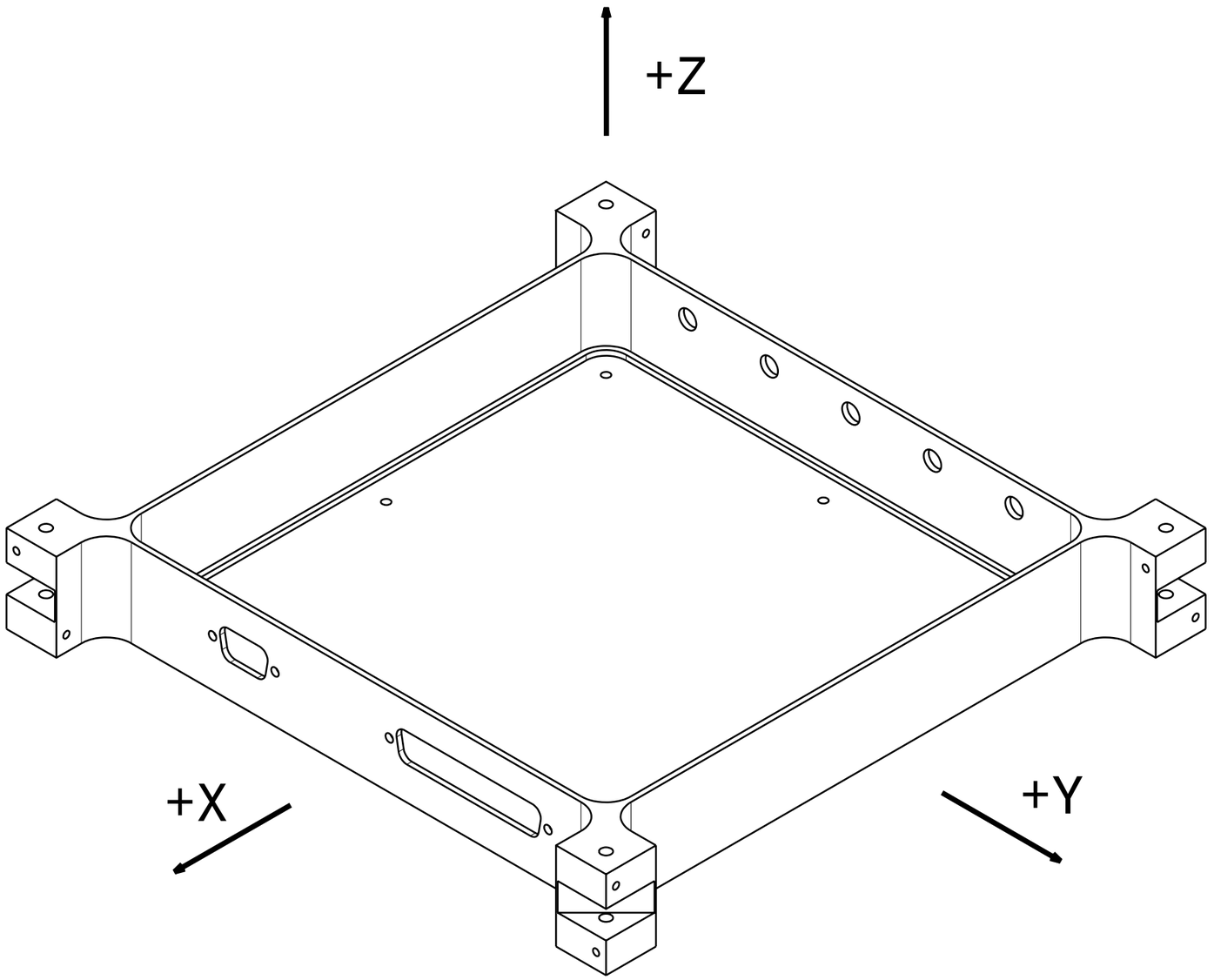
NO.	REVISION	DATE	APP.



NOTES: 1) The tray on the left is representative of the general layout of all trays T1-T5, with D-connectors on the +X face, the upright tray pointing in the +Z direction, and the +Y axis forming a right-handed co-ordinate system.

2) The tools to be used are:

T1 = End Mill D20
T2 = Ball Nose End Mill D12
T3 = End Mill D10
T4 = Center Drill D2
T5 = Drill D2.5
T6 = Drill D3.1
T7 = Drill D10
T8 = End Mill D4
T9 = Drill D7
T10 = End Mill D12
T11 = Drill D3
T12 = Drill D4 (long series)
T13 = Drill D8
T14 = End Mill D2
T15 = Conical Mill D0.1
T16 = Drill D8.75
T17 = Ball Nose End Mill D8

ALL DIMENSIONS ARE IN MM

TOLERANCES (UNLESS OTHERWISE SPECIFIED):
DIMENSIONS = ±.025
ANGLES = ±1°

CATIA DRAWING - TO BE MANUFACTURED USING CNC MILL, NOT MANUALLY
USE SYMMETRY TO CALCULATE DIMENSIONS

ULSSD BLUESAT UNSW STUDENT SATELLITE PROJECT

All dimensions are in mm

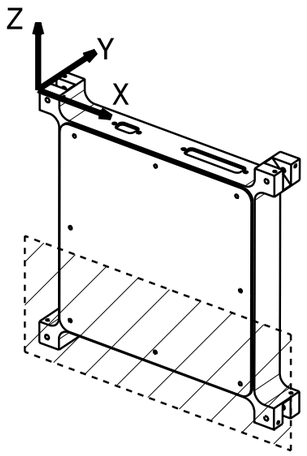
DRAWN	DATE
Christopher Hale	9/5/2008
MATERIAL: Aluminium 6061-T6	WEIGHT: ---

TITLE

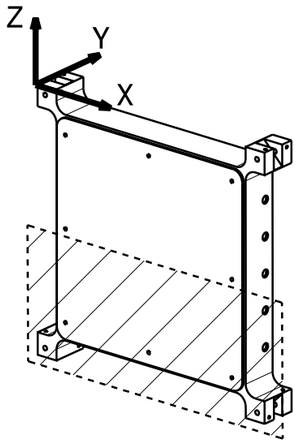
MACHINING INFO FOR TRAYS T1-T5

SIZE	DWG. NO.	REV.
A3	MECH-0205-23May08	1.0
SCALE ---	RELEASED 09/05/2008	SHEET 1/2

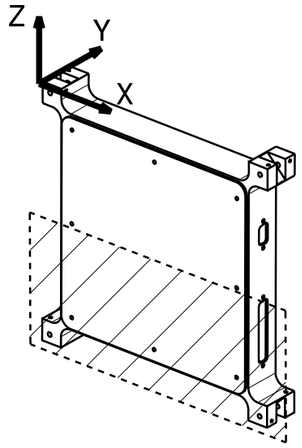
NO.	REVISION	DATE	APP.



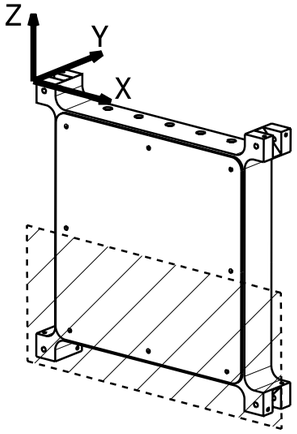
PROCESS 1 - POSX



PROCESS 2 - POSY

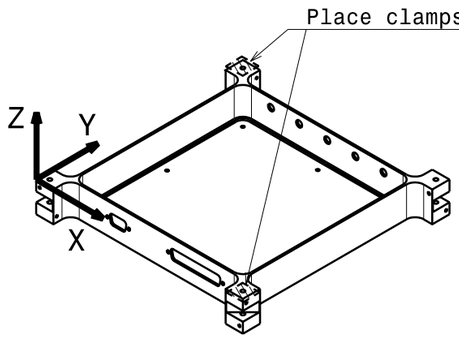


PROCESS 3 - NEGY

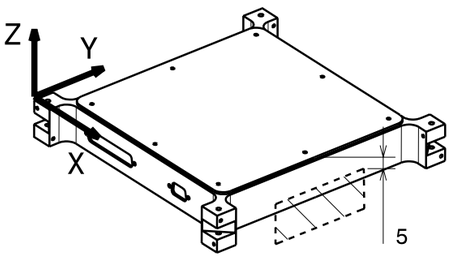


PROCESS 4 - NEGX

NOTES:
1) The name of each process refers to the face of the tray being machined
2) The machining axes for each process, as shown, have been placed according to the original stock material. ALWAYS use the outermost dimensions for setting up the machining axes
3) The machining axes align the Z-axis with the tool axis, and the X-axis along the longest dimension for the process face. Also note the location of the D-connectors when positioning for processes 5 and 6
4) All but process 6 use a vice grip to hold the stock material. The shaded areas indicate the placement for one side of this symmetric clamp. For process 6, small clamps should be used to hold down the corners of the tray



PROCESS 6 - POSZ



PROCESS 5 - NEGZ

ALL DIMENSIONS ARE IN MM

TOLERANCES (UNLESS OTHERWISE SPECIFIED):
DIMENSIONS = ±.025
ANGLES = ±1°

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USE SYMMETRY TO CALCULATE DIMENSIONS

ULSSD BLUESAT UNSW STUDENT SATELLITE PROJECT

All dimensions are in mm

DRAWN: Christopher Hale
DATE: 9/5/2008
MATERIAL: Aluminium 6061-T6
WEIGHT: ---

TITLE

MACHINING INFO FOR TRAYS T1-T5

SIZE: A3
DWG. NO.: MECH-0205-23May08
REV.: 1.0
SCALE: ---
RELEASED: 09/05/2008
SHEET: 2/2