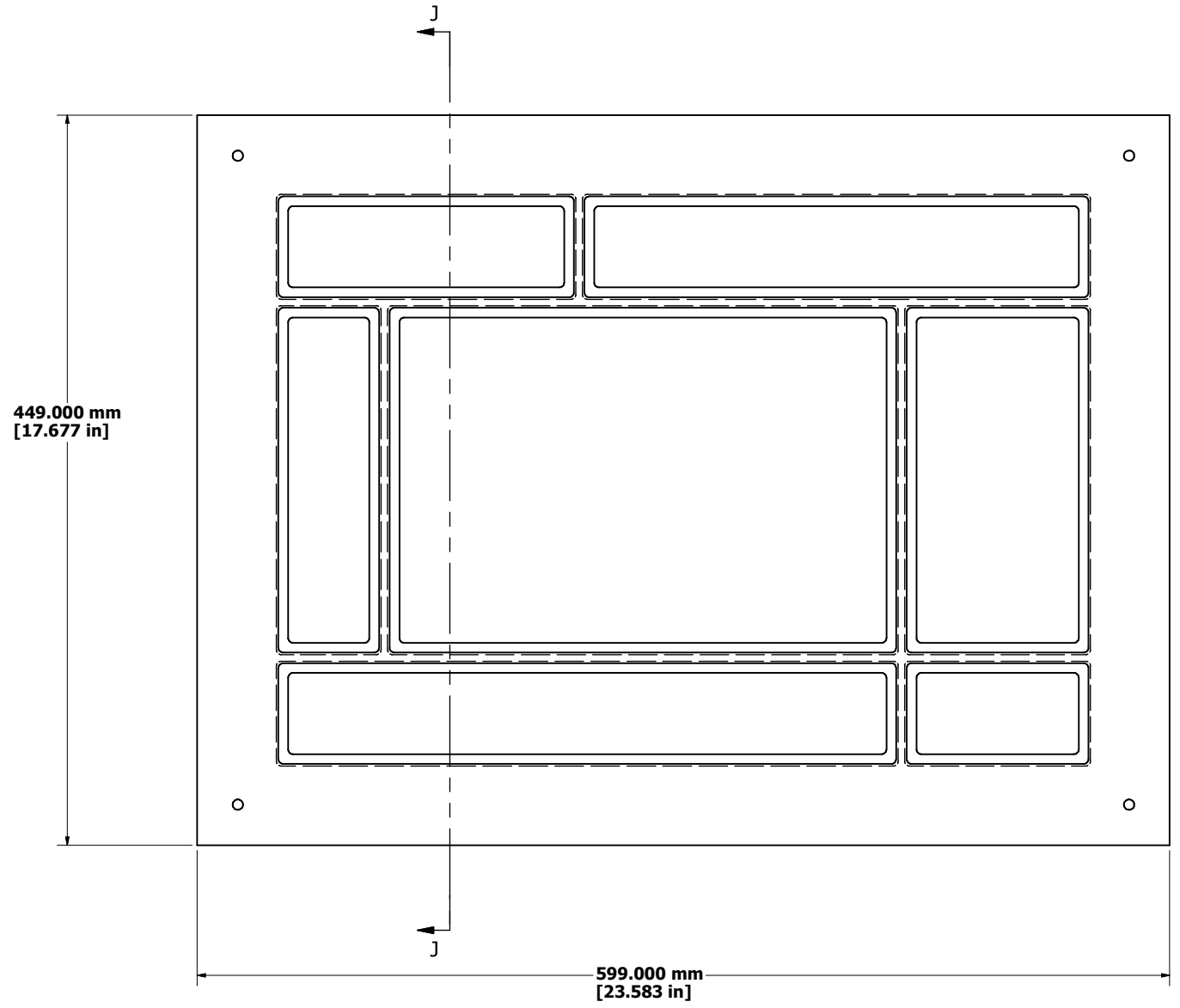
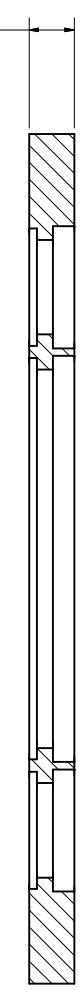


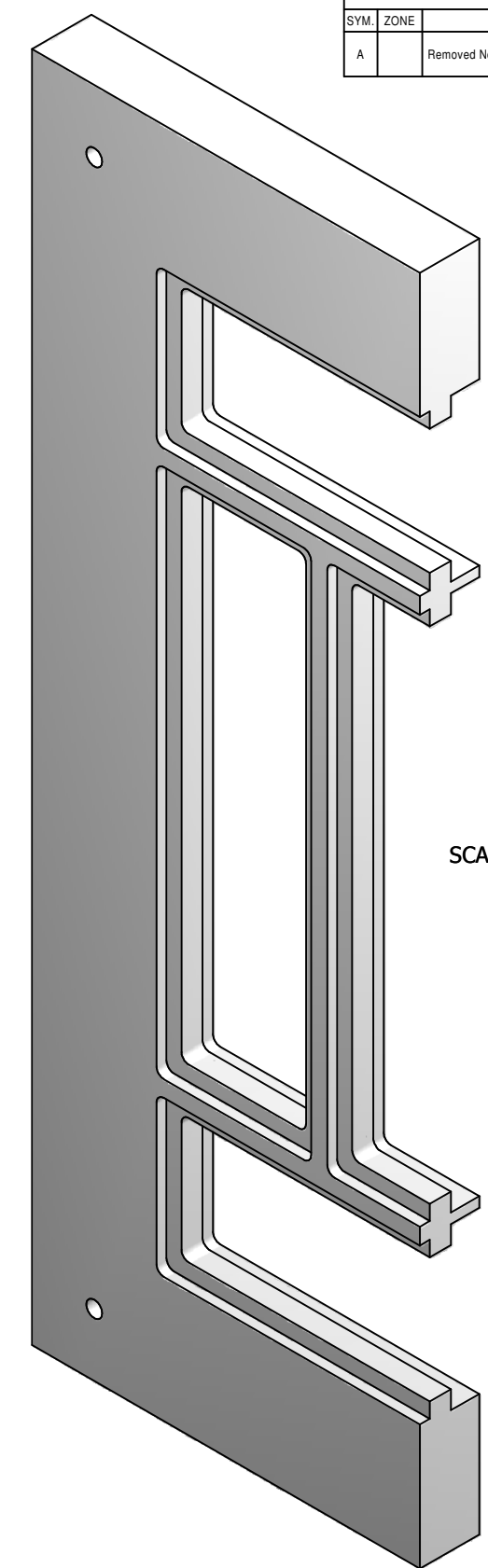
REVISIONS				
SYM.	ZONE	DESCRIPTION	DATE	APP.
A		Removed Notes on sht 2 & 3	12/18/07	DPP



23.876 mm
[0.940 in]



SECTION J-J
SCALE 1 / 2



SCALE 1 : 1

Matl: Alum. 6061 T651

Part requires multi-step process.

- 1) Machine all surfaces and holes, Except the outer perimeter, leaving 0.030inch extra material.
Machine the outer perimeter surface to final dimensions.**
- 2) Deliver part to Cornell for stress relief process (Liquid Nitrogen cold shock).**
- 3) Machine all , Except the outer perimeter, surfaces and holes leaving 0.010inch extra material.**
- 4) Deliver part to Cornell for stress relief process (Liquid Nitrogen cold shock).**
- 5) Machine all surfaces and holes to final specifications.**

Technical questions, including clarifications and proposals for exceptions, are to be directed to

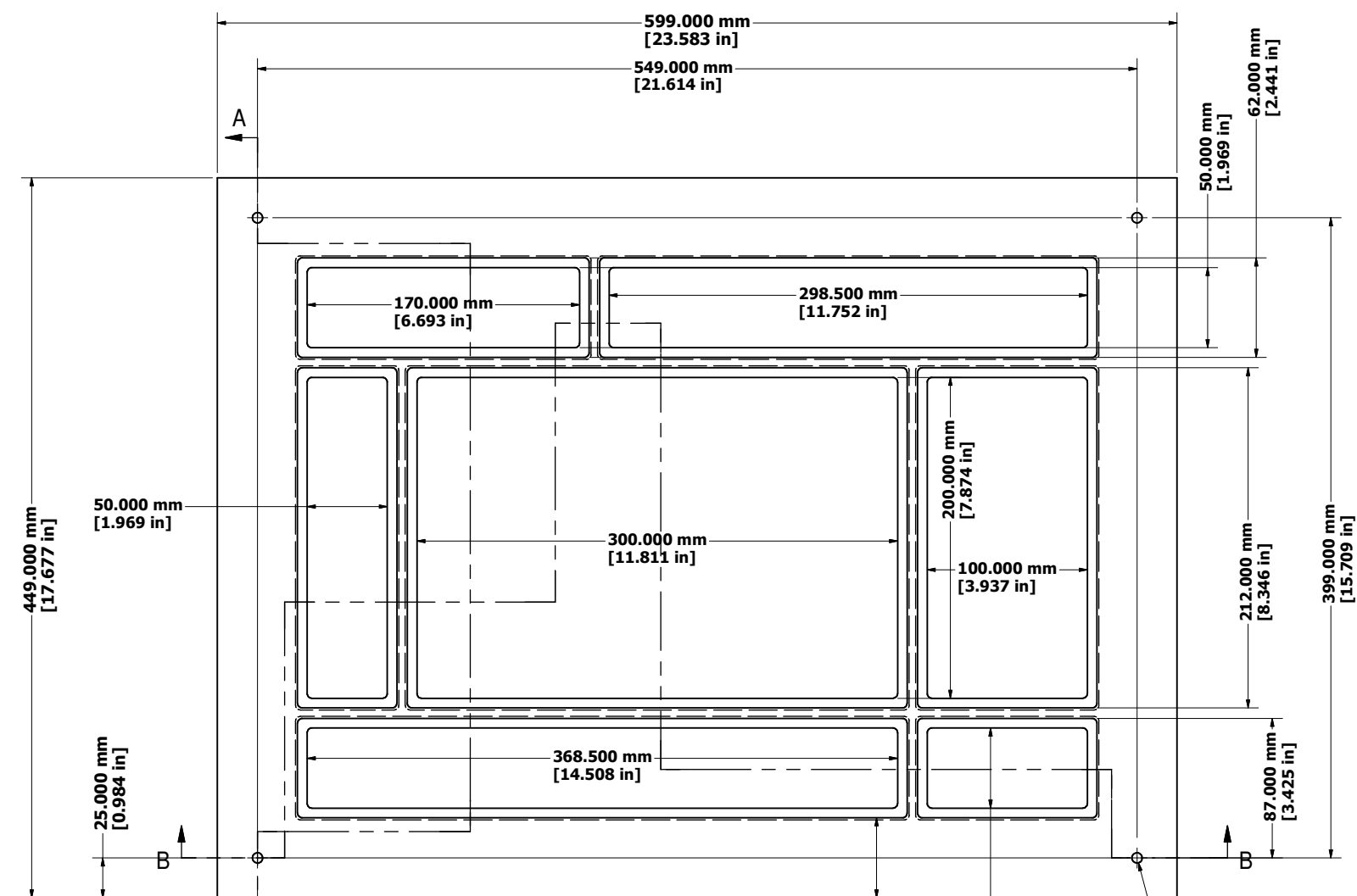
Dan Peterson
Senior Physicist, Laboratory for Elementary-Particle Physics, Cornell University
607-255-8784
dpp@lepp.cornell.edu

FOR MACHINING LUBRICANT USE ONLY
 ALKALINE DETERGENT LUBRICANT CIMSTAR 40
 OR EQUIVALENT APPROVED BY CORNELL LEPP

TECHNICAL RESOURCE APPROVALS REQUIRED BEFORE FABRICATION			
	OK	DATE	N/A
DRAFTING (O'Connell):			
MACHINE SHOP (Kaminski):			
CHEMISTRY (Conklin):			
ELECTRONICS SHOP (Barley):			
FURNACE BRAZING (Sherwood):			
BEAM WELDING (Sears):			
WELDING OTHER (Gallagher):			
UTILITIES INTEGRATION (Gallagher):			
STOCKROOMS (Lockwood):			

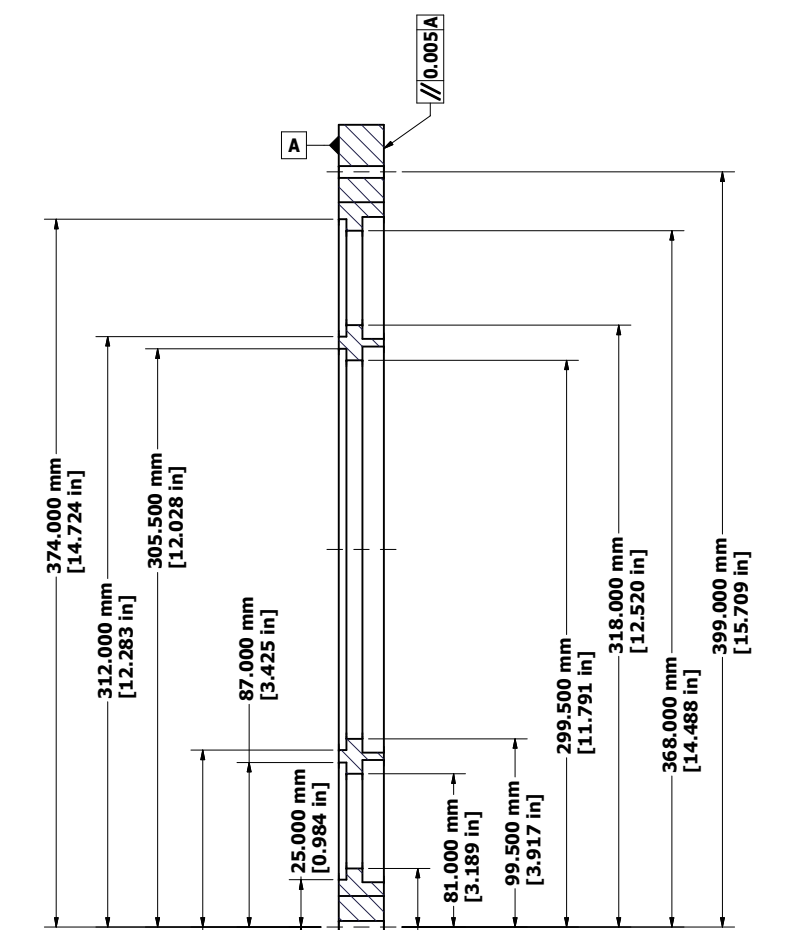
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			QUANTITY				
PRINT DISTR.		PLOT DATE: 12/18/2007 CAD FILE NAME: 6080-018 BOTTOM SIDE STRONGBACK.idw					
CR-1		UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES: TOLERANCES ON: .00 ± 0.10 .000 ± 0.005 FRACTIONS ± 1/64 ANGLES ± 0.5° ALL SURFACES					
				CORNELL UNIVERSITY Floyd R. Newman Laboratory Ithaca, NY 14853			
		STRESS RELIEF TEST PIECE					
CHECKED BY: PETERSON	DRAWN BY: MDS	DRAWN FOR: PETERSON	DATE: 12/18/2007	SCALE: Noted	D	6080-018	REV.
APPROVED BY: PETERSON						SH. NO. 1 OF 3	

REVISIONS				
SYM.	ZONE	DESCRIPTION	DATE	APP.
A		ADDED STRONGBACK TO MULLIONS	12.12.06	DPP

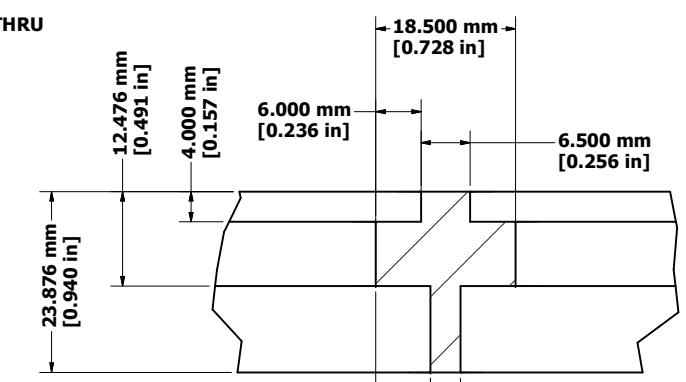


SCALE 1 / 2

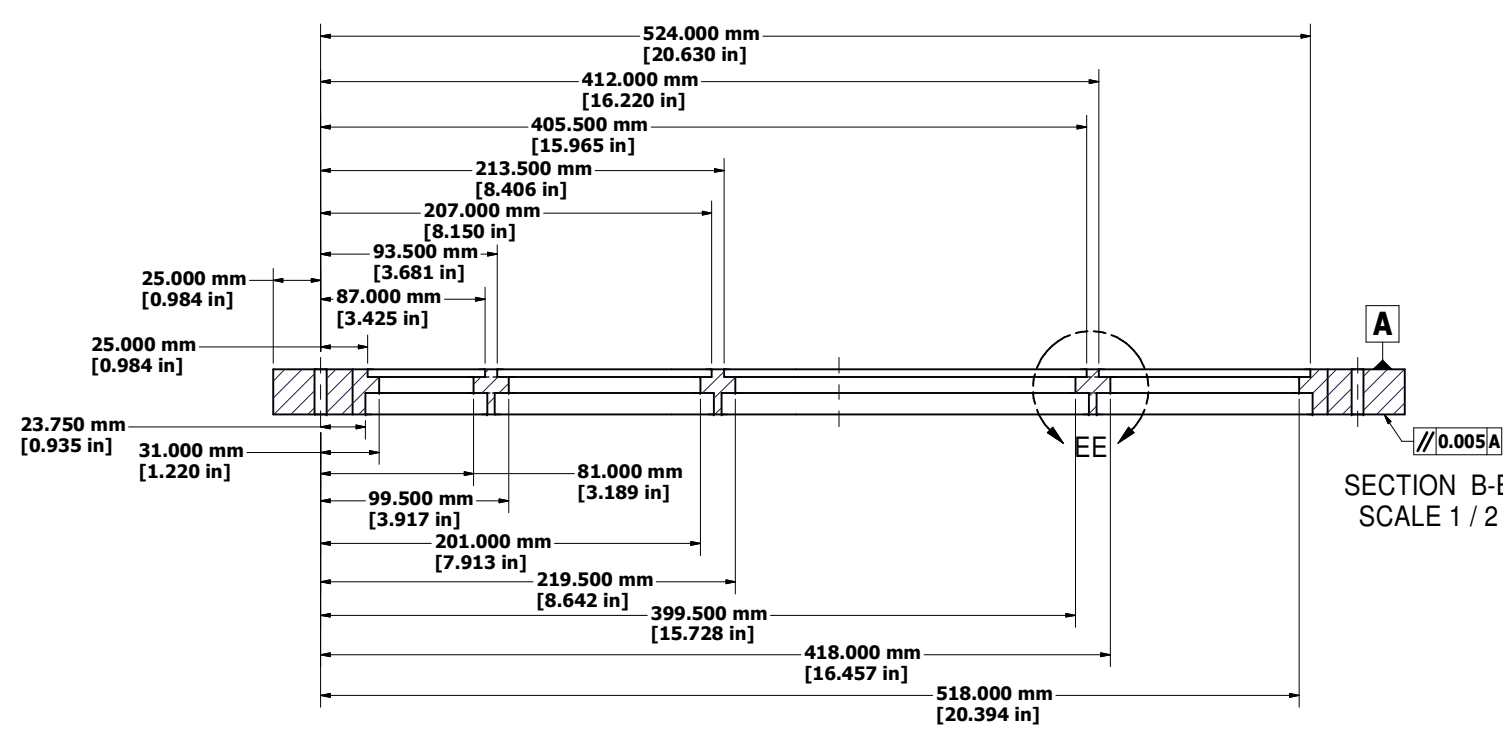
Ø6.350 mm THRU
TYP 4 PLCs



SECTION A-A
SCALE 1 / 2



DETAIL EE
SCALE 2 : 1



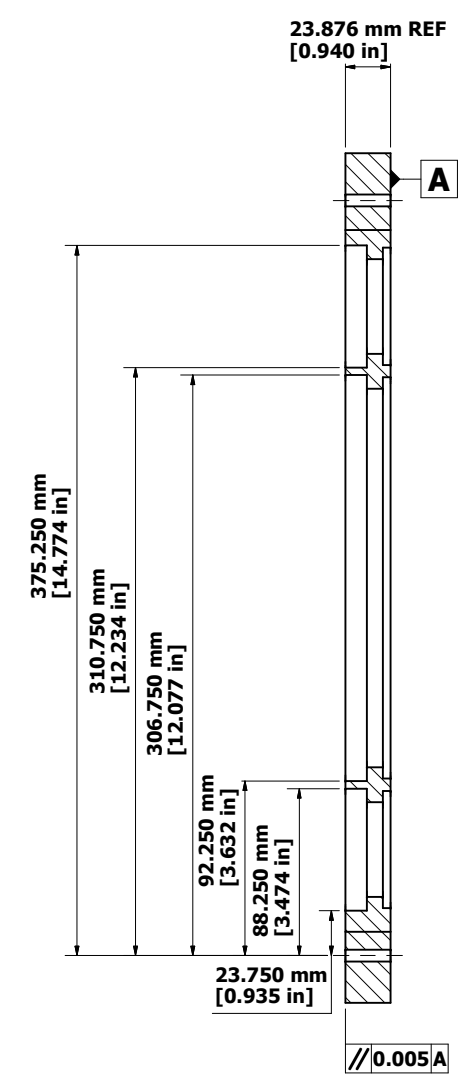
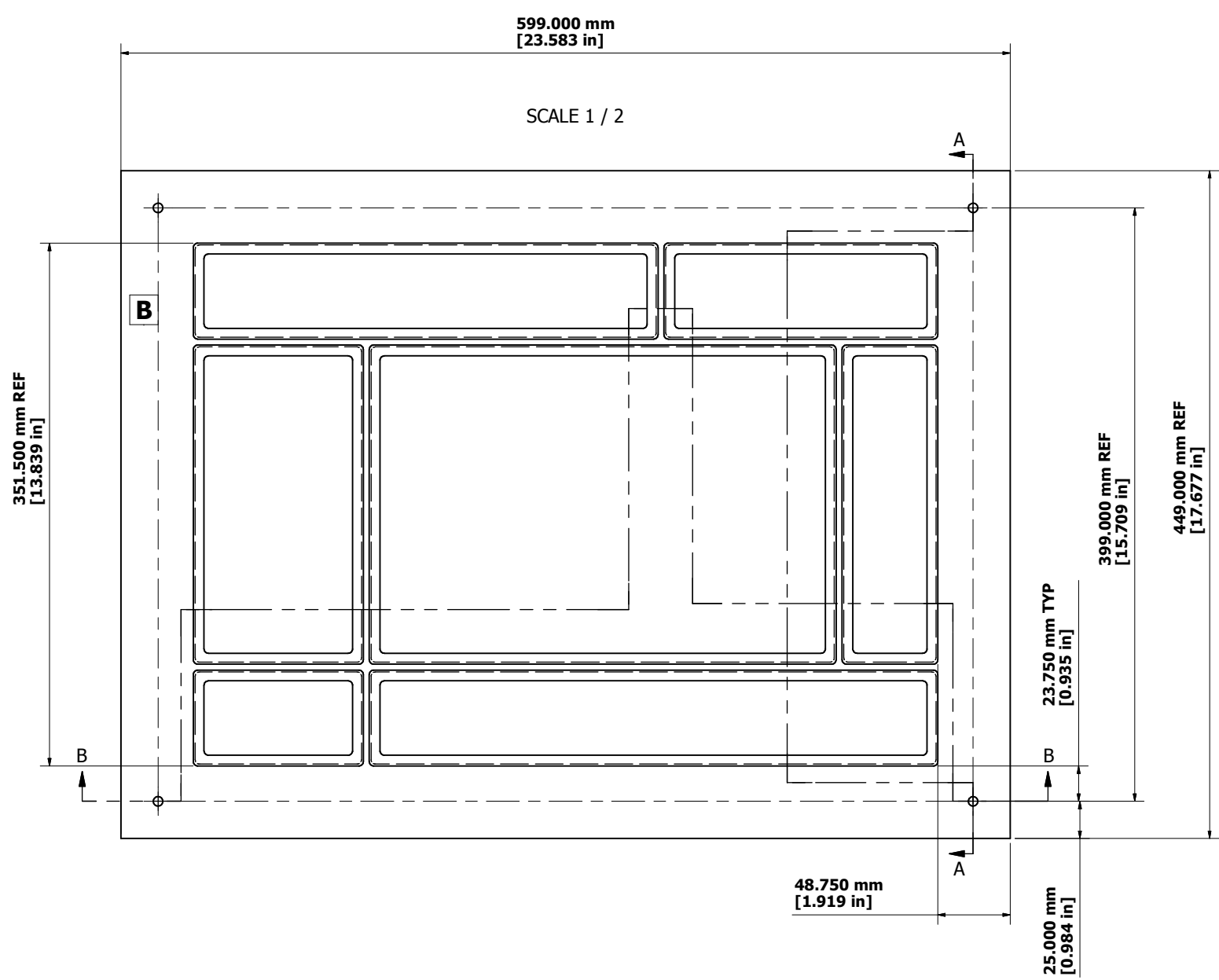
SECTION B-B
SCALE 1 / 2

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ALKALINE DETERGENT LUBRICANT CIMSTAR 40
OR EQUIVALENT APPROVED BY CORNELL LEPP

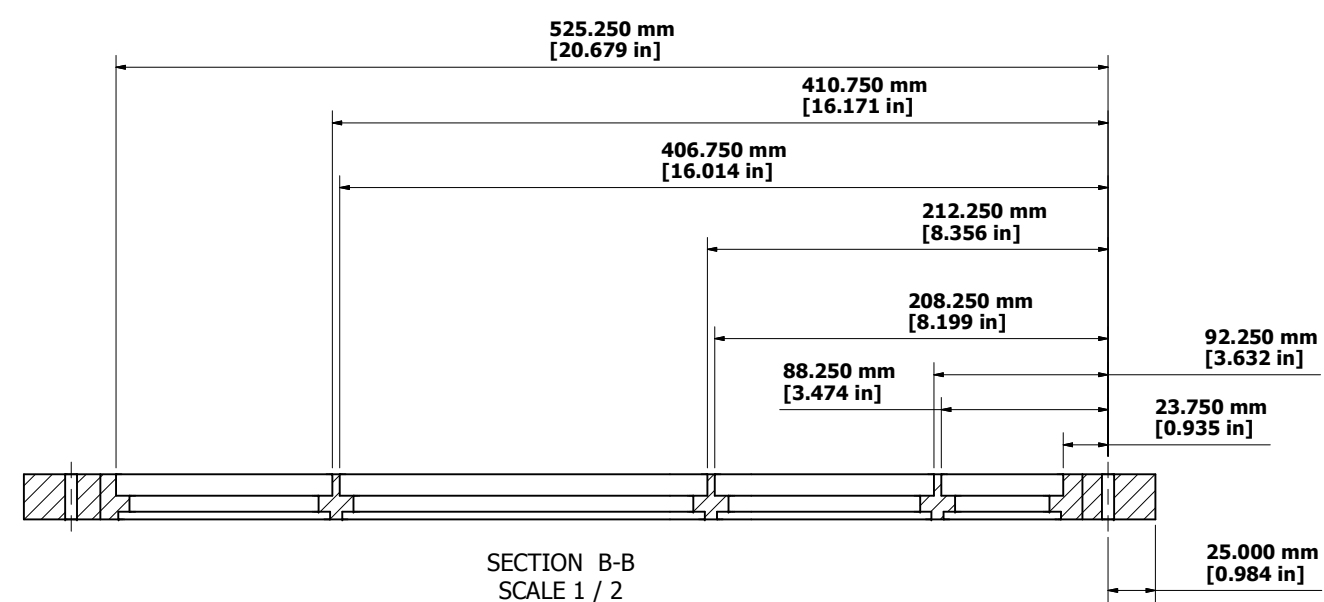
TECHNICAL RESOURCE APPROVALS REQUIRED BEFORE FABRICATION			
	OK	DATE	N/A
DRAFTING (O'Connell):			
MACHINE SHOP (Kaminski):			
CHEMISTRY (Conklin):			
ELECTRONICS SHOP (Barley):			
FURNACE BRAZING (Sherwood):			
BEAM WELDING (Sears):			
WELDING OTHER (Gallagher):			
UTILITIES INTEGRATION (Gallagher):			
STOCKROOMS (Lockwood):			

ITEM	DWG. NO.	DESCRIPTION	G1	G2	G3	REMARKS	REV.
			QUANTITY				
PRINT DISTR. PLOT DATE: 12/18/2007 CAD FILE NAME: 6080-018 BOTTOM SIDE STRONGBACK.idw							
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES: TOLERANCES ON: .00 ± 0.10 .000 ± 0.005 FRACTIONS ± 1/64 ANGLES ± 0.5° ALL SURFACES			CORNELL UNIVERSITY Floyd R. Newman Laboratory Ithaca, NY 14853				
CR-1 6080-018 SH. NO. 2 OF 3			STRESS RELIEF TEST PIECE				
CHECKED BY: PETERSON APPROVED BY: PETERSON		DRAWN BY: MDS	DRAWN FOR: PETERSON	DATE: 12/18/2007	SCALE: Noted	6080-018 SH. NO. 2 OF 3	REV.

REVISIONS				
SYM.	ZONE	DESCRIPTION	DATE	APP.
A		ADDED STRONGBACK TO MULLIONS	12-12-06	DPP



SECTION A-A
SCALE 1 / 2



SECTION B-B
SCALE 1 / 2

Technical questions, including clarifications and proposals for exceptions, are to be directed to
Dan Peterson
 Senior Physicist, Laboratory for Elementary-Particle Physics, Cornell University
 607-255-8784
 dpp@lepp.cornell.edu

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 ALKALINE DETERGENT LUBRICANT CIMSTAR 40
 OR EQUIVALENT APPROVED BY CORNELL LEPP

TECHNICAL RESOURCE APPROVALS REQUIRED BEFORE FABRICATION			
	OK	DATE	N/A
DRAFTING (O'Connell):			
MACHINE SHOP (Kaminski):			
CHEMISTRY (Conklin):			
ELECTRONICS SHOP (Barley):			
FURNACE BRAZING (Sherwood):			
BEAM WELDING (Sears):			
WELDING OTHER (Gallagher):			
UTILITIES INTEGRATION (Gallagher):			
STOCKROOMS (Lockwood):			

ITEM	DWG. NO.	DESCRIPTION	G1	G2	G3	REMARKS	REV.
			QUANTITY				
PRINT DISTR.		PLOT DATE: 12/18/2007 CAD FILE NAME: 6080-018 BOTTOM SIDE STRONGBACK.idw					
CR-1		UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES: TOLERANCES ON: .00 ±.010 .000 ±.005 FRACTIONS ±1/64 ANGLES ±0.5° ALL SURFACES					
6080-018				CORNELL UNIVERSITY Floyd R. Newman Laboratory Ithaca, NY 14853			
REV. A		STRESS RELIEF TEST PIECE					
CHECKED BY: PETERSON	DRAWN BY: MDS	DRAWN FOR: PETERSON	DATE: 12/18/2007	SCALE: NOTED	D	6080-018 SH. NO. 3 OF 3	REV. A