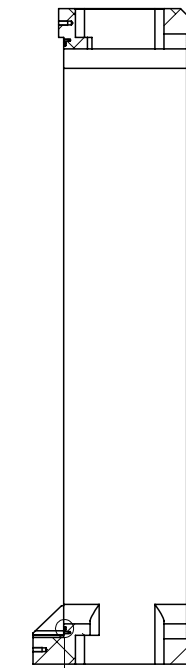
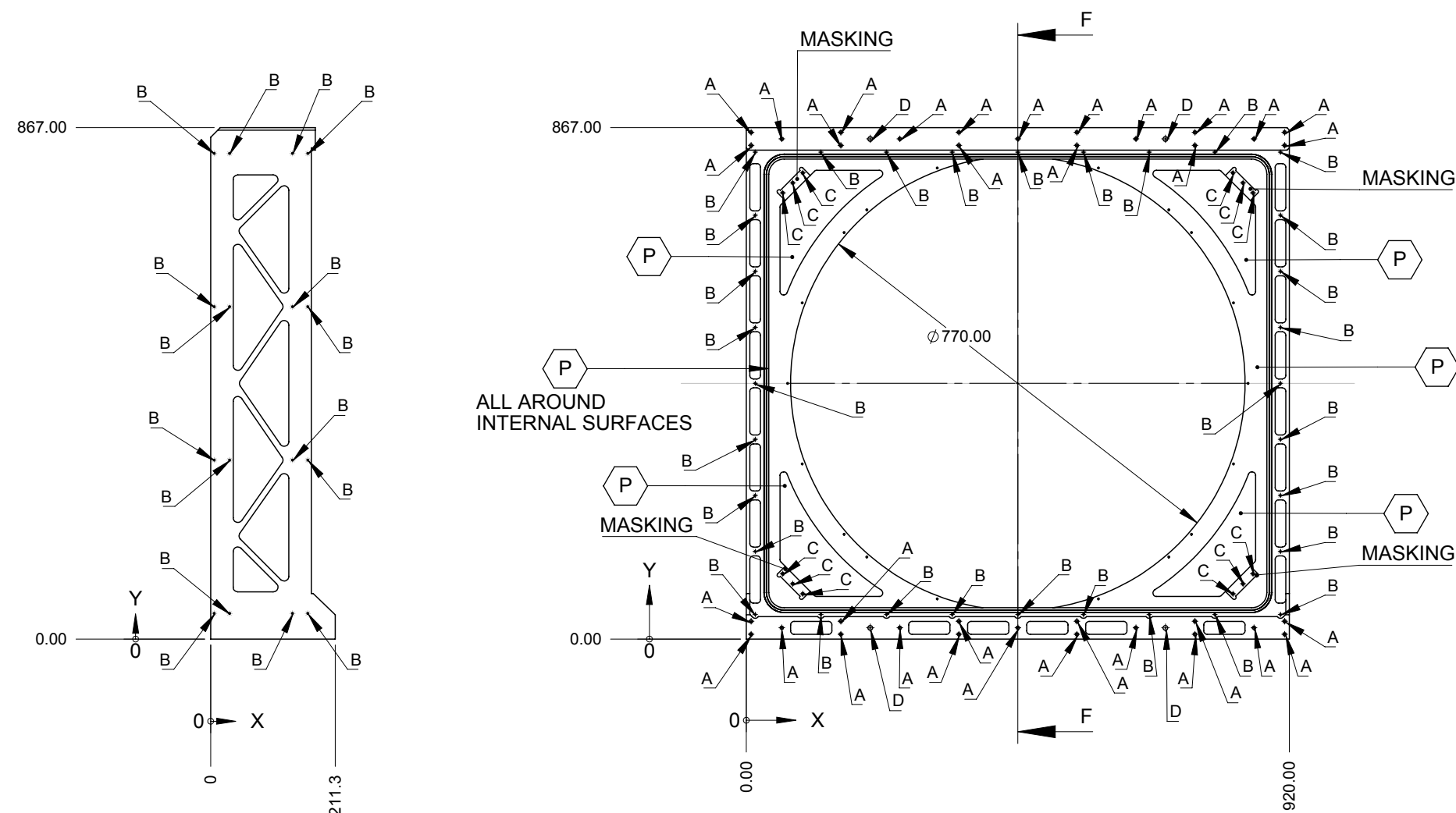
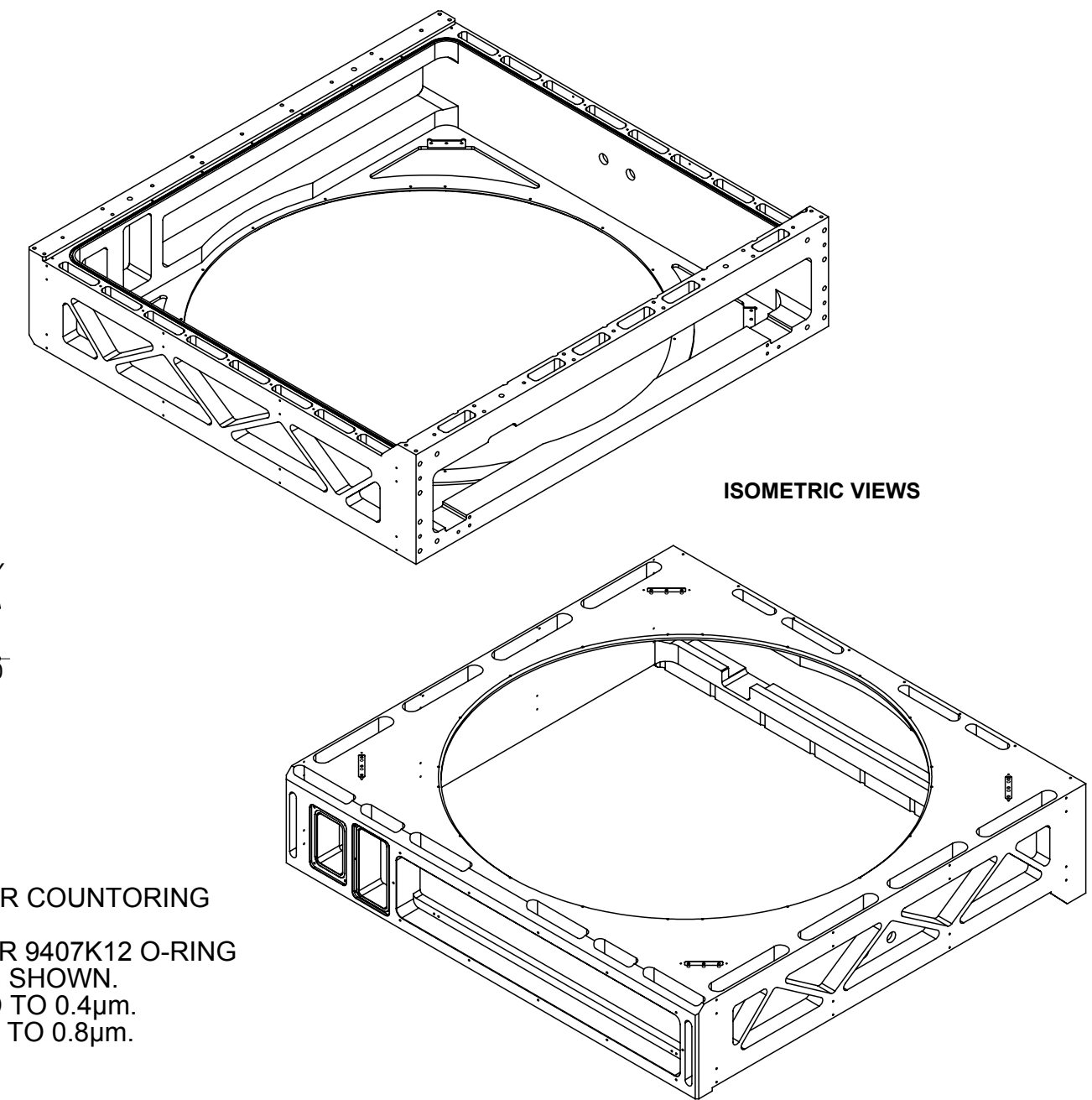
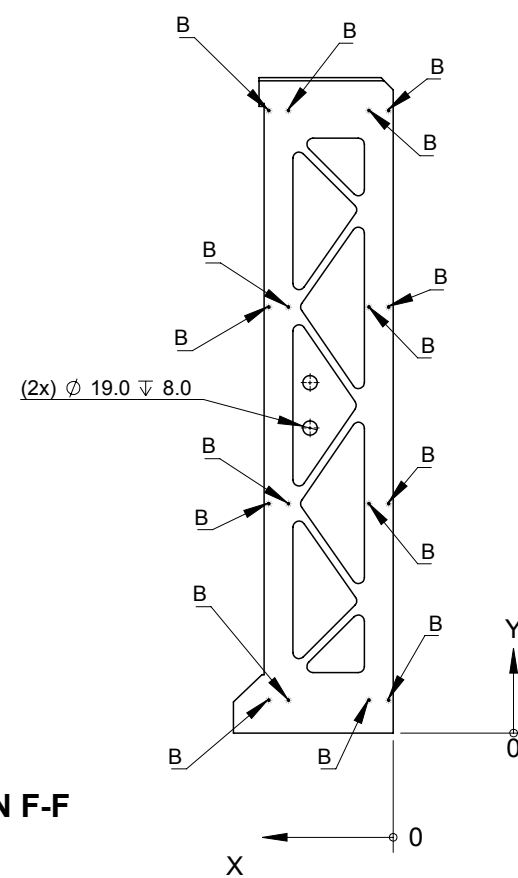


REVIEW	ZONE	DESCRIPTION	DRAWIN	RESPONSIBLE	DATE	SIGN
00		FIRST ISSUE	F.LOURENÇO	F.SANTORO	OCT/2014	

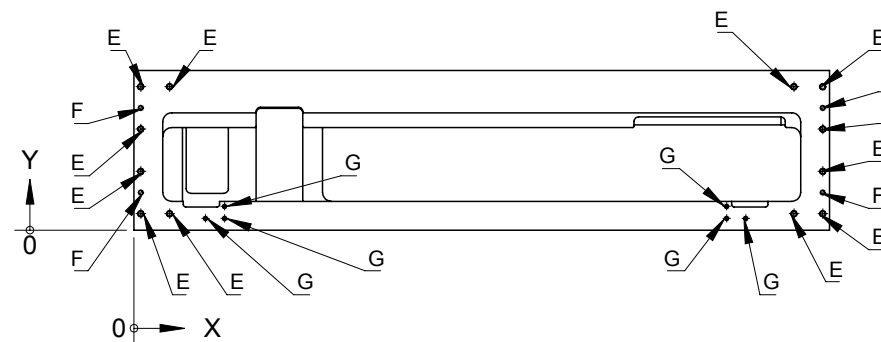


SECTION F-F

ALL AROUND  
INTERNAL SURFACES

MASKING

MASKING

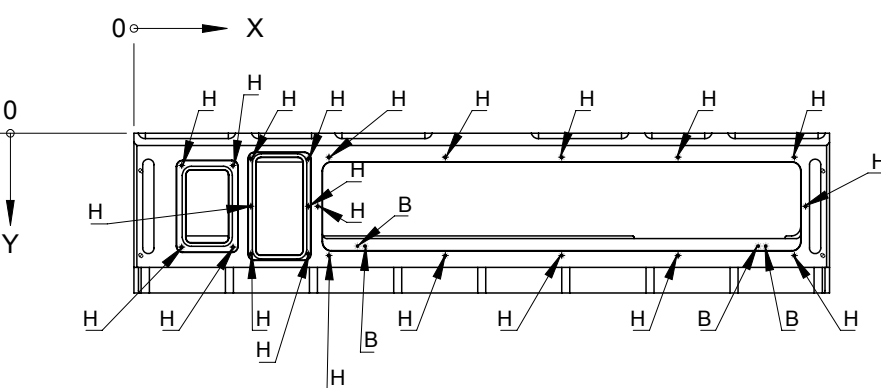
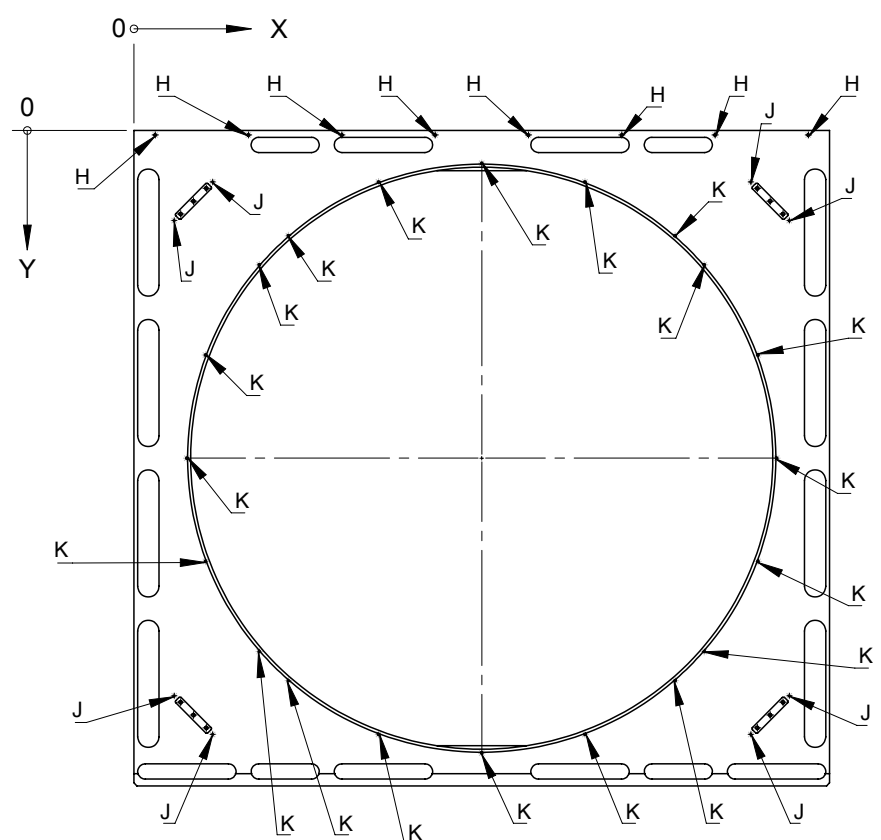
DETAIL G  
SCALE 1 : 1

(Ø 3.2)

- REFER TO 3D-CAD MODEL FOR COUNTORING OF O-RING GROOVE.
- GROOVE FOR MCMMASTER-CAR 9407K12 O-RING SEAL 0.125in (SOFT VITON) AS SHOWN.
- BOTTOM SURFACE POLISHED TO 0.4µm.
- OTHER SURFACES POLISHED TO 0.8µm.

## NOTES:

- THIS PART TO BE FABRICATED USING CNC MACHINING TECHNIQUES. USE WIRE-EDM FOR MAJOR CUTS TO REDUCE BUILD UP STRESSES. LET THE PART REST BETWEEN MILLING MACHINE CUTS.
- REFER TO THE SOLID MODEL PART FILE FOR GEOMETRY AND HOLE LOCATIONS.
- REFER TO THIS DRAWING FOR HOLE CALLOUTS, SURFACE FINISHES, PROCESSES AND TOLERANCES.
- DIMENSIONS NOT SHOWN SHALL BE TAKEN FROM THE 3D SOLID MODEL.
- GEOMETRIC TOLERANCES:
  - ALL SURFACES ARE ASSUMED TO HAVE A PROFILE TOLERANCE OF  $\sqrt{0.13}$  UNLESS OTHERWISE SPECIFIED ON DRAWING FACE.
  - LOCATING DIMENSIONS OF FEATURES HAVING GEOMETRIC TOLERANCES INDICATED ARE ASSUMED TO BE BASIC.
  - HOLE FEATURES WITH NO POSITIONAL TOLERANCE INDICATED SHALL HAVE A POSITIONAL TOLERANCE OF  $\sqrt{0.13(M)}$  WITH RESPECT TO DATUMS IMPLIED BY PART GEOMETRY. RESPECT TO DATUMS IMPLIED BY PART GEOMETRY.
- PAINT ALL INTERNAL SURFACES MARKED "P" WITH LORD ADHESIVES AEROGLAZE® Z306 ABSORPTIVE POLYURETHANE (FLAT BLACK). AFTER PAINTING, REMOVE MASKING TAPE IF APPLICABLE AND LET CURE AT ROOM TEMPERATURE FOR 24 HOURS.
- PRIOR TO MASKING, CLEAN ALL GREASE, OIL, AND DEBRIS FROM ALL SURFACES INCLUDING THREADED HOLES. WASHING WITH SOAP AND WATER FOLLOWED BY SOLVENT SUCH AS ACETONE OR ETHANOL IS RECOMMENDED.
- MASK OR PLUG ALL THREADED HOLES, CLEARANCE HOLES FOR FASTENERS AND COUNTERBORES PRIOR TO PAINTING. THESE SURFACES TO REMAIN UNPAINTED. MASK OTHER SURFACES AS INDICATED ON DRAWING.



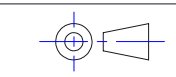
LABEL	SIZE	QUANTITY
A	Ø 5.0 ± 17.0 - M6x1.0 ± 12.0	34
B	Ø 2.5 ± 8.5 - M3x0.5 ± 6.0	68
C	Ø 4.2 ± 8.0 - M5x0.8 ± 7.0	12
D	Ø 8.0 ± 10.0	3
E	Ø 6.8 ± 22.3 - M8x1.25 ± 16.0	12
F	Ø 6.0 ± 8.0 LIGHT PRESS FIT WITH M6 DOWEL PIN	4
G	Ø 4.2 ± 14.0 - M5x0.8 ± 10.0	6
H	Ø 2.5 ± 8.5 - M3x0.5 ± 6.0	30
J	Ø 1.6 ± 5.0 - M2x0.4 ± 4.0	8
K	Ø 2.5 THRU ALL - M3x0.5	20

ASTRO

SYSTEM/SUB-SYSTEM:

OAJ T250

JPCam



DIMENSIONS: mm

SIZE: A2

SCALE: 1:10

TOLERANCES UNLESS OTHERWISE NOTED: DIN 7168-4/R

- NOTES: UNLESS OTHERWISE NOTED
- DIMENSION LIMITS AFTER PLATING
  - DIMENSIONS ARE IN MILLIMETERS (mm)
  - REMOVE AL BURRS AND SHARP EDGES

MATERIAL/SIZE:

AL 6061-T6  
PLATE 9" x 950 x 900mm

TITLE:

FSU STRUCTURAL SUPPORT FRAME

CHECKED: F.SANTORO

SIGN: OCT/2014

DESIGNED: F.SANTORO

SIGN: OCT/2014

DRAWIN: F.LOURENÇO

SIGN: OCT/2014

SURFACE RUGHNESS:

3.2

PLATING:

BLACK HARD ANODIZING

HEAT TREATMENT:

N/A

REVIEWS: 00

QTY.: 01

DENSITY: 2700

[kg/m³] MASS: 35.6kg

MEDIA FILE:

JPC-500-DWG-0202

SHEET: 01/01