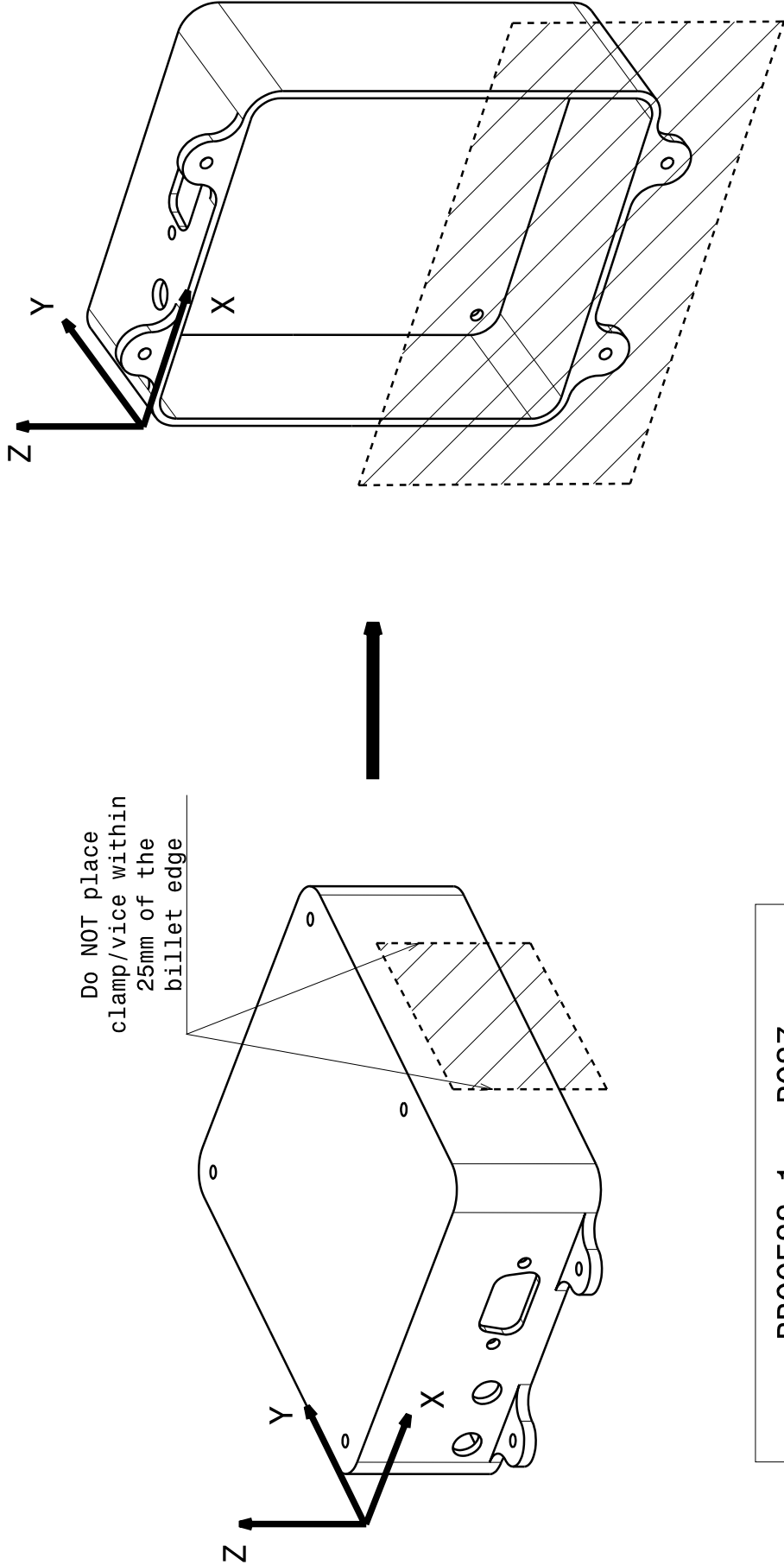
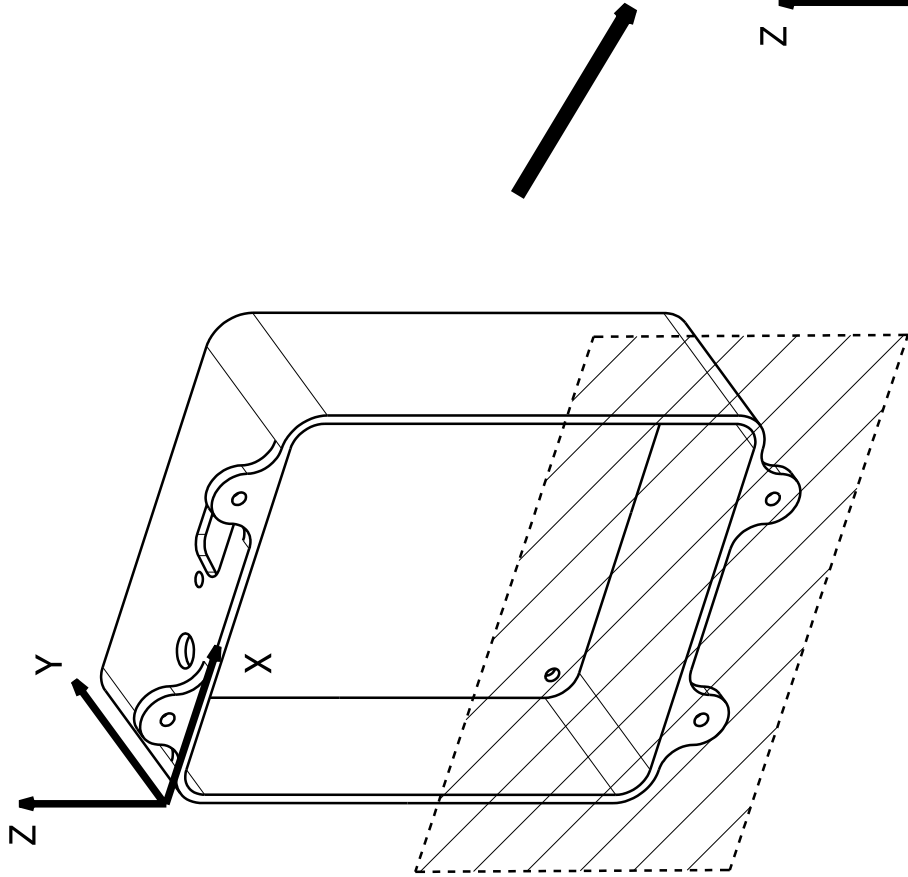


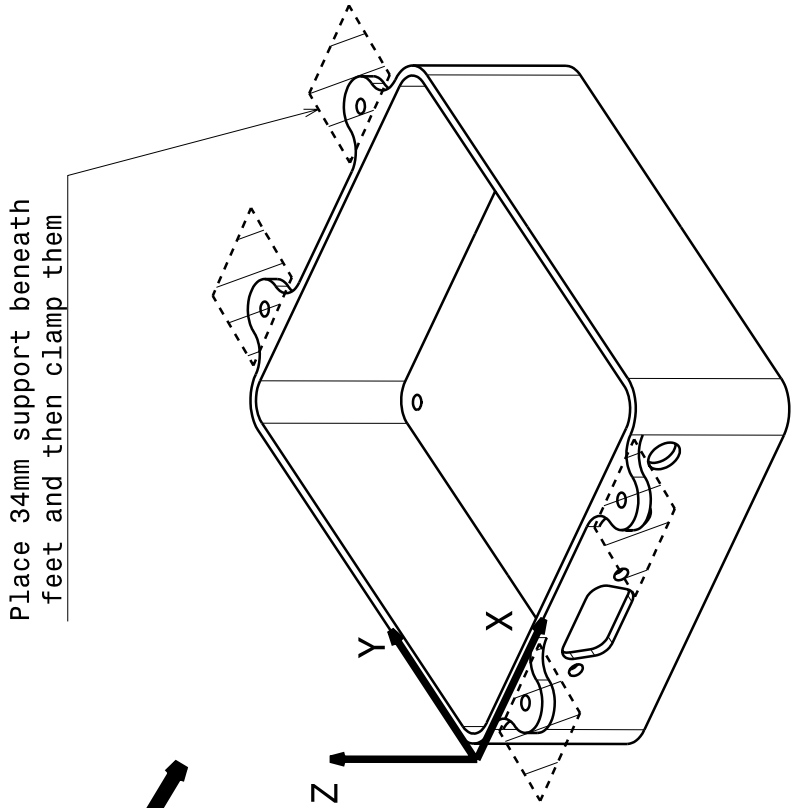
NO.	REVISION	DATE	APP.



PROCESS 1 - POSZ
(WARNING: CODE IS DIFFERENT
FOR ALL 4 HOUSINGS!)




PROCESS 2 - POSX



PROCESS 3 - NEGZ

- NOTES: 1) The name of each process refers to the face of the housing being machined
2) The machining axes for process 1 have been placed at the outer corner of the stock material. However, for processes 2 and 3, the machining axes have been placed on the +X surface with the D-connector holes (ie they are NOT measured from the outer radii of the housing feet)
3) The machining axes align the Z-axis with the tool axis, and the X-axis along the longest dimension for the process face. Note the location of the D-connectors when positioning for each of the processes
4) Processes 1 and 2 use a vice grip vice grip to hold the material. Process 3 uses clamps over the feet, but these feet MUST be supported by additional material so as to not shear them off during machining

ALL DIMENSIONS ARE IN MM		TITLE	
TOLERANCES (UNLESS OTHERWISE SPECIFIED): DIMENSIONS = ± 0.025 ANGLES = $\pm 1^\circ$			
CATIA DRAWING - TO BE MANUFACTURED USING CNC MILL, NOT MANUALLY USE SYMMETRY TO CALCULATE DIMENSIONS		DRAWN <i>Christopher Hale</i>	DATE 23/5/2008
		MATERIAL Aluminium 6061-T6	WEIGHT ---
		SIZE A3	DWG. NO. MECH-0206-23May08
		SCALE - : -	RELEASED 23/05/2008
			REV. 1.0
			SHEET 2/2
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MACHINING INFO FOR RX AND TX HOUSINGS