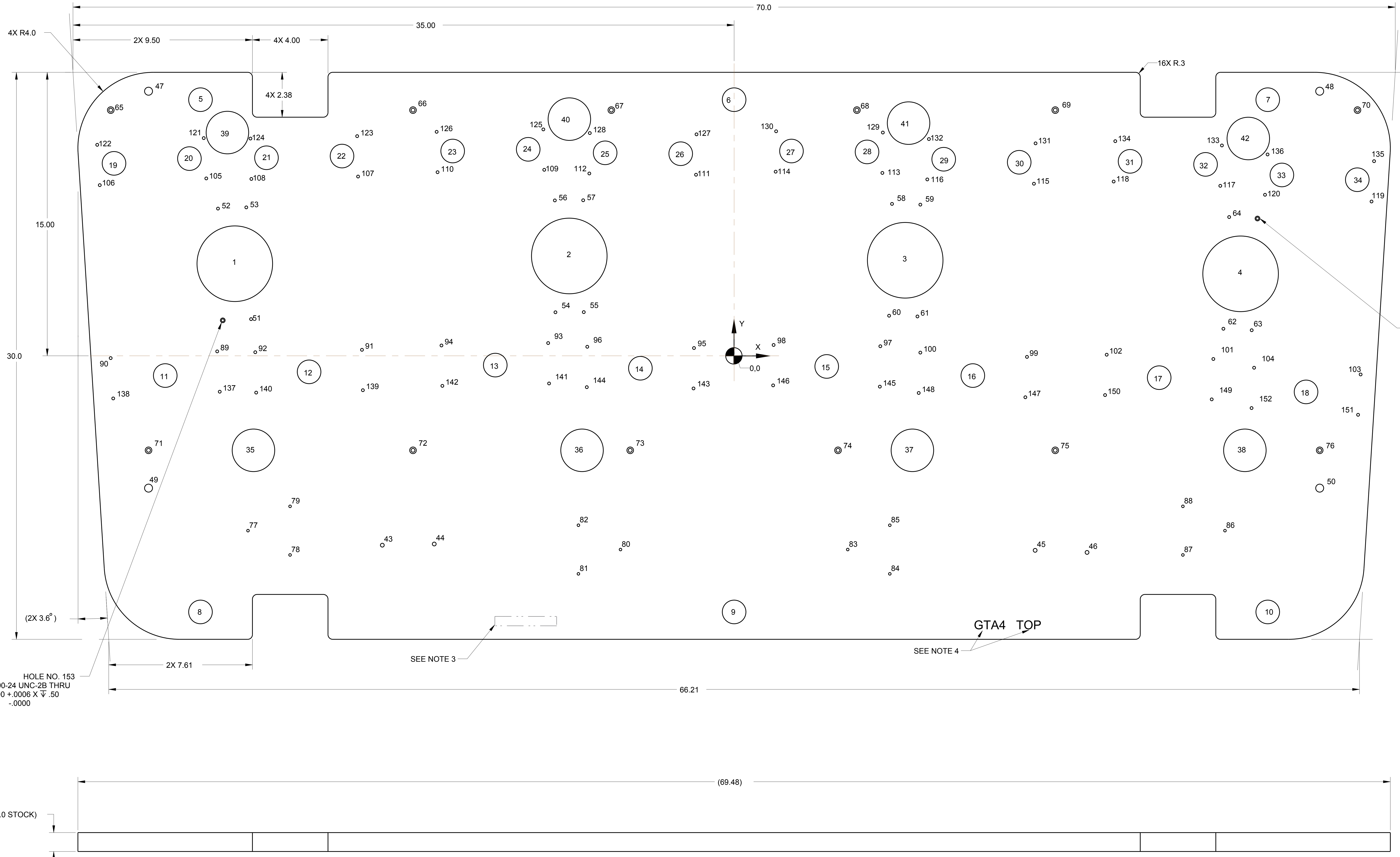


- NOTES:
1. MATERIAL: PLATE ALUMINUM 1.0 THK TYPE 6061-T6 PER ASTM B209
  2. MAKE FROM DXF FILE
  3. VIBRO-ETCH PART WITH DRAWING NUMBER WITH MIN .25 HIGH CHARACTERS IN ACCORDANCE WITH MIL-STD-130, LOCATE APPROX AS SHOWN.
  4. VIBRO-ETCH PLATE WITH PART NAME AND SIDE DESIGNATION WITH MIN .25 HIGH CHARACTERS.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

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



HOLE NO. 153  
 .190-24 UNC-2B THRU  
 $\varnothing .2500 +.0006 X \sqrt{.50}$   
 -.0000

HOLE NO. 154  
 .190-24 UNC-2B THRU  
 $\varnothing .2500 +.0006 X \sqrt{.50}$   
 -.0000

GTA4 TOP  
 SEE NOTE 4

SEE NOTE 3

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 DIMENSIONS ARE IN INCHES DECIMAL TOLERANCES .005 .015 .030 .050 .100 .150 .300 .500 ANGULAR TOLERANCE ±		DRAWN BY: TRABOCCHI/GRAU CHECKED BY: S. RESTMEYER DESIGNED BY: A. ARNO END USER APPROVAL: S. TRABOCCHI APPROVED BY: G. MAHLER SEE ENG: J. TUZZOLO		DRAWN: 5/9/18 CHECKED: 5/21/18 DESIGNED: 4/30/18 APPROVED: 5/9/18 DATE: 5/9/18	
USED ON DRAWING NO. 2570M0023 APPLICATION:		QTY. PER ASSY. 1 FINISH: 125 BREAK SHARP EDGES: <input checked="" type="checkbox"/> MAX. OPEN: 015		SIZE: E DRAWING NUMBER: 2570M0022 REV: A CATEGORY: A3 SCALE: 1/2 WEIGHT: 185.6 SHEET OF 1 2	

DWG NO 2570M0022

SHT 1 of 1

CREO

HOLE TABLE			
HOLE NO.	X	Y	NOTE
1	-26.43	4.87	Ø 4.00 THRU
2	-8.73	5.28	Ø 4.00 THRU
3	9.06	5.06	Ø 4.00 THRU
4	26.81	4.34	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	-30.12	-1.04	Ø 1.25 THRU
12	-22.50	-0.85	Ø 1.25 THRU
13	-12.64	-0.49	Ø 1.25 THRU
14	-4.96	-0.66	Ø 1.25 THRU
15	4.90	-0.56	Ø 1.25 THRU
16	12.64	-1.05	Ø 1.25 THRU
17	22.50	-1.16	Ø 1.25 THRU
18	30.28	-1.91	Ø 1.25 THRU
19	-32.83	10.18	Ø 1.25 THRU
20	-28.84	10.43	Ø 1.25 THRU
21	-24.76	10.48	Ø 1.25 THRU
22	-20.76	10.57	Ø 1.25 THRU
23	-14.90	10.84	Ø 1.25 THRU
24	-10.90	10.93	Ø 1.25 THRU
25	-6.83	10.74	Ø 1.25 THRU
26	-2.83	10.69	Ø 1.25 THRU
27	3.04	10.84	Ø 1.25 THRU
28	7.04	10.79	Ø 1.25 THRU
29	11.10	10.40	Ø 1.25 THRU
30	15.09	10.24	Ø 1.25 THRU
31	20.96	10.29	Ø 1.25 THRU
32	24.96	10.13	Ø 1.25 THRU
33	29.00	9.57	Ø 1.25 THRU
34	32.99	9.32	Ø 1.25 THRU
35	-25.45	-5.00	Ø 2.25 THRU
36	-8.05	-5.00	Ø 2.25 THRU
37	9.44	-5.00	Ø 2.25 THRU
38	27.04	-5.00	Ø 2.25 THRU
39	-26.82	11.81	Ø 2.25 THRU
40	-8.72	12.52	Ø 2.25 THRU
41	9.24	12.31	Ø 2.25 THRU
42	27.22	11.50	Ø 2.25 THRU
43	-18.62	-10.02	250-20 UNC-2B $\nabla$ .75
44	-15.87	-9.96	250-20 UNC-2B $\nabla$ .75
45	15.94	-10.29	250-20 UNC-2B $\nabla$ .75
46	18.68	-10.40	250-20 UNC-2B $\nabla$ .75
47	-31.00	14.00	500-13 UNC-2B THRU
48	31.00	14.00	500-13 UNC-2B THRU
49	-31.00	-7.00	500-13 UNC-2B THRU
50	31.00	-7.00	500-13 UNC-2B THRU
51	-25.57	1.94	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
52	-27.32	7.79	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
53	-25.82	7.85	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
54	-9.46	2.30	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
55	-7.96	2.31	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
56	-9.49	8.22	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
57	-7.99	8.23	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
58	8.36	8.04	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
59	9.86	8.00	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
60	8.21	2.12	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
61	9.70	2.08	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
62	25.90	1.43	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
63	27.40	1.35	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
64	26.21	7.34	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
65	-33.00	13.00	Ø 203 $\nabla$ .19, $\nabla$ Ø .350 X 120°
66	-17.00	13.00	Ø 203 $\nabla$ .19, $\nabla$ Ø .350 X 120°
67	-6.50	13.00	Ø 203 $\nabla$ .19, $\nabla$ Ø .350 X 120°
68	6.50	13.00	Ø 203 $\nabla$ .19, $\nabla$ Ø .350 X 120°
69	17.00	13.00	Ø 203 $\nabla$ .19, $\nabla$ Ø .350 X 120°
70	33.00	13.00	Ø 203 $\nabla$ .19, $\nabla$ Ø .350 X 120°

HOLE TABLE			
HOLE NO.	X	Y	NOTE
71	-31.00	-5.00	Ø 203 $\nabla$ .19, $\nabla$ Ø .350 X 120°
72	-17.00	-5.00	Ø 203 $\nabla$ .19, $\nabla$ Ø .350 X 120°
73	-5.50	-5.00	Ø 203 $\nabla$ .19, $\nabla$ Ø .350 X 120°
74	5.50	-5.00	Ø 203 $\nabla$ .19, $\nabla$ Ø .350 X 120°
75	17.00	-5.00	Ø 203 $\nabla$ .19, $\nabla$ Ø .350 X 120°
76	31.00	-5.00	Ø 203 $\nabla$ .19, $\nabla$ Ø .350 X 120°
77	-25.74	-9.25	.164-32 UNC-2B $\nabla$ .50
78	-23.51	-10.54	.164-32 UNC-2B $\nabla$ .50
79	-23.51	-7.96	.164-32 UNC-2B $\nabla$ .50
80	-6.02	-10.25	.164-32 UNC-2B $\nabla$ .50
81	-8.24	-11.54	.164-32 UNC-2B $\nabla$ .50
82	-8.24	-8.96	.164-32 UNC-2B $\nabla$ .50
83	6.02	-10.25	.164-32 UNC-2B $\nabla$ .50
84	8.24	-11.54	.164-32 UNC-2B $\nabla$ .50
85	8.24	-8.96	.164-32 UNC-2B $\nabla$ .50
86	25.99	-9.25	.164-32 UNC-2B $\nabla$ .50
87	23.76	-10.54	.164-32 UNC-2B $\nabla$ .50
88	23.76	-7.96	.164-32 UNC-2B $\nabla$ .50
89	-27.37	0.23	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
90	-33.00	-0.12	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
91	-19.70	0.32	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
92	-25.35	0.19	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
93	-9.84	0.67	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
94	-15.49	0.55	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
95	-2.12	0.41	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
96	-7.77	0.48	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
97	7.74	0.51	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
98	2.09	0.57	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
99	15.50	-0.06	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
100	9.86	0.17	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
101	25.37	-0.17	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
102	19.72	0.06	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
103	33.17	-0.99	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
104	27.53	-0.63	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
105	-27.94	9.39	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
106	-33.58	9.03	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
107	-19.91	9.49	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
108	-25.56	9.36	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
109	-10.05	9.84	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
110	-15.70	9.72	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
111	-2.02	9.58	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
112	-7.67	9.65	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
113	7.85	9.68	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
114	2.20	9.74	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
115	15.87	9.11	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
116	10.23	9.33	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
117	25.74	8.99	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
118	20.09	9.22	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
119	33.74	8.16	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
120	28.11	8.52	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
121	-28.08	11.52	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
122	-33.72	11.16	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
123	-19.96	11.62	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
124	-25.60	11.50	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
125	-10.10	11.98	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
126	-15.75	11.85	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
127	-1.99	11.72	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
128	-7.64	11.79	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
129	7.87	11.81	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
130	2.22	11.88	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
131	15.96	11.24	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
132	10.31	11.47	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
133	25.82	11.13	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
134	20.18	11.36	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
135	33.88	10.30	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
136	28.24	10.65	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
137	-27.23	-1.90	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
138	-32.87	-2.25	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
139	-19.65	-1.82	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
140	-25.30	-1.95	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.

HOLE TABLE			
HOLE NO.	X	Y	NOTE
141	-9.80	-1.46	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
142	-15.45	-1.59	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
143	-2.15	-1.73	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
144	-7.80	-1.66	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
145	7.71	-1.63	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
146	2.07	-1.56	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
147	15.42	-2.19	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
148	9.77	-1.97	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
149	25.28	-2.30	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
150	19.64	-2.08	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
151	33.03	-3.12	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
152	27.39	-2.76	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD. MIN.
153	-27.070 ± .002	1.877 ± .002	SEE F/D ZONE C8
154	27.705 ± .002	7.265 ± .002	SEE F/D ZONE E1