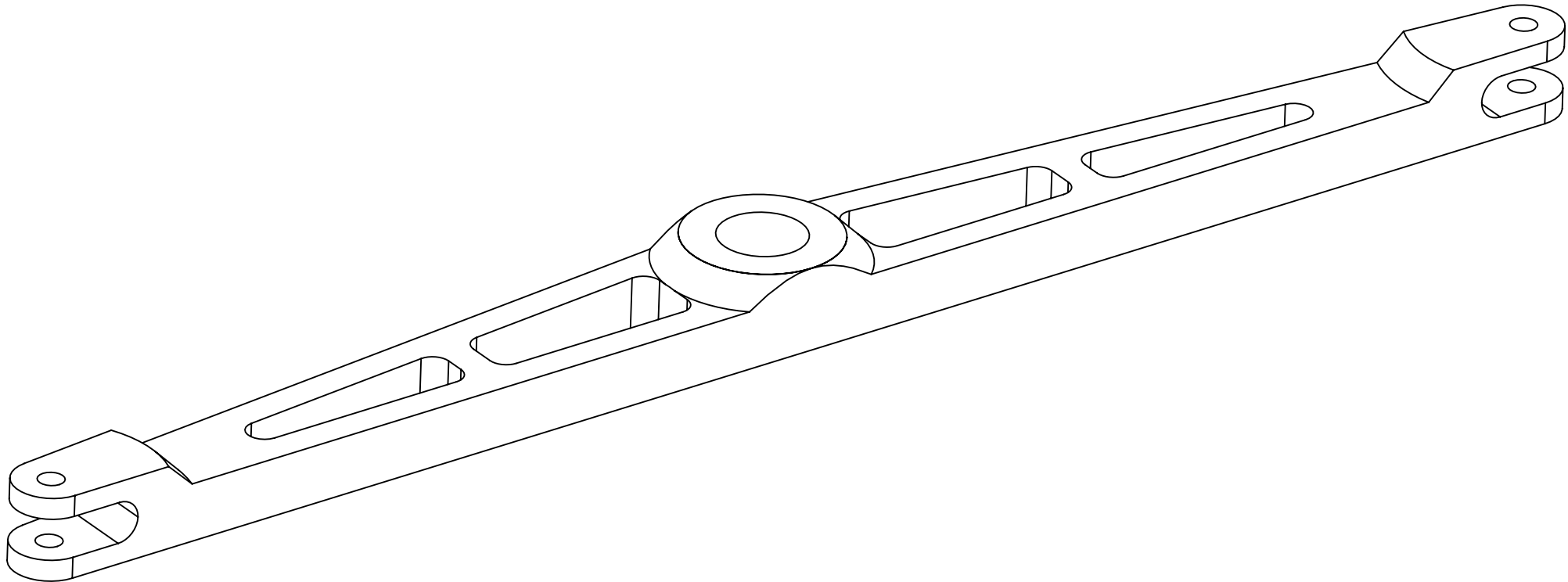
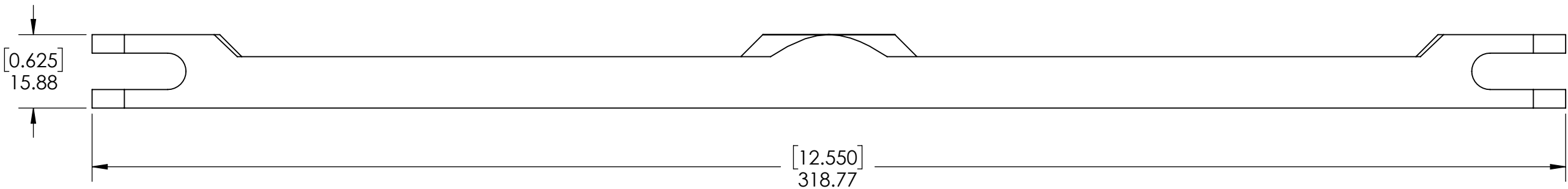
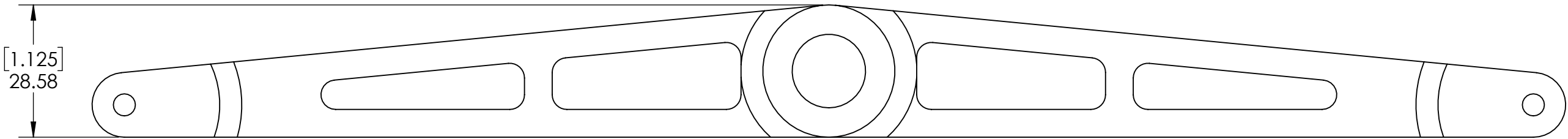


REVISIONS			
REV.	DESCRIPTION	DATE	APPR.
1	INITIAL RELEASE	2023-03-14	



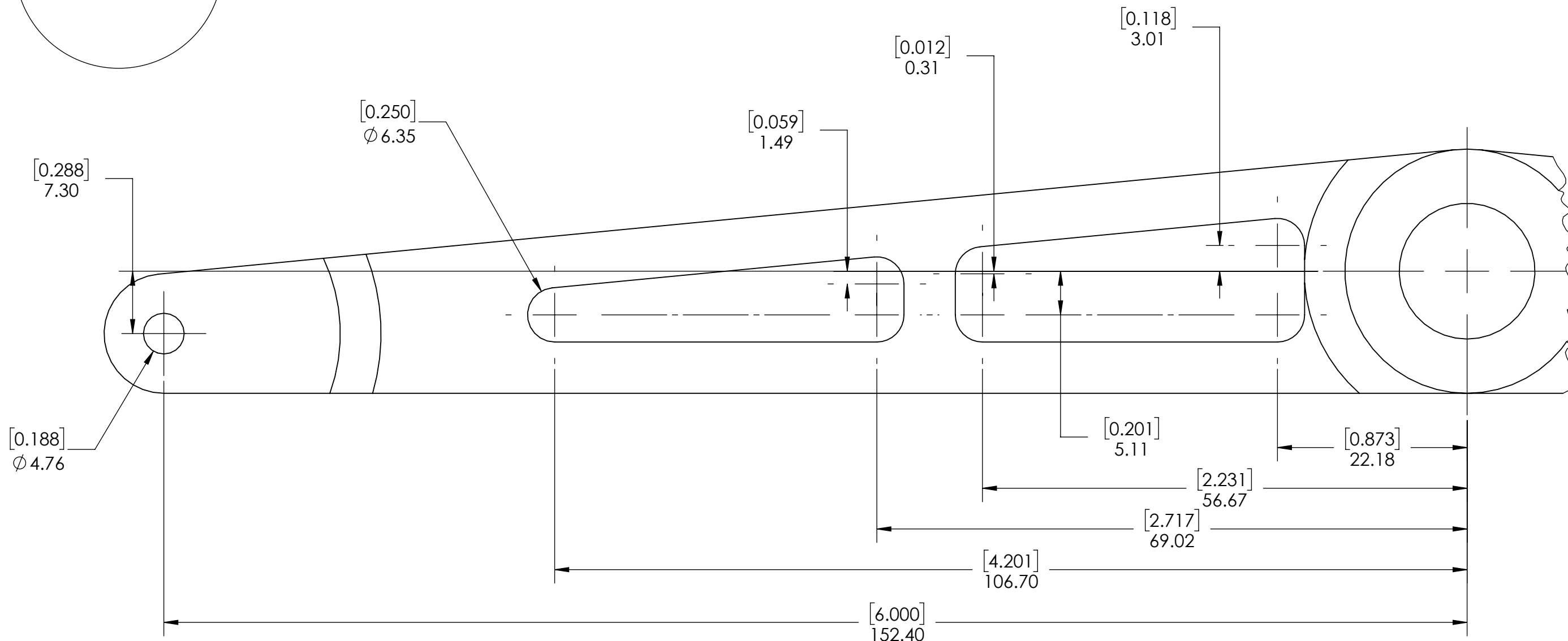
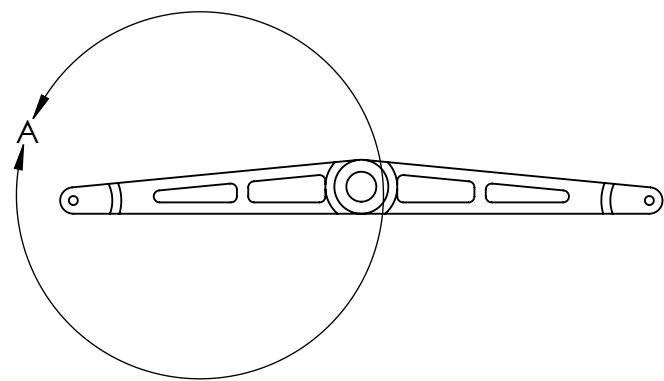
NOTE:  
THIS PART IS INTENDED AS A TRIAL RUN ON THE  
MILL TO TEST SET-UP OPERATIONS.  
  
DO NOT USE ON THE ROVER.

UNLESS OTHERWISE SPECIFIED:		NAME	DATE	<div>UOROVER</div> <div>TITLE</div> <div>TEST SWING ARM</div> <div>SIZE DWG. NO. REV</div> <div>B UOR23-CNS-4-P-005_V1 1</div> <div>SCALE: 1:1 WEIGHT: [g] SHEET 1 OF 8</div>		
DIMS. ARE IN <b>MILLIMETERS</b> TOLERANCE ON ANGLES 0.5° 0 PLACE DECIMAL ± 0.5mm 1 PLACE DECIMAL ± 0.25mm 2 PLACE DECIMAL ± 0.13mm  BREAK ALL SHARP EDGES .25-.50mm  INTERPRET THIS DRAWING IN ACCORDANCE WITH: ASME Y14.5-2018		DRAWN	V.CÔTÉ-LAROUCHE			
		CHECKED				
		MFG APPR.				
		Q.A.				
		MATERIAL				
				ALUMINUM 6061		
		MATL. SPEC.		SURFACE TEXTURE		
				1.6/		
		HEAT TREAT				
		FINISH				



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

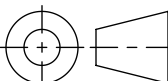
UNLESS OTHERWISE SPECIFIED:		NAME	DATE	<div>UOROVER</div> <div>TITLE</div> <div>TEST SWING ARM</div> <div>SIZE <b>B</b></div> <div>DWG. NO. UOR23-CNS-4-P-005_V1</div> <div>REV <b>1</b></div> <div>SCALE: 1:1</div> <div>WEIGHT: [g]</div> <div>SHEET 2 OF 8</div>		
DIMS. ARE IN <b>MILLIMETERS</b> TOLERANCE ON ANGLES 0.5° 0 PLACE DECIMAL ± 0.5mm 1 PLACE DECIMAL ± 0.25mm 2 PLACE DECIMAL ± 0.13mm BREAK ALL SHARP EDGES .25-.50mm		DRAWN	V.CÔTÉ-LAROUCHE			
		CHECKED				
		MFG APPR.				
		Q.A.				
INTERPRET THIS DRAWING IN ACCORDANCE WITH: ASME Y14.5-2018		MATERIAL ALUMINUM 6061				
		MATL. SPEC.		SURFACE TEXTURE 1.6/√		
		HEAT TREAT				
		FINISH				
DO NOT SCALE DRAWING						

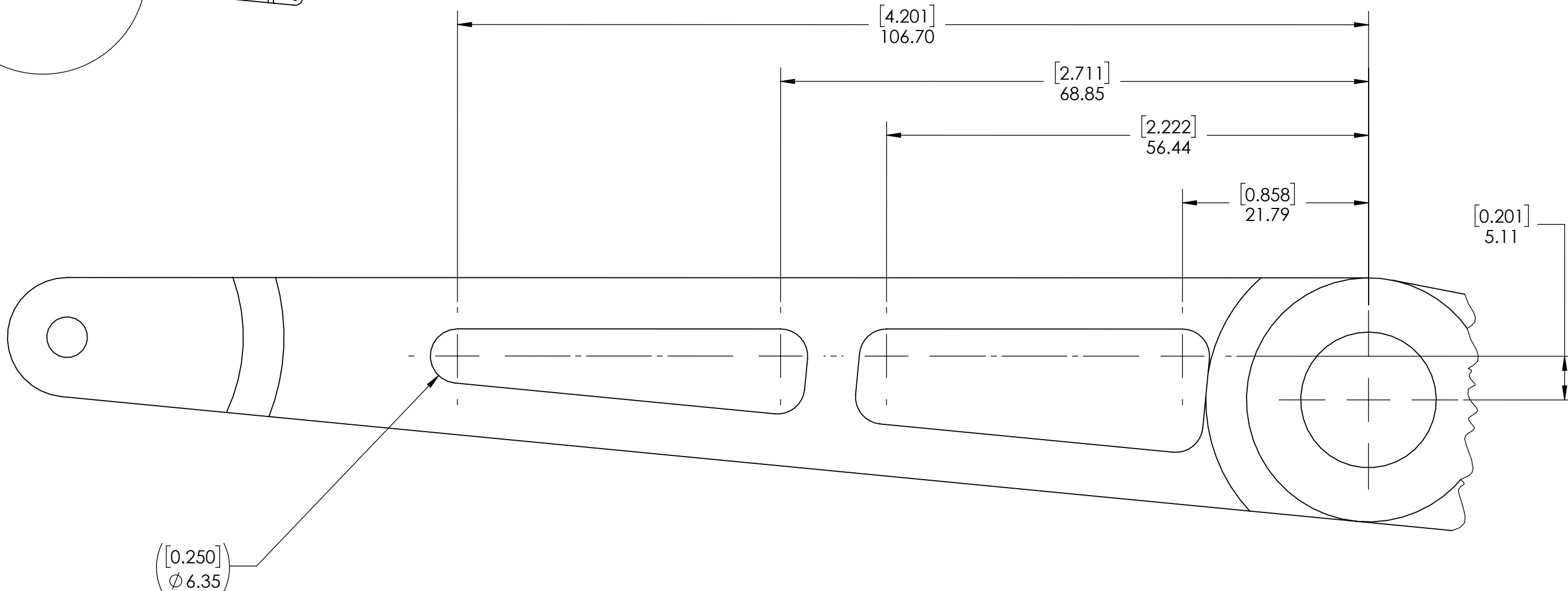
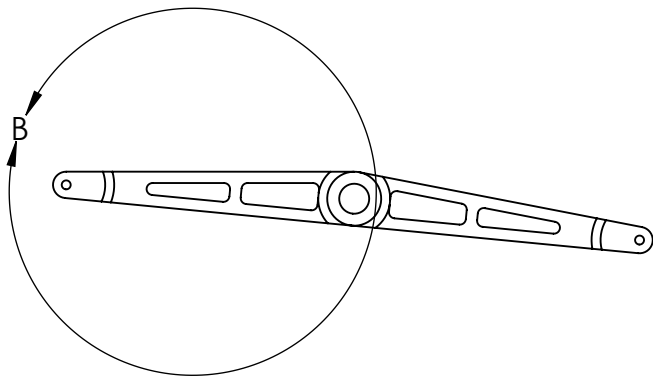


DETAIL A  
SCALE 2 : 1

SET-UP 2:

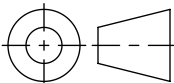
1. USE OVERSIZED 3/16" REAMER FOR CENTRAL PIVOT AND END HOLES
2. USE .25" ENDMILL TO HOLLOW OUT POCKETS IN X-Y DIRECTION

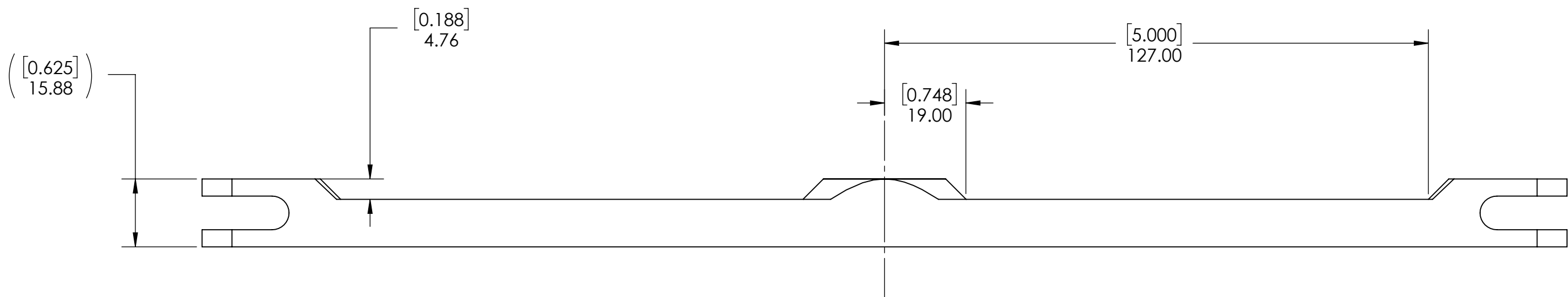
UNLESS OTHERWISE SPECIFIED:		NAME		DATE		<div>UOROVER</div> <div>TITLE</div> <div>TEST SWING ARM</div>					
DIMS. ARE IN <b>MILLIMETERS</b> TOLERANCE ON ANGLES 0.5° 0 PLACE DECIMAL ± 0.5mm 1 PLACE DECIMAL ± 0.25mm 2 PLACE DECIMAL ± 0.13mm  BREAK ALL SHARP EDGES .25-.50mm		DRAWN		V.CÔTÉ-LAROUCHE						2023-03-14	
		CHECKED									
		MFG APPR.									
		Q.A.									
INTERPRET THIS DRAWING IN ACCORDANCE WITH: ASME Y14.5-2018		MATERIAL		ALUMINUM 6061							
		MATL. SPEC.		SURFACE TEXTURE		SIZE		DWG. NO.		REV	
				1.6/√		<b>B</b>		UOR23-CNS-4-P-005_V1		1	
		HEAT TREAT									
DO NOT SCALE DRAWING		FINISH				SCALE: 1:4		WEIGHT: [g]		SHEET 3 OF 8	



DETAIL B  
SCALE 2 : 1

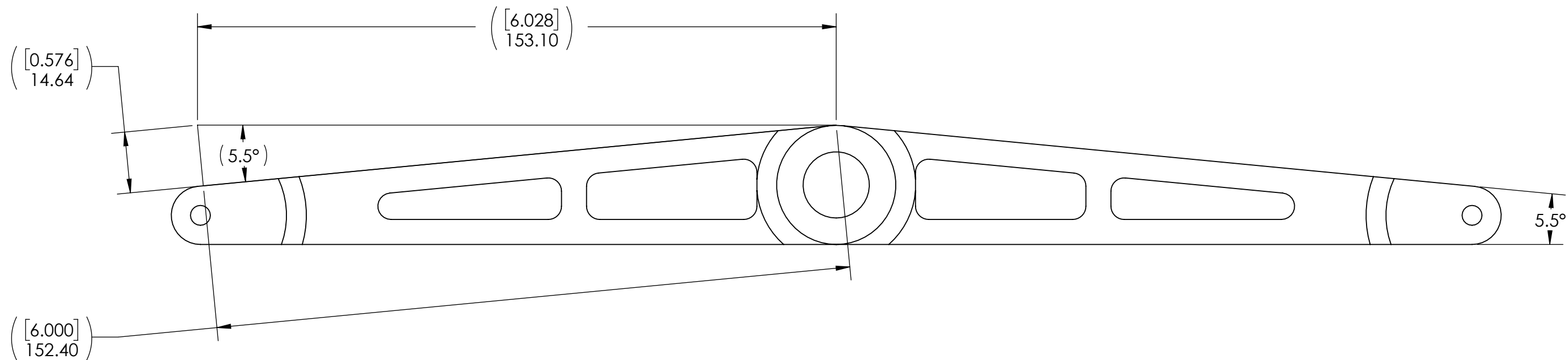
SET-UP 3:  
ROTATE VICE 5.5 DEGREES. USE INDICATOR AND SINE TRIANGLE RULE FOR MORE  
ACCURATE ANGLE (SEE SHEET 6).  
1. USE .25" ENDMILL TO HOLLOW OUT POCKETS IN X DIRECTION

UNLESS OTHERWISE SPECIFIED:		NAME		DATE		<div>UOROVER</div>						
DIMS. ARE IN <b>MILLIMETERS</b> TOLERANCE ON ANGLES 0.5° 0 PLACE DECIMAL ± 0.5mm 1 PLACE DECIMAL ± 0.25mm 2 PLACE DECIMAL ± 0.13mm  BREAK ALL SHARP EDGES .25-.50mm		DRAWN	V.CÔTÉ-LAROUCHE		2023-03-14		TITLE					
		CHECKED										
		MFG APPR.										
		Q.A.										
INTERPRET THIS DRAWING IN ACCORDANCE WITH: ASME Y14.5-2018		MATERIAL ALUMINUM 6061				<div>TEST SWING ARM</div>						
		MATL. SPEC.		SURFACE TEXTURE						SIZE	DWG. NO.	REV
				1.6/						<b>B</b>	UOR23-CNS-4-P-005_V1	1
		HEAT TREAT										
DO NOT SCALE DRAWING		FINISH				SCALE: 1:4		WEIGHT: [g]	SHEET 4 OF 8			

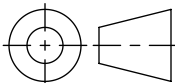


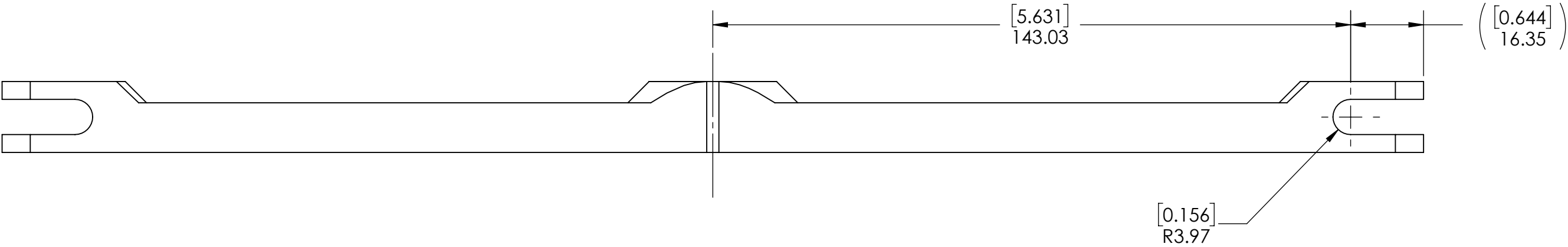
SET-UP 4:  
RETURN VICE TO SQUARE POSITION  
1. USE A FACE END MILL TO REDUCE THICKNESS IN INDICATED AREAS.  
LEAVE .100" AROUND THE CHAMFERED EDGES FOR FUTURE CHAMFERING OPERATION.

UNLESS OTHERWISE SPECIFIED:		NAME		DATE		<div>UOROVER</div>			
<div>DIMS. ARE IN <b>MILLIMETERS</b> TOLERANCE ON ANGLES 0.5° 0 PLACE DECIMAL ± 0.5mm 1 PLACE DECIMAL ± 0.25mm 2 PLACE DECIMAL ± 0.13mm  BREAK ALL SHARP EDGES .25-.50mm</div>		DRAWN	V.CÔTÉ-LAROUCHE		2023-03-14		TITLE  TEST SWING ARM		
		CHECKED							
		MFG APPR.							
		Q.A.							
INTERPRET THIS DRAWING IN ACCORDANCE WITH: ASME Y14.5-2018		MATERIAL ALUMINUM 6061							
<div></div> <div>DO NOT SCALE DRAWING</div>		MATL. SPEC.		SURFACE TEXTURE		SIZE	DWG. NO.	REV	
				<div>1.6/</div>		<b>B</b>	UOR23-CNS-4-P-005_V1	1	
		HEAT TREAT							
		FINISH				SCALE: 1:1		WEIGHT: [g]	SHEET 5 OF 8



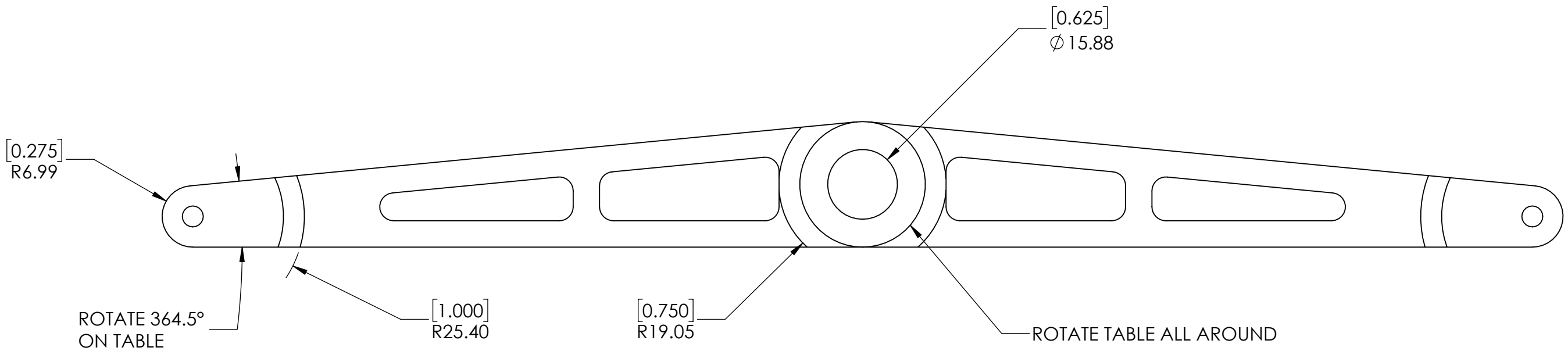
SET-UP 5:  
USE 5 DEGREE ANGLE BLOCKS TO APPROXIMATELY MOUNT PART IN VICE. USE  
INDICATOR AND SINE TRIANGLE RULE FOR MORE ACCURATE ANGLE.  
1. USE FACING ENDMILL TO CUT ANGLES

UNLESS OTHERWISE SPECIFIED:		NAME		DATE		<div>UOROVER</div>			
<div>DIMS. ARE IN <b>MILLIMETERS</b> TOLERANCE ON ANGLES 0.5° 0 PLACE DECIMAL ± 0.5mm 1 PLACE DECIMAL ± 0.25mm 2 PLACE DECIMAL ± 0.13mm  BREAK ALL SHARP EDGES .25-.50mm</div>		DRAWN	V.CÔTÉ-LAROUCHE		2023-03-14		TITLE  TEST SWING ARM		
		CHECKED							
		MFG APPR.							
		Q.A.							
INTERPRET THIS DRAWING IN ACCORDANCE WITH: ASME Y14.5-2018		MATERIAL ALUMINUM 6061							
		MATL. SPEC.		SURFACE TEXTURE		SIZE		DWG. NO.	REV
				<div>1.6/</div>		<b>B</b>		UOR23-CNS-4-P-005_V1	1
		HEAT TREAT							
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

UNLESS OTHERWISE SPECIFIED:		NAME	DATE	<div>UOROVER</div> <div>TITLE</div> <div>TEST SWING ARM</div> <div>SIZE DWG. NO. REV</div> <div>B UOR23-CNS-4-P-005_V1 1</div> <div>SCALE: 1:1 WEIGHT: [g] SHEET 7 OF 8</div>		
DIMS. ARE IN <b>MILLIMETERS</b> TOLERANCE ON ANGLES 0.5° 0 PLACE DECIMAL ± 0.5mm 1 PLACE DECIMAL ± 0.25mm 2 PLACE DECIMAL ± 0.13mm  BREAK ALL SHARP EDGES .25-.50mm  INTERPRET THIS DRAWING IN ACCORDANCE WITH: ASME Y14.5-2018		DRAWN	V.CÔTÉ-LAROUCHE			
		CHECKED				
		MFG APPR.				
		Q.A.				
		MATERIAL		ALUMINUM 6061		
		MATL. SPEC.		SURFACE TEXTURE		
		HEAT TREAT				
DO NOT SCALE DRAWING		FINISH				



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:		NAME		DATE		<div>UOROVER</div>					
<div>DIMS. ARE IN <b>MILLIMETERS</b></div> <div>TOLERANCE ON ANGLES 0.5°</div> <div>0 PLACE DECIMAL ± 0.5mm</div> <div>1 PLACE DECIMAL ± 0.25mm</div> <div>2 PLACE DECIMAL ± 0.13mm</div> <div>BREAK ALL SHARP EDGES .25-.50mm</div> <div>INTERPRET THIS DRAWING IN ACCORDANCE WITH: ASME Y14.5-2018</div> <div></div> <div>DO NOT SCALE DRAWING</div>		DRAWN	V.CÔTÉ-LAROUCHE		2023-03-14		<div>TITLE</div> <div>TEST SWING ARM</div>				
		CHECKED									
		MFG APPR.									
		Q.A.									
		MATERIAL									
		ALUMINUM 6061									
		MATL. SPEC.		SURFACE TEXTURE		SIZE		DWG. NO.		REV	
				<div>1.6/</div>		<div>B</div>		UOR23-CNS-4-P-005_V1		<div>1</div>	
		HEAT TREAT									
		FINISH				SCALE: 1:1		WEIGHT: [g]		SHEET 8 OF 8	