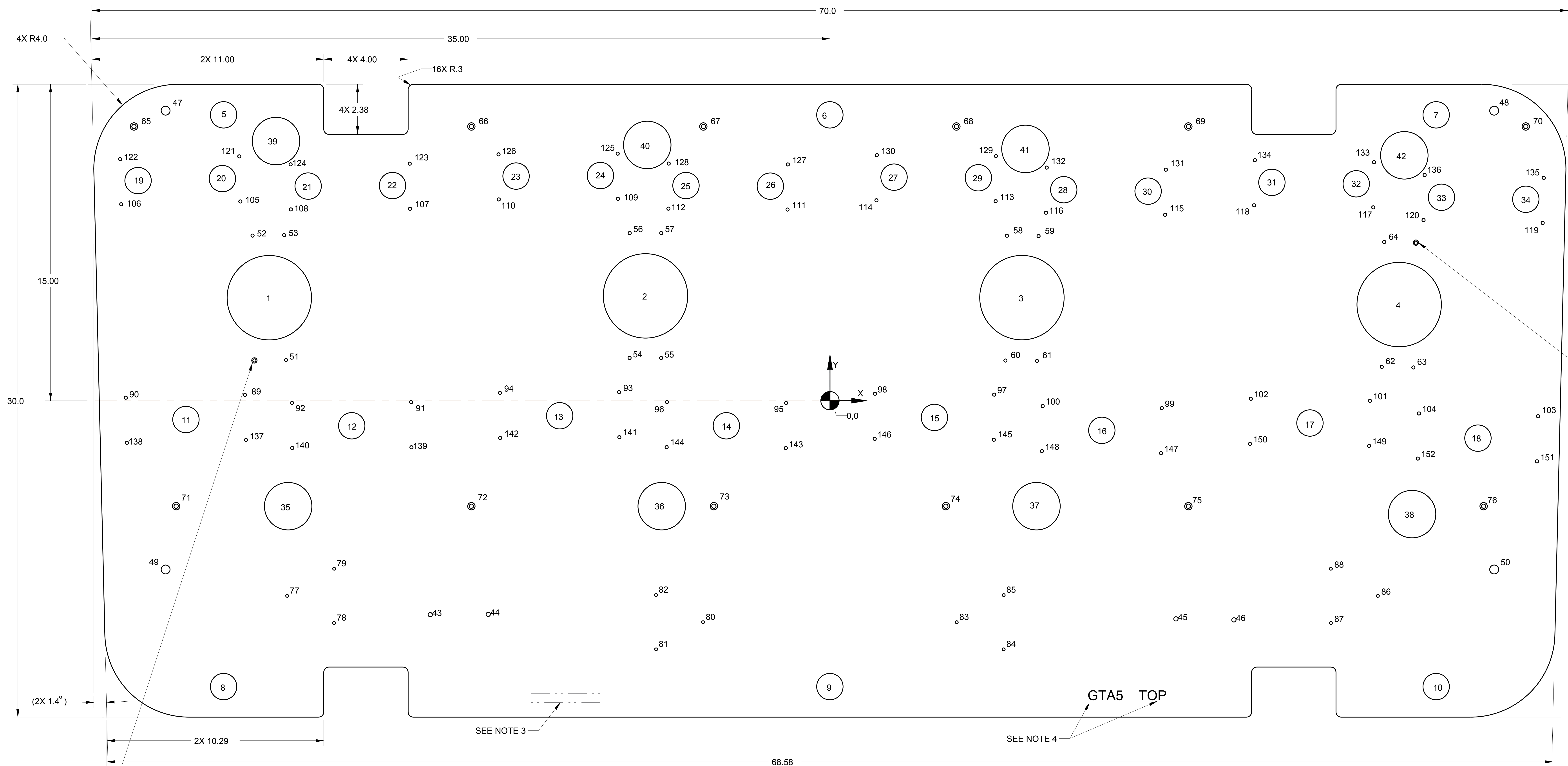


NOTES:

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
 ∅ .2500 ± .0006 X .50 ± .0000

HOLE NO. 154
 .190-24 UNC-2B THRU
 ∅ .2500 ± .0006 X .50 ± .0000

(1.0) STOCK

GTA5 TOP

SEE NOTE 3

SEE NOTE 4

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/GRAU CHECKED BY: S. RESTMEYER DESIGNED BY: A. ARNO DIMENSIONAL TOLERANCES: S. TRABOCCHI JOB: 016 DATE: 05/05 APPROVAL: G. MAHLER DESIGNED BY: J. TUZZOLO		33018 5218 43018 5318 5218	
DIMENSIONS ARE IN INCHES		BREAK SHARP EDGES		SIZE: E	
FINISH: 125		SAFETY / ISC: 016		DRAWING NUMBER: 2570M0025	
USED ON DRAWING NO. 2570M0026		QTY. PER ASSY. 1		REV. A	
APPLICATION:		CATEGORY: A3		SCALE: 1/2	
WEIGHT: 189.3		SHEET OF 1 2		CREO	

DWG NO 2570M0025 SHT 1 of 1

HOLE TABLE			
Hole No.	X	Y	NOTE
1	-26.58	4.88	Ø 4.00 THRU
2	-8.74	4.97	Ø 4.00 THRU
3	9.11	4.89	Ø 4.00 THRU
4	27.00	4.56	Ø 4.00 THRU
5	-28.75	13.55	Ø 1.25 THRU
6	0.00	13.55	Ø 1.25 THRU
7	28.75	13.55	Ø 1.25 THRU
8	-28.75	-13.55	Ø 1.25 THRU
9	0.00	-13.55	Ø 1.25 THRU
10	28.75	-13.55	Ø 1.25 THRU
11	-30.54	-0.89	Ø 1.25 THRU
12	-22.67	-1.19	Ø 1.25 THRU
13	-12.81	-0.71	Ø 1.25 THRU
14	-4.91	-1.19	Ø 1.25 THRU
15	4.96	-0.79	Ø 1.25 THRU
16	12.90	-1.40	Ø 1.25 THRU
17	22.77	-1.06	Ø 1.25 THRU
18	30.73	-1.77	Ø 1.25 THRU
19	-32.81	10.43	Ø 1.25 THRU
20	-28.81	10.53	Ø 1.25 THRU
21	-24.74	10.18	Ø 1.25 THRU
22	-20.74	10.20	Ø 1.25 THRU
23	-14.88	10.65	Ø 1.25 THRU
24	-10.88	10.67	Ø 1.25 THRU
25	-6.82	10.20	Ø 1.25 THRU
26	-2.82	10.17	Ø 1.25 THRU
27	3.04	10.60	Ø 1.25 THRU
28	11.09	10.00	Ø 1.25 THRU
29	7.04	10.57	Ø 1.25 THRU
30	15.09	9.93	Ø 1.25 THRU
31	20.96	10.35	Ø 1.25 THRU
32	24.96	10.28	Ø 1.25 THRU
33	29.00	9.65	Ø 1.25 THRU
34	33.00	9.55	Ø 1.25 THRU
35	-25.69	-5.00	Ø 2.25 THRU
36	-7.97	-5.00	Ø 2.25 THRU
37	9.80	-5.00	Ø 2.25 THRU
38	27.61	-5.38	Ø 2.25 THRU
39	-26.26	12.31	Ø 2.25 THRU
40	-8.66	12.13	Ø 2.25 THRU
41	9.27	11.94	Ø 2.25 THRU
42	27.24	11.63	Ø 2.25 THRU
43	-18.95	-10.14	.250-20 UNC-2B ∇ .75 FULL THD MIN
44	-16.20	-10.13	.250-20 UNC-2B ∇ .75 FULL THD MIN
45	16.41	-10.34	.250-20 UNC-2B ∇ .75 FULL THD MIN
46	19.16	-10.39	.250-20 UNC-2B ∇ .75 FULL THD MIN
47	-31.50	13.75	.500-13 UNC-2B THRU
48	31.50	13.75	.500-13 UNC-2B THRU
49	-31.50	-8.00	.500-13 UNC-2B THRU
50	31.50	-8.00	.500-13 UNC-2B THRU
51	-25.79	1.93	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD. MIN.
52	-27.38	7.83	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD. MIN.
53	-25.88	7.85	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD. MIN.
54	-9.50	2.03	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD. MIN.
55	-8.00	2.03	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD. MIN.
56	-9.49	7.95	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD. MIN.
57	-7.99	7.95	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD. MIN.
58	8.40	7.82	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD. MIN.
59	9.90	7.80	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD. MIN.
60	8.32	1.91	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD. MIN.
61	9.82	1.89	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD. MIN.
62	26.17	1.61	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD. MIN.
63	27.67	1.58	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD. MIN.
64	26.29	7.52	Ø .149 THRU .190-24 UNC-2B X .75 FULL THD. MIN.
65	-33.00	13.00	Ø .203 ∇ .19. ∇ Ø .350 X 120°
66	-17.00	13.00	Ø .203 ∇ .19. ∇ Ø .350 X 120°
67	-6.00	13.00	Ø .203 ∇ .19. ∇ Ø .350 X 120°
68	6.00	13.00	Ø .203 ∇ .19. ∇ Ø .350 X 120°
69	17.00	13.00	Ø .203 ∇ .19. ∇ Ø .350 X 120°
70	33.00	13.00	Ø .203 ∇ .19. ∇ Ø .350 X 120°

HOLE TABLE			
Hole No.	X	Y	NOTE
71	-31.00	-5.00	Ø .203 ∇ .19. ∇ Ø .350 X 120°
72	-17.00	-5.00	Ø .203 ∇ .19. ∇ Ø .350 X 120°
73	-5.50	-5.00	Ø .203 ∇ .19. ∇ Ø .350 X 120°
74	5.50	-5.00	Ø .203 ∇ .19. ∇ Ø .350 X 120°
75	17.00	-5.00	Ø .203 ∇ .19. ∇ Ø .350 X 120°
76	31.00	-5.00	Ø .203 ∇ .19. ∇ Ø .350 X 120°
77	-25.74	-9.25	.164-32 UNC-2B ∇ .50
78	-23.51	-10.54	.164-32 UNC-2B ∇ .50
79	-23.51	-7.96	.164-32 UNC-2B ∇ .50
80	-6.02	-10.50	.164-32 UNC-2B ∇ .50
81	-8.24	-11.79	.164-32 UNC-2B ∇ .50
82	-8.24	-9.21	.164-32 UNC-2B ∇ .50
83	6.02	-10.50	.164-32 UNC-2B ∇ .50
84	8.24	-11.79	.164-32 UNC-2B ∇ .50
85	8.24	-9.21	.164-32 UNC-2B ∇ .50
86	25.99	-9.25	.164-32 UNC-2B ∇ .50
87	23.76	-10.54	.164-32 UNC-2B ∇ .50
88	23.76	-7.96	.164-32 UNC-2B ∇ .50
89	-27.74	0.28	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
90	-33.39	0.14	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
91	-19.85	-0.07	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
92	-25.50	-0.10	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
93	-9.99	0.41	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
94	-15.64	0.37	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
95	-2.08	-0.11	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
96	-7.73	-0.06	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
97	7.79	0.29	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
98	2.14	0.33	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
99	15.74	-0.35	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
100	10.09	-0.25	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
101	25.61	0.00	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
102	19.96	0.09	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
103	33.58	-0.74	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
104	27.93	-0.60	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
105	-27.96	9.45	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
106	-33.60	9.31	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
107	-19.91	9.10	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
108	-25.56	9.07	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
109	-10.05	9.58	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
110	-15.70	9.54	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
111	-2.01	9.06	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
112	-7.66	9.10	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
113	7.86	9.46	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
114	2.21	9.50	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
115	15.90	8.82	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
116	10.25	8.91	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
117	25.77	9.17	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
118	20.12	9.26	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
119	33.80	8.43	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
120	28.15	8.56	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
121	-28.01	11.58	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
122	-33.65	11.45	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
123	-19.92	11.24	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
124	-25.57	11.21	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
125	-10.06	11.71	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
126	-15.71	11.68	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
127	-1.99	11.20	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
128	-7.64	11.24	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
129	7.87	11.60	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
130	2.22	11.64	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
131	15.93	10.95	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
132	10.28	11.05	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
133	25.80	11.30	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
134	20.15	11.40	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
135	33.85	10.57	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
136	28.20	10.70	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
137	-27.69	-1.86	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
138	-33.34	-1.99	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
139	-19.84	-2.21	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
140	-25.49	-2.24	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN

HOLE TABLE			
Hole No.	X	Y	NOTE
141	-9.98	-1.73	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
142	-15.63	-1.76	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
143	-2.09	-2.24	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
144	-7.74	-2.20	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
145	7.77	-1.85	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
146	2.12	-1.81	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
147	15.70	-2.49	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
148	10.05	-2.39	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
149	25.57	-2.14	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
150	19.92	-2.04	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
151	33.53	-2.88	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
152	27.88	-2.74	Ø .1495 THRU, .190-24 UNC-2B X .75 FULL THD MIN
153	-27.289 ± .002	1.909 ± .002	SEE F/D ZONE C8
154	27.790 ± .002	7.494 ± .002	SEE F/D ZONE E1