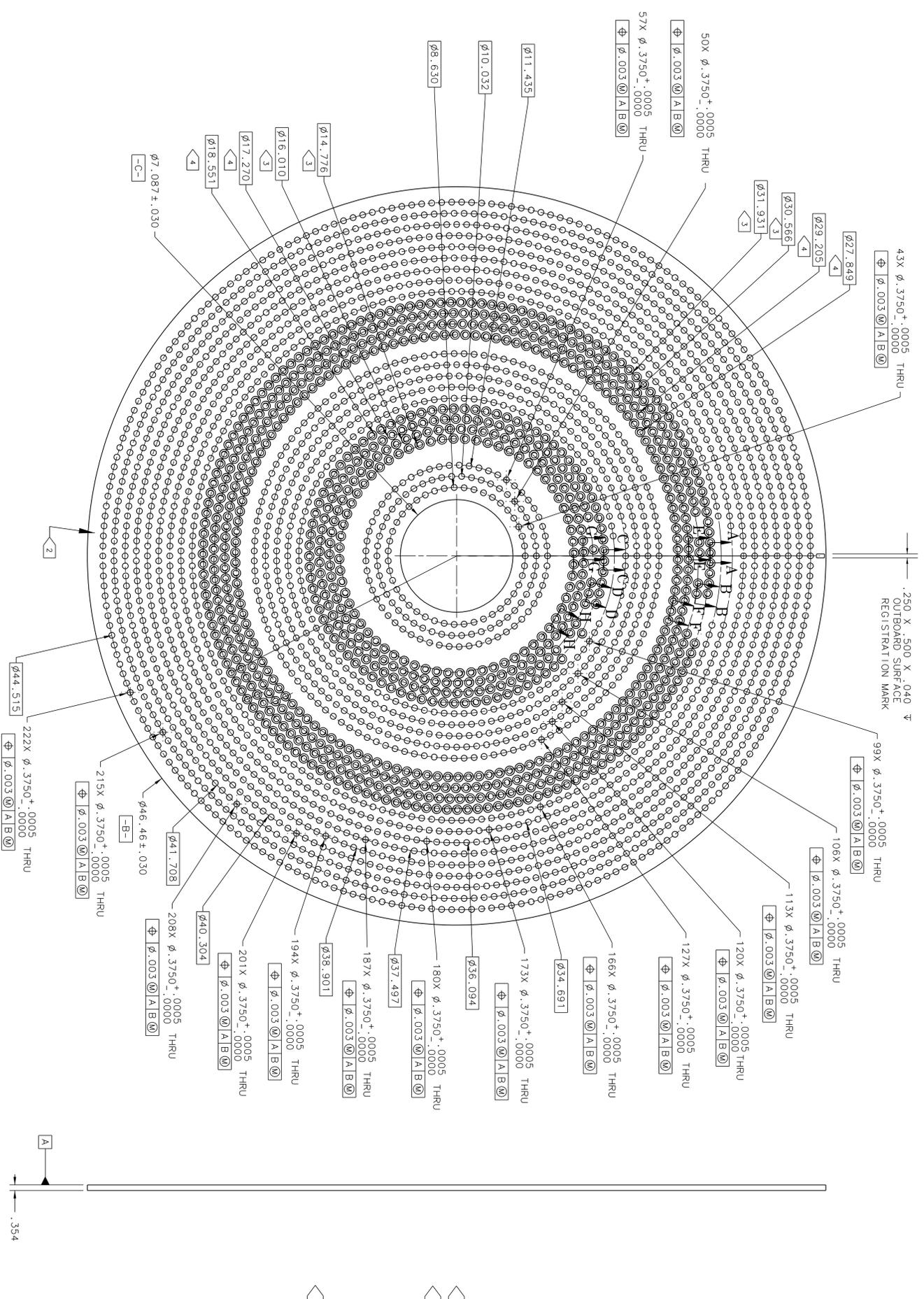
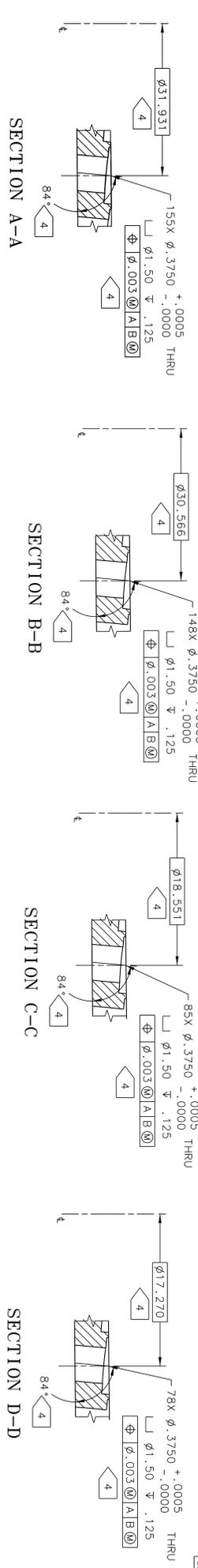
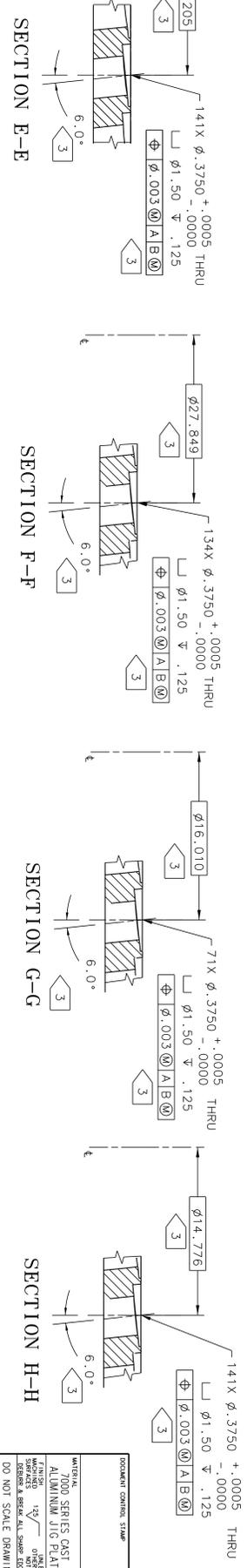


ZONE	REV	DESCRIPTION	DATE	APPROVED

REVISION HISTORY	DATE	APPROVED



NOTE: SOME HOLES NOT SHOWN FOR CLARITY



- ALL DIMENSIONS ARE IN INCHES.
- MACHINE ALL HOLES FROM INDICATED SURFACE.
- DIMENSION APPLIES TO POINT OF INTERSECTION. THE FEATURES ARE MACHINED IN A UNIQUE HEADING THAT IS ROTATED NEGATIVE 6° FROM NORMAL PROJECTION FROM DATUM -A-. THE RESULTING HOLES WILL FORM A PATTERN OF STEREO ANGLES, OF WHICH EACH WILL HAVE A UNIQUE MACHINED VECTOR. THE TOTAL QUANTITY OF HOLES IN THIS NEGATIVE 6° ORIENTATION IS 410. ALL MACHINING DATA IS TO BE DERIVED FROM THE CAD IGES FILE.
- DIMENSION APPLIES TO POINT OF INTERSECTION. THE FEATURES ARE MACHINED IN A UNIQUE HEADING THAT IS ROTATED POSITIVE 6° FROM NORMAL PROJECTION FROM DATUM -A-. THE RESULTING HOLES WILL FORM A PATTERN OF STEREO ANGLES, OF WHICH EACH WILL HAVE A UNIQUE MACHINED VECTOR. THE TOTAL QUANTITY OF HOLES IN THIS POSITIVE 6° ORIENTATION IS 410. ALL MACHINING DATA IS TO BE DERIVED FROM THE CAD IGES FILE.
- ALL HOLES AND EDGES TO BE BURR FREE.
- IT IS RECOMMENDED THAT ALL MACHINING BE PERFORMED IN AN AMBIENT ENVIRONMENT AS CLOSE AS POSSIBLE TO 70-72° IN ORDER TO ENSURE THAT THERMAL DEFORMATIONS DO NOT CAUSE FEATURES TO BE OUT OF TOLERANCE.
- CLEAN AND HANDLE PER IJMAF SPECIFICATION: 11141-S-0028A.
- TOTAL QUANTITY OF 6° 3750 HOLES MACHINED NORMAL TO DATUM -A- IS 2461. TOTAL QUANTITY OF 6° 3750 HOLES W/ STEREO ANGLES IS 876.

PRELIMINARY
22-MARCH-2007

DOCUMENT CONTROL STATE		DATE & TIME FOR RELEASE TO PRODUCTION		DRAWING NO.	
ISSUED	155	11/14/07	11:41	11141-S-0028A	11141-S-0028A
MATERIAL		FINISH		APPROVALS	
ALUMINUM 7075-T6		ANODIZED		DESIGNED	DATE
ALUMINUM IJIC PLATE		DIP COATED		DRAWN	11/14/07
DO NOT SCALE DRAWING		THIRD ANGLE PROJECTION		APPROVED	
				DATE	19-03-07-CTK-00001
				REV	1

HALL D 120GV
CENTRAL DRIFT CHAMBER
UPSTREAM END PLATE