Matl: Alum. 6061 T651
Part requires multi-step process.
1) Machine all surfaces and holes leaving 0.030inch extra material.
2) Deliver part to Cornell for stress relief process (Liquid Nitrogen cold shock).
3) Machine all surfaces and holes leaving 0.010inch extra material.
4) Deliver part to Cornell for stress relief process (Liquid Nitrogen cold shock).
5) Machine all surfaces and holes to final specifications.

Technical questions, including clarifications and proposals for exceptions, are to be directed to:
Dan Peterson
Senior Physicist, Laboratory for Elementary-Particle Physics, Cornell University
607-255-8784
dpp@lepp.cornell.edu
This sheet shows profile dimensions. "Outside", "Inside", and "profile" views are shown.
Specification for holes in the flange area.

Dowel holes 'B' have tolerance +/- 0.002 inch, within a frame defined by the hole locations B1, B11, B21, B31.
NOTE: This is the Bounding Box.
It is not a part for construction.
It is an abstract geometrical shape, located on the Endplate, within which the module and all mountings for the module are defined.

* This dimensions includes the small, non-zero, offset of the radii of curvature needed to keep the model adaptive.
This shows the locations of seven (7) replications of the Bounding Box on the Endplate.
This shows the details of features that are placed within each Bounding Box.
This sheet shows dowel holes that are defined within the Bounding Box. Global locations are shown here for reference and certification measurements.

Dowel hole locations and cut-out features have tolerance +/- 0.001 inch within the Bounding Box.

Dowel hole locations have tolerance +/- 0.002 within a frame defined by holes B1, B11, B21, B31.
Note: This sheet shows certification measurements. These measurement are locally defined within the Bounding Box.

Dowel hole locations and cut-out features have tolerance +/- 0.001 inch within the Bounding Box. Dowel hole locations have tolerance +/- 0.002 within a frame defined by holes B1, B11, B21, B31.

<table>
<thead>
<tr>
<th>Dimension</th>
<th>Description</th>
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<tbody>
<tr>
<td>2.900 mm</td>
<td>[0.114 in]</td>
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<tr>
<td>6.315 mm</td>
<td>[0.249 in]</td>
</tr>
<tr>
<td>198.045 mm</td>
<td>[7.797 in]</td>
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<tr>
<td>221.153 mm</td>
<td>[8.707 in]</td>
</tr>
<tr>
<td>187.579 mm</td>
<td>[7.390 in]</td>
</tr>
<tr>
<td>5.900 mm</td>
<td>[0.232 in]</td>
</tr>
<tr>
<td>6.000 mm</td>
<td>[0.236 in]</td>
</tr>
</tbody>
</table>

For machining lubricant, use only alkaline detergent lubricant CIMSTAR 40 or equivalent approved by Cornell LEPP.