MATL: 6061-T651 Alum.
Machining Process:

1) Cut to +0.030 in. Oversize
2) Cold Shock*
3) Cut to +0.010 in. 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 dimension includes the small, non zero, offset of the radii of curvature needed to keep the model adaptable.

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.

Location Tolerance: 0.025mm (0.001 in) True Position
Dowel Hole, Lead hole (Specified depth), 4 PLCs

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OR EQUIVALENT APPROVED BY CORNELL LEPP

DEFINED TOL. FOR DOWEL HOLES E 1/4/2008 DPP
NOTE: This sheet shows the
shows the threaded 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.

Details:
- Location Tolerance: 0.025mm (0.001 in) True Position Dowel Hole.
- Lead hole Ø6 mm, Reamed (Specified depth), 4 PLC's TYP.
- Dowel Hole, Lead hole Ø6 mm, Reamed (Specified depth), 4 PLC's TYP.

Dimensions:
- R1599.500 mm 62.9724 in
- R1598.500 mm 62.9331 in
- R1431.500 mm 56.3583 in
- R1430.500 mm 56.3189 in
- 1.000 mm 0.0394 in
- 1.000 mm 0.0394 in
- Location Tolerance: 0.025mm (0.001 in) True Position Dowel Hole.
- Lead hole Ø6 mm, Reamed (Specified depth), 4 PLC's TYP.

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Technical Resource Approvals Required Before Fabrication:
- MDS Peterson 1/4/2008
- 6080-104 3GEMG backframe & assmb. jig
NOTE: Part # 6080-123 Assembly Jig
Certification measurements
NOTE: This Sheet shows certification measurements for the dowel holes.
NOTE: This Sheet shows certification measurements for surfaces, in the "x" dimension.

TABLE OF MEASUREMENTS
CAUTION: Values listed in the table are entered manually; They are not driven by the model.

<table>
<thead>
<tr>
<th>NUMBER</th>
<th>SET Y</th>
<th>MEASURE X OBSERVED</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>2.5979</td>
<td>-0.7576 0.3984</td>
</tr>
<tr>
<td>2</td>
<td>0.0000</td>
<td>0.3984</td>
</tr>
<tr>
<td>3</td>
<td>2.5603</td>
<td>0.6417</td>
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<tr>
<td>4</td>
<td>5.1831</td>
<td>0.8340</td>
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<tr>
<td>5</td>
<td>2.5979</td>
<td>-7.4726 -7.7989</td>
</tr>
<tr>
<td>6</td>
<td>0.0000</td>
<td>-7.8545</td>
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<tr>
<td>7</td>
<td>2.5603</td>
<td>-8.0422</td>
</tr>
<tr>
<td>8</td>
<td>5.1831</td>
<td>-8.2345</td>
</tr>
</tbody>
</table>

TABLE OF MEASUREMENTS

| CAUTION: Values listed in the table are entered manually; They are not driven by the model. |
NOTE: This Sheet shows certification measurements for surfaces, in the "y" dimension.

TABLE OF MEASUREMENTS

CAUTION: Values listed in the table are entered manually; They are not driven by the model.

<table>
<thead>
<tr>
<th>Number</th>
<th>Set X</th>
<th>Measure Y</th>
<th>Observed</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>-3.7003 mm</td>
<td>-0.0373 in</td>
<td>93.987 mm</td>
</tr>
<tr>
<td>2</td>
<td>-3.7003 mm</td>
<td>-0.6082 in</td>
<td>15.449 mm</td>
</tr>
<tr>
<td>3</td>
<td>-3.7003 mm</td>
<td>5.4745 in</td>
<td>139.052 mm</td>
</tr>
<tr>
<td>4</td>
<td>-3.7003 mm</td>
<td>6.0454 in</td>
<td>153.552 mm</td>
</tr>
</tbody>
</table>

CAUTION: Values listed in the table are entered manually; They are not driven by the model.

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MACHINIST PET: 6080-104 3GEMG Backframe & Assmb. Jig
This sheet shows certification measurements.

Part 6080-123 Backframe Jig

Backframe 6080-104

Mounting Bracket 6080-110

SECTION MM-MM
SCALE 1:1

279.400 mm
11.0000 in
MM

139.700 mm
5.5000 in

24.306 mm
0.9569 in
(Top left dowel)

29.414 mm
1.1580 in
(Left outside at horizontal midpoint)

36.518 mm
1.4377 in

43.883 mm
1.7277 in
(Bottom left dowel)

1.7277 in
(Left inside at vertical midpoint)

9.2723 in
(Right inside at vertical midpoint)

242.882 mm
9.5623 in
(Bottom right dowel)

249.986 mm
9.8420 in
(Right outside at vertical midpoint)

255.094 mm
10.0431 in
(Top right dowel)