**MATL: 6061-T651 Alum.**
Machining Process:

1) Cut to +0.030in. Oversize
2) Cold Shock*
3) Cut to +0.010in. Oversize
4) Cold Shock*
5) Cut to final size
6) Dowel holes (4) to be cut to final diameter with a single poit cutter at final cut.

**COLD SHOCK*:**

1) Immerse in liquid nitrogen for 30 minutes
2) Remove
3) Allow to come to room temperature.
4) Dry.
NOTE: This is the Bounding Box.
It is an abstract geometrical shape, within which the module and all mountings for the module are defined.
* These dimensions are from the Bounding Box
This sheet is for Dan Peterson's use only!
NOTE: This sheet shows backframe and dowel dimensions.
NOTE: This sheet shows the threads of holes. These holes can be made in process step 5.

* Mirror Angles on Centerline

SCALE 1:1
Note: This sheet shows the side mount threaded holes. These holes can be made in process step 5.
Note: This sheet shows the pad board locating dowel holes. These holes can be made in process step 5.
NOTE: This Sheet shows certification measurements.
This sheet shows certification measurements.

Part 6080-123 Backframe Jig

Dimensions:
- 279.400 mm (10.000 in) (top outside at horizontal midpoint)
- 27.000 mm (1.063 in) (top inside at horizontal midpoint)
- 211.346 mm (8.321 in) (top outside at horizontal midpoint)
- 196.846 mm (7.750 in) (top inside at horizontal midpoint)
- 29.414 mm (1.158 in) (left outside at vertical midpoint)
- 249.986 mm (9.842 in) (right outside at vertical midpoint)
- 279.400 mm (10.000 in) (top outside at horizontal midpoint)
- 255.094 mm (10.043 in) (top right dowel)
- 242.882 mm (9.562 in) (bottom right dowel)
- 36.518 mm (1.438 in) (top left dowel)
- 254.000 mm (10.000 in) (4.873 in) (bottom left dowel)