREA - SEE NOTE 2

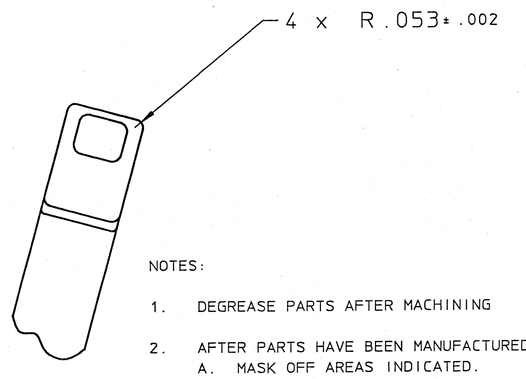
.5 / 12.7



DETAIL 2
SCALE 2:1



DETAIL 3
SCALE 2:1



24A4366A

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
REMARKS: .X/.X = ±.06/.15 ANGLES ±5° | .XX/.X = ±.02/0.05 FINISH 125/32 | 0.XXX/.XX=±.005/.01
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: SER. NO:
DATE RECD: DATE REQD: NO. REQD:
DELIVER TO:
SURFACE TREATMENT: DEGREASE
IDENTIFICATION METHOD: TAG
DRWN BY: J. BOEHM DATE: 9/10/04
CHECK BY: DATE:

WBS # 0.00.0
Production Approval: Cognizant Engineer: J. BERCOVITZ
STAR DRAWING NUMBER: TPC412-E-1 REV.: A
RHIC DRAWING NUMBER REV.: XXXXXXXXXX -

LAWRENCE BERKELEY LABORATORY
UNIVERSITY OF CALIFORNIA - BERKELEY
RHIC-STAR-TPC
OUTER SECTOR COOLING MANIFOLD
TUBE #07 MACHINING

PATENT CLEAR
DRAWING TYPE: DETAIL
SHOWN ON: 24A4296
SCALE: FULL
DO NOT SCALE PRINTS
MICROFILMED
DESIGN ACCOUNT: 8052-24
CATEGORY CODE: SR-02-04
LBL DRAWING NUMBER: 24A4366 REV.: A