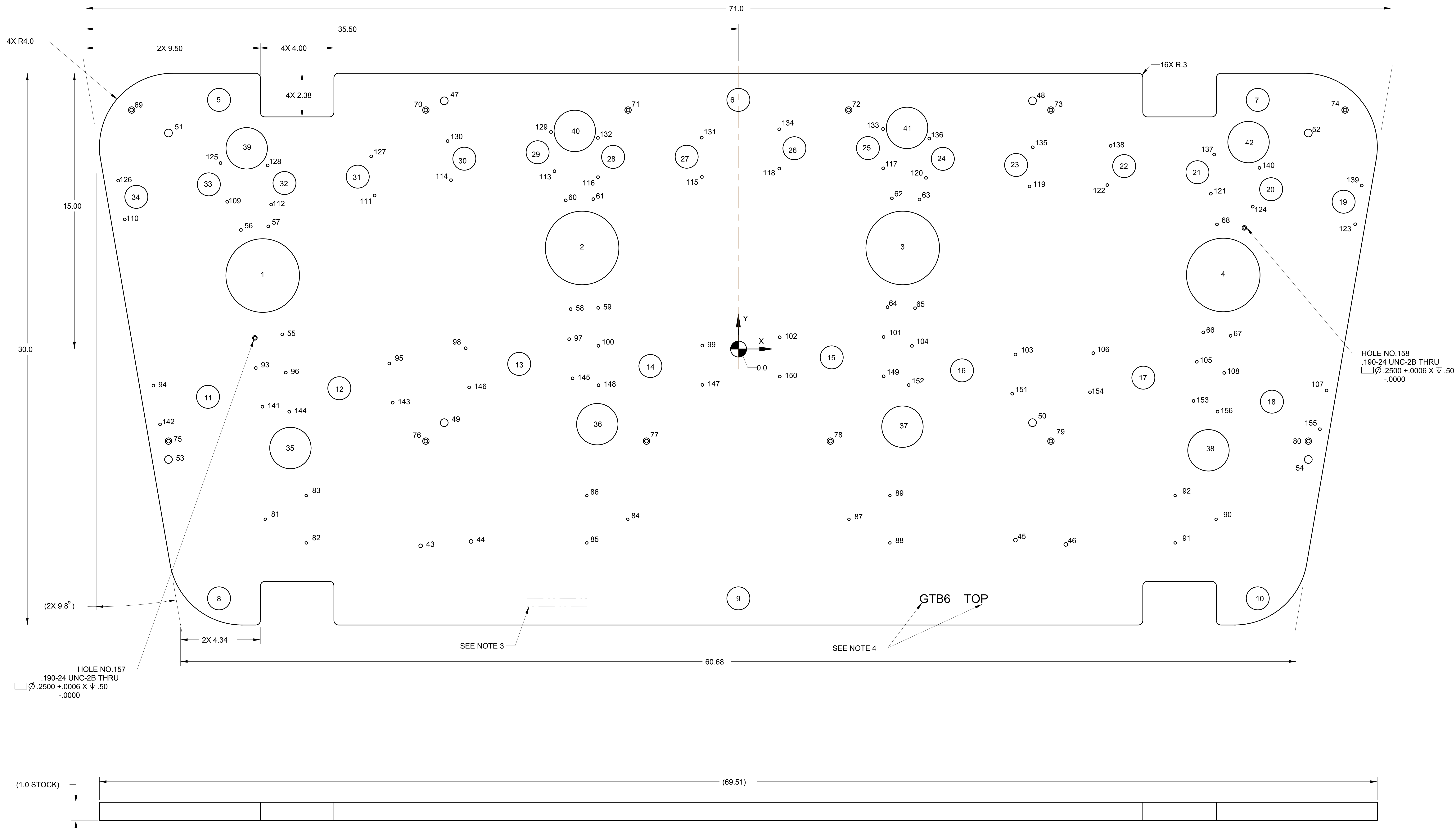


NOTES:

1. MATERIAL: PLATE ALUMINUM 1.0 THK TYPE 6061-T6 PER ASTM B209
2. MAKE FROM DXF FILE
3. VIBRO-ETCH PART WITH DRAWING NUMBER WITH MIN .25 HIGH CHARACTERS IN ACCORDANCE WITH MIL-STD-130, LOCATE APPROX AS SHOWN.
4. VIBRO-ETCH PLATE WITH PART NAME AND SIDE DESIGNATION WITH MIN .25 HIGH CHARACTERS. LOCATE APPROX AS SHOWN.

REVISION APPROVALS									
REV	ECN NO.	DESCRIPTION	DATE	BY	CHK	DES	ENG	SUPV	
A	-	INITIAL RELEASE	-	-	-	-	-	-	-



REV	DESCRIPTION
A	INITIAL RELEASE

INTERPRET IN GENERAL ACCORDANCE WITH ASME Y14.5				COLLIDER-ACCELERATOR DEPARTMENT BROOKHAVEN NATIONAL LABORATORY UPTON, N.Y. 11973	
UNLESS OTHERWISE SPECIFIED		DRAWN BY: TRABOCCHI/GRAL CHECKED BY: S. RESTMEYER APPROVED BY: A. ARNO		DATE: 3/31/18 DATE: 5/2/18 DATE: 5/8/18	
DIMENSIONAL TOLERANCES ARE IN INCHES DECIMAL FRACTIONS: .005, .010, .015, .020, .030, .040, .050, .060, .070, .080, .090, .100, .125, .150, .200, .250, .300, .375, .500, .625, .750, .875, 1.000 ANGULAR TOLERANCE: ±1°		DESIGN APPROVAL: S. TRABOCCHI APPROVAL: G. MAHLER DATE: 5/8/18 DATE: 5/8/18		DATE: 4/30/18 DATE: 5/3/18	
USED ON DRAWING NO. 2570M0053 QTY. PER ASSY. 1		FINISH: 125 BREAK SHARP EDGES		SIZE: E DRAWING NUMBER: 2570M0052 REV. A	
APPLICATION:		SAFETY / RSC DEPARTMENT CODE:		D.A. CATEGORY: A3 SCALE: 1/2 WEIGHT: 175.7 SHEET OF 1 2	

DWG NO 2570M0052 SHEET 1 OF 2

A

CREO

HOLE TABLE			
HOLE NO.	X	Y	NOTE
1	-25.88	4.00	Ø 4.00 THRU
2	-8.50	5.50	Ø 4.00 THRU
3	8.94	5.50	Ø 4.00 THRU
4	26.38	4.03	Ø 4.00 THRU
5	-28.25	13.55	Ø 1.25 THRU
6	0.00	13.55	Ø 1.25 THRU
7	28.25	13.55	Ø 1.25 THRU
8	-28.25	-13.55	Ø 1.25 THRU
9	0.00	-13.55	Ø 1.25 THRU
10	28.25	-13.55	Ø 1.25 THRU
11	-28.85	-2.59	Ø 1.25 THRU
12	-21.71	-2.13	Ø 1.25 THRU
13	-11.92	-0.80	Ø 1.25 THRU
14	-4.79	-0.92	Ø 1.25 THRU
15	5.08	-0.45	Ø 1.25 THRU
16	12.16	-1.16	Ø 1.25 THRU
17	22.03	-1.55	Ø 1.25 THRU
18	29.02	-2.86	Ø 1.25 THRU
19	32.92	8.02	Ø 1.25 THRU
20	28.98	8.69	Ø 1.25 THRU
21	24.97	9.62	Ø 1.25 THRU
22	20.98	9.95	Ø 1.25 THRU
23	15.11	10.01	Ø 1.25 THRU
24	11.12	10.35	Ø 1.25 THRU
25	7.05	10.93	Ø 1.25 THRU
26	3.05	10.92	Ø 1.25 THRU
27	-2.81	10.46	Ø 1.25 THRU
28	-6.81	10.45	Ø 1.25 THRU
29	-10.92	10.70	Ø 1.25 THRU
30	-14.91	10.35	Ø 1.25 THRU
31	-20.71	9.38	Ø 1.25 THRU
32	-24.69	9.03	Ø 1.25 THRU
33	-28.81	8.96	Ø 1.25 THRU
34	-32.75	8.28	Ø 1.25 THRU
35	-24.37	-5.38	Ø 2.25 THRU
36	-7.68	-4.08	Ø 2.25 THRU
37	8.92	-4.22	Ø 2.25 THRU
38	25.57	-5.50	Ø 2.25 THRU
39	-26.75	10.92	Ø 2.25 THRU
40	-8.90	11.86	Ø 2.25 THRU
41	9.18	12.03	Ø 2.25 THRU
42	27.75	11.26	Ø 2.25 THRU
43	-17.28	-10.69	.250-20 UNC-2B ∇ .75
44	-14.54	-10.45	.250-20 UNC-2B ∇ .75
45	15.07	-10.39	.250-20 UNC-2B ∇ .75
46	17.81	-10.62	.250-20 UNC-2B ∇ .75
47	-16.00	13.50	.500-13 UNC-2B THRU
48	16.00	13.50	.500-13 UNC-2B THRU
49	-16.00	-4.00	.500-13 UNC-2B THRU
50	16.00	-4.00	.500-13 UNC-2B THRU
51	-31.00	11.75	.500-13 UNC-2B THRU
52	31.00	11.75	.500-13 UNC-2B THRU
53	-31.00	-6.00	.500-13 UNC-2B THRU
54	31.00	-6.00	.500-13 UNC-2B THRU
55	-24.81	0.80	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
56	-27.06	6.48	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
57	-25.57	6.67	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
58	-9.12	2.18	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
59	-7.63	2.24	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
60	-9.39	8.09	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
61	-7.89	8.16	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
62	8.35	8.20	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
63	9.85	8.14	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
64	8.11	2.28	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
65	9.61	2.22	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
66	25.29	0.91	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
67	26.77	0.72	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
68	26.03	6.78	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
69	-33.00	13.00	Ø .203 ∇ .19 ∇ Ø .350 X 120°
70	-17.00	13.00	Ø .203 ∇ .19 ∇ Ø .350 X 120°

HOLE TABLE			
HOLE NO.	X	Y	NOTE
71	-6.00	13.00	Ø .203 ∇ .19 ∇ Ø .350 X 120°
72	6.00	13.00	Ø .203 ∇ .19 ∇ Ø .350 X 120°
73	17.00	13.00	Ø .203 ∇ .19 ∇ Ø .350 X 120°
74	33.00	13.00	Ø .203 ∇ .19 ∇ Ø .350 X 120°
75	-31.00	-5.00	Ø .203 ∇ .19 ∇ Ø .350 X 120°
76	-17.00	-5.00	Ø .203 ∇ .19 ∇ Ø .350 X 120°
77	-5.00	-5.00	Ø .203 ∇ .19 ∇ Ø .350 X 120°
78	5.00	-5.00	Ø .203 ∇ .19 ∇ Ø .350 X 120°
79	17.00	-5.00	Ø .203 ∇ .19 ∇ Ø .350 X 120°
80	31.00	-5.00	Ø .203 ∇ .19 ∇ Ø .350 X 120°
81	-25.74	-9.25	.164-32 UNC-2B ∇ .50
82	-23.51	-10.54	.164-32 UNC-2B ∇ .50
83	-23.51	-7.96	.164-32 UNC-2B ∇ .50
84	-6.02	-9.25	.164-32 UNC-2B ∇ .50
85	-8.24	-10.54	.164-32 UNC-2B ∇ .50
86	-8.24	-7.96	.164-32 UNC-2B ∇ .50
87	6.02	-9.25	.164-32 UNC-2B ∇ .50
88	8.24	-10.54	.164-32 UNC-2B ∇ .50
89	8.24	-7.96	.164-32 UNC-2B ∇ .50
90	25.99	-9.25	.164-32 UNC-2B ∇ .50
91	23.76	-10.54	.164-32 UNC-2B ∇ .50
92	23.76	-7.96	.164-32 UNC-2B ∇ .50
93	-26.25	-1.03	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
94	-31.82	-1.98	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
95	-18.99	-0.78	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
96	-24.62	-1.27	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
97	-9.20	0.54	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
98	-14.83	0.05	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
99	-1.96	0.19	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
100	-7.61	0.18	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
101	7.90	0.66	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
102	2.25	0.65	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
103	15.07	-0.29	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
104	9.44	0.18	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
105	24.94	-0.69	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
106	19.31	-0.22	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
107	31.99	-2.25	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
108	26.43	-1.29	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
109	-27.81	8.01	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
110	-33.37	7.05	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
111	-19.79	8.35	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
112	-25.42	7.86	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
113	-10.00	9.68	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
114	-15.63	9.18	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
115	-1.99	9.36	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
116	-7.64	9.35	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
117	7.88	9.83	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
118	2.23	9.82	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
119	15.84	8.84	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
120	10.21	9.32	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
121	25.70	8.45	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
122	20.07	8.92	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
123	33.55	6.79	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
124	27.98	7.75	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
125	-28.17	10.12	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
126	-33.74	9.16	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
127	-19.97	10.48	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
128	-25.60	9.99	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
129	-10.19	11.81	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
130	-15.82	11.31	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
131	-1.99	11.50	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
132	-7.64	11.48	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
133	7.87	11.97	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
134	2.22	11.95	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
135	16.01	10.97	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
136	10.38	11.45	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
137	25.88	10.58	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
138	20.25	11.05	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
139	33.91	8.90	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
140	28.34	9.85	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN

HOLE TABLE			
HOLE NO.	X	Y	NOTE
141	-25.89	-3.13	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
142	-31.46	-4.09	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
143	-18.80	-2.91	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
144	-24.43	-3.40	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
145	-9.02	-1.59	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
146	-14.65	-2.08	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
147	-1.96	-1.95	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
148	-7.61	-1.96	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
149	7.90	-1.48	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
150	2.25	-1.49	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
151	14.89	-2.42	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
152	9.26	-1.95	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
153	24.76	-2.82	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
154	19.13	-2.35	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
155	31.63	-4.36	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
156	26.06	-3.40	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD MIN
157	-26.300±.002	.612±.002	SEE F/D ZONE C8
158	27.522±.002	6.592±.002	SEE F/D ZONE E1