MAKE BEST EFFORT TO APPLY PRIMER COAT INSIDE TUBE.

MAKE BEST EFFORT TO APPLY PRIMER COAT INSIDE LEG. FINISH COAT NOT REQUIRED.

FINISHING OF ALL EXPOSED SURFACES EXCEPT INSIDES OF ARMS:
COMMERCIAL BLAST CLEAN TO SSPC-SP6 STANDARD.
IMMEDIATELY PRIME WITH ONE COAT ONLY OF ZINC-RICH PRIMER (AMERON DIMETCOTE 9HS, CARBOZINC 11 OR EQUIV.)
SPRAY EQUIPMENT SHOULD USE AGITATED PRESSURE POT TO KEEP ZINC UNIFORMLY MIXED DURING APPLICATION.
TAPPED HOLES SHOULD HAVE ONLY LIGHT COVERAGE OF PRIMER.
OVERCOAT WITH ONE COAT ONLY OF WHITE SILOXANE EPOXY (AMERON PSX 700, CARBOLINE CARBOXANE 2000 OR EQUIV.)
FOLLOW ALL MANUFACTURER’S APPLICATION INSTRUCTIONS. USE PLUGS TO AVOID OVERCOAT IN TAPPED HOLES.

FINISHING OF EXPOSED SURFACES INSIDE ARMS:
AS ABOVE EXCEPT NO OVERCOAT OF WHITE SILOXANE IS REQUIRED.
MOUNT POINT HOLES N2, S2, W2 ON TOP SIDE, TRUE POSITION WITHIN 1/8 INCH.
LOCATIONS SHOULD FORM AN EQUILATERAL TRIANGLE.

FOOT POINT HOLES N1, S1, W1 ON BOTTOM SIDE, POSITION NOT CRITICAL.

LIFT POINT HOLES A, B, C, D ON ARMS, TRUE POSITION WITHIN 1/8 INCH.
SEE ALSO SHEET B.

LOCATE POINT HOLES A, B, C, D ON ARMS, TRUE POSITION WITHIN 1/16 INCH.
A FIXTURE IS AVAILABLE FOR FINAL ALIGNMENT.
SEE ALSO SHEET B.

SURFACES OF 24-09-251 LIFTING PLATES, ITEM 21, MUST BE TRUE PLANET WITHIN 1/4".
SEE ALSO SHEET 4 & 8.

CROSS SECTIONS ARE SHOWN ON THE FOLLOWING PAGES.

SECTION A-A SHEET 5 ARM DIMS
SECTION B-B SHEET 5 DOOR RIM DIMS
SECTION C-C SHEET 5 WEST WALL DIMS
SECTION A-A SHEET 6 WELD SYMBOLS
SECTION B-B SHEET 6 WELD SYMBOLS

M. C. Fleming
2005-01-24

Radio Astronomy Lab
University of California - Berkeley
Tel: 510-642-5040 Fax: 510-642-3411

CARMA 6m Base Assem
Top View, Dims & Tolerance

B 24-09-210 3 of 8 A

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LIFT PLATES ON ALL 4 ARMS MUST BE IN PLANE WITHIN 1/4"

1 3/4" INSIDE

24" INSIDE

24" INSIDE

3 1/16" DIA INSIDE

1 3/16" PROJECT

7 5/16" FOR FOOT & SCREW

7 3/4" FOR AIR SPRING

3/4" PLATE

13 3/4" TO GROUND

7 3/4" GROUND CLEAR

VIEW EAST SIDE WITH DOOR

LIFT PLATES ON ALL 4 ARMS MUST BE IN PLANE WITHIN 1/4"

40°

40°

28°

28°

13 3/4" TO GROUND

8 1/2" GROUND CLEAR

7 3/4" GROUND CLEAR

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE INCHES & DEGREES

TOLEANCES:

WHOLE & FRACTION DECIMAL XXX DECIMAL XXX

LINEAR ANGLE

± 1/16 ± 1°

± 0.01 ± 0.1°

± 0.005 ± 0.001°

MACHINED SURF FINISH < 125 MICROINCH

BREAK SHARP EDGES 0.010 RAD ± 0.003

UNLESS OTHERWISE SPECIFIED
SECTION B-B
SCALE 1 : 20

ALL INTERIOR CORNERS
WALLS TO FLOOR & WALLS TO CEILING

TOP RING
1/4
5/16

AROUND TOP RING
1/4
5/16

AROUND DOOR RIM
1/4

AROUND BOTTOM RING
1/4

BOTTOM RING
5/16

GRIND WELD AT 27 ARM LOWER FLANGE
FLAT PRIOR TO WELDING SUPPORT PAD IN PLACE
IT WILL OVER HANG THIS JOINT LINE BY 1/2"

SECTION A-A
SCALE 1 : 20

SEE VIEWS ON SHEET 8
FOR ADDITIONAL WELD INFORMATION

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University of California - Berkeley
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CARMA 6m BASE ASSEM
Side Sections & Weld Info
Light fixture bracket 1 of 4 welded to ceiling with 3/16 fillet welds shown here projected as if ceiling removed. Dimensions typical and symmetrical 4 places.

4 3/8" offset from wall

8" square tube
3/8" wall
ARM ASSEMBLY SHOULD PROBABLY BE WELDED UP IN A FIXTURE AND THEN INSERTED INTO BASE ASSEMBLY.

CUSTOMER HAS A LARGE LIFTING FRAME FIXTURE FOR ALIGNMENT OF LOCATOR SOCKETS AND LIFTING HOLES. THIS FIXTURE COULD BE USED TO GUARANTEE PROPER ALIGNMENT OF HOLES PER TOLERANCE ON SHEET 3.

ANOTHER OPTION TO CONSIDER IS ITEM 22 LIFTING PLATE IS DESIGNED WITH A 1/4" GAP FROM EDGE OF SIDE PLATES. THIS PLATE COULD BE LEFT LOOSE OR TACKED LIGHTLY AND LATER REPOSTIONED BEFORE FINAL WELDING. THIS COULD BE HELPFUL IF ARMS MOVE DURING FINISH WELDING TO BASE.

ITEM 29 LOCATOR BASE COULD ALSO BE LEFT FLOATING UNTIL FINAL WELDING IS COMPLETE. IT COULD THEN BE POSITIONED AND TACKED WITH THE AID OF LIFTING FRAME FIXTURE SUPPLIED BY CUSTOMER.

BASIC WELDING SCHEME

ALL EXTERIOR JOINTS TO BE CONTINUOUS WELDS SO THAT BASE WILL BE RAINWATER TIGHT.

INTERIOR WELDS CAN BE INTERMITTENT WELDED 2" ON 4" CENTERS

1/4 PLATE JOINTS SHOULD TYPICALLY HAVE 1/4 FILLET WELDS

3/8 PLATE JOINTS SHOULD TYPICALLY HAVE 5/16 FILLET WELDS

SEE CROSS-SECTIONS ON SHEET 6 FOR ADDITIONAL WELD INFORMATION
THIS PART CAN BE FABRICATED FROM SEVERAL PIECES.

1 REQUIRED PER ASSEM

M.C. FLEMING 2004-12-23

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CARMA 6m Base, Bottom Plate

491.5 LBS
STEEL, A-36 1/4" THICK

DIMENSIONS ARE INCHES & DEGREES
TOLERANCES:
WHOLE & FRACTION DECIMAL X.X DECIMAL X.XXX
LINEAR  1/16  0.1  0.01  0.001
ANGLE   ± 1°  ± 0.01° ± 0.001° ± 0.0001°

BREAK SHARP EDGES 0.010 RAD  ± 0.003
MACHINED SURF FINISH ≤ 125 MICROINCH

UNLESS OTHERWISE SPECIFIED

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CARMA 6m Base, Curved Plate East Door

12 3/8" RAD

.19 X 45" CHAMFER
2 PLACES
WELD PREP

2 REQUIRED PER ASSEM

WEIGHT: 410 lbs

TOLERANCES:

NAME DATE
M. C. FLEMING 2004-12-23

BREAK SHARP EDGES 0.010 RAD + 0.003
MACHINED SURF FINISH < 125 MICROINCH

MATERIAL: STEEL, A-36 1" THICK BURNED

SCALE: 1/16

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE INCHES & DEGREES

11”

17”

11 11/32”

(4 5/8”)
This part can be fabricated from several pieces.

 Yaz 1/8" inside

Radius edges 1/32 to 1/16 exposed on interior

Part likely to knock heads

Steel, A-36, 3/8 thick

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CARMA 6m Base, Top Ring

Weight: 145.3 lbs

Material: Steel, A-36, 3/8 thick

Finish: Machined surf finish < 125 microinch

Break sharp edges 0.010 rad ± 0.003

Dimensions are inches & degrees

Tolerances: Linear ± angle

Whole & Fraction

Decimal XX

Decimal XXX

± 1/16 ± 0.1 ± 0.01 ± 0.005 ± 0.001°

Scale: Lin

Drawn: M. C. Fleming 2005-01-15

Checked: M. C. Fleming 2005-01-15

REV
DESCRIPTION
ZONE
NAME
DATE
A
RELEASED
M.C.F. 2005-01-15
\( \Phi 62'' \text{ OUTSIDE} \)

\( \Phi 61\frac{1}{2}'' \text{ INSIDE} \)

195 1/4''

7''

FLATTENED VIEW

\( \text{THIS PART CAN BE FABRICATED FROM SEVERAL PIECES} \)

1 REQUIRED PER ASSEM

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University of California - Berkeley
Tel: 510-642-5040    Fax: 510-642-3411

FINISH

WEIGHT: 96.1 lbs

SCALE:

SIZE

CARMA 6m Base, Bottom Ring

MATERIAL

STEEL, A-36, 1/4'' THICK

TOLERANCES:

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE INCHES & DEGREES

WHOLE & FRACTION

DECIMAL XX

DECIMAL XXX

LINEAR X

LINEAR XX

LINEAR XXX

ANGLE ± 1/16 ± 0.1 ± 0.01 ± 0.005

BREAK SHARP EDGES 0.010 RAD 0.003

MACHINED SURF FINISH < 125 MICROINCH

UNLESS OTHERWISE SPECIFIED
RADIUS ALL EDGES 1/32 TO 1/16
TO MAKE ENTRANCEWAY SAFE
SUGGEST FLAP DISK GRINDING

24 3/4" OUTSIDE

12" RAD

36 3/4" OUTSIDE

12"

2.00

5.00

10.00

8"

HINGE SIDE

100 1/2"

LATCH SIDE

2.00

4.00

2.00

3/4" DRILL THRU, 4 PLACES
CAN BE DONE AFTER
WELDED INTO BASE ASSEMBLY

FLATTENED VIEW

1 REQUIRED
PER ASSEM

MATERIAL
STEEL, A-36, 3/8 THICK

FINISH

WEIGHT:
85.3 lbs

SCALE:

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CARMA 6m Base, Door Reinforcement Ring

12345678
8 7 6 5 4 3 2 1

REV.
NAME
DRAWN
CHECRED
DATE
NAME
DATE
REV.
DESCRIP
ZONE
NAME
DATE
A
M.C.F.
2005-01-15

M.C.F. 2005-01-15

MUST FIT
EAST WALL OPENING
MAY WISH TO FIT OPENING
THEN WELD & DRILL.

M.C.F. 2005-01-15

2 HALVES OK

24-09-219    1 of 1

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University of California - Berkeley
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CARMA 6m Base, Door Reinforcement Ring

12345678
8 7 6 5 4 3 2 1

REV.
NAME
DRAWN
CHECKED
DATE
NAME
DATE
REV.
DESCRIP
ZONE
NAME
DATE
A
M.C.F.
2005-01-15

M.C.F. 2005-01-15

2 HALVES OK

24-09-219    1 of 1

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CARMA 6m Base, Door Reinforcement Ring

12345678
8 7 6 5 4 3 2 1

REV.
NAME
DRAWN
CHECKED
DATE
NAME
DATE
REV.
DESCRIP
ZONE
NAME
DATE
A
M.C.F.
2005-01-15

M.C.F. 2005-01-15

2 HALVES OK

24-09-219    1 of 1

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CARMA 6m Base, Door Reinforcement Ring

12345678
8 7 6 5 4 3 2 1

REV.
NAME
DRAWN
CHECKED
DATE
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DATE
REV.
DESCRIP
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NAME
DATE
A
M.C.F.
2005-01-15

M.C.F. 2005-01-15

2 HALVES OK

24-09-219    1 of 1

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CARMA 6m Base, Door Reinforcement Ring

12345678
8 7 6 5 4 3 2 1

REV.
NAME
DRAWN
CHECKED
DATE
NAME
DATE
REV.
DESCRIP
ZONE
NAME
DATE
A
M.C.F.
2005-01-15

M.C.F. 2005-01-15

2 HALVES OK

24-09-219    1 of 1

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CARMA 6m Base, Door Reinforcement Ring

12345678
8 7 6 5 4 3 2 1

REV.
NAME
DRAWN
CHECKED
DATE
NAME
DATE
REV.
DESCRIP
ZONE
NAME
DATE
A
M.C.F.
2005-01-15

M.C.F. 2005-01-15

2 HALVES OK

24-09-219    1 of 1

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CARMA 6m Base, Door Reinforcement Ring

12345678
8 7 6 5 4 3 2 1

REV.
NAME
DRAWN
CHECKED
DATE
NAME
DATE
REV.
DESCRIP
ZONE
NAME
DATE
A
M.C.F.
2005-01-15

M.C.F. 2005-01-15

2 HALVES OK

24-09-219    1 of 1

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CARMA 6m Base, Door Reinforcement Ring

12345678
8 7 6 5 4 3 2 1

REV.
NAME
DRAWN
CHECKED
DATE
NAME
DATE
REV.
DESCRIP
ZONE
NAME
DATE
A
M.C.F.
2005-01-15

M.C.F. 2005-01-15

2 HALVES OK

24-09-219    1 of 1

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2 REQUIRED
PER ASSEM

DIMENSIONS ARE INCHES & DEGREES

TOLERANCES:

NAME DATE
M.C. FLEMING 2005-01-18

BREAK SHARP EDGES 0.010 RAD + 0.003
MACHINED SURF FINISH < 125 MICROINCH

UNLESS OTHERWISE SPECIFIED

MATERIAL: STEEL A-36, 3/8" THICK

WEIGHT: 29.6 lbs

SCALE: 1/16

REV DESCRIPTION ZONE NAME DATE
A RELEASED M.C. 2005-01-18

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CARMA 6m Base,
Floor Stiffener
**DEBURR EDGE EXPOSED TO INTERIOR (ALONG ONE SIDE)**

Radius inboard edge 1/32-1/16 to make interior more friendly.

---

### Material

- **Steel Bar, A-36 or 1018**

### Weight

- **19.5 lbs**

---

### Notes

- 2 REQUIRED PER ASSEM

---

### Drawing Information

- **Name:** M.C. Fleming
- **Date:** 2005-01-19
- **Material:** Steel Bar, A-36 or 1018

---

### Tolerances

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<th>Tolerances</th>
<th>Linear</th>
<th>Angle</th>
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</thead>
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<td>Whole &amp; Fraction</td>
<td>Decimal</td>
<td>X</td>
</tr>
<tr>
<td>Break Sharp Edges</td>
<td>0.010 RAD</td>
<td>&lt; 125 MICROINCH</td>
</tr>
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---

### Drawing Number

- **B 24-09-221 1 of 1\* A**

---

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### Release

- **REVISIONS**
  - **REV:** A
  - **DESCRIPTION:** RELEASED
  - **ZONE:** M.C.F.
  - **NAME:** 2005-01-19

---

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  - **Fax:** 510-642-3411

---

### CARMA 6m Base

- **Gusset, N & S Wall**
RADIUS EXPOSED EDGES 1/32 TO 1/16 ONE SIDE

2" RAD
4 PLACES

2 REQUIRED
PER ASSEM

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CARMA 6m Base, Support Pad

M. C. FLEMING
2005-01-18

WEIGHT: 29.0 lbs

SCALE: X.X
DECIMAL: X.X
MACHINED SURF FINISH < 125 MICROINCH

DIMENSIONS ARE INCHES & DEGREES
TOLERANCES:

WHOLE & FRACTION  DECIMAL   X.X  DECIMAL   X.XX  DECIMAL   X.XXX
1/16  ± 0.1"  1/16  ± 0.01"  1/16  ± 0.005"
1/16  ± 0.01"  1/16  ± 0.005"
1/16  ± 0.005"

BREAK SHARP EDGES 0.010 RAD  + 0.003 MACHINED SURF FINISH ± 125 MICROINCH

UNLESS OTHERWISE SPECIFIED

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NAME DATE
M. C. FLEMING 2005-01-18

Drawing Sheet 1 of 1

24-09-222
3 1/2" DIA OUTSIDE
NOMINAL 3" PIPE

.216 SCH 40

6"

1/32 RAD,
DEBURR EDGES
BOTH ENDS

3 1/2" DIA OUTSIDE
NOMINAL 3" PIPE

3" PIPE, SCH 40, STEEL

2 REQUIRED PER ASSEM

2 REQUIRED PER ASSEM

3.8 lbs

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M. C. FLEMING

2005-01-19

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE INCHES & DEGREES

TOLERANCES:

<table>
<thead>
<tr>
<th>WHOLE &amp; FRACTION</th>
<th>LINEAR (in)</th>
<th>ANGULAR (deg)</th>
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<tbody>
<tr>
<td>1/32</td>
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<td>±1/32</td>
</tr>
<tr>
<td>1/64</td>
<td>±1/64</td>
<td>±1/64</td>
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<tr>
<td>1/128</td>
<td>±1/128</td>
<td>±1/128</td>
</tr>
<tr>
<td>0.01</td>
<td>±0.01</td>
<td>±0.001</td>
</tr>
<tr>
<td>0.005</td>
<td>±0.005</td>
<td>±0.001</td>
</tr>
</tbody>
</table>

MATERIAL
3" PIPE, SCH 40, STEEL

BREAK SHARP EDGES 0.010 RAD  ± 0.003
MACHINED SURF FINISH < 125 MICROINCH

WEIGHT: 3.8 lbs

CARMA 6m Base,
Pass Through Pipe

24-09-223 1 of 1

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9" 13/16" 6" 1 1/2" 3/8" DRILL THRU 2 PLACES

1 1/2" 1/8" 1 1/2" 1 1/2" 1 1/2" 4 REQUIRED PER ASSEM

0.9 lbs ANGLE, STEEL, 1 1/2" X 1 1/2" 4 REQUIRED PER ASSEM

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University of California - Berkeley
Tel: 510-642-5040   Fax: 510-642-3411

CARMA 6m Base, Light Fixture Bracket

CARMA 6m Base, Light Fixture Bracket

CARMA 6m Base, Light Fixture Bracket

CARMA 6m Base, Light Fixture Bracket

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TOLERANCES:
- WHOLE & FRACTION
- DECIMAL X.X
- DECIMAL X.XX
- DECIMAL X.XXX

MATERIAL: ANGLE, STEEL, 1 1/2" X 1 1/2"

FINISH: MACHINED SURF FINISH < 125 MICROINCH

WEIGHT: 0.9 lbs

SCALE:
CARMA 6m Base, Column Tube West

DIMENSIONS ARE INCHES & DEGREES

UNLESS OTHERWISE SPECIFIED

MATERIAL  BOX TUBE, STEEL

BREAK SHARP EDGES 0.000 RAD  \pm 0.003
MACHINED SURF FINISH < 125 MICROINCH

TOLERANCES:

<table>
<thead>
<tr>
<th>NAME</th>
<th>DATE</th>
<th>WHOLE &amp; FRACTION</th>
<th>DECIMAL X.X</th>
<th>DECIMAL X.XX</th>
<th>DECIMAL X.XXX</th>
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<tr>
<td>DRAWN</td>
<td>2004-12-23</td>
<td></td>
<td></td>
<td></td>
<td></td>
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<tr>
<td>CHECKED</td>
<td>M. C. Fleming</td>
<td></td>
<td></td>
<td></td>
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<tr>
<td>WHOLE &amp; FRACTION</td>
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<td>\pm 0.01</td>
<td>\pm 0.005</td>
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<tr>
<td>DECIMAL X.X</td>
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<td>\pm 0.003</td>
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<td></td>
<td></td>
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<tr>
<td>DECIMAL X.XX</td>
<td></td>
<td></td>
<td></td>
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<td></td>
</tr>
</tbody>
</table>

WEIGHT: 144.00 LBS

REV. DESCRIPTION ZONE NAME DATE
A RELEASED M.C.F. 2004-12-23

M. C. FLEMING 2004-12-23

24-09-23 1 of 1 A

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RADIUS EXPOSED EDGES 1/32 TO 1/16 RADIUS
BOTH SIDES EXCEPT EDGE FLUSH TO FLOOR BOTTOM PLATE

THESE DIMENSIONS AND TOLERANCES APPLY UNLESS OTHER WISE SPECIFIED.
DIMENSIONS ARE IN INCHES & DEGREES.

MACHINED SURF FINISH < 125 MICROINCH UNLESS OTHERWISE SPECIFIED.

TOLERANCES:

<table>
<thead>
<tr>
<th>Linear</th>
<th>Angle</th>
</tr>
</thead>
<tbody>
<tr>
<td>± 1/16</td>
<td>± 1°</td>
</tr>
<tr>
<td>± 0.1</td>
<td>± 0.1°</td>
</tr>
<tr>
<td>± 0.01</td>
<td>± 0.01°</td>
</tr>
<tr>
<td>± 0.005</td>
<td>± 0.005°</td>
</tr>
</tbody>
</table>

MATERIAL: STEEL, A-36, 1 1/2" THICK BURNT.

FINISH: BLANCHARD GROUND
TWO SIDES, SEE NOTE

WEIGHT: 296 lbs

DRAWN: M. C. FLEMING 2005-01-15
CHECKED: M. C. FLEMING 2005-01-15

M. C. FLEMING 2005-01-15

CARMA 6m Base, Column Base West

1 REQUIRED PER ASSEM
MATERIAL:
PIPE, STEEL SCHEDULE 80 OR EXTRA HEAVY WALL
4" NOMINAL (4.50 OD) X .337 WALL (3.826 ID)

SECTION A-A
SCALE 1 : 1.5

0.20 X 45° CHAMFER

FACE BOTH ENDS IN LATHE TO CLEAN UP SAW CUT

1 REQUIRED PER ASSEM

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE INCHES & DEGREES
TOLERANCES:
WHOLE & FRACTION: ± 1/16
DECIMAL: ± 0.01
DECIMAL XXX: ± 0.001

BREAK SHARP EDGES 0.010 RAD ± 0.003
MACHINED SURF FINISH < 125 MICROINCH

WEIGHT: 4.0 lbs

RADIO ASTRONOMY LAB
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Tel: 510-642-5040  Fax: 510-642-3411

CARMA 6m Base, Column Extender West

M.C.F. 2005-01-17
2 REQUIRED PER ASSEM

1/2" RAD
4 PLACES

Ø 1 7/64 DRILL THRU
Ø 1 5/16 X 45° COUNTERSINK, BOTH SIDES
TAP 1 1/4-7 THRU, STANDARD TAP
CUSTOMER WILL REF-TAP IN FIELD WITH SPECIAL GH21 TO ACCEPT GALVANIZED BOLT
1/2" CUSTOMER HAS TAP (Matt 925-757-6785)

1.438±.010
BLANCHARD GRIND
BOTH SIDES FROM
1 1/2" STOCK

RADIUS EXPOSED EDGES 1/32 TO 1/16 ONE SIDE

M.C. FLEMING
2005-01-15

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE INCHES & DEGREES

TOLERANCES: LINEAR ANGLE

WHOLE & FRACTION
DECIMAL XX
DECIMAL XXX

BREAK SHARP EDGES 0.010 RAD 0.003
MACHINED SURF FINISH ≤ 125 MICROINCH

MACHINER
24-09-242 1 of 1

CARMA 6m Base,
Column Cap N & S
1.438 ± 0.010
BLANCHARD GRIND
BOTH SIDES FROM
1 1/2" STOACK

RADIUS EXPOSED EDGES 1/32 TO 1/16
BOTH SIDES EXCEPT EDGES FLUSH WITH BOTTOM PLATE

REV.
NAME
DATE
DRAWN
M. C. FLEMING
2005-01-15
CHECKED
MATERIAL
STEEL A-36, 1 1/2" THICK BURNED
FINISH
BLANCHARD GROUND
TOLERANCES:
WHOLES & FRACTIONS:  ± 1/16
DECIMAL:  ± 0.1
DECIMAL:  ± 0.01
DECIMAL:  ± 0.005
BREAK SHARP EDGES 0.010 RAD  ± 0.003
MACHINED SURF FINISH  < 125 MICROINCH
WEIGHT:  25.2 lbs
SCALE:  WHOLE & FRACTION
DECIMAL
DECIMAL
DECIMAL
MACHINED SURF FINISH
< 125 MICROINCH
WEIGHT:
SCALE:
RADIO ASTRONOMY LAB
University of California - Berkeley
Tel: 510-642-5040  Fax: 510-642-3411
CARMA 6m Base, Column Base, N & S
24-09-243  1 of 1
PIPE, STEEL SCHEDULE 40
8" NOMINAL, .322 WALL
28.5 lbs
4 REQUIRED PER BASE ASSEM

CARMA 6m Base,
Arm, Lifting Tube

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M. C. FLEMING
2005-01-15
14.38±.010 BLANCHARD GRIND BOTH SIDES FROM 1 1/2" STOCK

14 11/32" TO SHARP CORNERS

1/2" RAD 2 PLACES

3" DIA BURNED OKAY PLEASE DEBURR

RADIUS EXPOSED EDGES 1/32 TO 1/16 BOTH SIDES EXCEPT BACK EDGES HIDDEN INSIDE LEG

10°

11°

5" RAD

Ø 27/64" DRILL THRU
Ø 532 X 45° C-SINK BOTH SIDES
TAP 1/2-13 THRU, 4 PLACES ON 5.000 DIA BOLT CIRCLE
STUDS TO BE INSERTED FROM BOTTOM SIDE

Ø 4.020±.010 DEBURR

Ø 22"

12 5/16"

4 11/16"

11 21/32"

4 REQUIRED PER BASE ASSEM
RADIUS EDGES 1/32 TO 1/16 TOP & BOTTOM ALONG BOTH SIDE EXPOSED EDGES
FACE IN LATHE TO CLEAN-UP TOP SURFACE AND INSIDE EDGES

0.080 X 45° CHAMFER 2 PLACES

PART SUPPLIED TO STEEL FABRICATOR BY U.C. BERKELEY

STAINLESS 303, 304 OR 18-8

4 REQUIRED PER BASE ASSEM

RADIO ASTRONOMY LAB
University of California - Berkeley
Tel: 510-642-5040 Fax: 510-642-3411

CARMA 6m Base, Leg, Washer

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE INCHES & DEGREES

TOLERANCES: LINEAR ANGLE

<table>
<thead>
<tr>
<th>WHOLE &amp; FRACTION</th>
<th>DECIMAL XX</th>
<th>DECIMAL XXX</th>
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<tr>
<td>WHOLE &amp; FRACTION</td>
<td>± 1/16</td>
<td>± 0.01</td>
</tr>
<tr>
<td>DECIMAL XX</td>
<td>± 0.1</td>
<td>± 0.005</td>
</tr>
<tr>
<td>DECIMAL XXX</td>
<td>± 0.1</td>
<td>± 0.005</td>
</tr>
</tbody>
</table>

MACHINED SURF FINISH < 125 MICROINCH

BREAK SHARP EDGES 0.010 RAD 0.003

FINISH

WEIGHT:

SCALE:

NAME DATE
M. C. FLEMING 2005-01-16

DRAWN CHECKED
M. C. FLEMING

M. C. F. 2005-01-16

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Unless otherwise specified, dimensions are inches & degrees.

Material: Steel 1018, 6" Diameter

Finish: Zinc Plate

Weight: 17.2 lbs

4 EA SAMPLE PARTS TO BE SUPPLIED TO STEEL FABRICATOR BY U. C. BERKELEY

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University of California - Berkeley
Tel: 510-642-5040    Fax: 510-642-3411

M. C. FLEMING 2005-01-16

REVISIONS

REV DESCRIPTION ZONE NAME DATE
A RELEASED M.C.F. 2005-01-16

UNLESS OTHERWISE SPECIFIED

DIMENSIONS ARE INCHES & DEGREES

TOLERANCES:

WHOLE & FRACTION ± 1/32 ± 1°
DECIMAL X.X ± 0.01 ± 0.1°
DECIMAL X.XX ± 0.005 ± 0.01°

BREAK SHARP EDGES 0.010 RAD ± 0.003
MACHINED SURF FINISH ± 125 MICROINCH

LINEAR ANGLE

SCALE: WHOLE & FRACTION
DECIMAL X.X
DECIMAL X.XX
DECIMAL X.XXX

NAME DATE
DRAWN M. C. FLEMING 2005-01-16
CHECKED

4 REQUIRED PER BASE ASSEM

CARMA 6m Base, Leg, Locator Socket 6m

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M. C. FLEMING 2005-01-16

CARMA 6m Base, Leg, Locator Socket 6m

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4 REQUIRED PER BASE ASSEM

SECTION A-A
SCALE 1 : 15

INTERNAL THREAD, 4 1/4-8
MAJOR DIA 4.2500
PITCH DIA 4.1688
MINOR DIA 4.1012

FACE BOTH ENDS IN LATHE

4.250 X 65° CHAMFER 2 PLACES

Diameter: 6.000

Diameter: 4.313

4.250 ± .010

TUBE (HOLLOW BAR), STEEL, 6" DIA X 1.00" WALL 4.6 lbs

PART SUPPLIED TO STEEL FABRICATOR BY U.C. BERKELEY

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M. C. FLEMING  2005-01-17

CARMA 6m Base, Locator Base