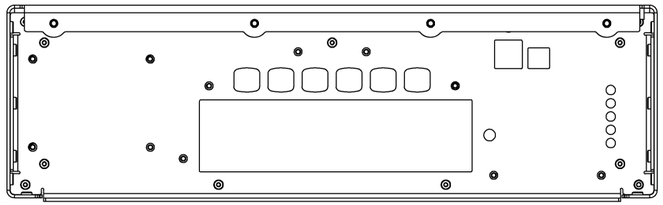
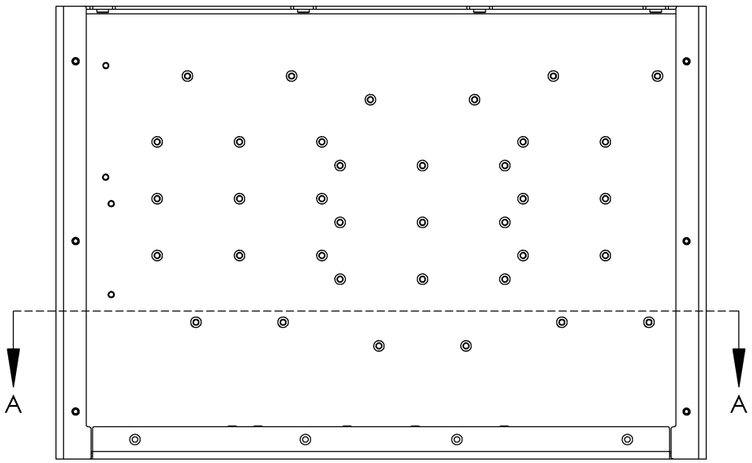
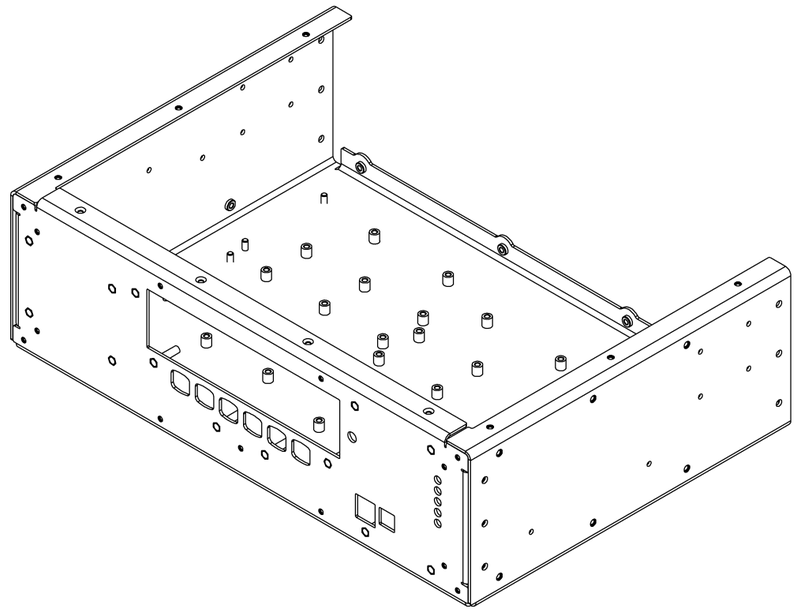
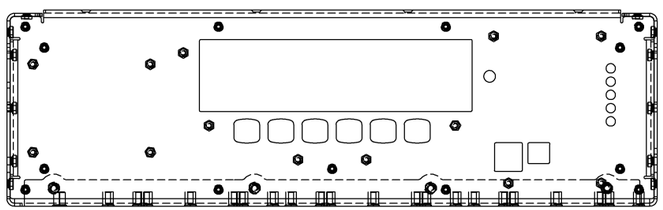
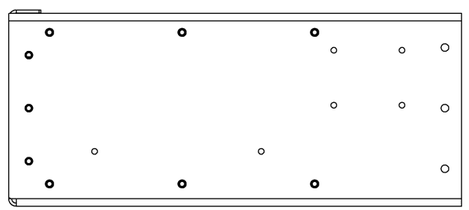
ASSEMBLY DETAILS











DATE	Rev.	Iss.	DESCRIPTION	APP'D
Nov. 28, 2008	1		Hole sizes and locations changed. K-Factor was .465. Flat Layout changed and DXF updated. Thru hole designation added to Hole Table. Tolerances of holes changed in Hole Table. Notes were added.	JJL
Feb. 10, 2009	2		"M" holes were .190". Location of five (5) "C" holes and four (4) "B" holes changed. Tolerance to hole "H" added. Flat Layout changed and DXF updated. Two (2) PEMs changed. PEM quantities changed in BOM table. Bubble ID "1" added. Neutral Axis details added. Bend notes changed. Note added.	JJL
March 11, 2009		1	Notes updated and added to include use of IGES and STEP files.	JJL
May 4, 2009	3		PEM quantity changed. Locking PEM replaced with non-locking type. Rib length and position changed. Rib length and location dimensions added. Bend note changed. Flat Layout changed and DXF, IGES, and STEP files changed and updated.	JJL
June 1, 2009	4		"No Painting" note removed. "Good Side" note removed. Deburring note removed. Finish notes changed and added. Notes 2 and 3 on Sheet 1 removed. Notes on sheet 3 removed. Grain direction note changed. Dimension added. Punching process added to notes. Section and Detail identification letters changed. Drawing title changed.	JJL
Aug. 18, 2009	5		Stiffening ribs removed. Bend reliefs changed. Flat Layout changed and DXF, IGES, and STEP files updated.	JJL
Dec. 1, 2009		2	Added material table to Sheet 5.	JJL

NOTE:

△4

1. Sheet metal is to be Coated in accordance with Manufacturing Standard D02677 prior to installation of PEMs.

UNITS ARE IN "INCHES"

UNLESS OTHERWISE SPECIFIED	.X ± .060
TOLERANCES FOR NONLIMITED DIMENSIONS	.XX ± .030
	.XXX ± .010
	ANGULAR ± 1°
SURFACE FINISH	125 RMS

THIRD ANGLE PROJECTION

DESIGN	JJL	DATE	
DRAWN	JJL	DATE	
CHECKED	JJL	DATE	
APP'D		DATE	
DWG No.		CONTRACTOR DWG No.	Methods Technologies Services 24402-379

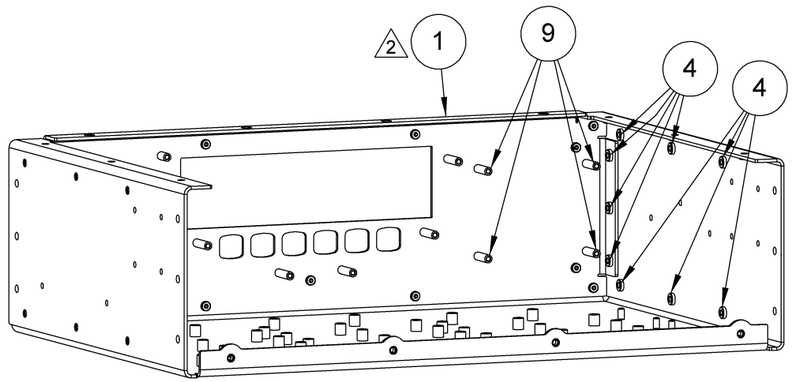
TITLE: **Chassis Assembly 4000 Relay/Recorder** △4

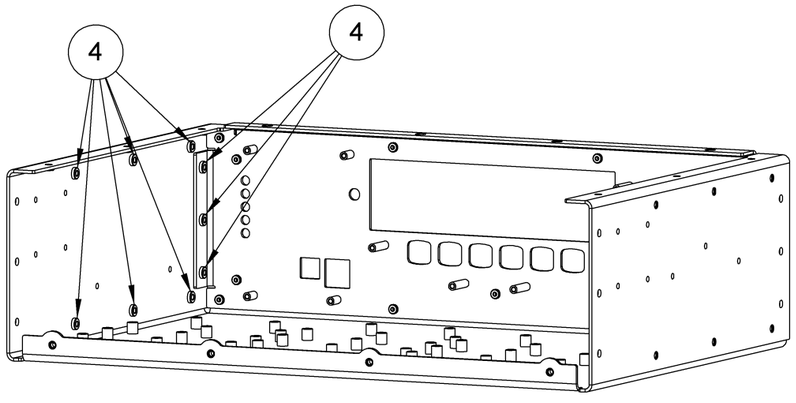
SCALE	SHEET SIZE	ITEM No.	Rev. No.	Iss. No.
1:4	B		5	2

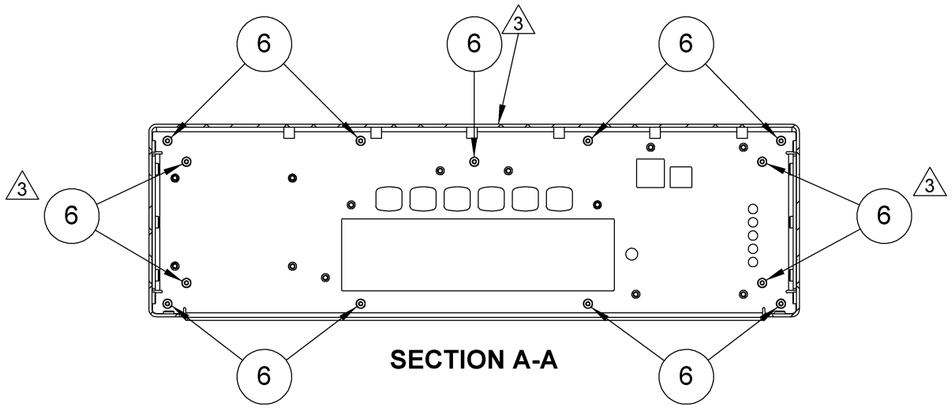
SHEET: 1 of 5

1 2 3 4 5

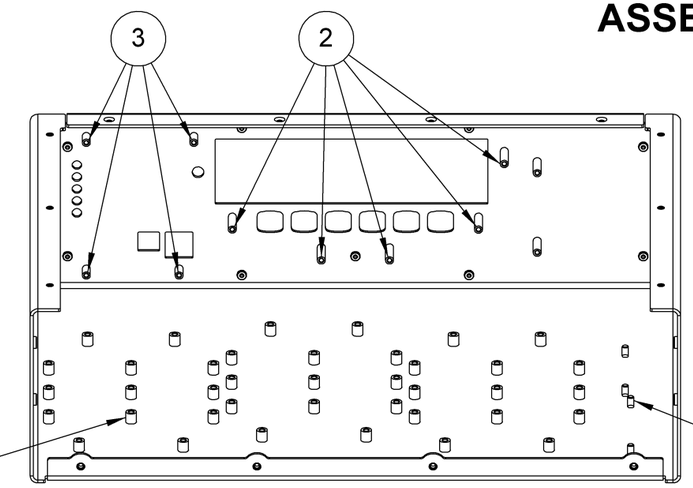
ASSEMBLY DETAILS

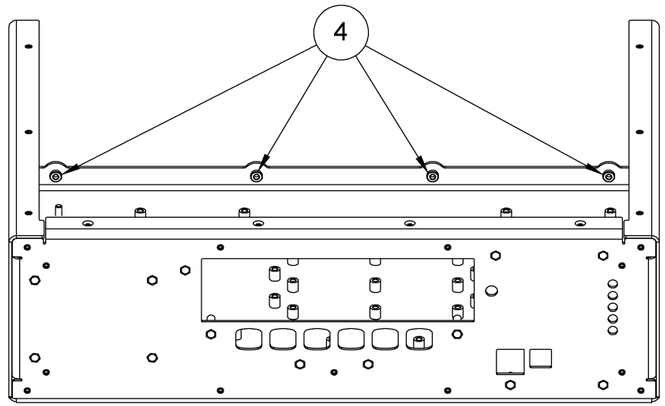


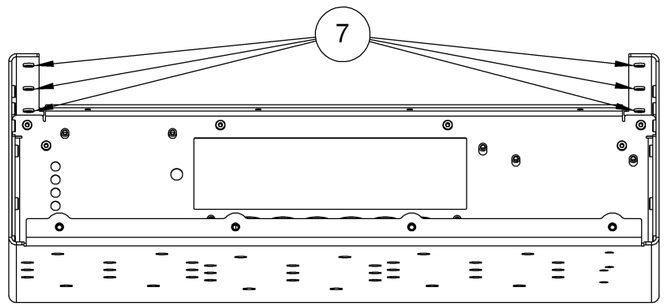




SECTION A-A



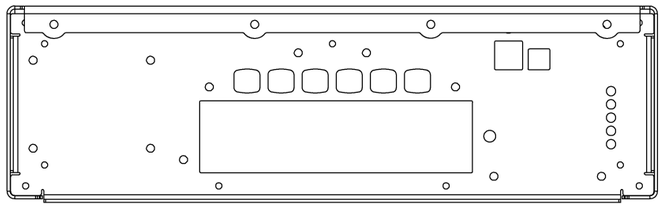


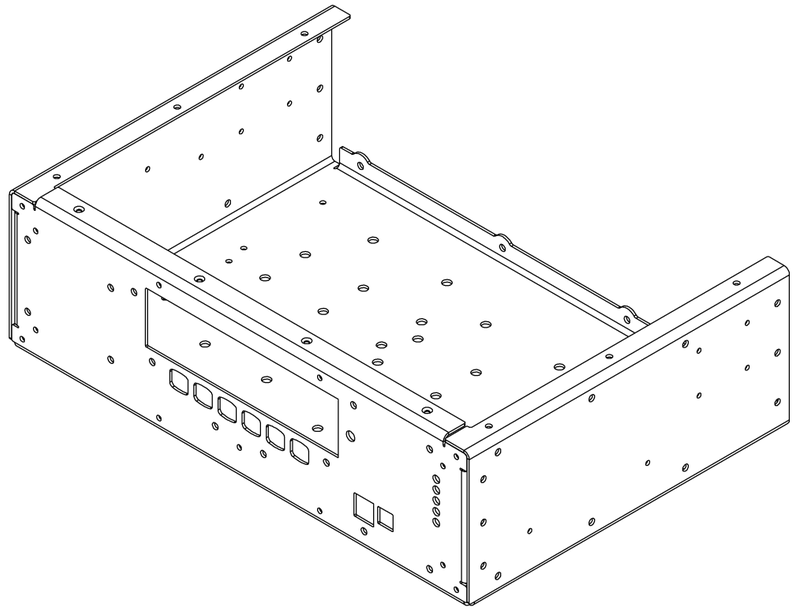


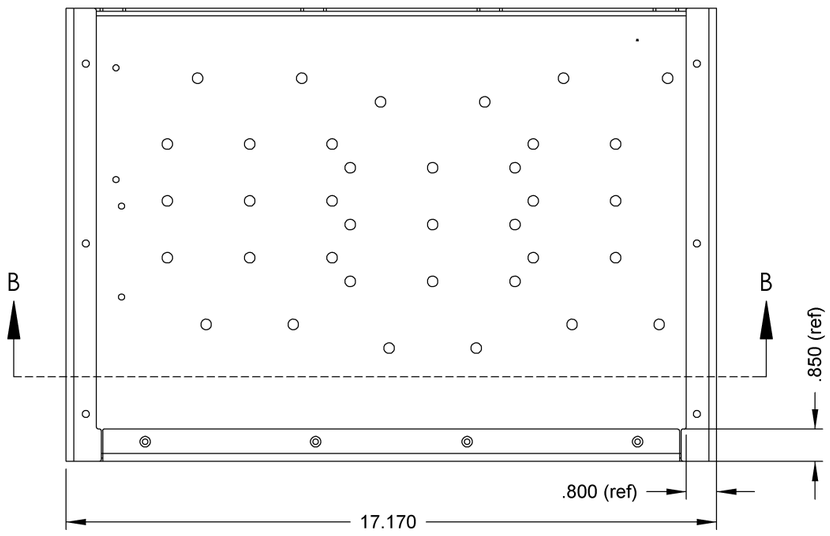
ITEM No.	VENDOR No.	DESCRIPTION	QTY.	
1			1	1 2
2			5	
3			4	2
4			22	
5			39	
6			13	2 3
7			6	
8			4	
9			4	2

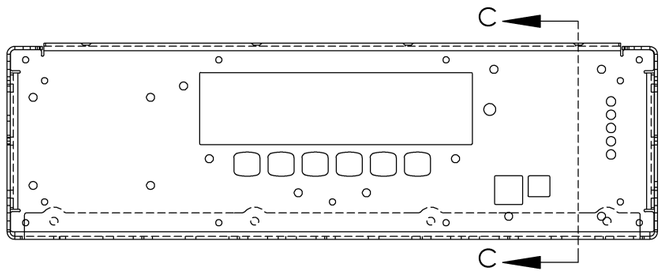
TITLE: **Chassis Assembly 4000 Relay/Recorder**				
SCALE: 1:4	SHEET SIZE: B	ITEM No.	Rev No.: 5	Iss No.: 2
DWG No.	CONTRACTOR DWG No.: Methods Technologies Services 24402-379	SHEET: 2 of 5		

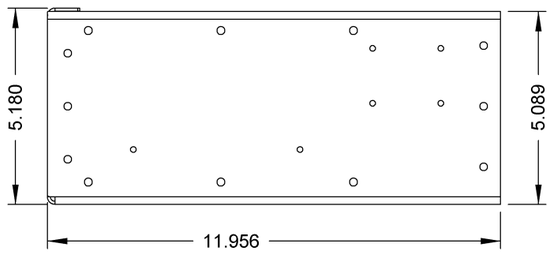
SHEET METAL DETAILS





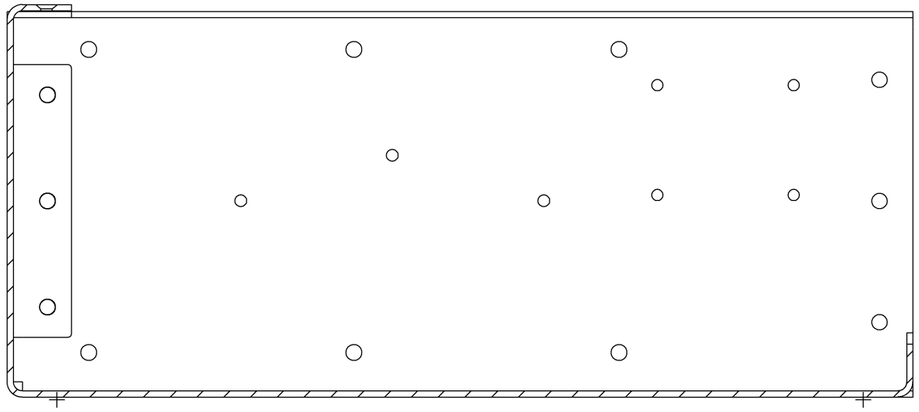




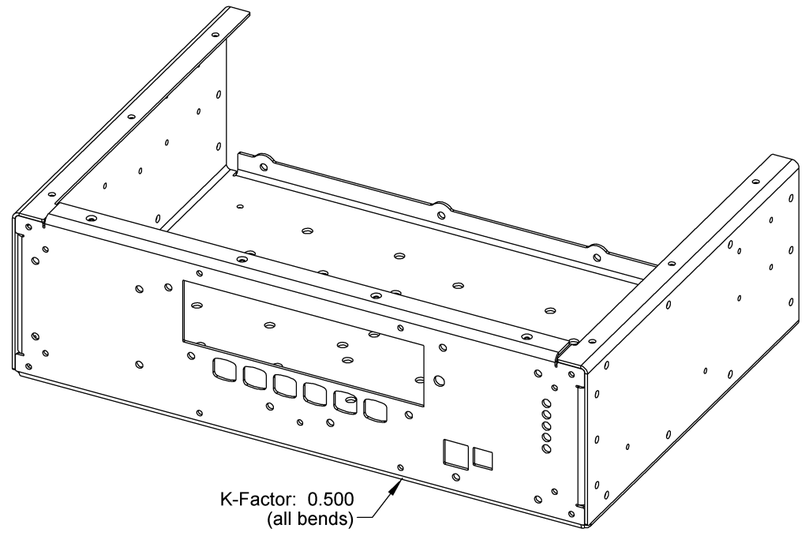


TITLE: **Chassis Assembly 4000 Relay/Recorder**					
SCALE: 1:4	SHEET SIZE: B	ITEM No.	Rev No.: 5	Iss No.: 2	
DWG No.	CONTRACTOR DWG No.: Methods Technologies Services 24402-379	SHEET: 3 of 5			

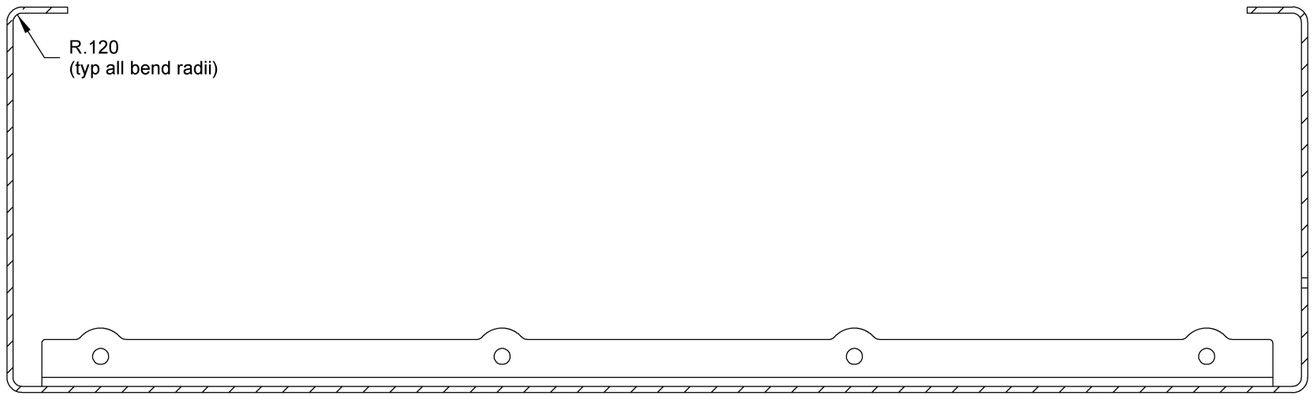
SHEET METAL DETAILS



SECTION C-C
SCALE 1 : 2



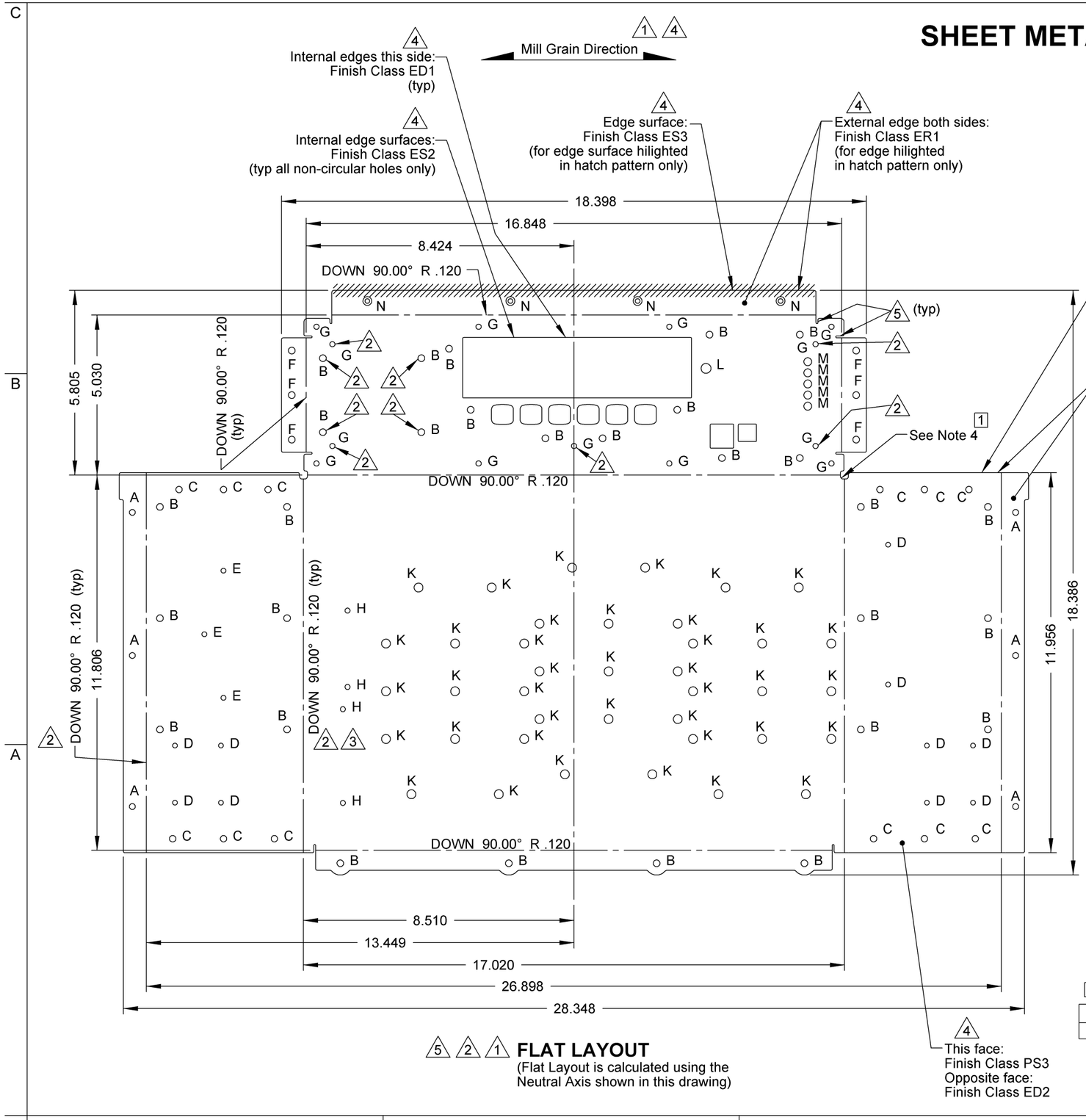
2 NEUTRAL AXIS DETAIL
Scale 1:4



SECTION B-B
SCALE 1 : 2

TITLE: **Chassis Assembly 4000 Relay/Recorder**					
SCALE: 1:4	SHEET SIZE: B	ITEM No.	Rev No.: 5	Iss No.: 2	
DWG No.	CONTRACTOR DWG No.: Methods Technologies Services 24402-379	SHEET: 4 of 5			

SHEET METAL DETAILS



Hole Table 1

	TAG	SIZE	QTY
1	A	∅.188 $^{+.003}_{-.000}$ THRU	6
	B	∅.213 $^{+.003}_{-.000}$ THRU	29
1	C	∅.203 $^{+.010}_{-.005}$ THRU	12
	D	∅.150 $^{+.010}_{-.005}$ THRU	10
	E	∅.156 $^{+.010}_{-.005}$ THRU	3
	F	∅.213 $^{+.003}_{-.000}$ THRU	6
	G	∅.166 $^{+.003}_{-.000}$ THRU	13
2 1	H	∅.163 $^{+.003}_{-.000}$ THRU	4
	K	∅.281 $^{+.003}_{-.000}$ THRU	39
	L	∅.313 $^{+.005}_{-.000}$ THRU	1
2	M	∅.250 $^{+.005}_{-.000}$ THRU	5
	N	∅ .150 THRU ⌵ ∅ .279 X 100.00°	4

NOTES: 1 2

1. Unless otherwise noted, all flat pattern features to be cut to a tolerance of +/- 0.006".
5 3 1 2 4 2. Flat pattern to be laser cut or punched only using DXF File No. D02542R04.dxf or IGES File No. D02542R04.igs or STEP File No. D02542R04.step. These files are to be used for manufacture and all feature dimensions of this model are considered to be correct.
1 3. Flat Layout is calculated using the Neutral Axis shown in this drawing. The Vendor is permitted to use an alternate Neutral Axis only as required in order to conform to the finished dimensions shown. Upon use of an alternate Neutral Axis, the Vendor is responsible to adjust the Flat Layout by stretching straight lines only at each Bend Line in the direction exactly perpendicular to each Bend Line. The Vendor may use the IGES and STEP files to generate a Flat Layout and must not alter any feature with exception to the flattened length at each bend. Any other alterations are not permitted.
1 4. The IGES and STEP files do not include inside radii at at each bend. It is the responsbility of the Vendor to include these to match the DXF listed in this drawing exactly in size and location.
1 5. If the Vendor uses the IGES or STEP file to generate a Flat Layout, the Vendor must inspect the new Flat Layout in a DXF format with the DXF file listed in this drawing by overlaying each DXF using compatible software to graphically compare the size and shape of every feature. The only permitted deviation is the flattened length of each bend. Any other deviations in any amount are NOT permitted.
1 6. Vendor is responsible to assure that receipt of the DXF, IGES, and STEP files used for manufacture have been interpreted by their (Vendor) software in a manner that does not affect the original model features. Upon interpretation by the vendor, dimensions shown on this drawing are to be used to check the DXF, IGES, and STEP files for accuracy. All measurements are to match the dimensions precisely; deviations in any amount are NOT permitted. If a deviation occurs, the file in question is NOT to be used and the anomaly is to be reported to the customer.
4 7. Component to be finished as per Manufacturing Standard D02677 and as illustrated in this drawing.

5 2 1 **FLAT LAYOUT**
(Flat Layout is calculated using the Neutral Axis shown in this drawing)

1

MATERIAL	Thickness

TITLE: **Chassis Assembly 4000 Relay/Recorder**				
SCALE: 1:4	SHEET SIZE: B	ITEM No.	Rev No.: 5	Iss No.: 2
DWG No.	CONTRACTOR DWG No.: Methods Technologies Services 24402-379	SHEET: 5 of 5		