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.

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

172.794 mm
6.8029 in

232.930 mm REF
9.1705 in
Chord Length
Backframe

208.213 mm REF
8.1974 in
Chord Length
Backframe

27.000 mm SEE TABLE
1.0630 in

1/64
0.00625
0.0005
0.001

0.5

63
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 RADIUS 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.

- SCALE 1:2
* 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 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.
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 (Values are in inches)
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 (Values are in inches)

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