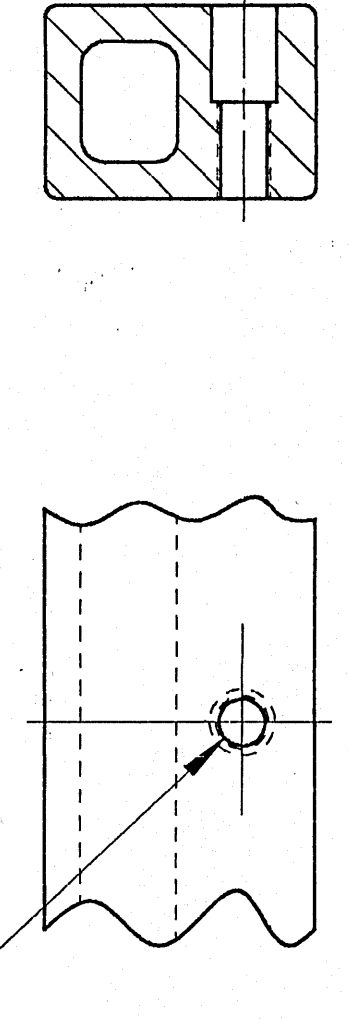


RECD	ITEM	PART NO.	DESCRIPTION
		24A0801B	COOLING TUBE EXTRUSION

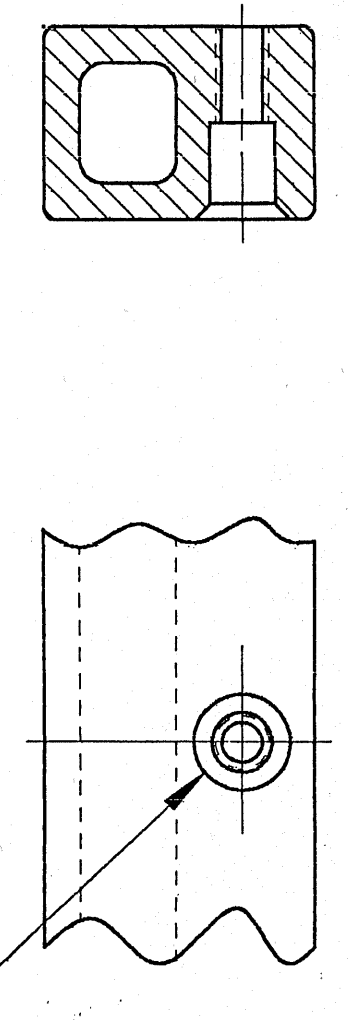
Ø .120 (#31) THRU (SPECIAL TAP DRILL SIZE)
#6 (.138) -32UNF-2C TAP THRU
C' BORE #18 (Ø.170) x .25 DEEP, FAR SIDE.

⊕ .010 ⓐ | ⓑ | Ⓒ



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

⊕ .010 ⓐ | ⓑ | Ⓒ

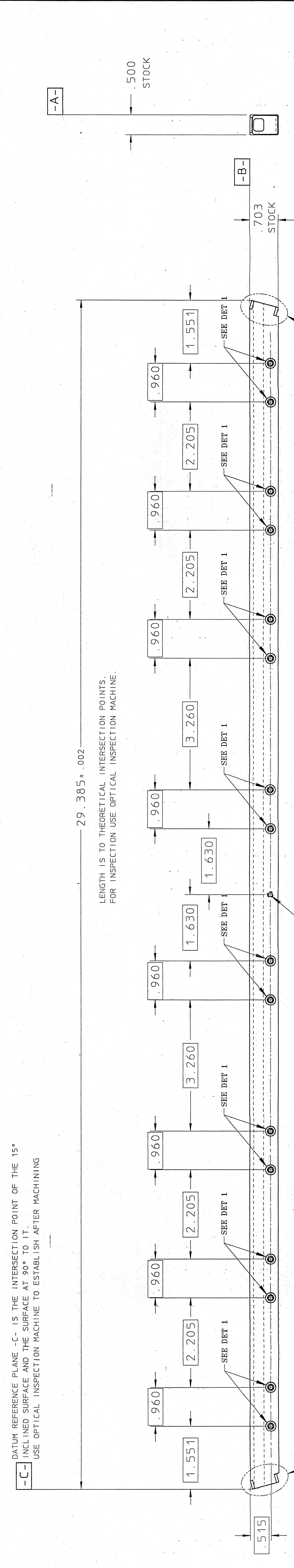


DETAIL 4
SCALE 2:1
1 PLACE

DETAIL 1
SCALE 2:1
16 PLACES

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

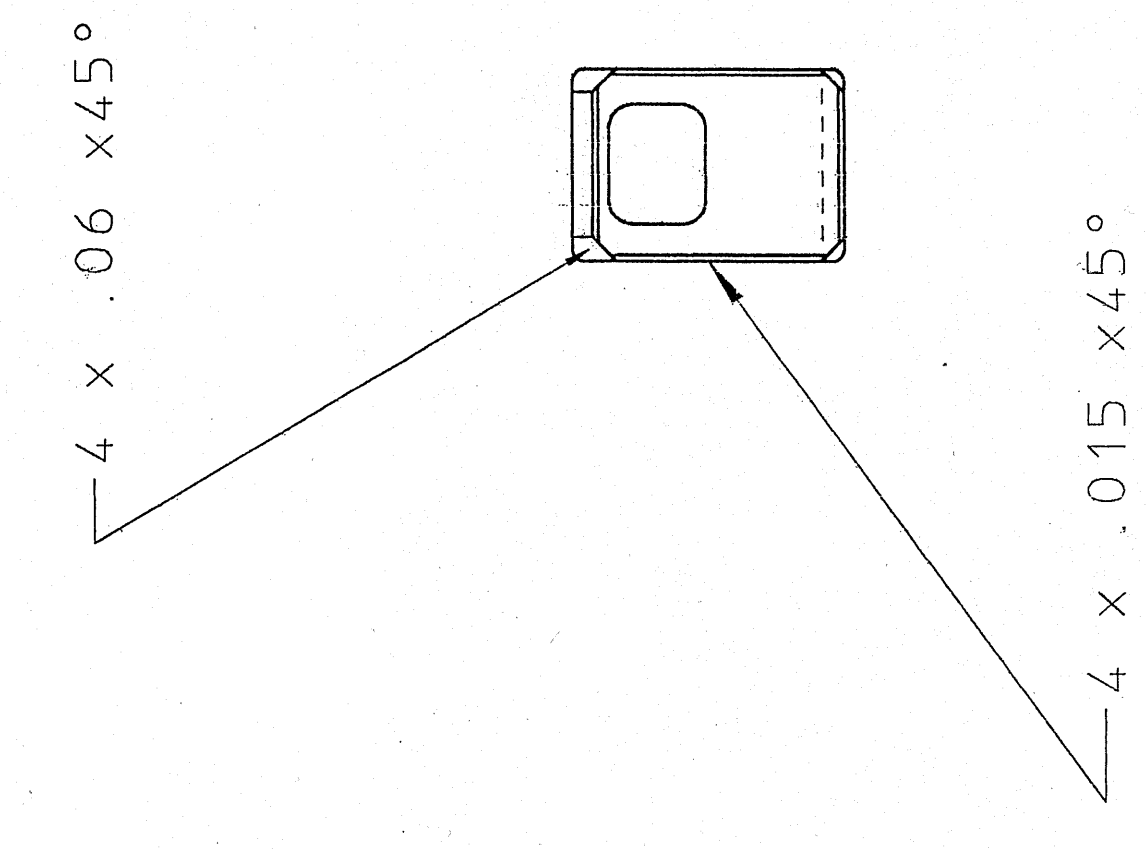
LENGTH IS TO THEORETICAL INTERSECTION POINTS.
FOR INSPECTION USE OPTICAL INSPECTION MACHINE.



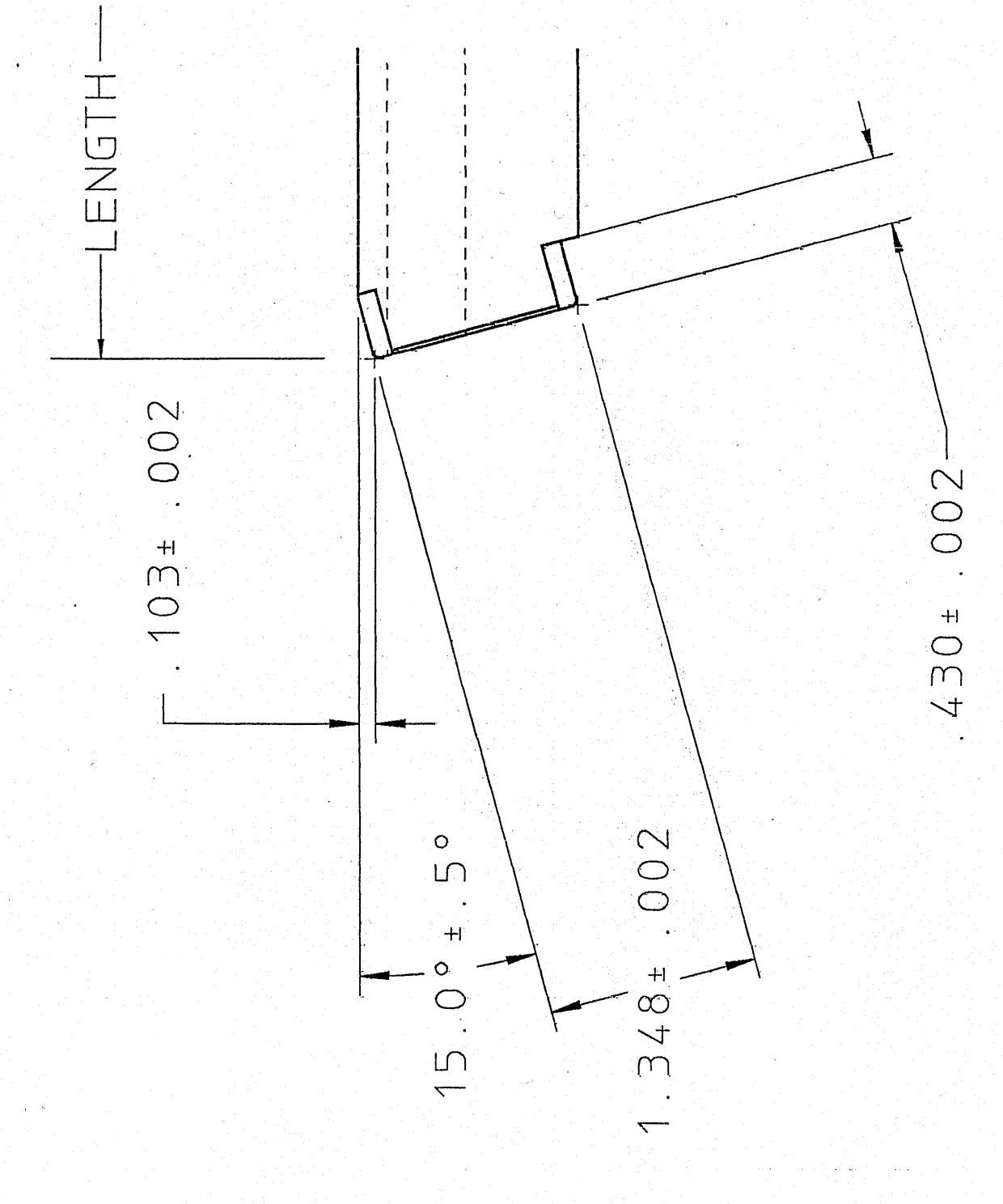
SEE DETAIL 2

SEE DETAIL 4

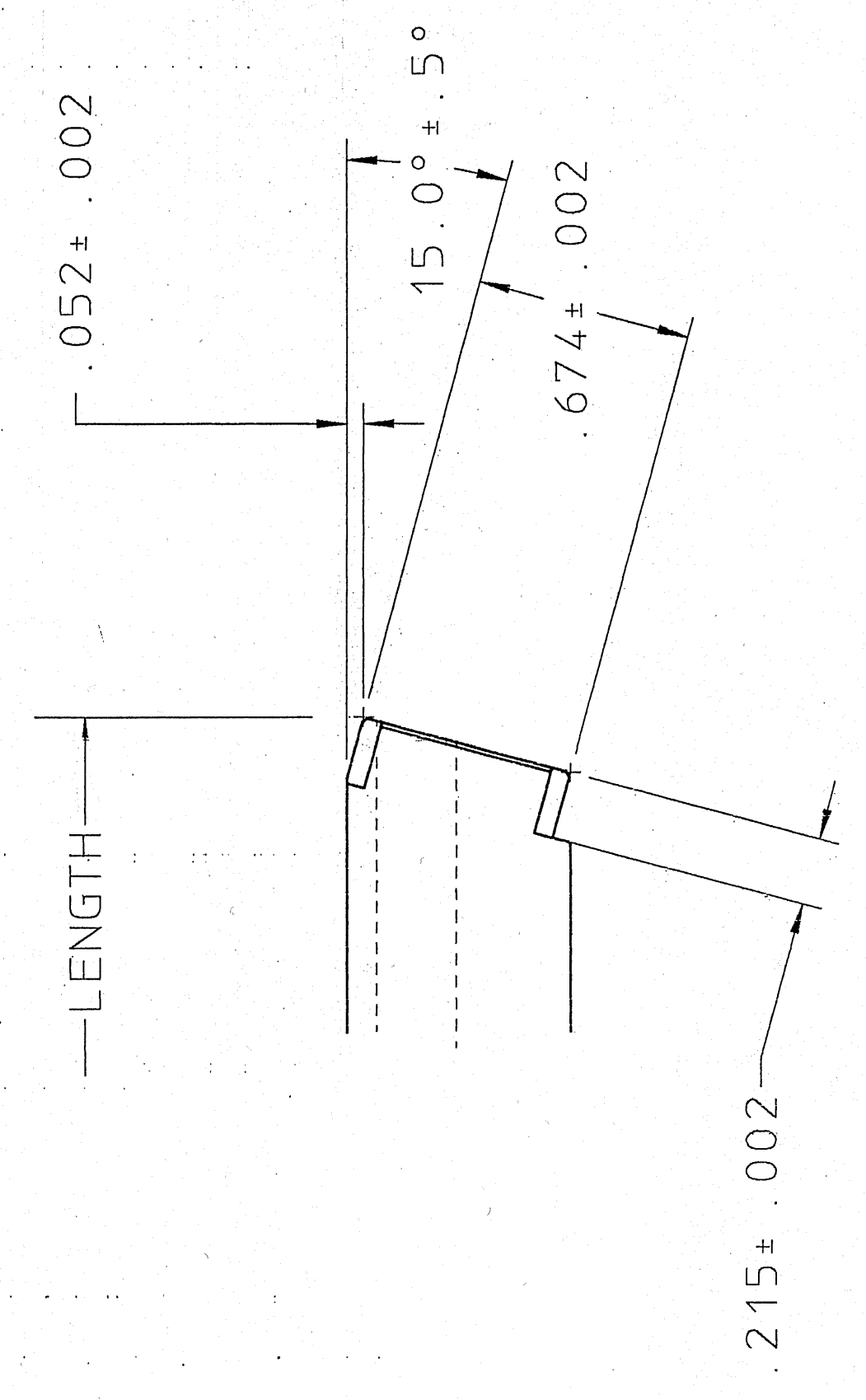
SEE DETAIL 3



DETAIL 2
SCALE 2:1



DETAIL 3
SCALE 2:1



DETAIL 1
SCALE 2:1

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

UNLESS OTHERWISE SPECIFIED	ACT.	SHOP ORDERS	
FINISH	1/164	DATE	NO.
ANGLES	± 1°	DATE	NO.
TOLERANCES	± .005	FINISH	12/31/79
TOLERANCES & ALL DIMENSIONS	FINISH	TREATMENT	DEGREASE
UNTIL 1.5 MILLIMETER REFERENCE SURFACE	TOLERANCES	TAG	
BREAK EDGES 0.125 MIN. ON MACHINED WORK	WORKING	DATE	
REVISIONS	DATE	BY	
1		J. BOEHM	
2		J. BERCOVITZ	

LAWRENCE BERKELEY LABORATORY	
UNIVERSITY OF CALIFORNIA - BERKELEY	
RHILC STAR-TPC	
OUTER SECTOR COOLING MANIFOLD	
TUBE #07 MACHINING	
PROJECT #	32000-02
NO.	0000
REVISION	00
CATEGORY	000
DATE	12/31/79
SIZE	FULL
NO.	24A4376