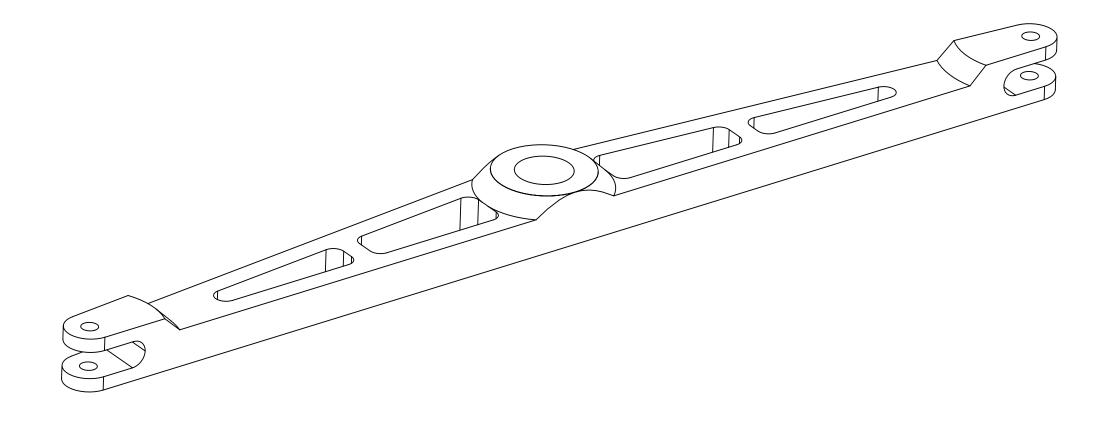
REVISIONS								
REV.	DESCRIPTION	DATE	APPR.					
1	INITIAL RELEASE	2023-03-14						

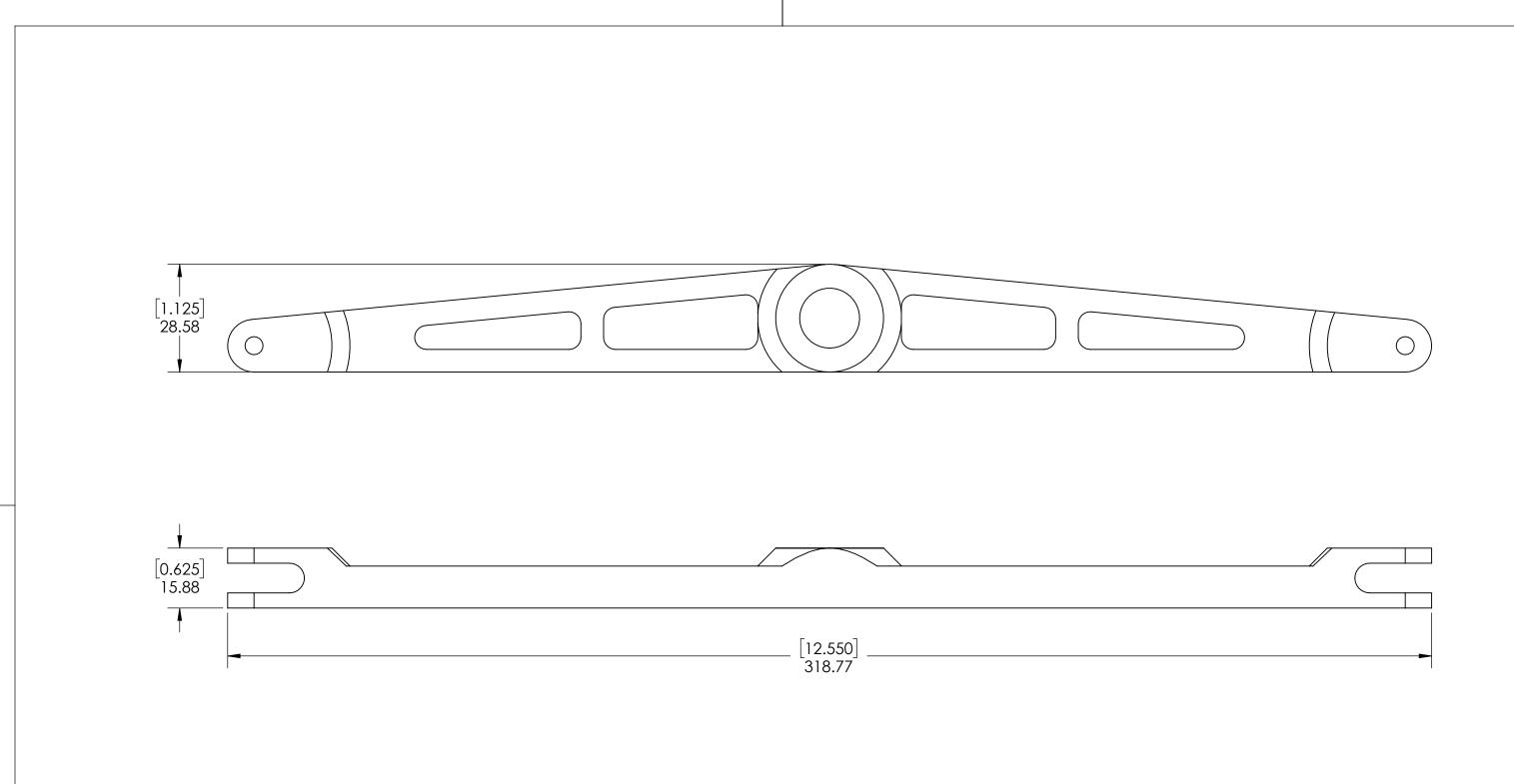


NOTE:

THIS PART IS INTENTED AS A TRIAL RUN ON THE MILL TO TEST SET-UP OPERATIONS.

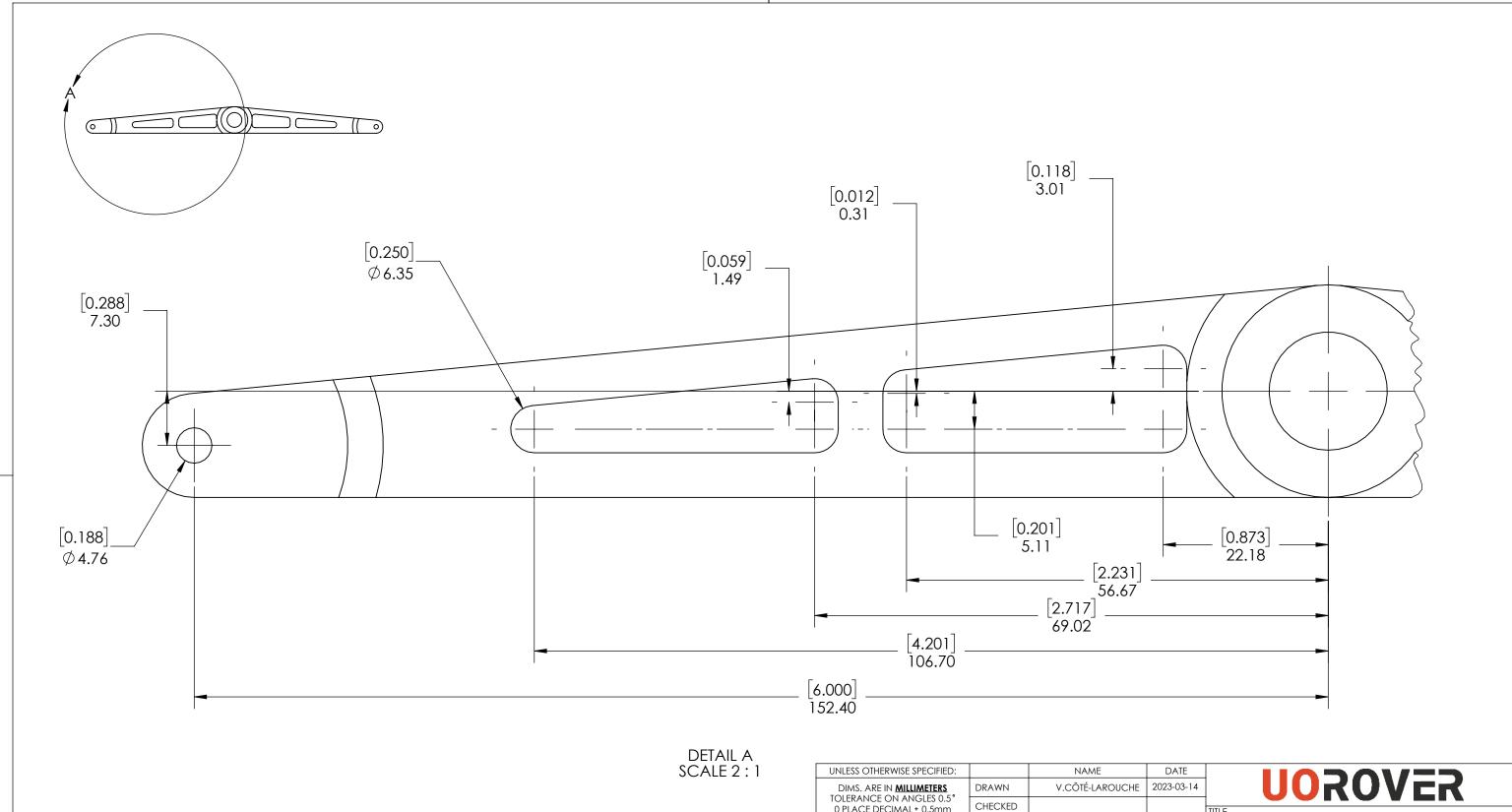
DO NOT USE ON THE ROVER.

	UNLESS OTHERWISE SPECIFIED:		NAME	DATE			2201/-		
	DIMS. ARE IN MILLIMETERS	DRAWN	V.CÔTÉ-LAROUCHE	2023-03-14		U	DROVE	:K	
	TOLERANCE ON ANGLES 0.5° 0 PLACE DECIMAL ± 0.5mm	CHECKED			TITLE				
	1 PLACE DECIMAL ± 0.25mm 2 PLACE DECIMAL ± 0.13mm	MFG APPR.							
	BREAK ALL SHARP EDGES .2550mm	Q.A.			<u> </u>	TFCT	SWING A	ΔRΛ	Λ
	INTERPRET THIS DRAWING IN ACCORDANCE WITH: ASME Y14.5-2018	MATERIAL A	LUMINUM 6061				34411407	XIX/V	1
		MATL. SPEC.	SURFACE TEXTURE	/	SIZE	DWG. NO.			REV
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									VER. 1: 2021/04/03



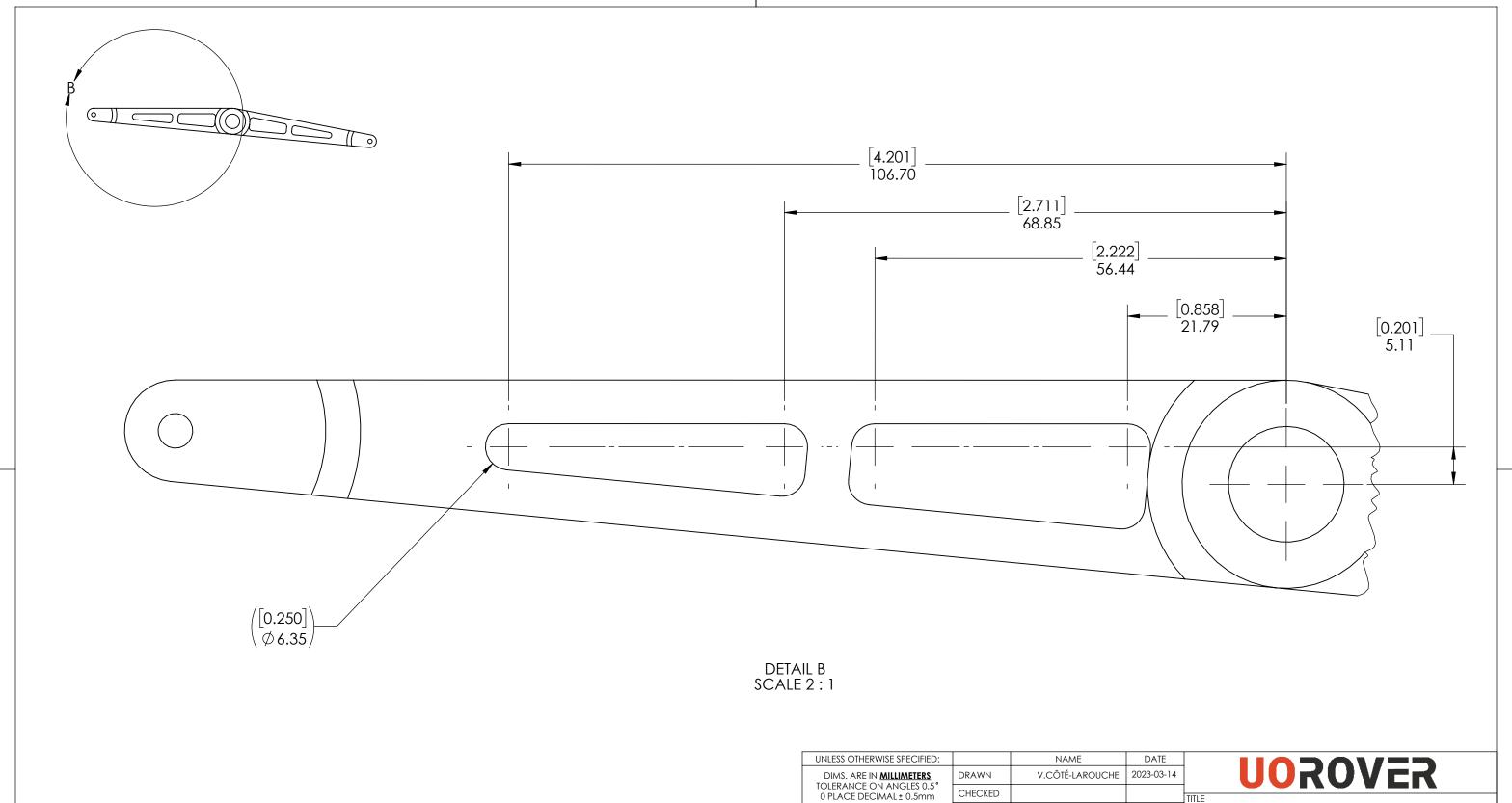
SET-UP 1:	
1. FACE BILLET TO CORRECT DIMENSIONS,	ADDING 0.010" ON BOTH SIDE FACES.

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DIMS. ARE IN MILLIMETERS TOLEPANCE ON ANGLES 0.5°  DRAWN  V.CÔTÉ-LAROUCHE  2023-03-14	ĸ
0 PLACE DECIMAL± 0.5mm CHECKED TITLE	
1 PLACE DECIMAL ± 0.25mm 2 PLACE DECIMAL ± 0.13mm MFG APPR.	
BREAK ALL SHARP EDGES .2550mm Q.A. TEST SWING A	P / /
INTERPRET THIS DRAWING IN ACCORDANCE WITH: ASME Y14.5-2018  ALUMINUM 6061	.1\/\
MATL. SPEC. SURFACE TEXTURE SIZE DWG. NO.	REV
<b>B</b> UOR23-CNS-4-P-005	\/1   <b>1</b>
HEAT TREAT D UOR23-CIN3-4-P-005_	_VI  I
DO NOT SCALE DRAWING FINISH SCALE: 1:1 WEIGHT: [g] SI	SHEET 2 OF 8



SET-UP 2:
1. USE OVERSIZED 3/16" REAMER FOR CENTRAL PIVOT AND END HOLES
2. USE .25" ENDMILL TO HOLLOW OUT POCKETS IN X-Y DIRECTION

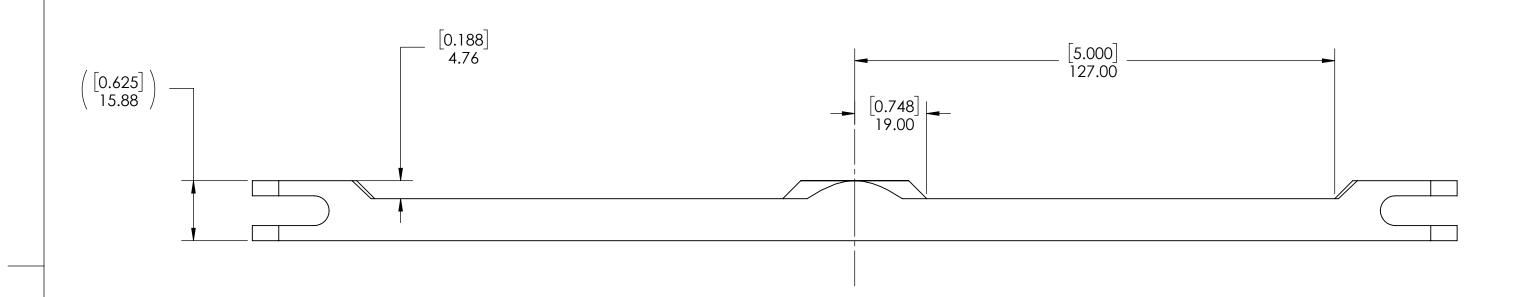
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BREAK ALL SHARP EDGES .2550	mm Q.A.			TE	T	SWING A	$\Delta RM$
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	MATL. SPEC.	SURFACE TEXTURE		SIZE DWG	. NO.		REV
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DO NOT SCALE DRAWING	FINISH			SCALE:	1:4	WEIGHT: [g]	SHEET 3 OF 8



SET-UP 3:
ROTATE VICE 5.5 DEGREES. USE INDICATOR AND SINE TRIANGLE RULE FOR MORE ACCURATE ANGLE (SEE SHEET 6).

1. USE .25" ENDMILL TO HOLLOW OUT POCKETS IN X DIRECTION

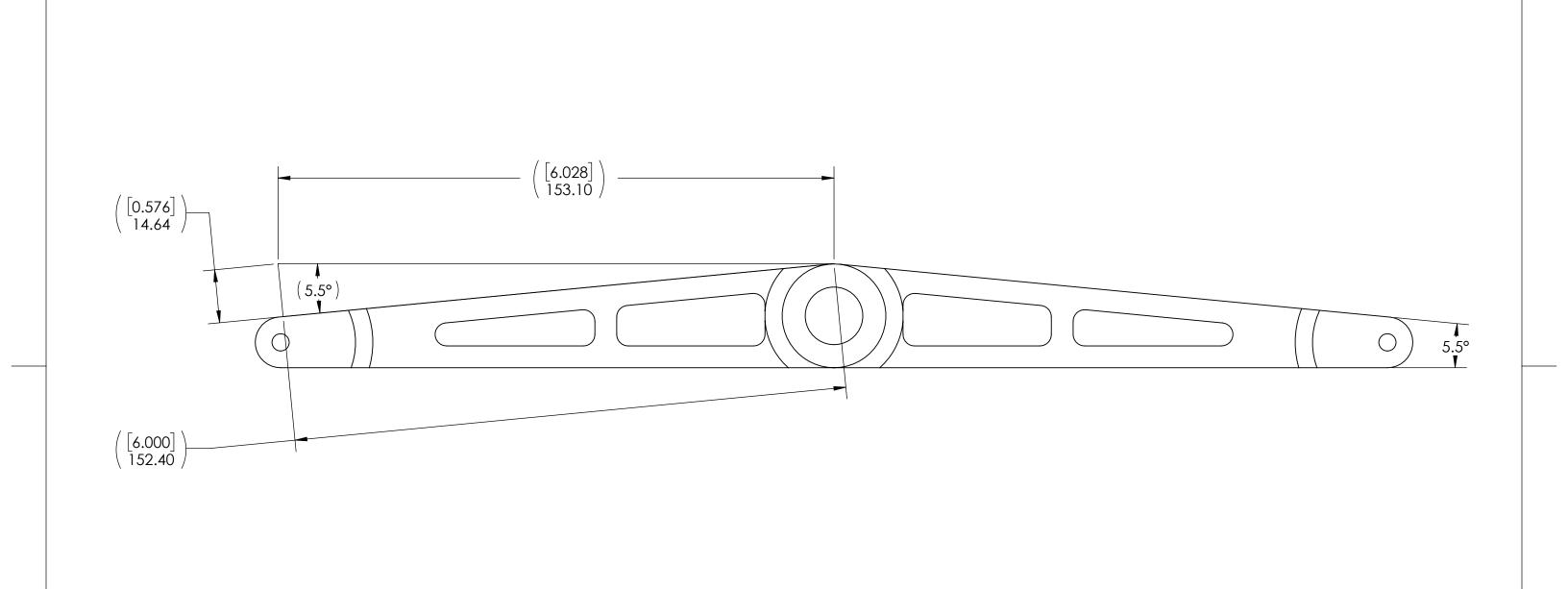
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DIMS. ARE IN MILLIMETERS	DRAWN	V.CÔTÉ-LAROUCHE	2023-03-14		U	DROVE	:K
TOLERANCE ON ANGLES 0.5° 0 PLACE DECIMAL ± 0.5mm	CHECKED			TITLE			
1 PLACE DECIMAL ± 0.25mm 2 PLACE DECIMAL ± 0.13mm	MFG APPR.						
BREAK ALL SHARP EDGES .2550mm	Q.A.				TFST	SWING	ARM
INTERPRET THIS DRAWING IN ACCORDANCE WITH: ASME Y14.5-2018	MATERIAL A	LUMINUM 6061				3111107	\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \
	MATL. SPEC.	SURFACE TEXTURE	,	SIZE	DWG. NO.		REV
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	HEAT TREAT			D	UURZ	3-CN3-4-F-00	3_VI
DO NOT SCALE DRAWING	FINISH			SC.	ALE: 1:4	WEIGHT: [g]	SHEET 4 OF 8
-				•		•	VER. 1: 2021/04/03



SET-UP 4:
RETURN VICE TO SQUARE POSITION

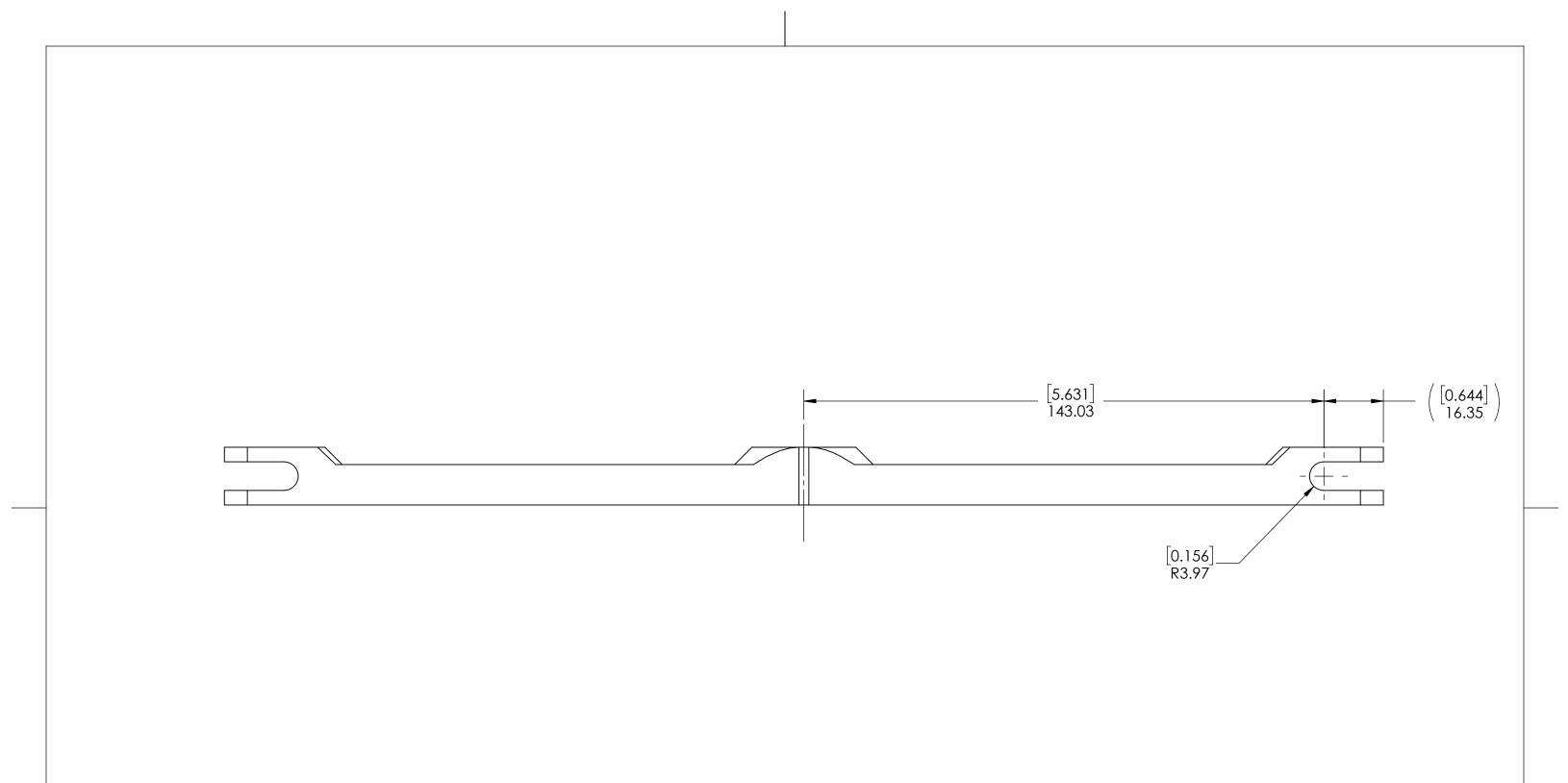
1. USE A FACE END MILL TO REDUCE THICKNESS IN INDICATED AREAS.
LEAVE .100" AROUND THE CHAMFERED EDGES FOR FUTURE CHAMFERING OPERATION.

UNLESS OTHERWISE SPECIFIED:		NAME	DATE		
DIMS. ARE IN MILLIMETERS TOLERANCE ON ANGLES 0.5°	DRAWN	V.CÔTÉ-LAROUCHE	2023-03-14	4 UOROVER	
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BREAK ALL SHARP EDGES .2550mm	Q.A.			TEST SWING ARM	
INTERPRET THIS DRAWING IN ACCORDANCE WITH: ASME Y14.5-2018	MATERIAL A	LUMINUM 6061		TEST SVVII VO ARM	
	MATL. SPEC.	SURFACE TEXTURE	,	SIZE DWG. NO.	EV
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	HEAT TREAT			<b>D</b>   UOR23-CN3-4-P-003_V1	
DO NOT SCALE DRAWING	FINISH			SCALE: 1:1 WEIGHT: [g] SHEET 5 O	
				VFR 1:20	2021/04/03



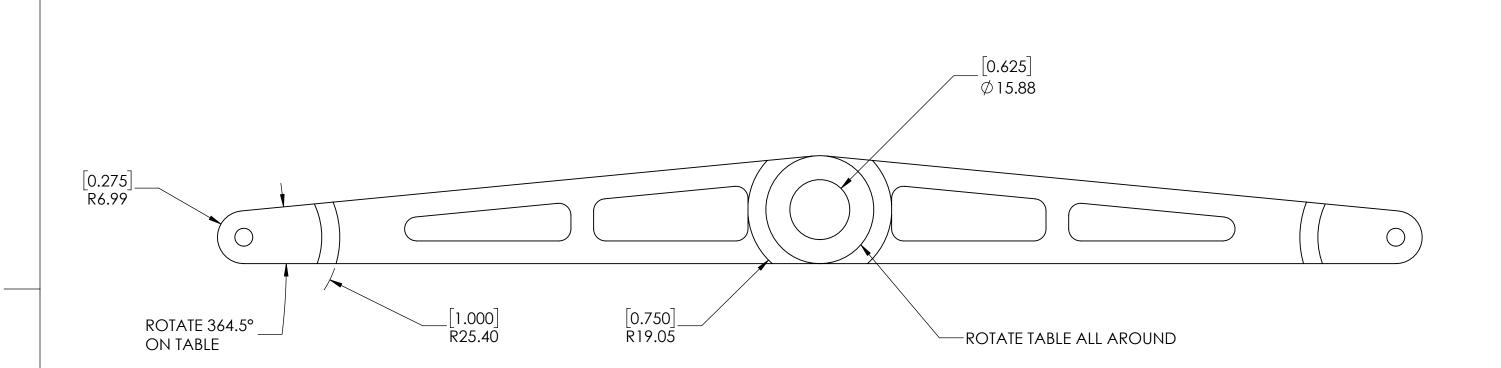
SET-UP 5: USE 5 DEGREE ANGLE BLOCKS TO APPROXIMATELY MOUNT PART IN VICE. USE INDICATOR AND SINE TRIANGLE RULE FOR MORE ACCURATE ANGLE. 1. USE FACING ENDMILL TO CUT ANGLES

UNITED OTHERWISE SPECIFIED.	
UNLESS OTHERWISE SPECIFIED: NAME DATE	
DIMS. ARE IN MILLIMETERS TOLERANCE ON ANOLES 0.5°  DRAWN  V.CÔTÉ-LAROUCHE  2023-03-14	
0 PLACE DECIMAL± 0.5mm CHECKED	
1 PLACE DECIMAL ± 0.25mm 2 PLACE DECIMAL ± 0.13mm MFG APPR.	
BREAK ALL SHARP EDGES .2550mm Q.A. TEST SWING ARA	Λ
INTERPRET THIS DRAWING IN ACCORDANCE WITH: ASME Y14.5-2018  ALUMINUM 6061	1
MATL. SPEC. SURFACE TEXTURE SIZE DWG. NO.	REV
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HEAT TREAT	ı
DO NOT SCALE DRAWING FINISH SCALE: 1:1 WEIGHT: [g] SHEET	6 OF 8



SET-UP 6: 1. USE 5/16 ENDMILL TO FACE SIDE CUTOUTS

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0 PL	TOLERANCE ON ANGLES 0.5° 0 PLACE DECIMAL ± 0.5mm	CHECKED			TITLE				
	1 PLACE DECIMAL ± 0.25mm 2 PLACE DECIMAL ± 0.13mm	MFG APPR.							
	BREAK ALL SHARP EDGES .2550mm	Q.A.				TPQT	SWING	$\Delta RM$	
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	$\overline{}$	MATL. SPEC.	SURFACE TEXTURE	,	SIZE	DWG. NO.		REV	
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		HEAT TREAT			D	UURZ	3-CNS-4-P-00	5_V	
	DO NOT SCALE DRAWING	FINISH			SC	ALE: 1:1	WEIGHT: [g]	SHEET 7 OF 8	



SET-UP 7:
MOUNT PART IN ROTARY TABLE FOR END AND CENTER RADII AND CHAMFERING. USE 3/16" DOWEL PINS AND JIG FOR MOUNTING.

1. USE .25" ENDMILL TO CUT RADII

2. USE 45 DEGREE CHAMFERING ENDMILL TO CUT CHAMFERS

3. OPEN UP CENTRAL PIVOT HOLE

UNLESS OTHERWISE SPECIFIED:  DIMS. ARE IN MILLIMETERS TOLERANCE ON ANGLES 0.5°  DRAWN  V.CÔTÉ-LAROUCHE  2023-03-14  UOROVER	
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TOLLIANCE ON ANGLES 0.5	
0 PLACE DECIMAL ± 0.5mm CHECKED TITLE	
1 PLACE DECIMAL ± 0.25mm 2 PLACE DECIMAL ± 0.13mm MFG APPR.	
BREAK ALL SHARP EDGES .2550mm Q.A. TEST SWING ARM	
INTERPRET THIS DRAWING IN ACCORDANCE WITH: ASME Y14.5-2018  MATERIAL ALUMINUM 6061	
MATL. SPEC. SURFACE TEXTURE SIZE DWG. NO. REV	V
<b>B</b> UOR23-CNS-4-P-005 V1 1	
HEAT TREAT   D   UOR23-CIN3-4-P-UU3_V I   I	
DO NOT SCALE DRAWING FINISH SCALE: 1:1 WEIGHT: [g] SHEET 8 OF	