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 point 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.

27,000 mm SEE TABLE
1.0630 in

232.930 mm REF
9.1705 in
Chord Length
Backframe

63.000mm ▼ Tolerances
Dowel Holes

208.213 mm REF
8.1974 in
Chord Length
Backframe

SECTION AA-AA
SCALE 1:1

SCALE 1:1

SCALE 2:1
NOTE: This is the Bounding Box. It is an abstract geometrical shape, within which the module and all mountings for the module are defined.

* NOTE: THIS DIMENSION INCLUDES THE SMALL, NON ZERO, OFFSET OF THE RADII OF CURVATURE NEEDED TO KEEP THE MODEL ADAPTABLE.
* These dimensions are from the Bounding Box
This sheet is for Dan Peterson's use only!
NOTE: This sheet shows backframe dimensions and locating dowel specifications.
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.

LOCATION TOLERANCE: 0.025 mm (0.001 in) True Position Dowel Hole, Lead hole 6.5 mm, Reamed (Specified depth), 4 PLCs TYP

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
1.000 mm 0.0394 in
1.000 mm 0.0394 in

DEFINITE TOL. FOR DOWEL HOLES E 1/4/2008 DPP

FOR MACHINING LUBRICANT USE ONLY
ALKALINE DETERGENT LUBRICANT CIMSTAR 40
OR EQUIVALENT APPROVED BY CORNELL LEPP

3GEMG Backframe & Assemb. Jig

3GEMG Backframe & Assemb. 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.
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.

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SCALE 2 : 1
This sheet shows certification measurements.