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 dimensions and locating dowel specifications.

SECTION DD-DD
SCALE 1:1

DETAIL CC
SCALE 2:1

Radii

DETAIL EE
SCALE 2:1

O-Ring Groove

SECTION DD-DD
SCALE 1:1

O-Ring Groove

O-Ring Groove

O-Ring Groove

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

NOTE: This sheet shows backframe dimensions and locating dowel specifications.
NOTE: This sheet shows the threading holes. These holes can be made in process step 5.

** Mirror Angles on Centerline

SCALE 1:1

FOR MACHINING LUBRICATION: USE ONLY ALKALINE DETERGENT. LUBRICANT OILSTAR 40 or equivalent approved by CORNELL LEPP

M3 x 0.5 - 6H \( \times \) 6.000 mm

TYP 30 PLCs

<table>
<thead>
<tr>
<th>Item</th>
<th>Description</th>
<th>Rev.</th>
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<tbody>
<tr>
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<td></td>
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- Dimensions in millimeters (mm) and inches (in)
- Tolerances: ±0.005 in, ±0.010 in
- Friction: 1/64 in
- Angles: ±0.5°, ±1.647°, ±2.471°, ±3.295°, ±1.683°, ±2.524°, ±3.366°

CORNELL UNIVERSITY
Floyd R. Newman Laboratory
Ithaca, NY 14853

Machining Facility:
- Machine Shop (Kaminski)
- Chemistry (Conklin)
- Electronics Shop (Barley)
- Furnace Brazing (Sherwood)
- Beam Welding (Sears)
- Welding Other (Gallagher)
- Utilities Integration (Gallagher)
- Stockrooms (Lockwood)
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: 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.
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.
This sheet shows certification measurements.