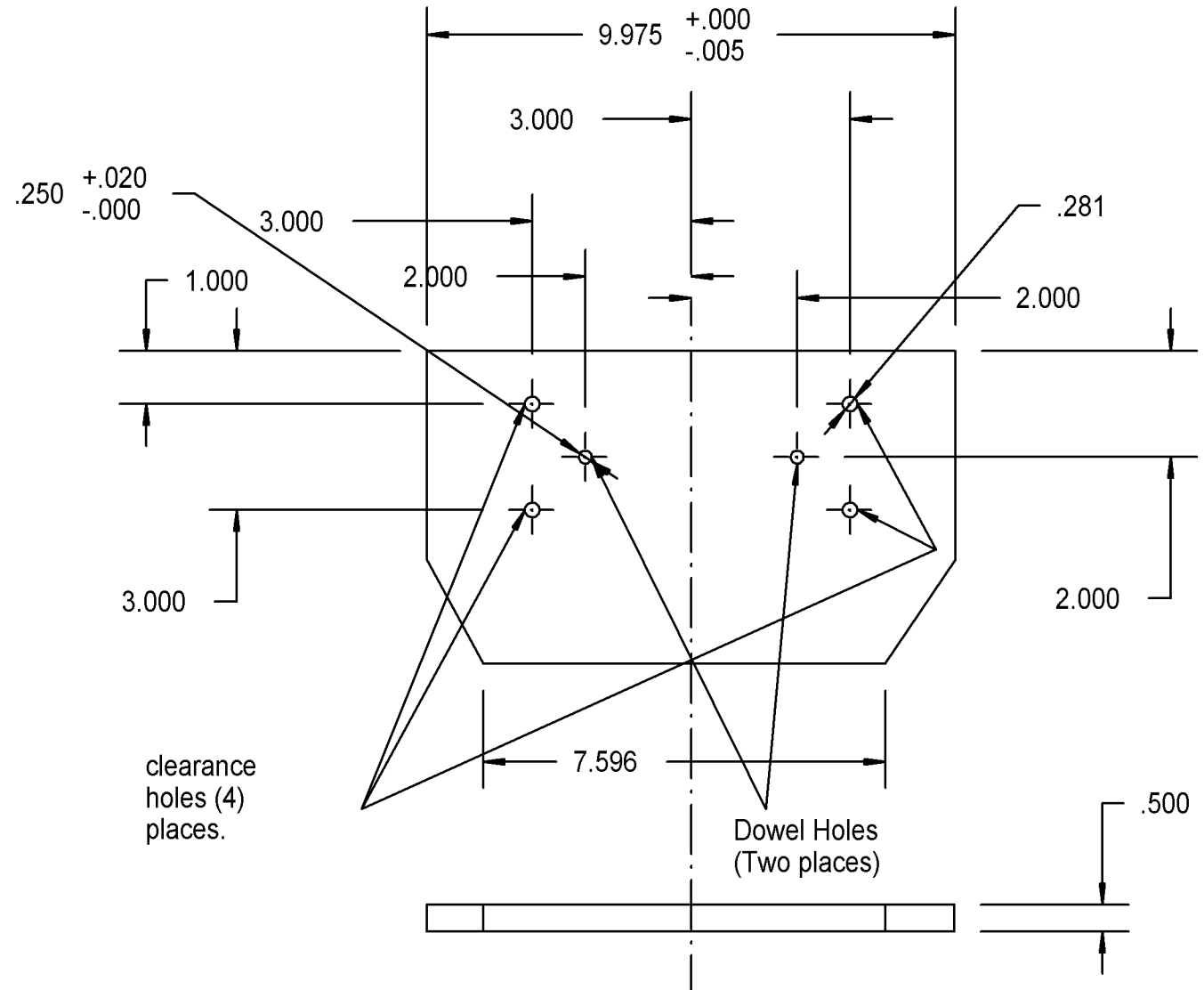


REV	DESCRIPTION	DWN	CHK	APVD	DATE
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REQD	ITEM	PART NUMBER	DESCRIPTION
00X0002A			Low Carbon Steel Plate
			Blanchard ground to 0.500 thickness



Four pole insert required for core assembly

				UNLESS OTHERWISE SPECIFIED		SHOP ORDERS		LAWRENCE BERKELEY LABORATORY							
				TOLERANCE X ±.1 XX ±.01 .XXX ±.001		ACCT NO SER NO		UNIVERSITY OF CALIFORNIA-BERKELEY							
				SURFACE FINISH 125 ✓		DATE ISSD DATE REQD NO REQD		LCLS Injector							
				1. SAWED, FLAMECUT, SHEARED OR CUT STOCK FINISH.		DELIVER TO		BXS Magnet Core							
				2. THREADS CLASS 2		SURFACE TREATMENT DEGREASE		Pole Inserts							
				3. CHAMFER ENDS OF ALL SCREW THRDS 30°		IDENTIFIC METHOD TAG		PAT CLEAR		DWG TYPE DETAIL		SHOWN ON 00X0000		SCALE: FULL	
				4. 1 1/2 PITCH RELIEF WITH ROUND NOSE TOOL ON ALL MACHINE CUT THRDS		DWG BY Jack Tanabe DATE 05-25-06		MICROFILMED		DESIGN ACCT NO 9999-99		CATEGORY CODE 999999		DO NOT SCALE PRINTS	
				5. BREAK EDGES 1/64 MAX. ON MACHINE WORK		CHK BY USUALLY NO ONE DATE 00-00-00								DWG NO LCLS072A	
				6. REMOVE BURRS, LOOSE SCALE AND WELD SPLATTER.										REV	
				7. REF.-USASI OR ASA STDS SECT Y-14 & B46-1.											
REV	DWN	CHK	DATE	DESCRIPTION											

--- DIMENSIONING AND TOLERANCING IS IN ACCORDANCE WITH ASME Y14.5M-1994.		SCALE: NONE		DO NOT SCALE DRAWING		CAD FILE NAME: pf38031707-0.dft	
--- UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES.		STANFORD LINEAR ACCELERATOR CENTER U.S. DEPARTMENT OF ENERGY STANFORD UNIVERSITY STANFORD, CALIFORNIA				LCLS MAGNET SYSTEMS BXS MAGNET CORE POLE INSERTS LBL-LCLS072 A	
--- TOLERANCES: BREAK EDGES .005-.015 INTERNAL CORNERS R.015 MAX		PROPRIETARY DATA OF STANFORD UNIVERSITY AND/OR U. S. DEPARTMENT OF ENERGY. RECIPIENT SHALL NOT PUBLISH THE INFORMATION WITHIN UNLESS GRANTED SPECIFIC PERMISSION OF STANFORD UNIVERSITY.					
--- FRACTIONS ± --- DEC .xx± --- .xxx± --- .xxxx± --- ANGLE ± ---		APPROVALS ENGR C. RAGO DWN JACK TENABE CHKR R. TRIVINO/J. ATILES					
--- NEXT ASSEMBLIES:		ALL SURF ✓		DRAWING NUMBER PF-380-317-07		REVISION NUMBER 0 C	

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