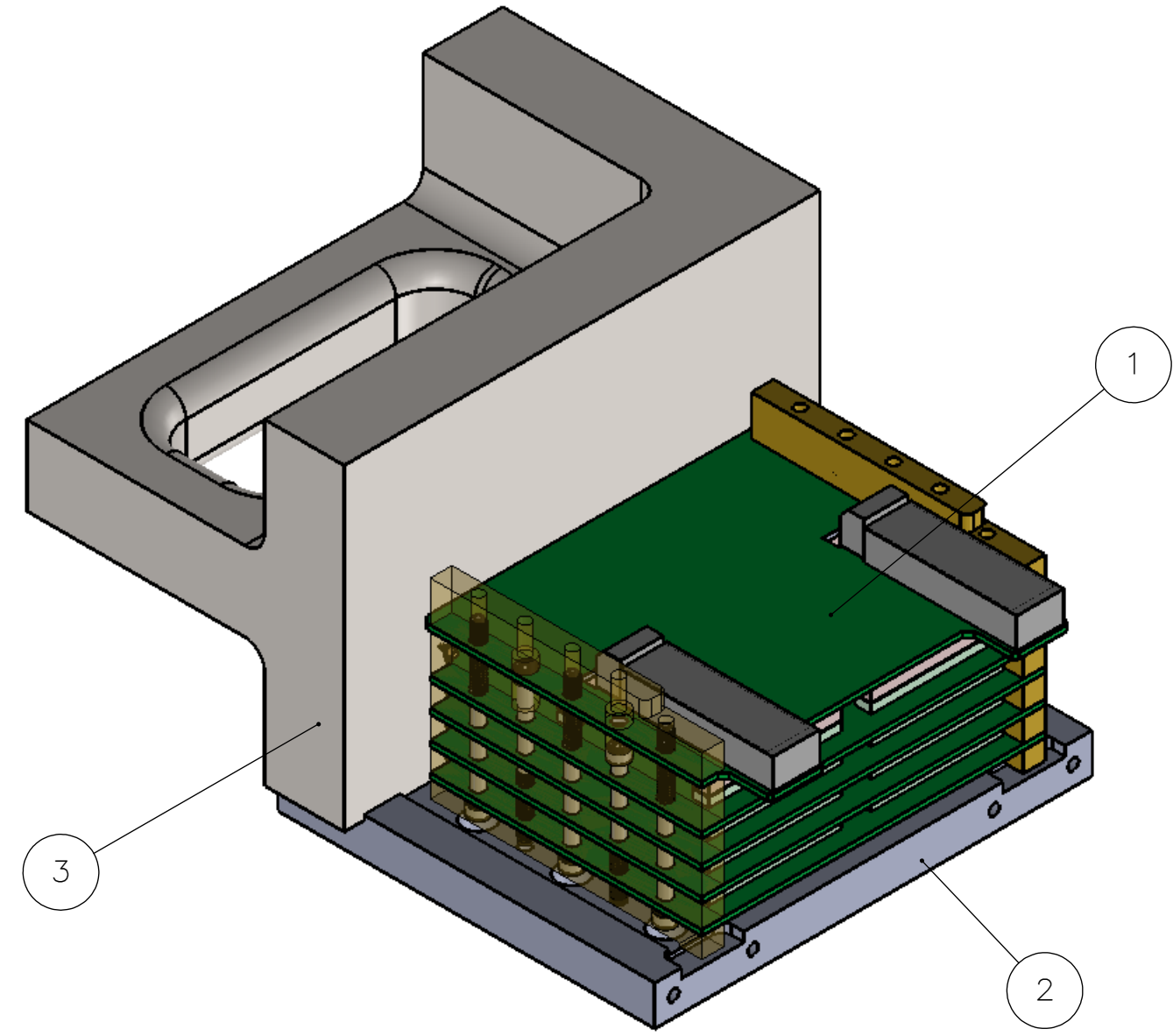


8 7 6 5 4 3 2 1

BILL OF MATERIALS

ITEM NO.	QTY.	TITLE	DESCRIPTION	MATERIAL	VENDOR	PART NUMBER
1	1	BOARD STACK ASSY				
2	1	BOARD STACK ALIGNMENT JIG PLATE	1/2" PLATE	STAINLESS STEEL		
3	1	ANGLE PLATES WITH HANDLE			McMASTER CARR	2244A66



GENERAL NOTES: (UNLESS OTHERWISE SPECIFIED)

1. ALL MATERIALS SHALL BE AS SPECIFIED OR APPROVED EQUAL.
2. DIMENSIONS ARE IN INCHES.
3. TOLERANCES:
 DECIMALS: .X = ±.1 .XX = ±.01 .XXX = ±.005
 ANGLES: X = ±1° .X = ±.02°
 FRACTION X/X = ±1/16
4. ALL MACHINED SURFACES SHALL BE 64 MICRORINCH OR BETTER AND SHALL BE IN ACCORDANCE WITH ANSI 846.1
5. BREAK ALL SHARP EDGES AND REMOVE ALL BURRS.
6. ALL UNSPECIFIED MACHINE TOOL RADII SHALL BE .015 MAX.
7. BILL OF MATERIALS LENGTHS ARE APPROXIMATE PLEASE REVIEW DRAWING BEFORE CUTTING.
8. DRILL HOLES TO NEAREST STANDARD IN OR MM SIZE, UNLESS EXPLICITLY TOLERANCED



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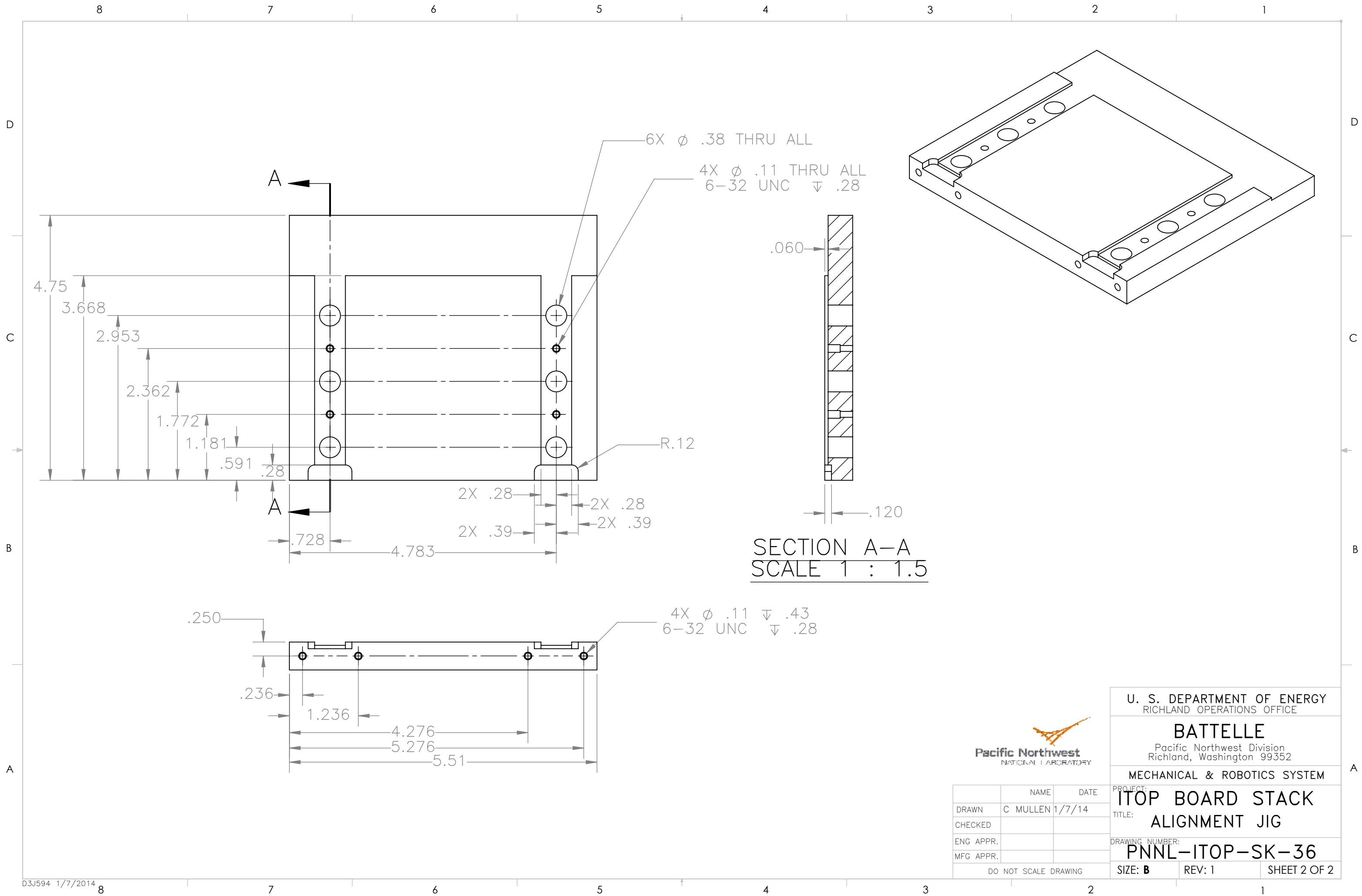
MECHANICAL & ROBOTICS SYSTEM

	NAME	DATE
DRAWN	C MULLEN	1/7/14
CHECKED		
ENG APPR.		
MFG APPR.		

PROJECT: **ITOP BOARD STACK**
 TITLE: **ALIGNMENT JIG**

DRAWING NUMBER: **PNNL-ITOP-SK-36**

DO NOT SCALE DRAWING SIZE: **B** REV: 1 SHEET 1 OF 2



SECTION A-A
SCALE 1 : 1.5



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MECHANICAL & ROBOTICS SYSTEM

PROJECT: **ITOP BOARD STACK**
TITLE: **ALIGNMENT JIG**

DRAWING NUMBER: **PNNL-ITOP-SK-36**

	NAME	DATE
DRAWN	C MULLEN	1/7/14
CHECKED		
ENG APPR.		
MFG APPR.		

SIZE: **B** REV: 1 SHEET 2 OF 2