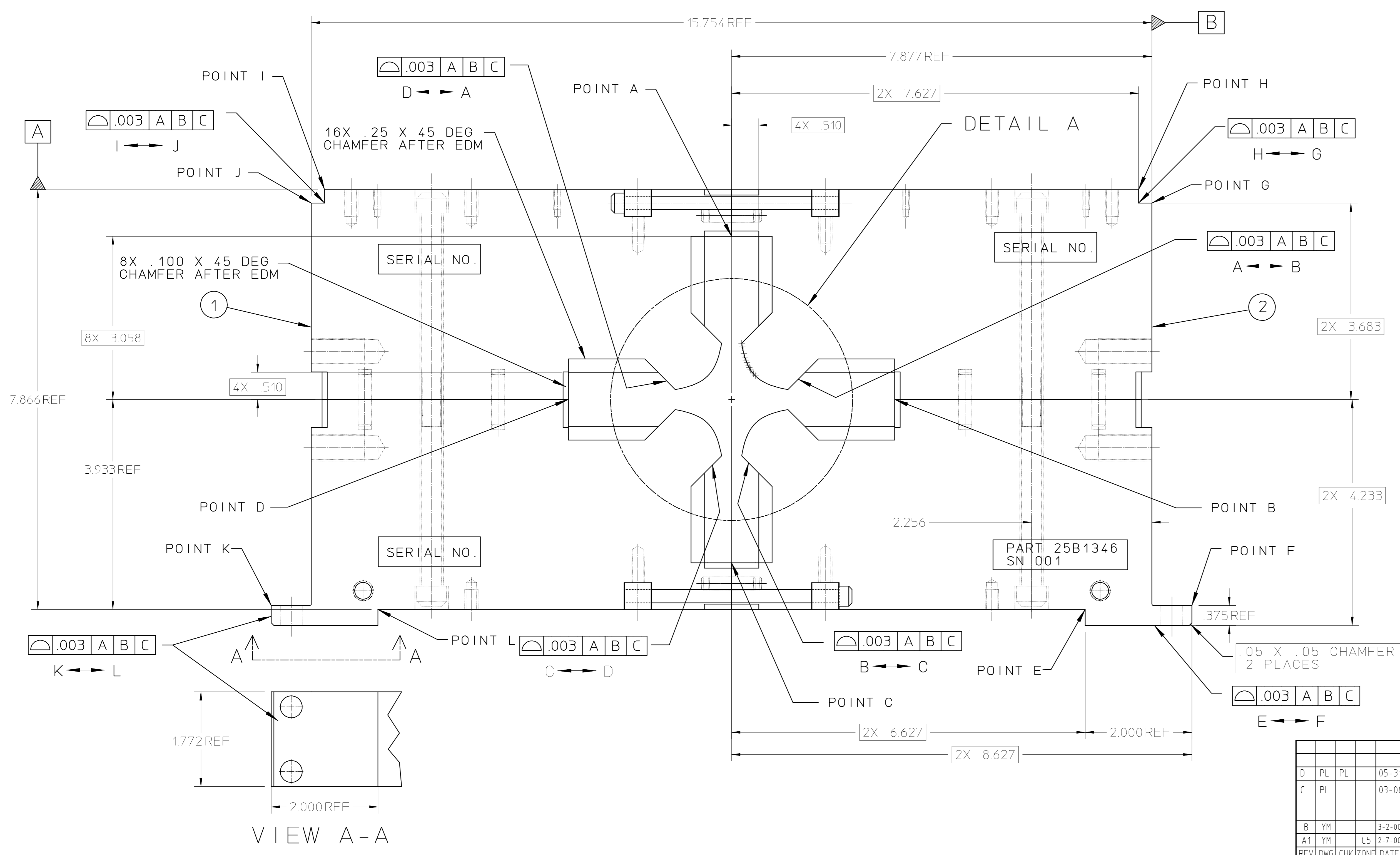
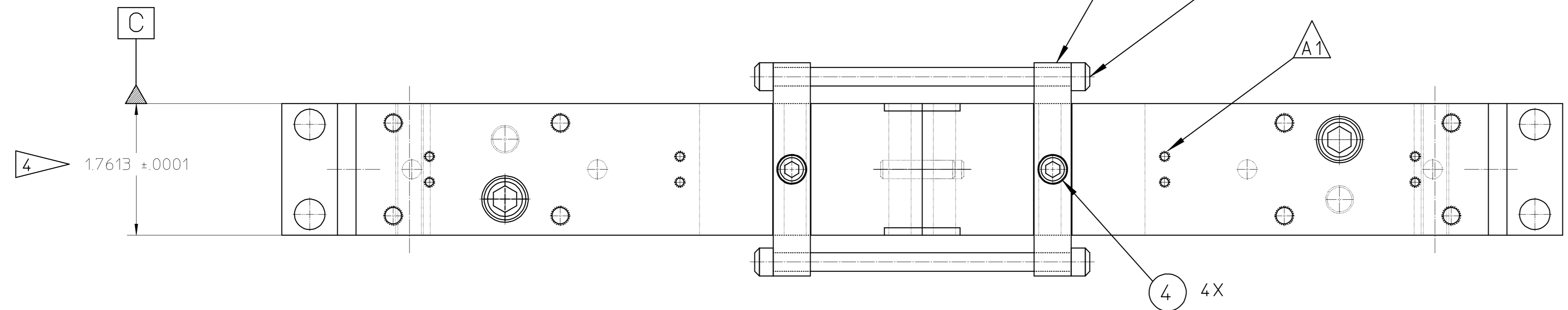


- NOTES: 1. ALL DIMENSIONS ARE IN INCHES.  
 2. ESTIMATED WT.: 64 LBS.  
 3. AFTER EDM PROCESS, DISASSEMBLE AND PLATE PER LBNL SPECIFICATION M912.  
 4. OBTAIN INDICATED ASSEMBLY THICKNESS BY GRINDING PRIOR TO EDM PROCESS.

POLE TIP COORDINATES - ALL NUMBERS BASIC

POINT 1 TO POINT 2: STRAIGHT LINE  
 POINT 2 TO POINT 26: HYPERBOLA  
 POINT 26 TO POINT 27: STRAIGHT LINE  
 POINT 28 TO POINT 29: STRAIGHT LINE  
 POINT 29 TO POINT 53: HYPERBOLA  
 POINT 53 TO POINT 54: STRAIGHT LINE  
 POINT 55 TO POINT 56: STRAIGHT LINE  
 POINT 56 TO POINT 80: HYPERBOLA  
 POINT 81 TO POINT 82: STRAIGHT LINE  
 POINT 82 TO POINT 83: STRAIGHT LINE  
 POINT 83 TO POINT 107: HYPERBOLA  
 POINT 107 TO POINT 108: STRAIGHT LINE  
 (HYPERBOLA FORMULA  $2XY = r^2$   $r = 0.630$  INCH)

POINT	-X-	-Y-	POINT	-X-	-Y-	POINT	-X-	-Y-
1	.510	1.378	37	.598	-.332	73	-.645	-.308
2	.188	1.056	38	.558	-.356	74	-.692	-.287
3	.201	.988	39	.518	-.383	75	-.738	-.269
4	.214	.927	40	.482	-.412	76	-.793	-.250
5	.231	.860	41	.445	-.445	77	-.860	-.231
6	.250	.793	42	.412	-.482	78	-.927	-.214
7	.269	.738	43	.383	-.518	79	-.988	-.201
8	.287	.692	44	.356	-.558	80	-1.056	-.188
9	.308	.645	45	.332	-.598	81	-1.378	-.510
10	.332	.598	46	.308	-.645	82	-1.378	.510
11	.356	.558	47	.287	-.692	83	-1.056	.188
12	.383	.518	48	.269	-.738	84	-.988	.201
13	.412	.482	49	.250	-.793	85	-.927	.214
14	.445	.445	50	.231	-.860	86	-.860	.231
15	.482	.412	51	.214	-.927	87	-.793	.250
16	.518	.383	52	.201	-.988	88	-.738	.269
17	.558	.356	53	.188	-1.056	89	-.692	.287
18	.598	.332	54	.188	-1.056	90	-.645	.308
19	.645	.308	55	-.510	-1.378	91	-.598	.332
20	.692	.287	56	-.188	-1.056	92	-.558	.356
21	.738	.269	57	-.201	-.988	93	-.518	.383
22	.793	.250	58	-.214	-.927	94	-.482	.412
23	.860	.231	59	-.231	-.860	95	-.445	.445
24	.927	.214	60	-.250	-.793	96	-.412	.482
25	.988	.201	61	-.269	-.738	97	-.383	.518
26	1.056	.188	62	-.287	-.692	98	-.356	.558
27	1.378	.510	63	-.308	-.645	99	-.332	.598
28	1.378	-.510	64	-.332	-.598	100	-.308	.645
29	1.056	-.188	65	-.356	-.558	101	-.287	.692
30	.988	-.201	66	-.383	-.518	102	-.269	.738
31	.927	-.214	67	-.412	-.482	103	-.250	.793
32	.860	-.231	68	-.445	-.445	104	-.231	.860
33	.793	-.250	69	-.482	-.412	105	-.214	.927
34	.738	-.269	70	-.518	-.383	106	-.201	.988
35	.692	-.287	71	-.558	-.356	107	-.188	1.056
36	.645	-.308	72	-.598	-.332	108	-.510	1.378



REQD	ITEM	PART NO.	DESCRIPTION
1	1	25B1324	POLE PIECE ASSEMBLY - LEFT HAND
1	2	25B1334	POLE PIECE ASSEMBLY - RIGHT HAND
4	3	25B1234	CROSSBAR
4	4		SCREW, SOC. HD., 1/4-20UNC-2A X .75" LONG, SST.
4	5		SCREW, SOC. HD., 1/4-20UNC-2A X .425" LONG, SST.

UNLESS OTHERWISE SPECIFIED				SHOP ORDERS				LAWRENCE BERKELEY LABORATORY			
CD	X ± -	FRAC.	± 1/64	ACCT.	SERIAL	NO.		UNIVERSITY OF CALIFORNIA-BERKELEY			
SS	XX ± .02	ANGLES	± 1°	DATE	DATE	NO.		SNS - FE MEBT			
CS	XXX ± .005	FINISH	125.7	DELIVER	NO.			QUADRUPOLE MAGNET			
THREADS ARE CLASS 2				SURFACE TREATMENT				DEGREASE			
CHAMFER ENDS OF ALL SCREW THREADS 30°				PATENT CLEAR				DWG. TYPE			
OUT 1.5 PITCH THRO RELIEF WITH ROUNDED END				ASSEMBLY				SCALE FULL			
ON MACHINE CUT THREADS				BY				REV			
BREAK EDGES .016 MAX ON MACHINED WORK				DWG. Y. MINAMIHARA				DATE			
REMOVE BURRS WELD SPLATTER & LOOSE SCALE				CHK				REV			
REFERENCES: ANSI Y14.5 & B46.1				DATE				REV			

25B1346D

REV	DWG	CHK	ZONE	DATE	CHANGES
B	YM			3-2-89	CHANGED CHAMFER AND POLE PROFILE
A1	YM	CS		2-7-89	RELOCATED 6-32UNC TAPPED HOLES

REV	DWG	CHK	ZONE	DATE	CHANGES
B	YM			3-2-89	CHANGED CHAMFER AND POLE PROFILE
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