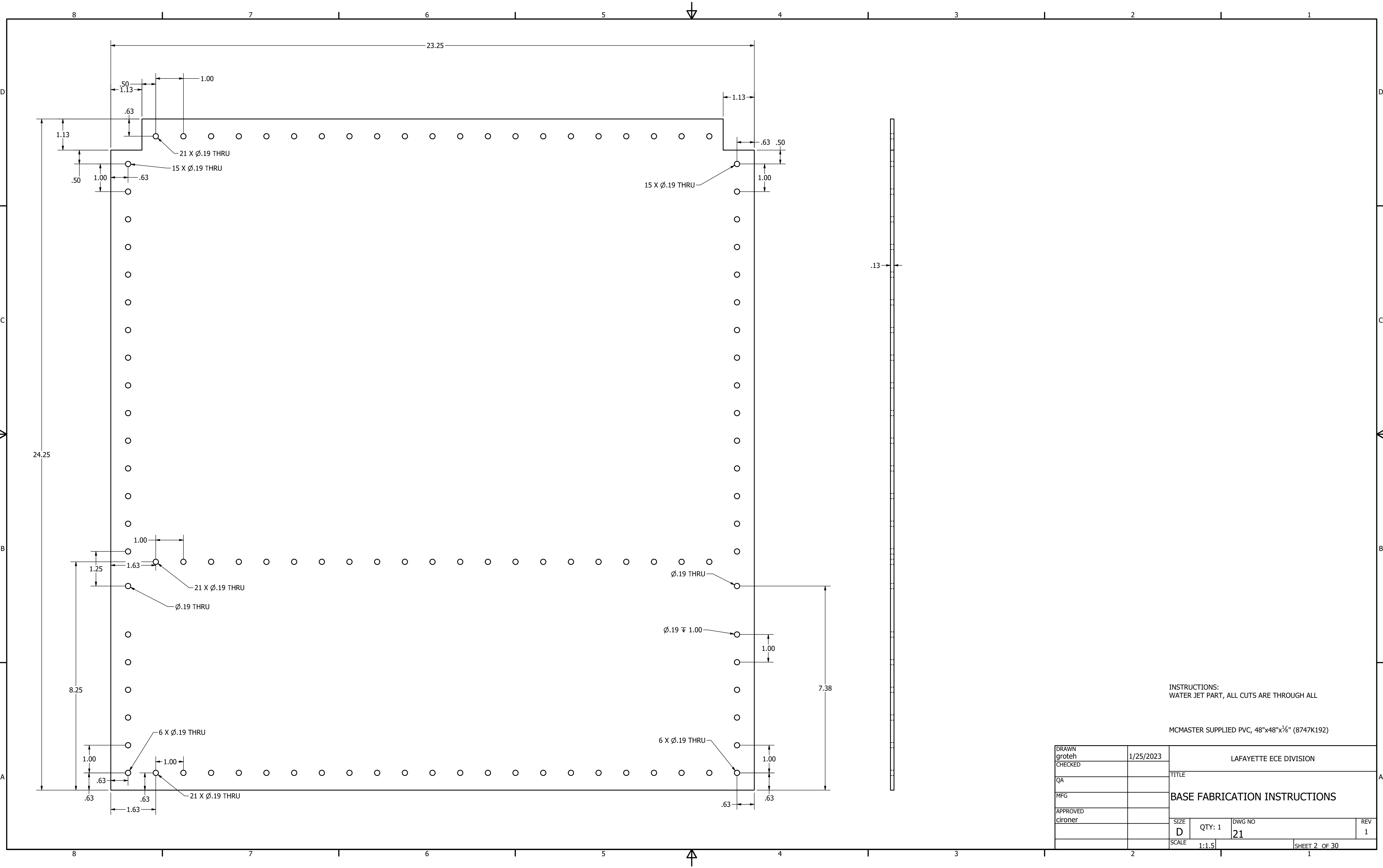


REVISION HISTORY				
ZONE	REV	DESCRIPTION	DATE	APPROVED
N / A	1	INITIAL DRAFT	1/26/2023	cironer

CONTENTS						CONTENTS								
ITEM	QTY	PART NAME	DESCRIPTION	MATERIAL	INSTRUCTIONS	ITEM	QTY	PART NAME	DESCRIPTION	MATERIAL	INSTRUCTIONS			
1	1	BASE PANEL BOTTOM	PVC PANELING	MCMaster SUPPLIED PVC, 48"x48"x1/8" (8747K192)	WATER JET PART, ALL CUTS ARE THROUGH ALL	16	2	HANDLES	1/2" ALUMINUM TUBE	MCMaster SUPPLIED ALUMINUM TUBE, 1/2" OD (9056K65)	CUT TO LENGTH IF NEEDED, DRILL HOLES			
2	1	BASE PANEL TOP	PVC PANELING	MCMaster SUPPLIED PVC, 48"x48"x1/8" (8747K192)	WATER JET PART, ALL CUTS ARE THROUGH ALL	17	3	SPACER FROM MOTOR PLATE	#10 SCREW SPACER	MCMaster SUPPLIED SPACER FOR #10 SCREW, .3130D, 3" LENGTH (92510A558)	CUT TO LENGTH			
3	1	BASE PANEL FRONT	PVC PANELING	MCMaster SUPPLIED PVC, 48"x48"x1/8" (8747K192)	WATER JET PART, ALL CUTS ARE THROUGH ALL	18	2	L STOCK 21" WITH CUTOUTS	L CHANNEL WITH CUTOUTS AND 1" REGULAR HOLE PATTERN	MCMaster SUPPLIED L-STOCK, 1"x1"x8" (8982K4-8982K21)	CUT TO LENGTH, CUT OUT WALLS ON EDGES, INCREASE CORNER FILLET OR CHAMFER (SEE NOTE D6), DRILL HOLES			
4	1	BASE PANEL BACK	PVC PANELING	MCMaster SUPPLIED PVC, 48"x48"x1/8" (8747K192)	WATER JET PART, ALL CUTS ARE THROUGH ALL, GRATING ALSO THROUGH ALL				L CHANNEL WITH 1" REGULAR HOLE PATTERN, ONE SIDE THREADED	MCMaster SUPPLIED L-STOCK, 1"x1"x8" (8982K4-8982K21)	CUT TO LENGTH, DRILL THROUGH HOLES, DRILL AND THREAD HOLES ON OTHER FACE			
5	1	BASE PANEL LEFT	PVC PANELING	MCMaster SUPPLIED PVC, 48"x48"x1/8" (8747K192)	WATER JET PART, ALL CUTS ARE THROUGH ALL	19	2	L STOCK 24" THREADED	L CHANNEL WITH 1" REGULAR HOLE PATTERN, ONE SIDE THREADED	MCMaster SUPPLIED L-STOCK, 1"x1"x8" (8982K4-8982K21)	CUT TO LENGTH, DRILL THROUGH HOLES, DRILL AND THREAD HOLES ON OTHER FACE			
6	1	BASE PANEL RIGHT	PVC PANELING	MCMaster SUPPLIED PVC, 48"x48"x1/8" (8747K192)	WATER JET PART, ALL CUTS ARE THROUGH ALL				L STOCK 21" THREADED	MCMaster SUPPLIED L-STOCK, 1"x1"x8" (8982K4-8982K21)	CUT TO LENGTH, DRILL THROUGH HOLES, DRILL AND THREAD HOLES ON OTHER FACE			
7	1	ELECTRONICS HOLDER BOARD	PVC PANELING	MCMaster SUPPLIED PVC, 48"x48"x1/8" (8747K192)	WATER JET PART, ALL CUTS ARE THROUGH ALL	20	2	L STOCK 21" THREADED	L CHANNEL WITH 1" REGULAR HOLE PATTERN, ONE SIDE THREADED	MCMaster SUPPLIED L-STOCK, 1"x1"x8" (8982K4-8982K21)	CUT TO LENGTH, DRILL THROUGH HOLES, DRILL AND THREAD HOLES ON OTHER FACE			
8	1	MOTOR MOUNT	PVC PANELING	MCMaster SUPPLIED PVC, 48"x48"x1/8" (8747K192)	WATER JET PART, ALL CUTS ARE THROUGH ALL				L STOCK 23" L BOTTOM	MCMaster SUPPLIED L-STOCK, 1"x1"x8" (8982K4-8982K21)	CUT TO LENGTH, DRILL HOLES			
9	3	BASE MOUNTED TURRET SLIDERS	ARCS OF PLASTIC THAT SUPPORT TURRET	MCMaster SUPPLIED UHMW SHEET, 24"x24"x3/16"(8752K412)	WATER JET PART THEN COUNTERSINK HOLES THE COUNTERSINK IS DRAWN AS THE DIMENSIONS OF THE SCREW WHICH IS INTENDED TO BE FLUSH MOUNTED.	21	1	L STOCK 23" R BOTTOM	L CHANNEL WITH 1" REGULAR HOLE PATTERN	MCMaster SUPPLIED L-STOCK, 1"x1"x8" (8982K4-8982K21)	CUT TO LENGTH, DRILL HOLES			
									22	1	L STOCK 21"	L CHANNEL WITH 1" REGULAR HOLE PATTERN	MCMaster SUPPLIED L-STOCK, 1"x1"x8" (8982K4-8982K21)	CUT TO LENGTH, DRILL HOLES
												23	1	L STOCK 21"
10	1	TURRET PULLY	32T PULLY	MCMaster SUPPLIED PULLY, 2.25" OD, 32T (1277N774)	BORE OUT CENTER	24	2	L STOCK 8"	L CHANNEL WITH 1" REGULAR HOLE PATTERN	MCMaster SUPPLIED L-STOCK, 1"x1"x8" (8982K4-8982K21)	CUT TO LENGTH, DRILL HOLES			
11	1	AXLE SHAFT	STEEL 1/2" SHAFT	MCMaster SUPPLIED SHAFT, .5" OD, 36" length (1346K19)	CUT TO LENGTH				L CHANNEL WITH 1" REGULAR HOLE PATTERN	MCMaster SUPPLIED L-STOCK, 1"x1"x8" (8982K4-8982K21)	CUT TO LENGTH, DRILL HOLES			
12	1	TURRET SHAFT	6" KEY STOCK	McMaster Supplied Keyed Shaft, 1 5/8" OD, 6" length (1497K183_1045)	CUT HOLE, OFF CENTER	25	1	L STOCK 7"	L CHANNEL WITH 1" REGULAR HOLE PATTERN	MCMaster SUPPLIED L-STOCK, 1"x1"x8" (8982K4-8982K21)	CUT TO LENGTH, DRILL HOLES			
13	1	MOTOR TO PULLY ADAPTER	MACHINED SHAFT END	MCMaster SUPPLIED SHAFT END, 31/4" LONG, 1 1/2" OD (3463N52)	MACHINE END				L CHANNEL WITH 1" REGULAR HOLE PATTERN	MCMaster SUPPLIED L-STOCK, 1"x1"x8" (8982K4-8982K21)	CUT TO LENGTH, DRILL HOLES			
14	2	TURRET SHAFT BUSHING	BUSHINGS TO HOLD TURRET SHAFT	MCMaster SUPPLIED BUSHING, 2" LONG, 2" OD, 15/8" ID (6338K599)	CUT BUSHING TO LENGTH	27	1	L STOCK 1"	L BRACKET	MCMaster SUPPLIED L-STOCK, 1"x1"x8" (8982K4-8982K21)	CUT TO LENGTH, DRILL HOLES			
									28	2	L STOCK 6.125"	L CHANNEL WITH 1.75" REGULAR HOLE PATTERN	MCMaster SUPPLIED L-STOCK, 1"x1"x8" (8982K4-8982K21)	CUT TO LENGTH, DRILL HOLES
15	2	FRONT LEGS	1"x1" ALUMINUM TUBE	MCMaster SUPPLIED 1x1 TUBE STOCK, 1/16" WALL (6546K53)	CUT TO LENGTH, DRILL #10 CLEARANCE HOLES									

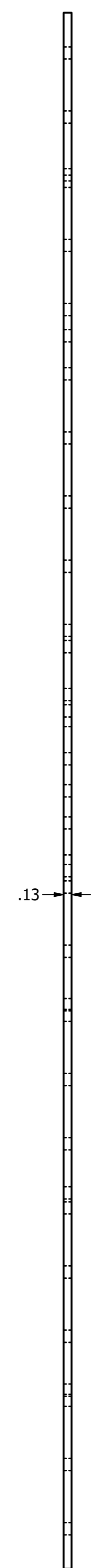
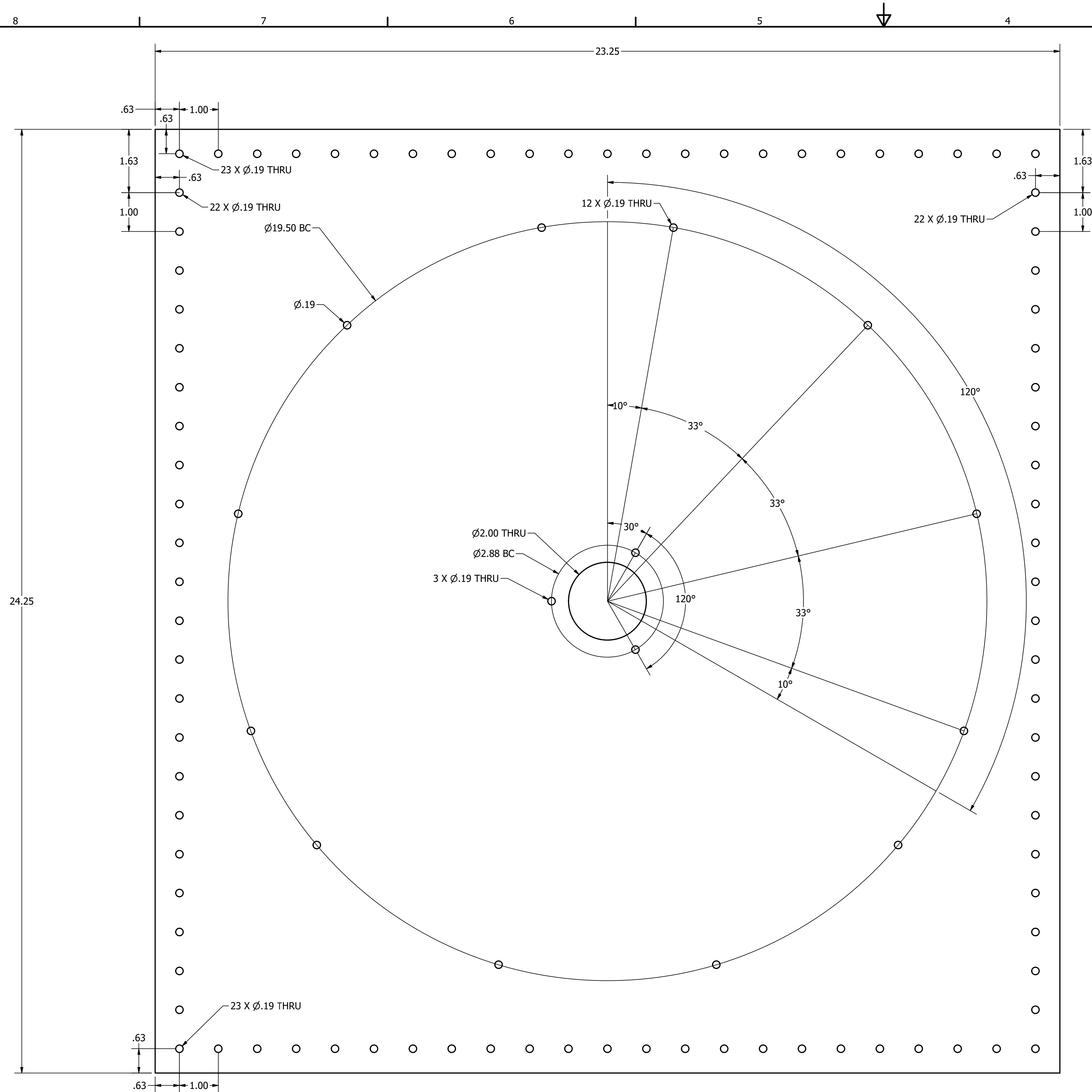
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CHECKED		TITLE		
QA		BASE FABRICATION INSTRUCTIONS		
MFG		SIZE D	DWG NO 21	REV 1
APPROVED cironer		SCALE	SHEET 1 OF 30	



INSTRUCTIONS:
WATER JET PART, ALL CUTS ARE THROUGH ALL

MCMaster SUPPLIED PVC, 48"x48"x¹/₈" (8747K192)

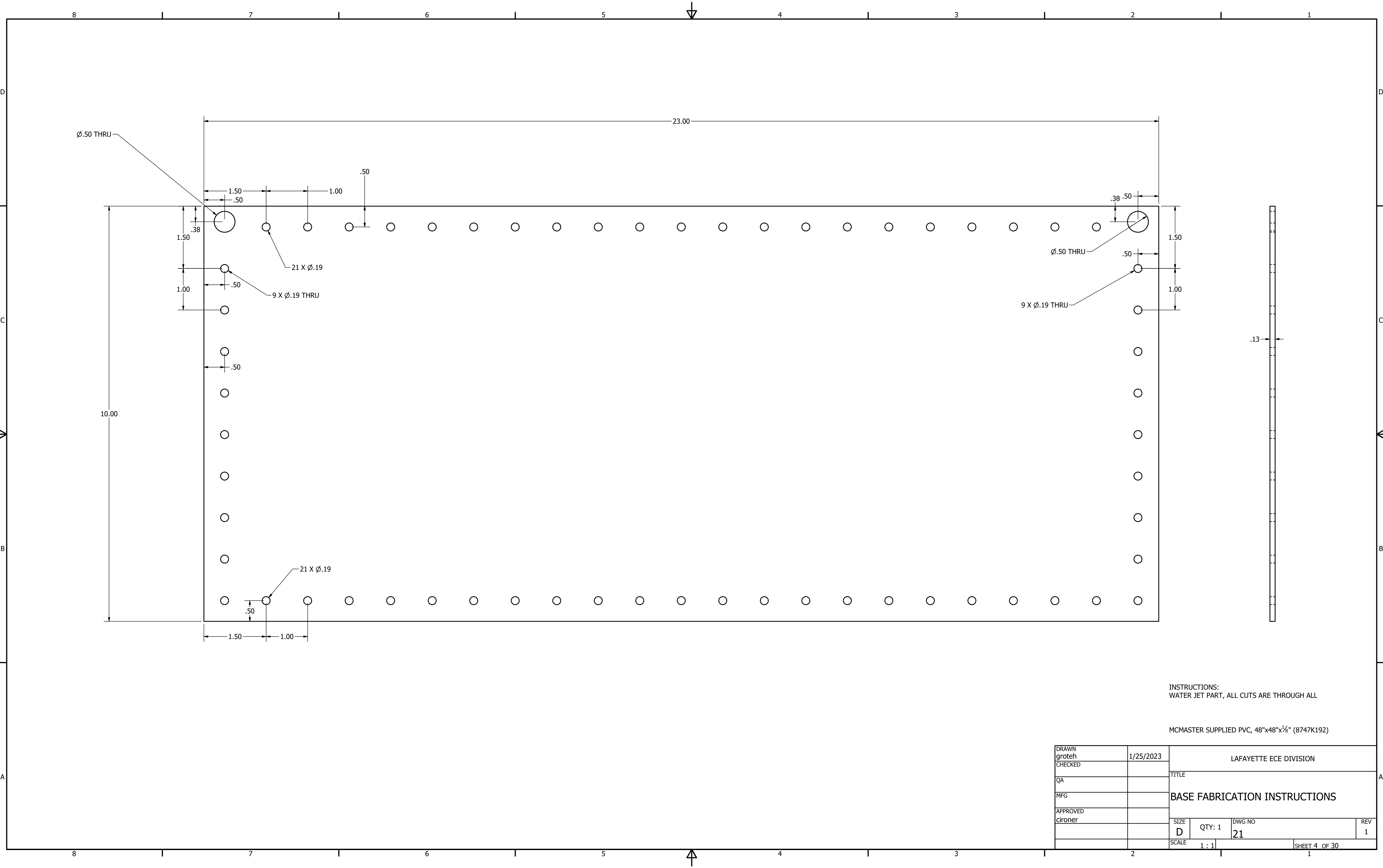
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MFG		SIZE	QTY: 1	DWG NO
APPROVED cironer		D	21	REV 1
SCALE		1:1.5	SHEET 2 OF 30	



INSTRUCTIONS:
WATER JET PART, ALL CUTS ARE THROUGH ALL

MCMaster SUPPLIED PVC, 48"x48"x $\frac{1}{8}$ " (8747K192)

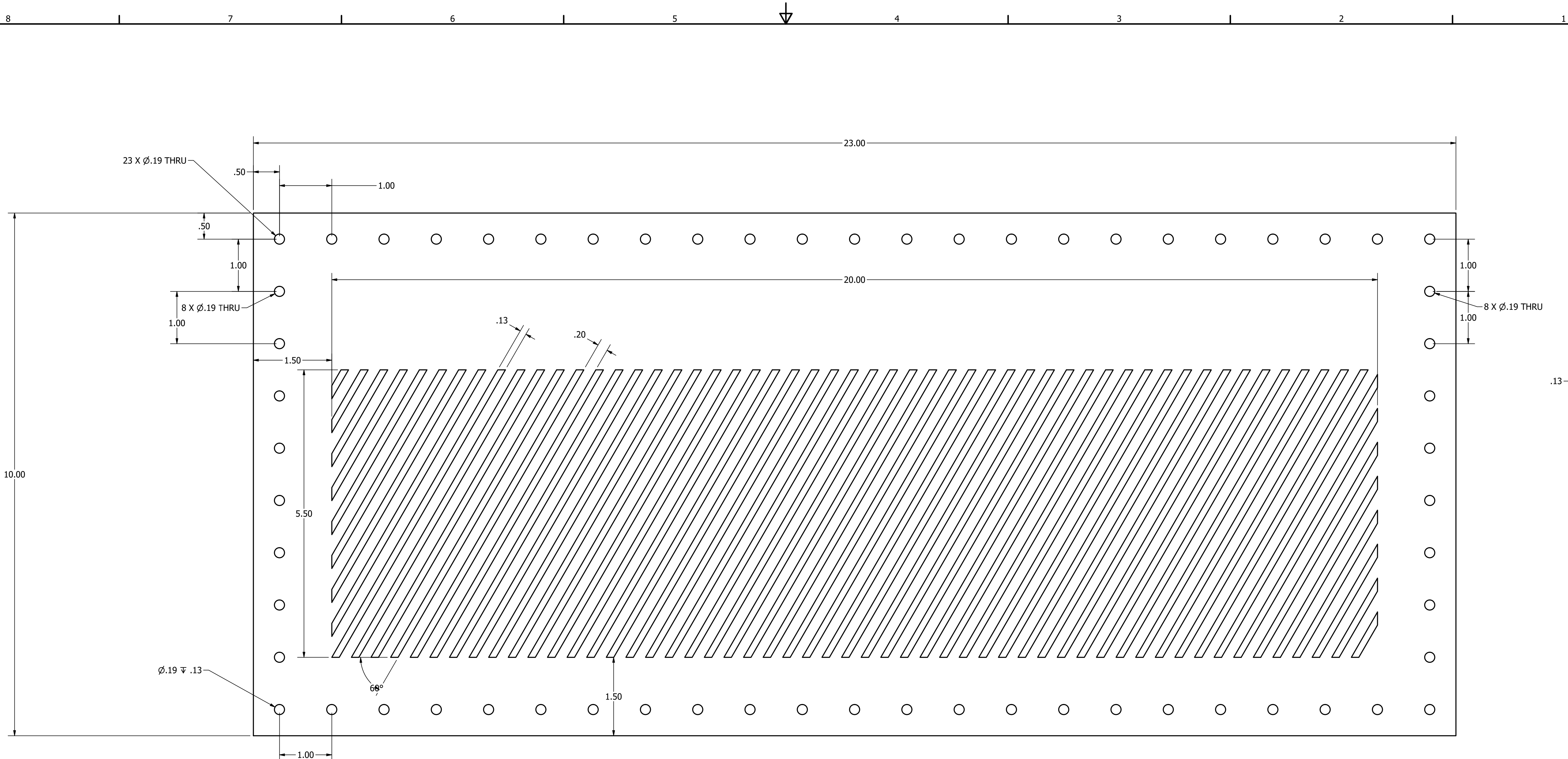
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QA		BASE FABRICATION INSTRUCTIONS		
MFG		SIZE	QTY: 1	DWG NO
APPROVED ctroner		D	21	REV 1
SCALE		1 : 1.5		SHEET 3 OF 30



INSTRUCTIONS:
WATER JET PART, ALL CUTS ARE THROUGH ALL

MCMASTER SUPPLIED PVC, 48"x48"x¹/₈" (8747K192)

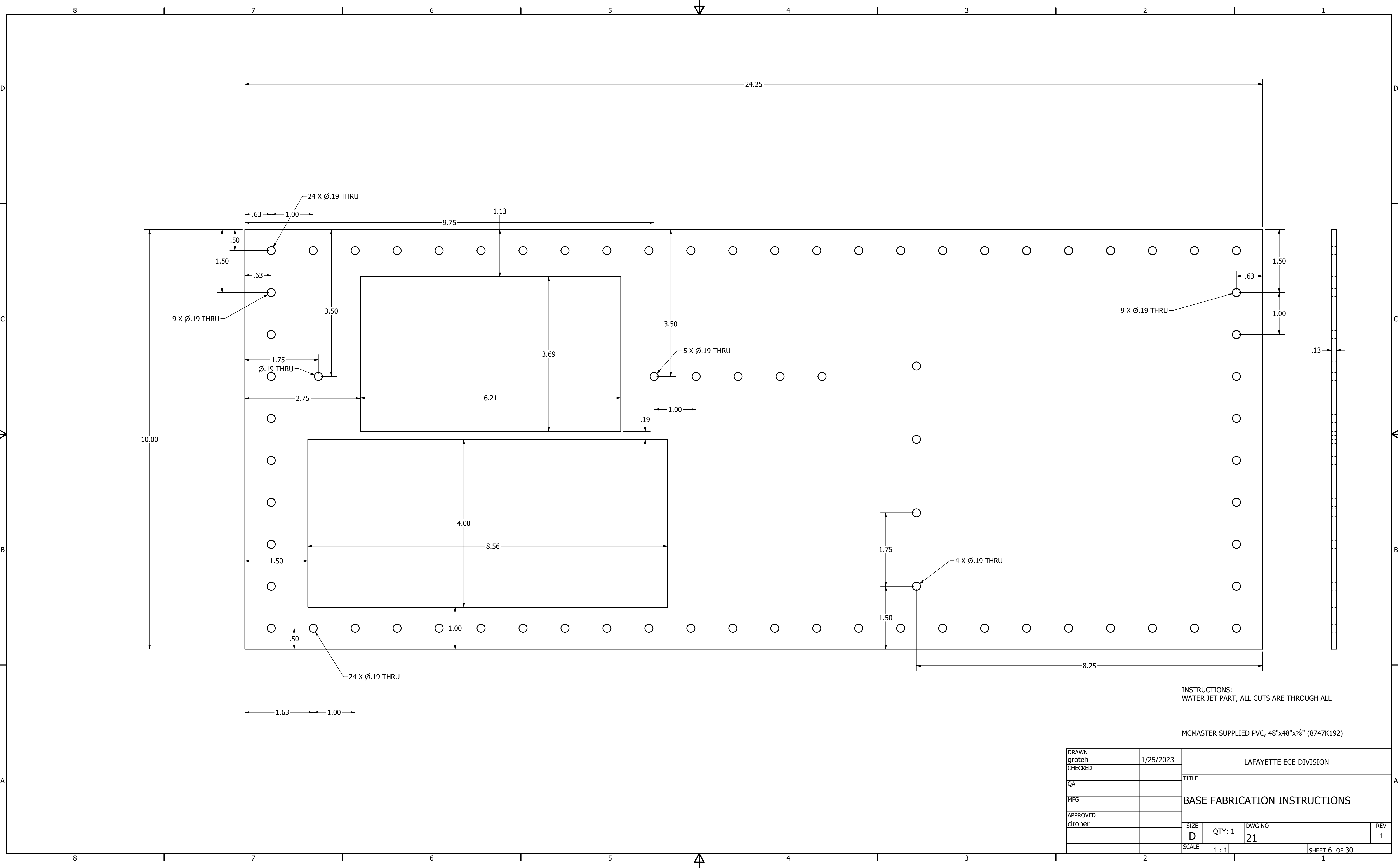
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QA		BASE FABRICATION INSTRUCTIONS		
MFG		SIZE	QTY: 1	DWG NO
APPROVED ctroner		D	21	1
		SCALE	1 : 1	SHEET 4 OF 30



INSTRUCTIONS:
 WATER JET PART, ALL CUTS ARE THROUGH ALL, GRATING ALSO THROUGH ALL

MCMASTER SUPPLIED PVC, 48"x48"x¹/₈" (8747K192)

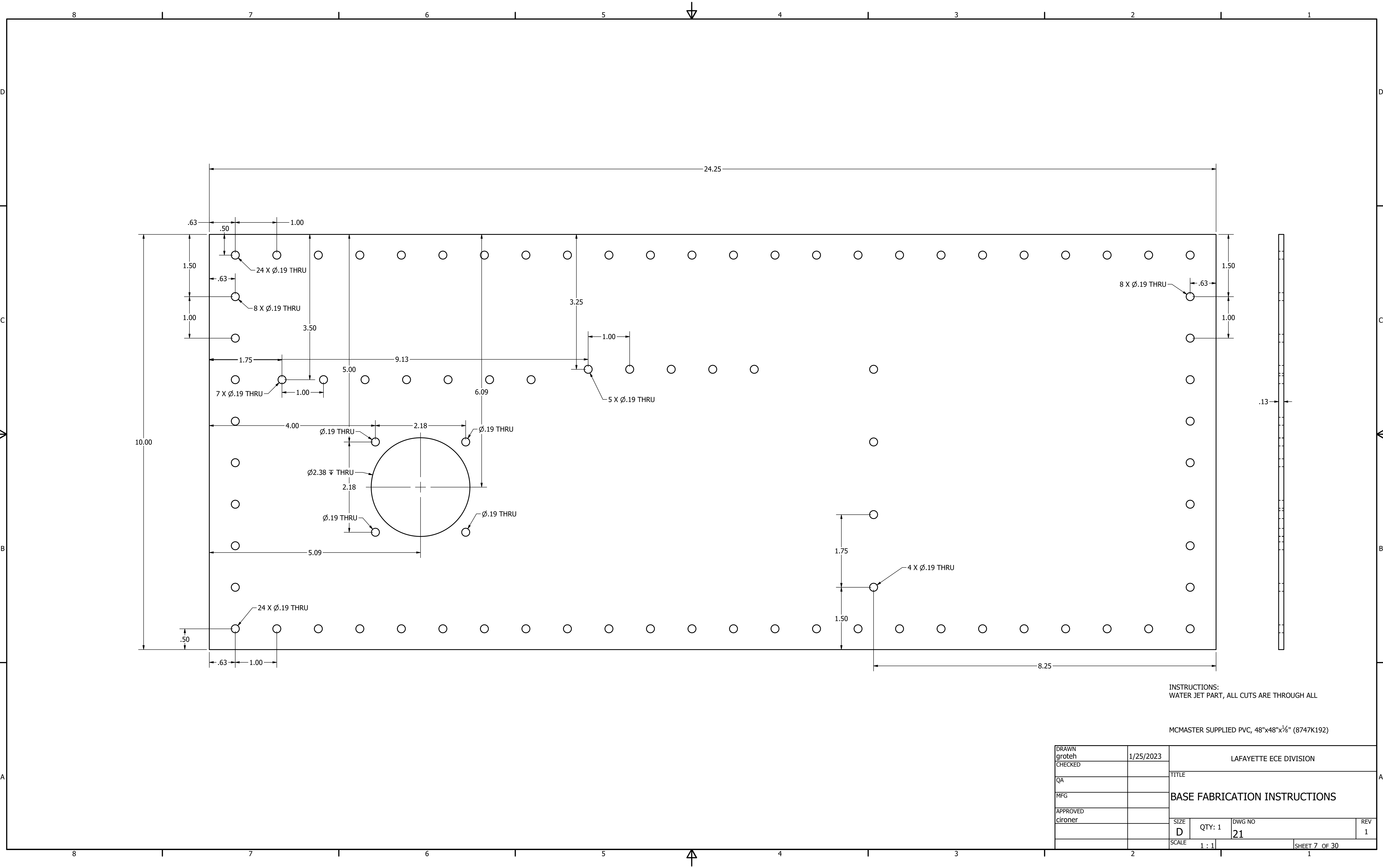
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QA		BASE FABRICATION INSTRUCTIONS		
MFG		SIZE	QTY: 1	DWG NO
APPROVED ctroner		D	21	REV 1
		SCALE	1 : 1	SHEET 5 OF 30



INSTRUCTIONS:
WATER JET PART, ALL CUTS ARE THROUGH ALL

MCMaster SUPPLIED PVC, 48"x48"x $\frac{1}{8}$ " (8747K192)

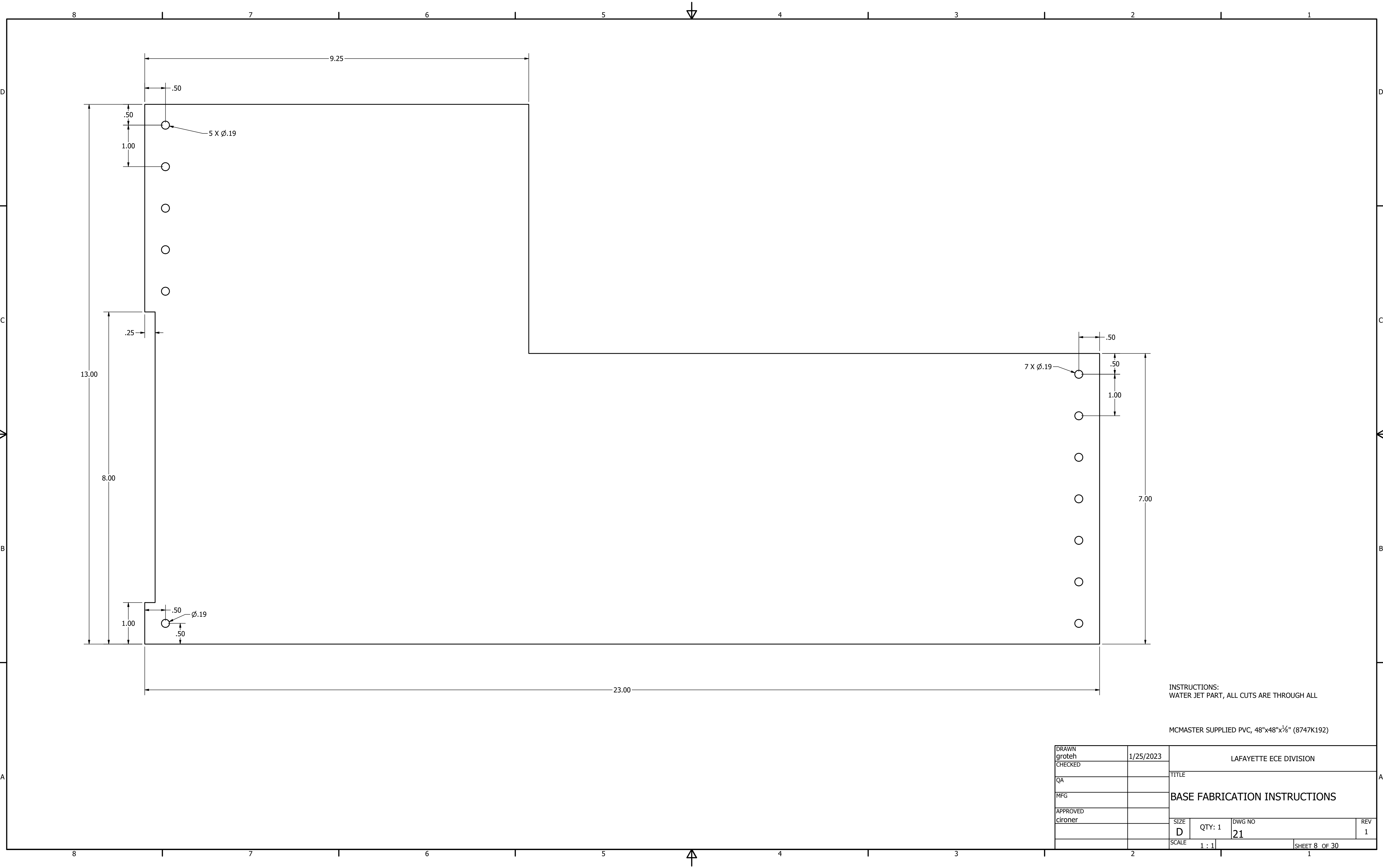
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QA		BASE FABRICATION INSTRUCTIONS		
MFG		SIZE	QTY: 1	DWG NO
APPROVED cironer		D	21	REV 1
		SCALE	1 : 1	SHEET 6 OF 30



INSTRUCTIONS:
WATER JET PART, ALL CUTS ARE THROUGH ALL

MCMASTER SUPPLIED PVC, 48"x48"x¹/₈" (8747K192)

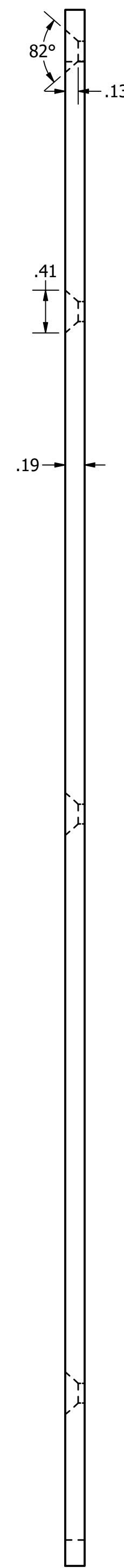
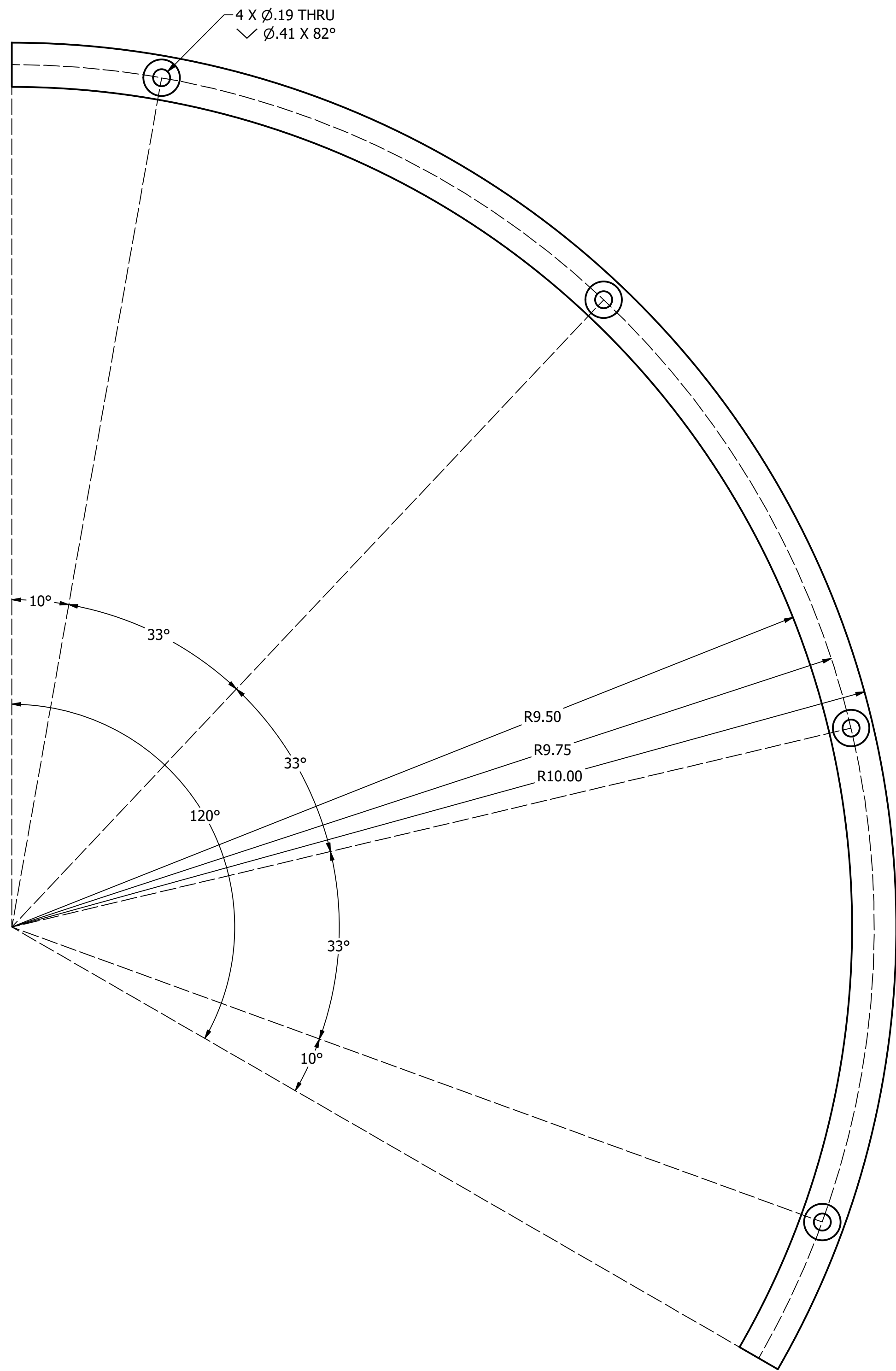
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QA		BASE FABRICATION INSTRUCTIONS		
MFG		SIZE	QTY: 1	DWG NO
APPROVED cironer		D	21	REV 1
		SCALE	1 : 1	SHEET 7 OF 30



INSTRUCTIONS:
WATER JET PART, ALL CUTS ARE THROUGH ALL

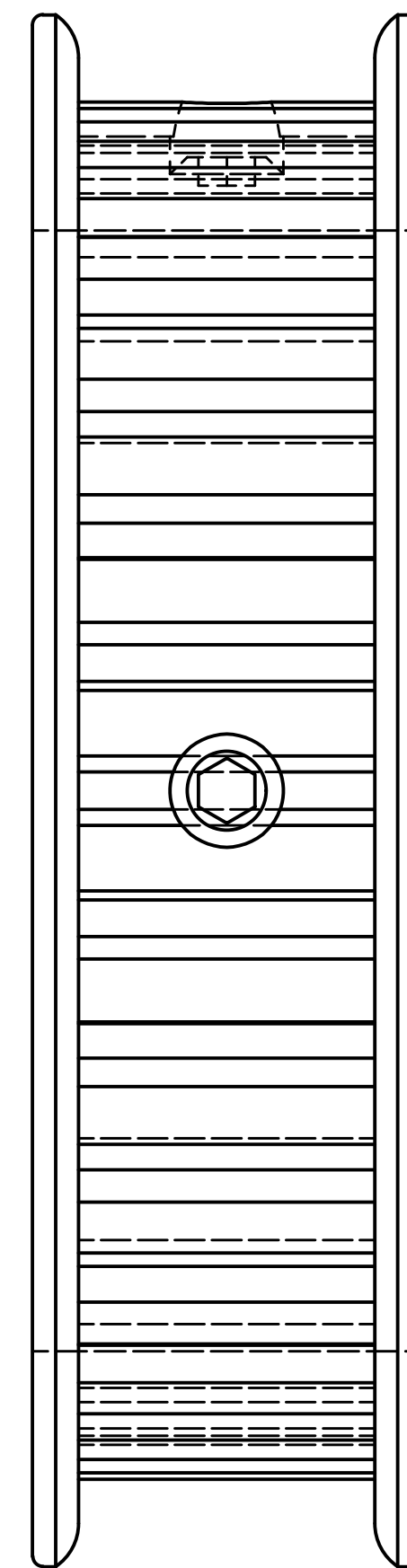
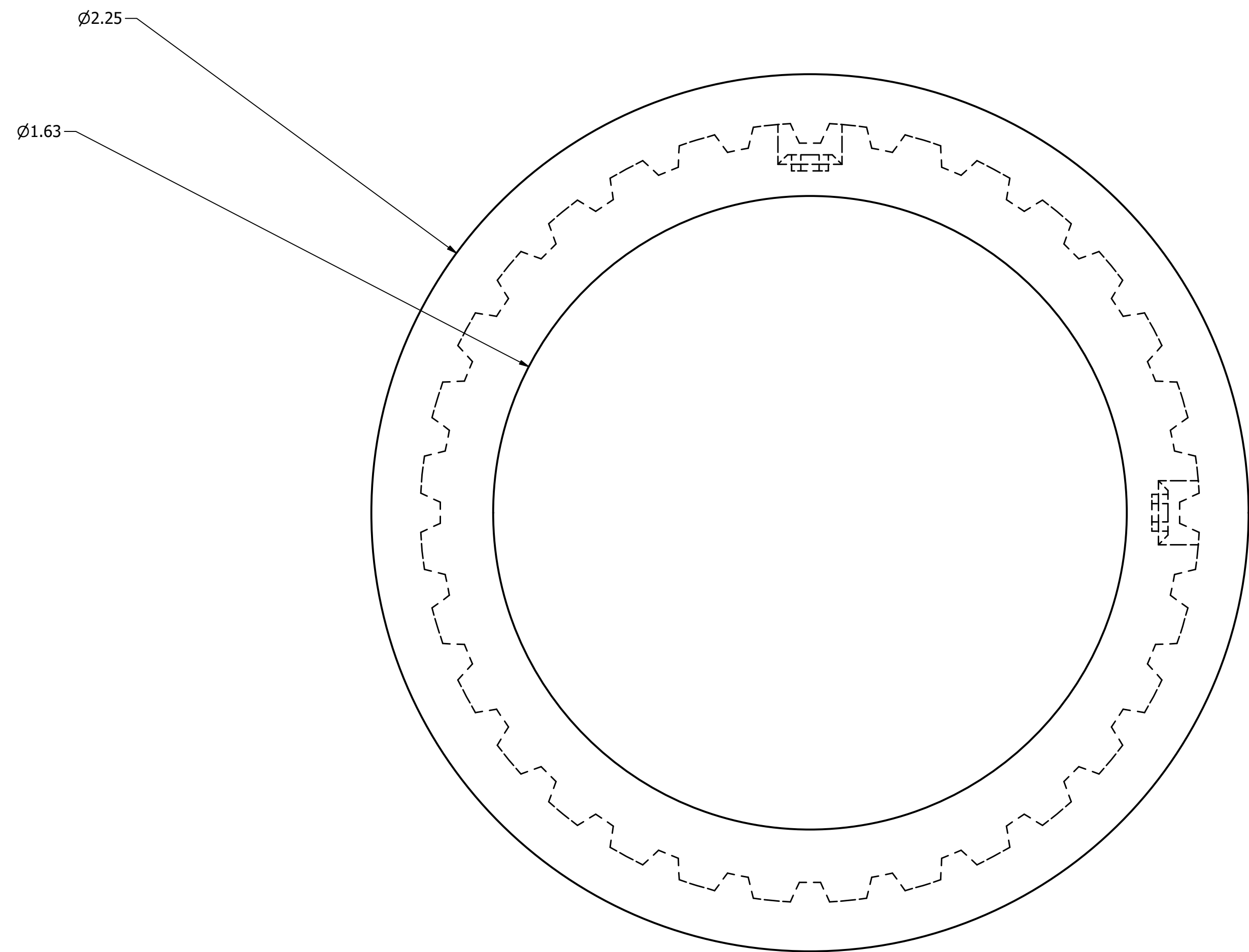
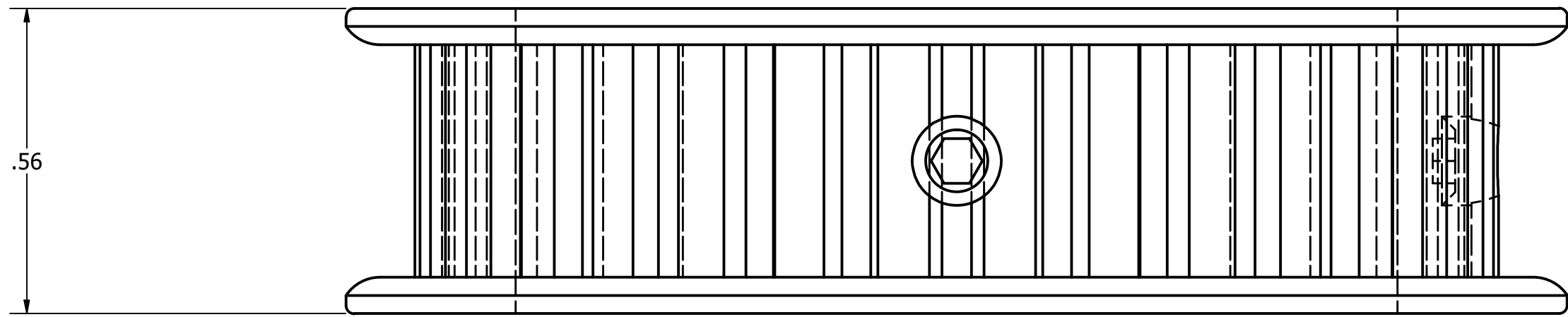
MCMaster SUPPLIED PVC, 48"x48"x1/8" (8747K192)

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CHECKED		TITLE		
QA		BASE FABRICATION INSTRUCTIONS		
MFG				
APPROVED cironer		SIZE D	QTY: 1	DWG NO 21
		SCALE 1 : 1		REV 1
				SHEET 8 OF 30



INSTRUCTIONS:
 WATER JET PART THEN COUNTERSINK HOLES
 THE COUNTERSINK IS DRAWN AS THE DIMENSIONS OF THE SCREW WHICH IS INTENDED TO BE FLUSH MOUNTED.
 NOTE: THE DXF FILE IS GIVEN FOR BOTH TOP AND BOTTOM SIDES, BUT ONLY THE TOP SIDE DXF HAS THE COUNTERSINK VISIBLE
 MCMaster SUPPLIED UHMW SHEET, 24"x24"x $\frac{3}{16}$ " (8752K412)

DRAWN groteh	1/25/2023	LAFAYETTE ECE DIVISION		
CHECKED		TITLE		
QA		BASE FABRICATION INSTRUCTIONS		
MFG		SIZE	QTY: 3	DWG NO
APPROVED ctroner		D	21	REV
		SCALE	1 : 1	1
				SHEET 10 OF 30



INSTRUCTIONS:
BORE OUT CENTER

MCMaster SUPPLIED PULLY, 2.25" OD, 32T (1277N774)

DRAWN groteh	1/25/2023	LAFAYETTE ECE DIVISION		
CHECKED		TITLE		
QA		BASE FABRICATION INSTRUCTIONS		
MFG				
APPROVED ctroner		SIZE D	QTY: 1 21	DWG NO 21
		SCALE 4 : 1		REV 1
				SHEET 11 OF 30



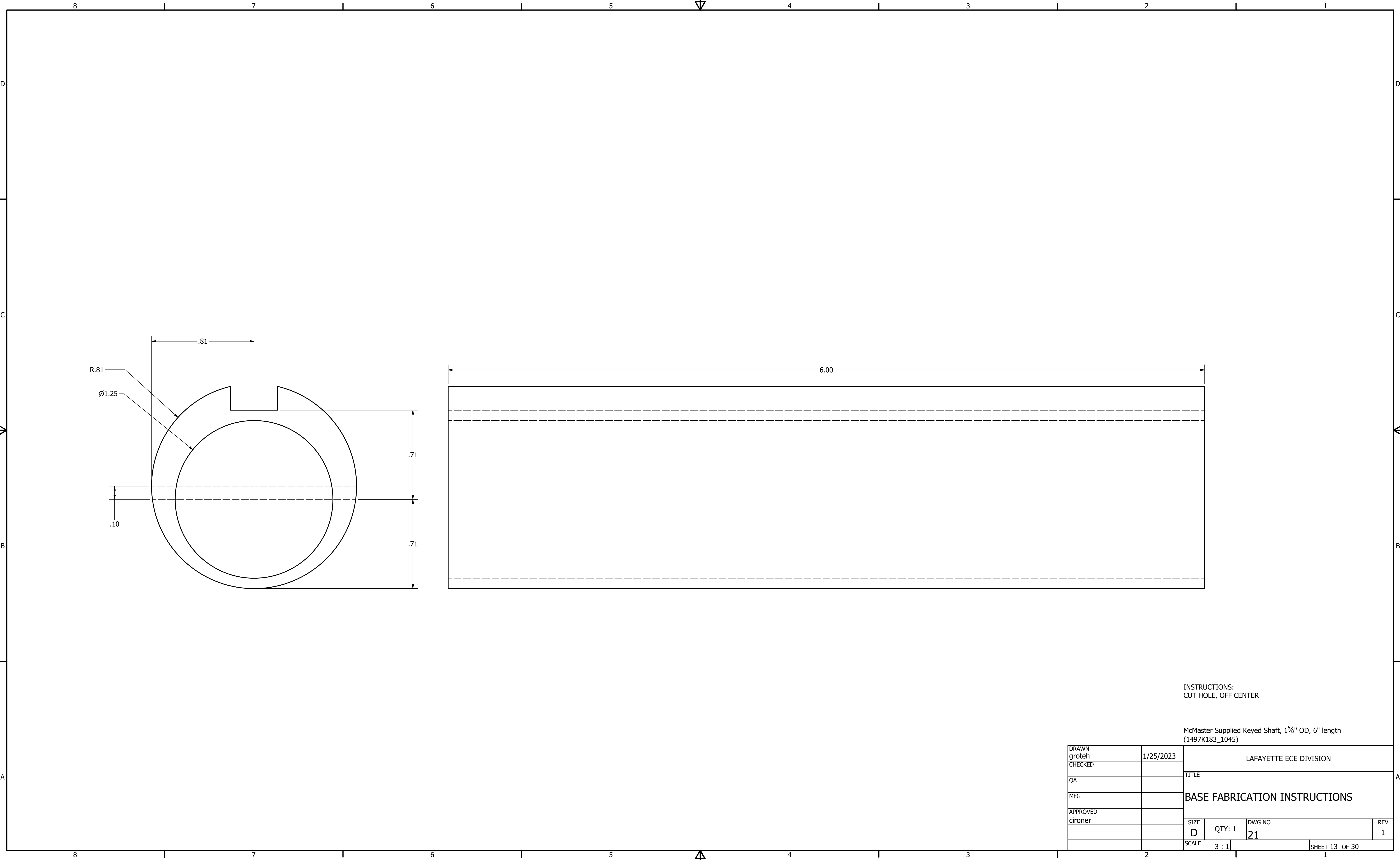
29.25

∅.50

INSTRUCTIONS:
CUT TO LENGTH

MCMASTER SUPPLIED SHAFT, .5" OD, 36" length (1346K19)

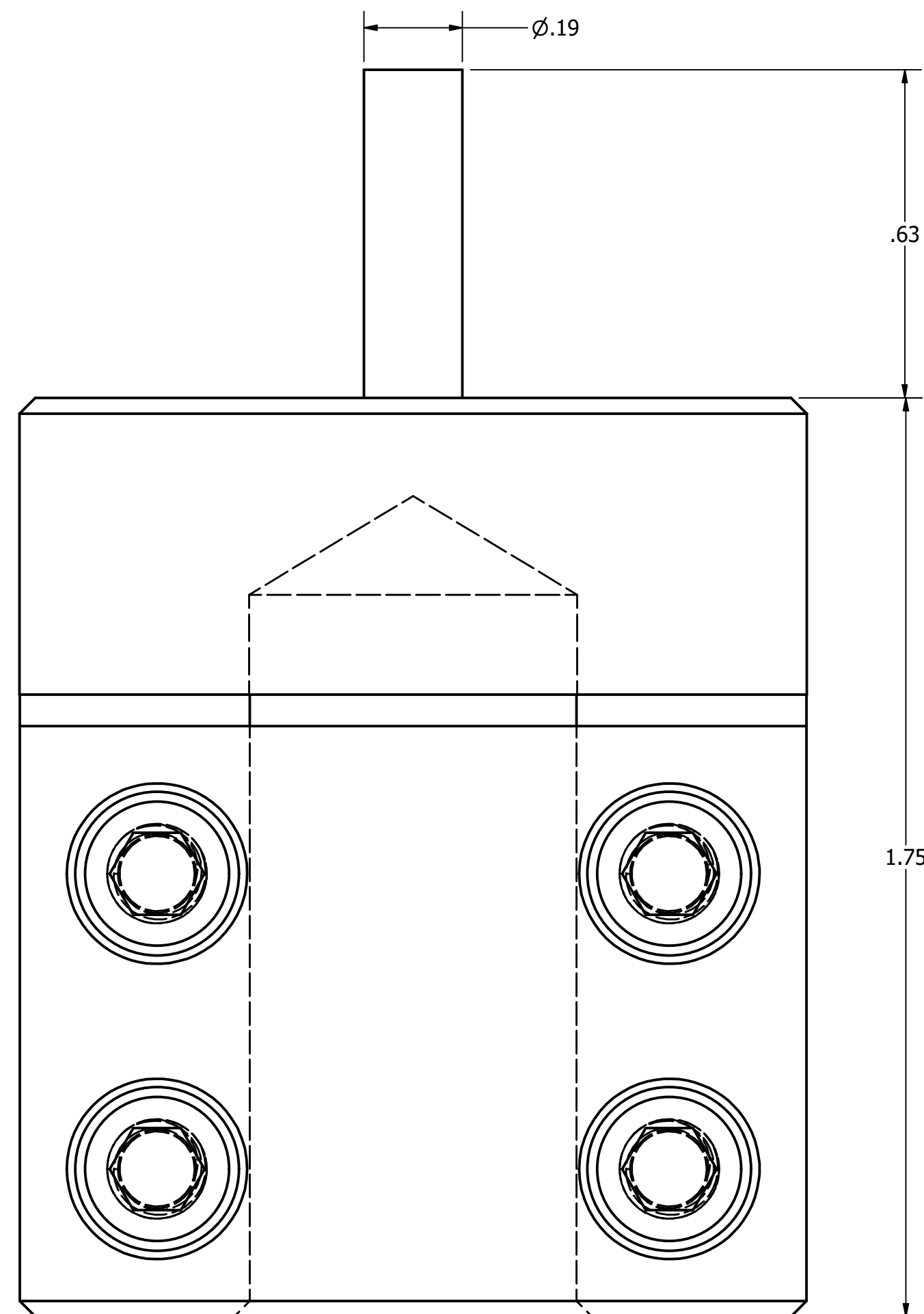
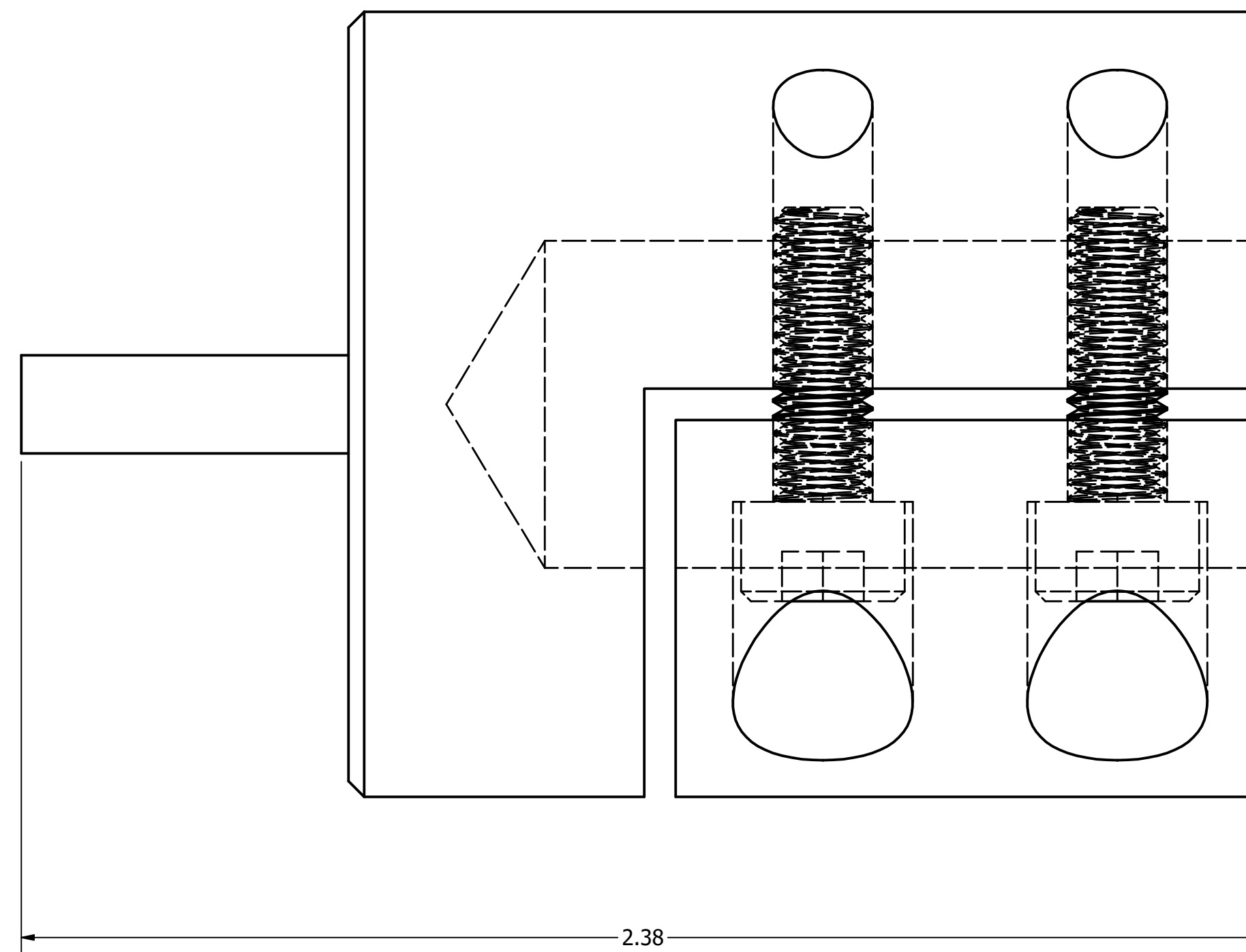
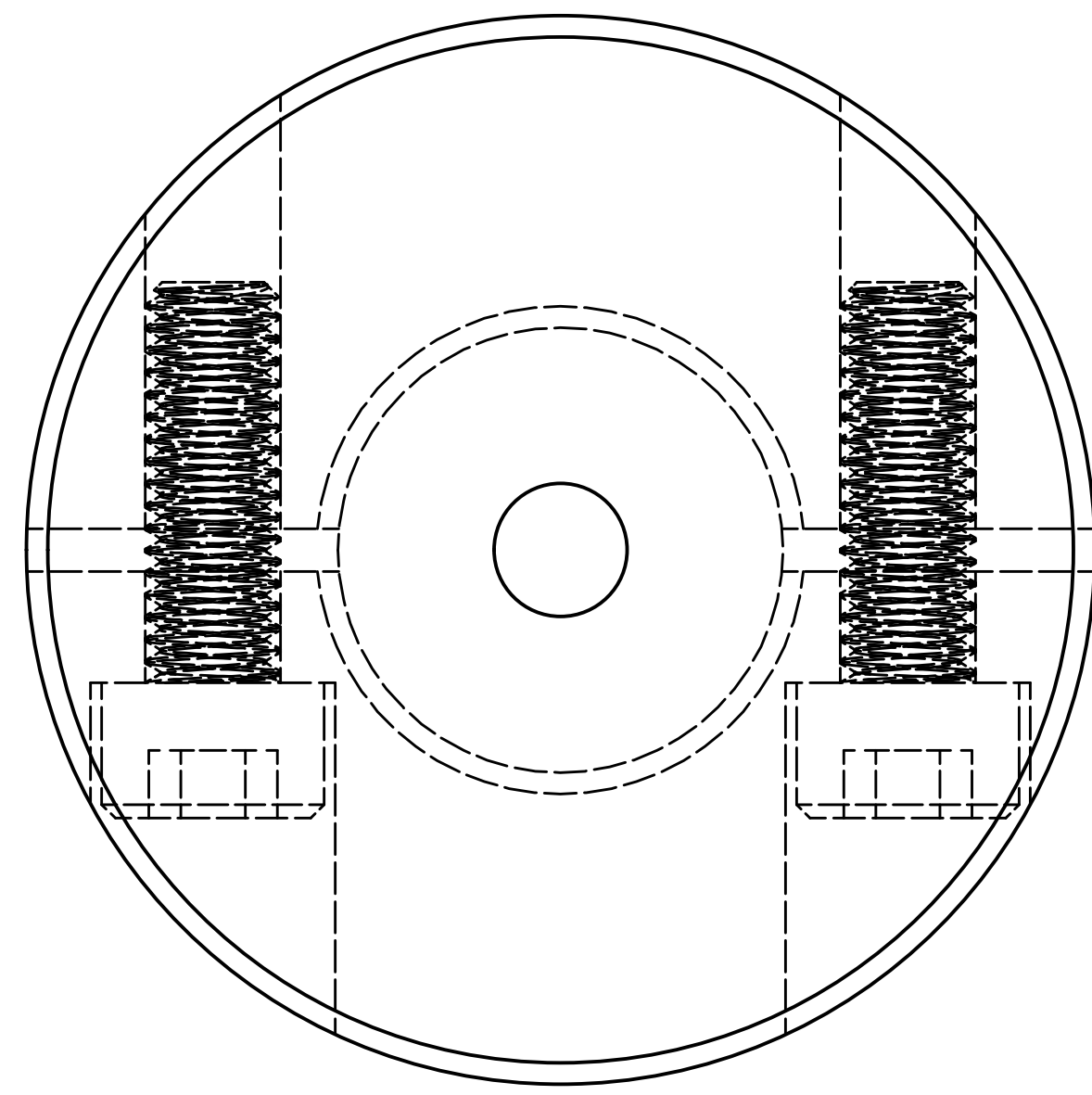
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QA		BASE FABRICATION INSTRUCTIONS		
MFG		SIZE	QTY: 1	DWG NO
APPROVED ctroner		D	21	REV 1
		SCALE	1 : 1	SHEET 12 OF 30



INSTRUCTIONS:
CUT HOLE, OFF CENTER

McMaster Supplied Keyed Shaft, 1 5/8" OD, 6" length
(1497K183_1045)

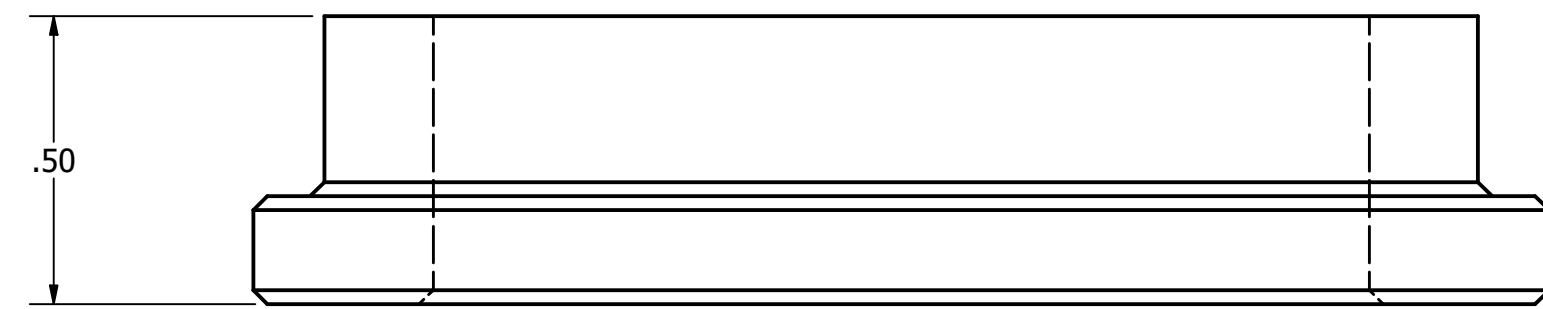
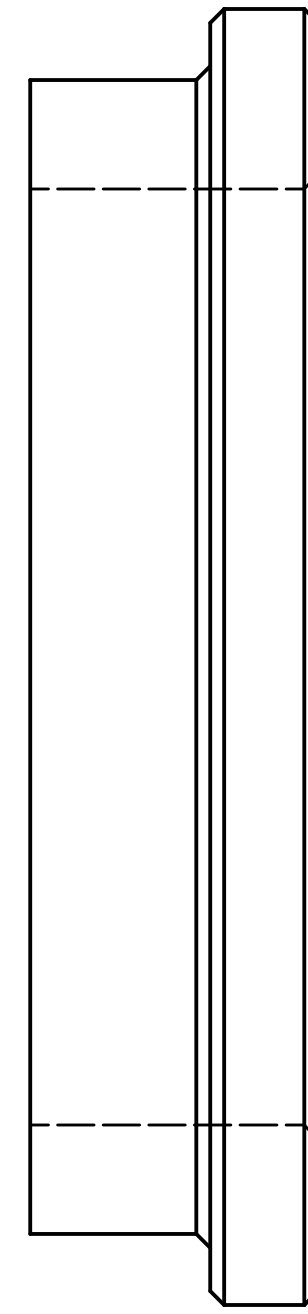
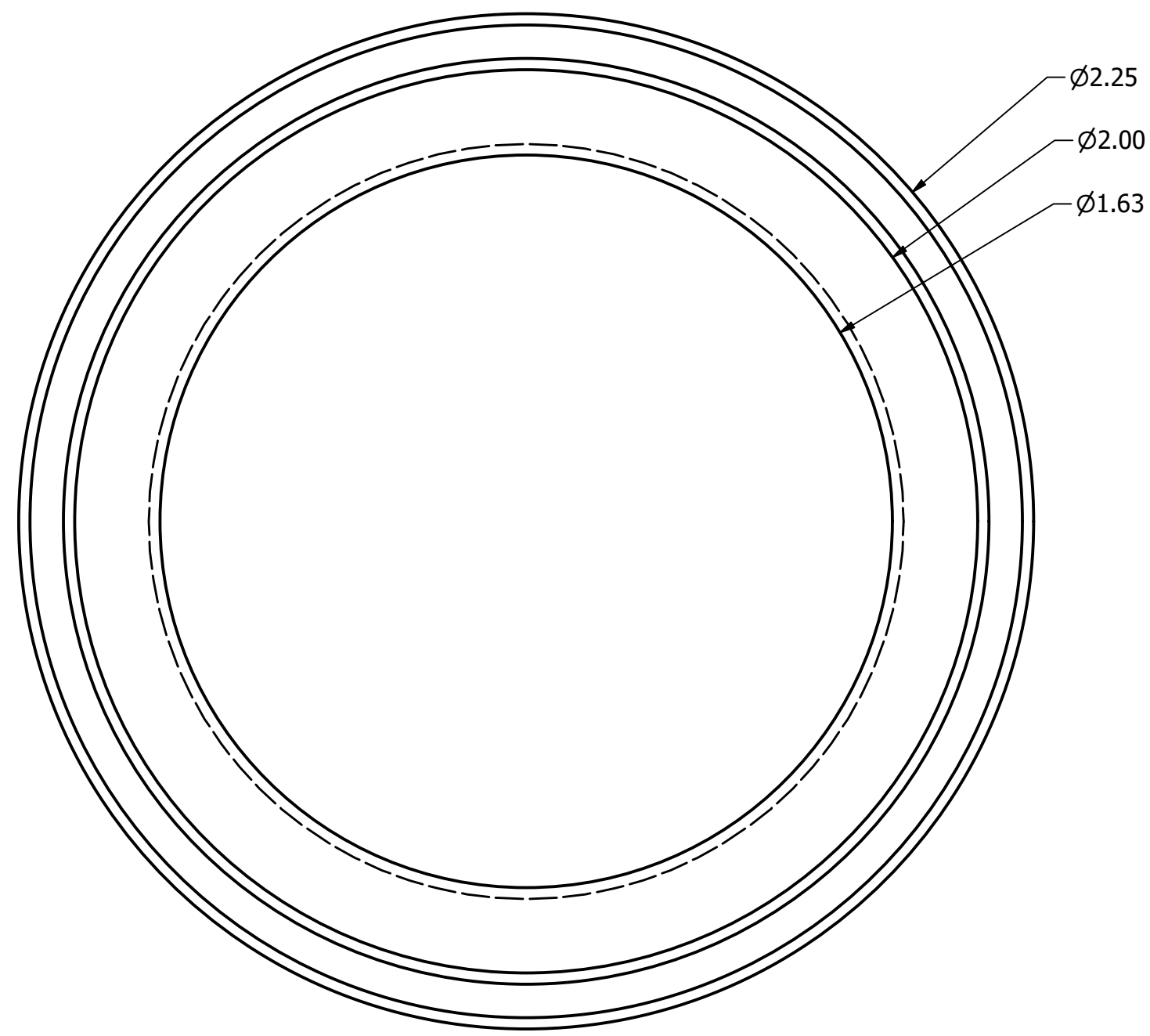
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CHECKED		TITLE		
QA		BASE FABRICATION INSTRUCTIONS		
MFG				
APPROVED ctroner		SIZE D	QTY: 1	DWG NO 21
		SCALE 3 : 1		REV 1
				SHEET 13 OF 30



INSTRUCTIONS:
MACHINE END

MCMASTER SUPPLIED SHAFT END, 3/4" LONG, 1 1/2" OD (3463N52)

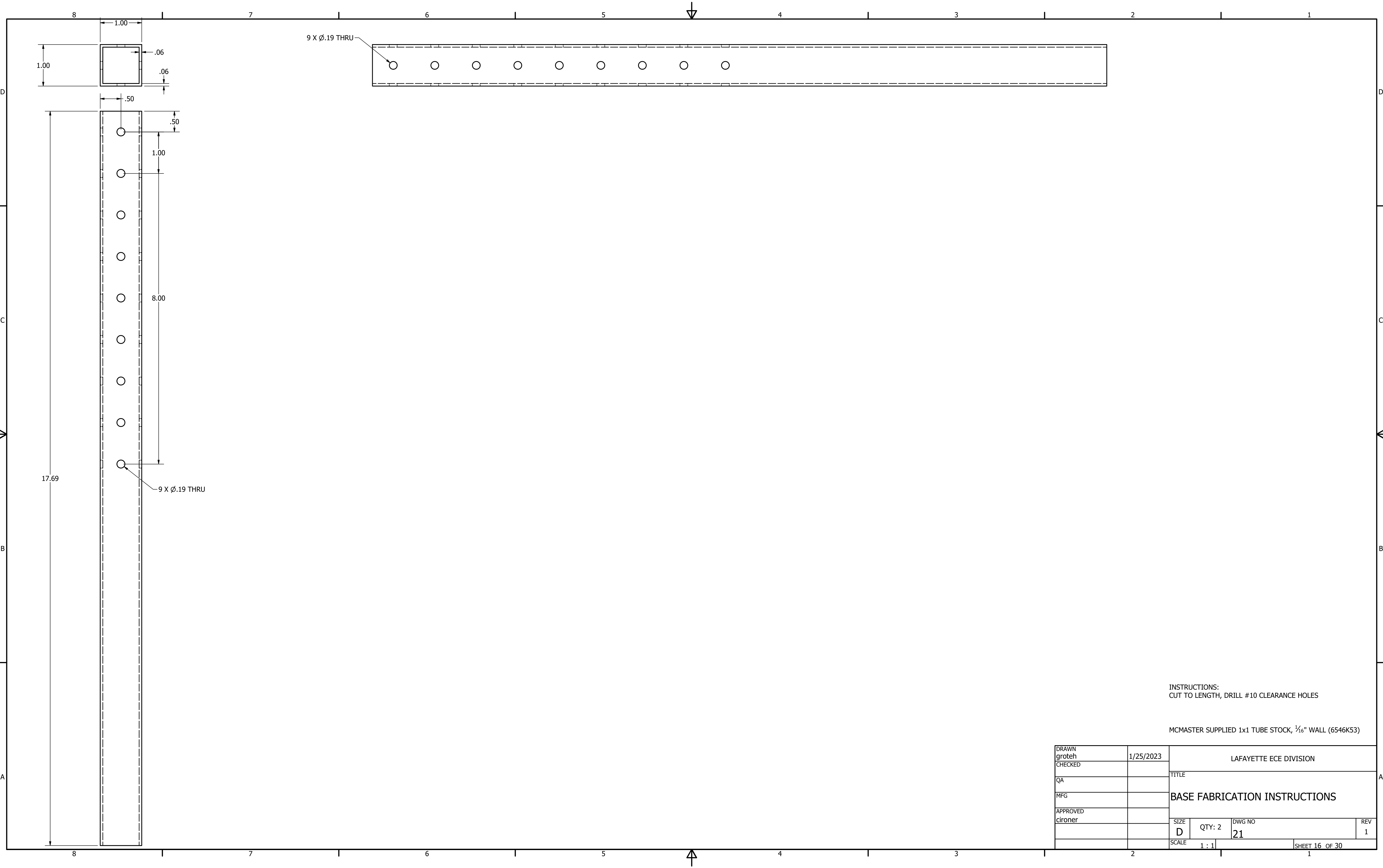
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QA		BASE FABRICATION INSTRUCTIONS		
MFG		SIZE	QTY: 1	DWG NO
APPROVED ctroner		D	21	REV 1
		SCALE	4 : 1	SHEET 14 OF 30



INSTRUCTIONS:
CUT BUSHING TO LENGTH

MCMASTER SUPPLIED BUSHING, 2" LONG, 2" OD, 1 1/8" ID
(6338K599)

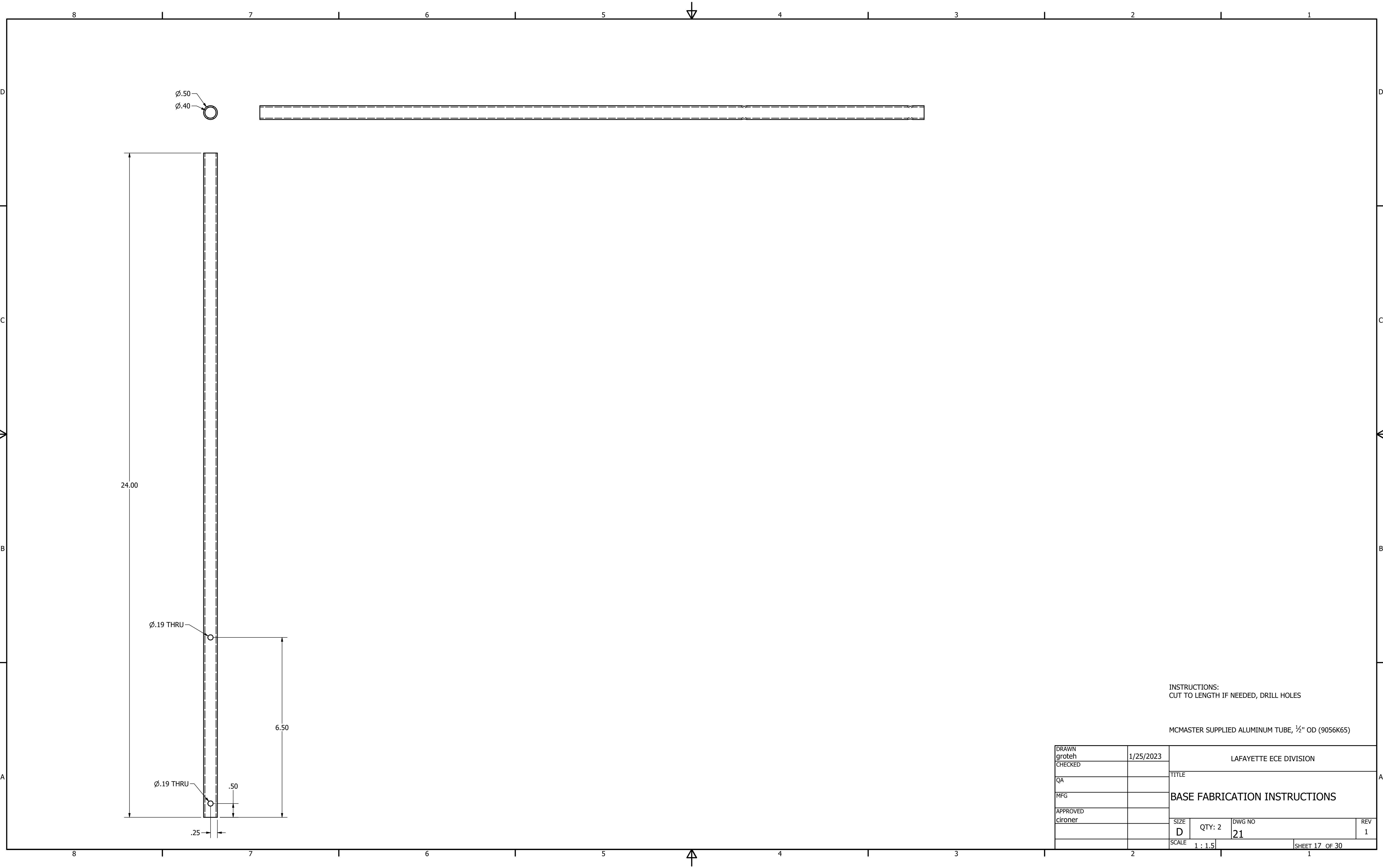
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QA		BASE FABRICATION INSTRUCTIONS		
MFG		SIZE	QTY: 2	DWG NO
APPROVED ctroner		D	21	REV 1
SCALE		3 : 1		SHEET 15 OF 30



INSTRUCTIONS:
CUT TO LENGTH, DRILL #10 CLEARANCE HOLES

MCMASTER SUPPLIED 1x1 TUBE STOCK, 1/16" WALL (6546K53)

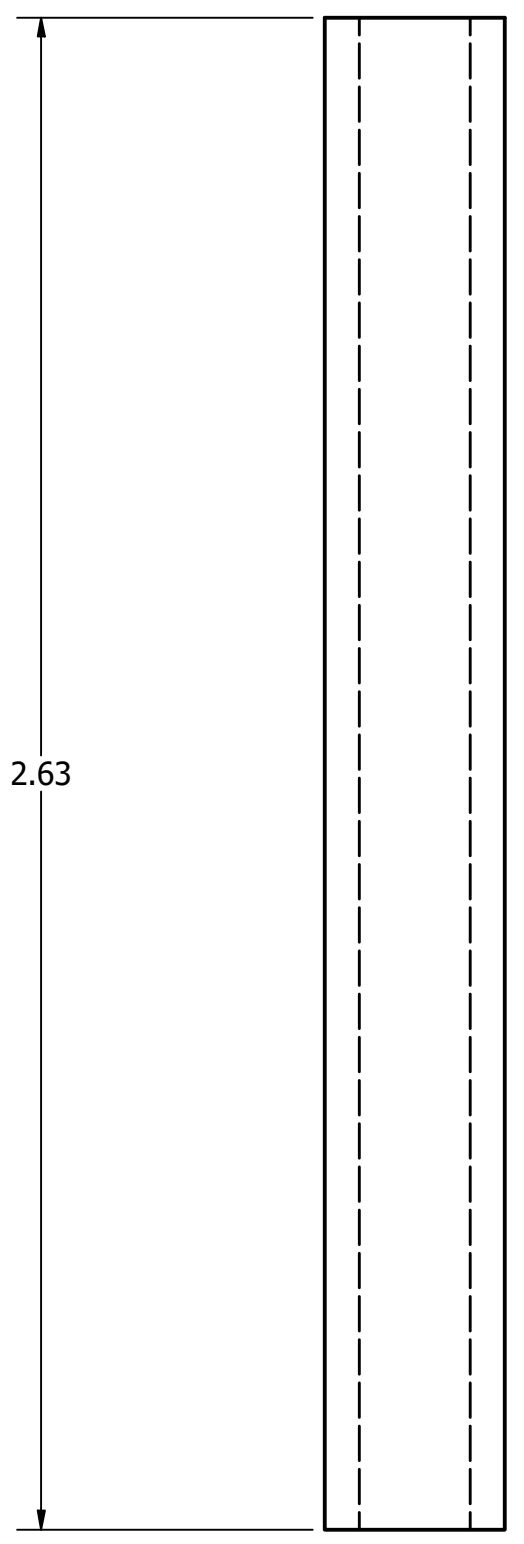
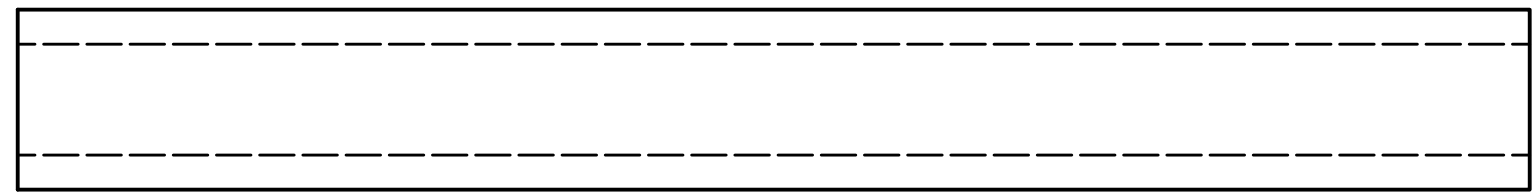
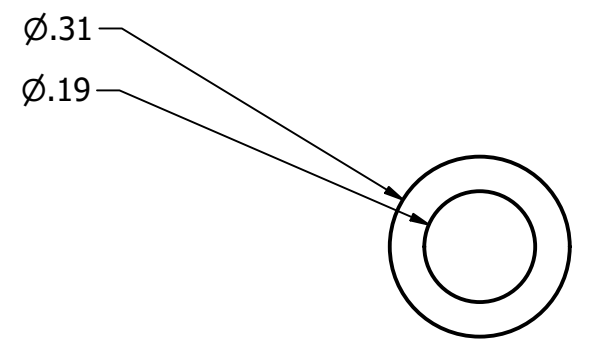
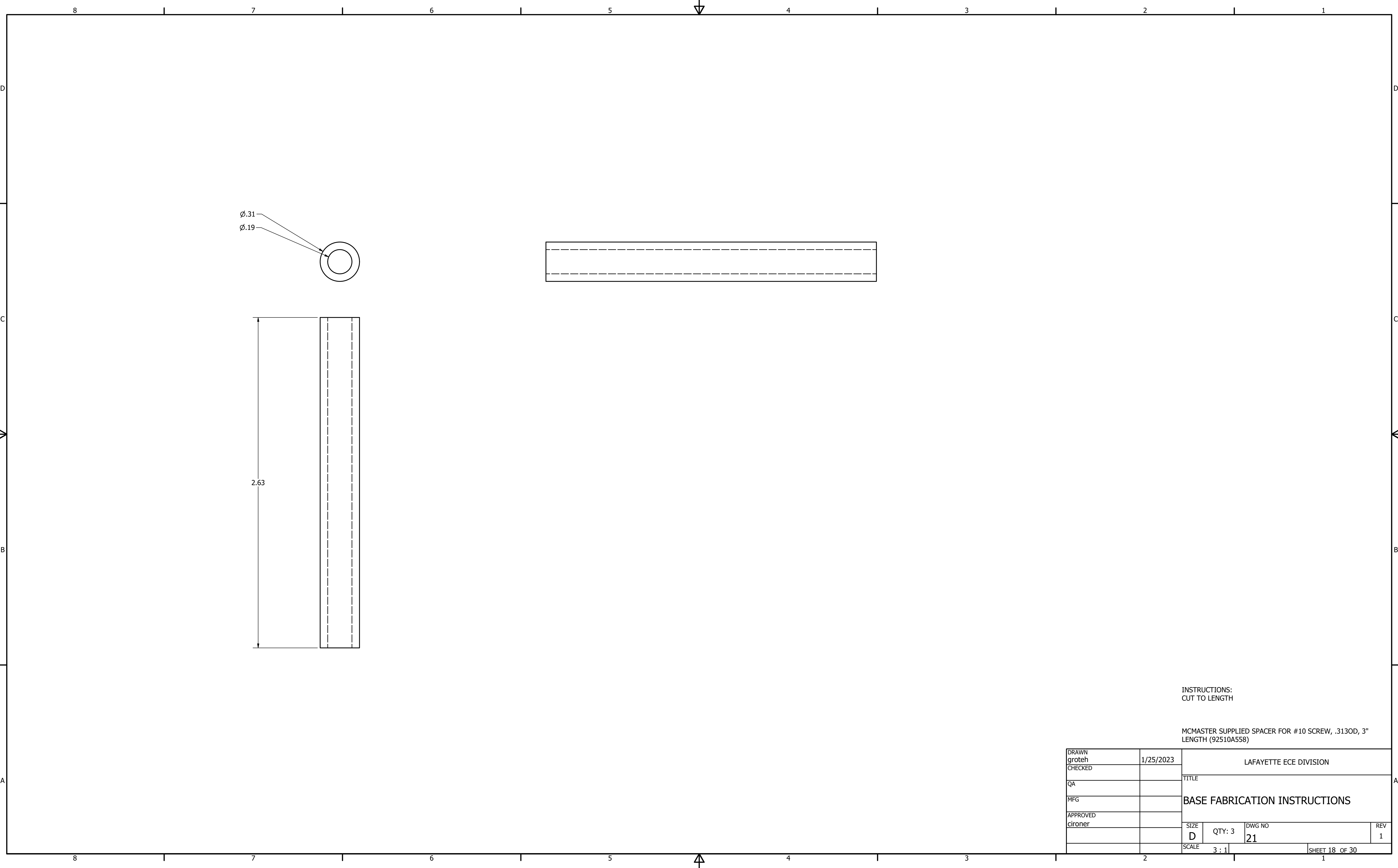
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QA		BASE FABRICATION INSTRUCTIONS		
MFG		SIZE	QTY: 2	DWG NO
APPROVED cironer		D	21	REV 1
		SCALE	1 : 1	SHEET 16 OF 30



INSTRUCTIONS:
CUT TO LENGTH IF NEEDED, DRILL HOLES

MCMASTER SUPPLIED ALUMINUM TUBE, 1/2" OD (9056K65)

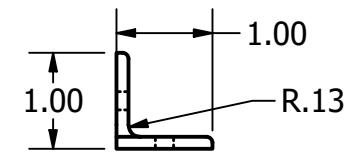
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MFG		SIZE	QTY: 2	DWG NO
APPROVED cironer		D	21	REV 1
SCALE 1 : 1.5		SHEET 17 OF 30		



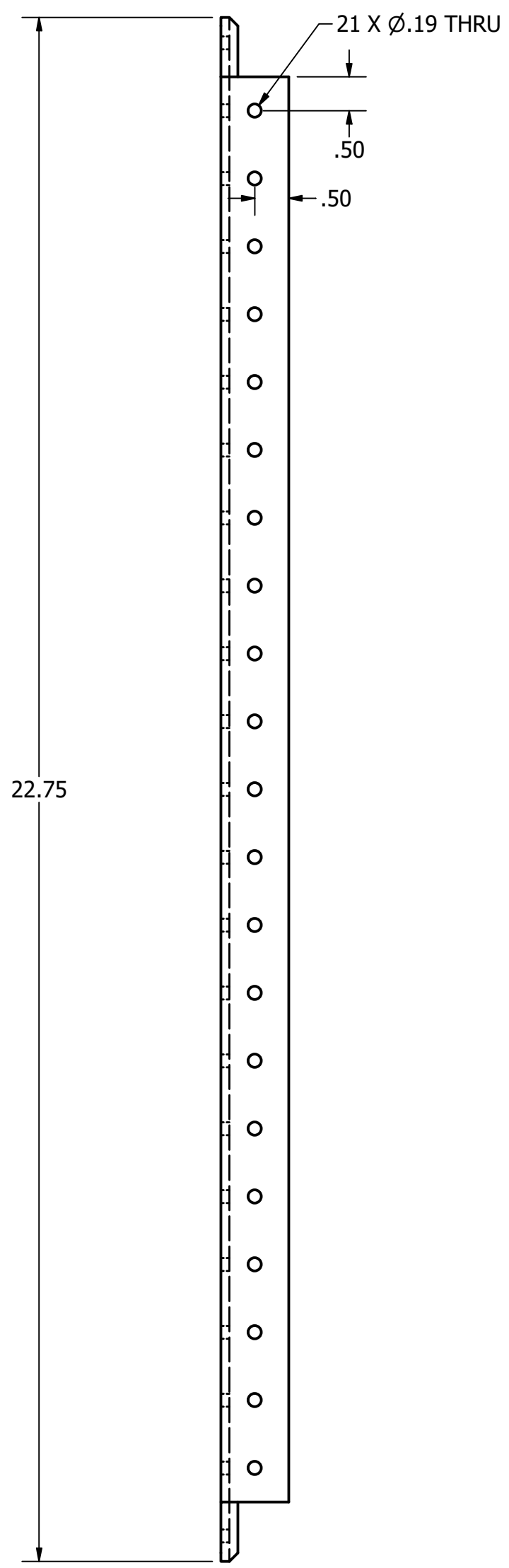
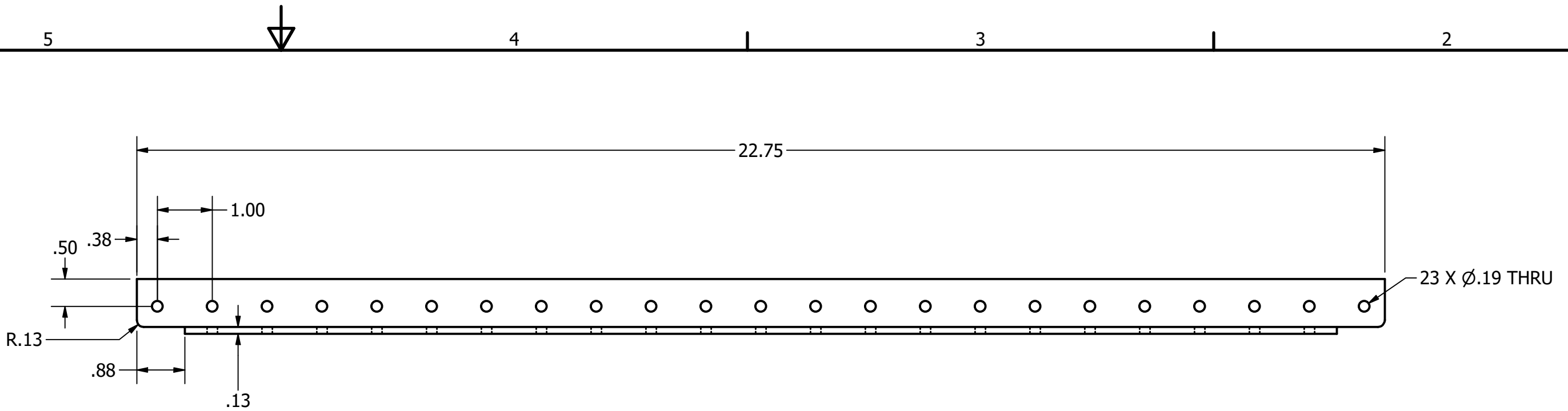
INSTRUCTIONS:
CUT TO LENGTH

MCMASTER SUPPLIED SPACER FOR #10 SCREW, .3130D, 3"
LENGTH (92510A558)

DRAWN groteh	1/25/2023	LAFAYETTE ECE DIVISION		
CHECKED		TITLE		
QA		BASE FABRICATION INSTRUCTIONS		
MFG				
APPROVED ctroner		SIZE D	QTY: 3	DWG NO 21
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				SHEET 18 OF 30



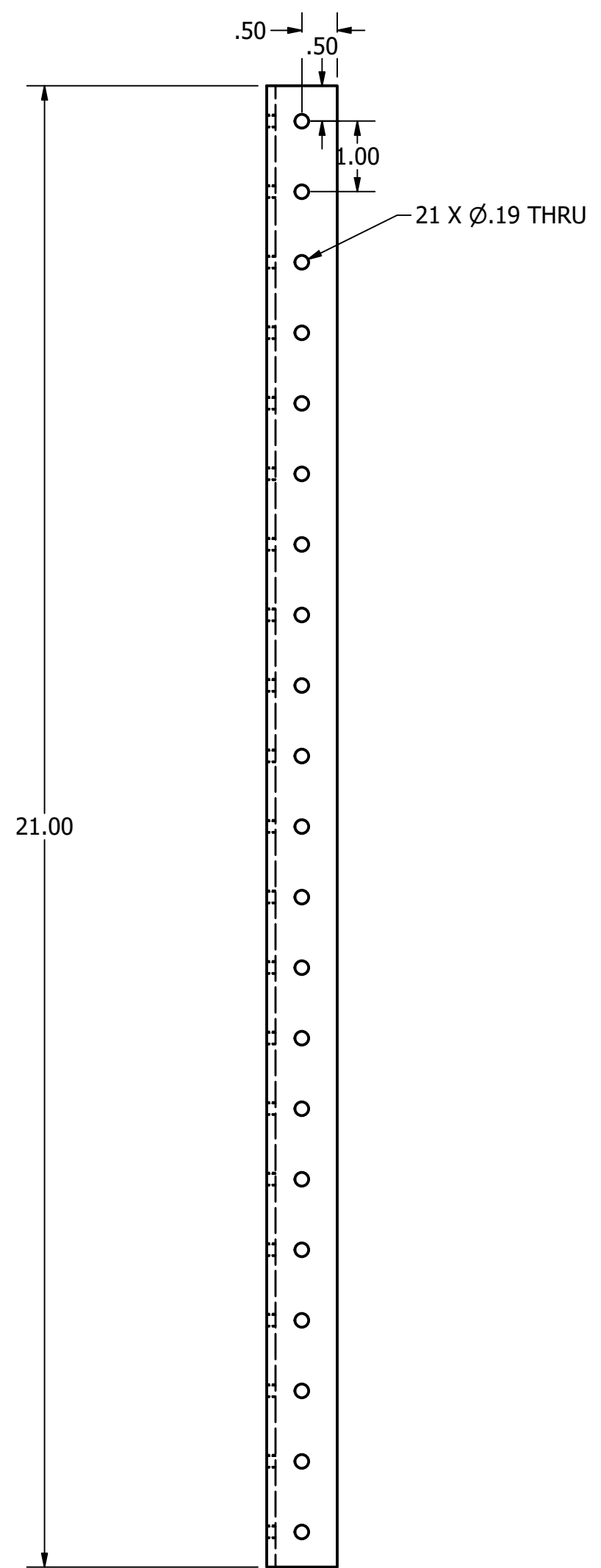
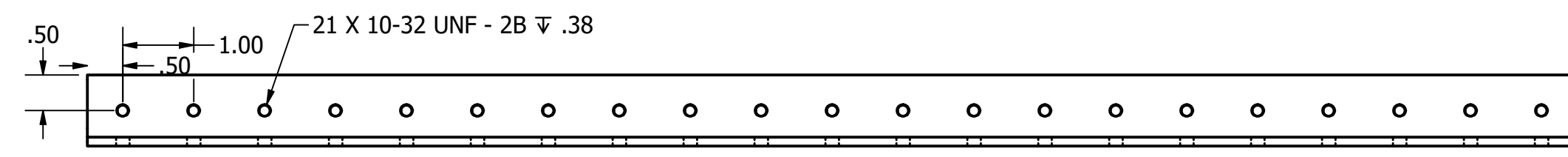
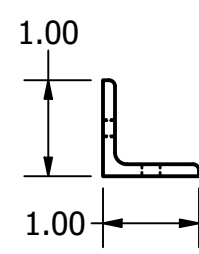
NOTE D6:
 FILLET OR CHAMFER CORNER SUCH WHEN
 PLACED ON A LEVEL SURFACE, THE THE
 PART CAN SIT "INSIDE" ANOTHER,
 EQUIVALENT L-STOCK



INSTRUCTIONS:
 CUT TO LENGTH, CUT OUT WALLS ON EDGES, INCREASE CORNER
 FILLET OR CHAMFER (SEE NOTE D6), DRILL HOLES

MCMASTER SUPPLIED L-STOCK, 1"x1"x8' (8982K4-8982K21)

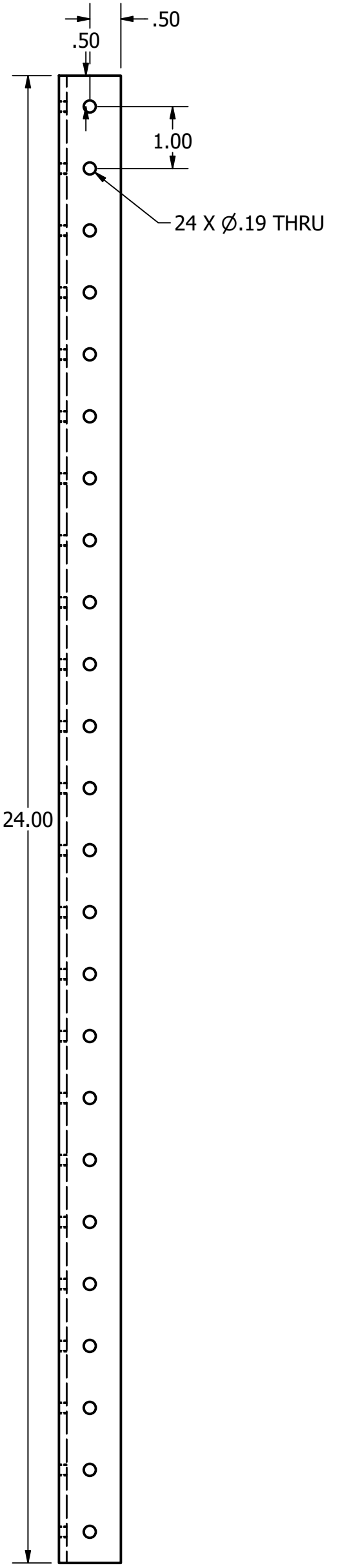
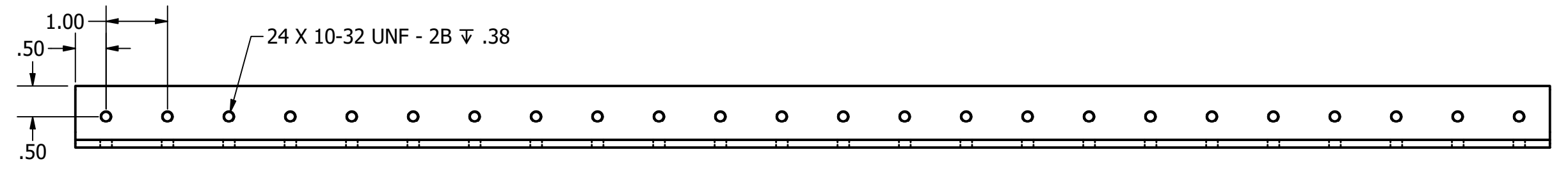
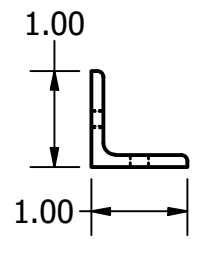
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MFG				
APPROVED ctroner		SIZE D	QTY: 2	DWG NO 21
		SCALE 1 / 2		REV 1
				SHEET 19 OF 30



INSTRUCTIONS:
CUT TO LENGTH, DRILL THROUGH HOLES, DRILL AND THREAD HOLES ON OTHER FACE

MCMASTER SUPPLIED L-STOCK, 1"x1"x8' (8982K4-8982K21)

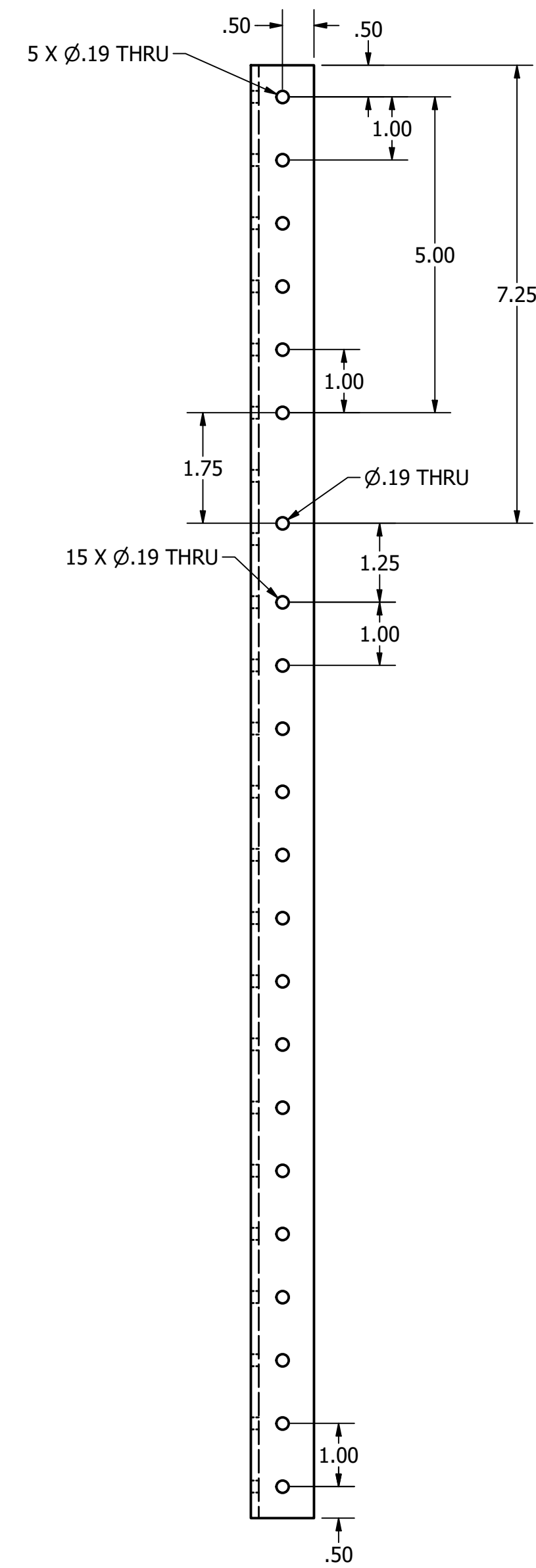
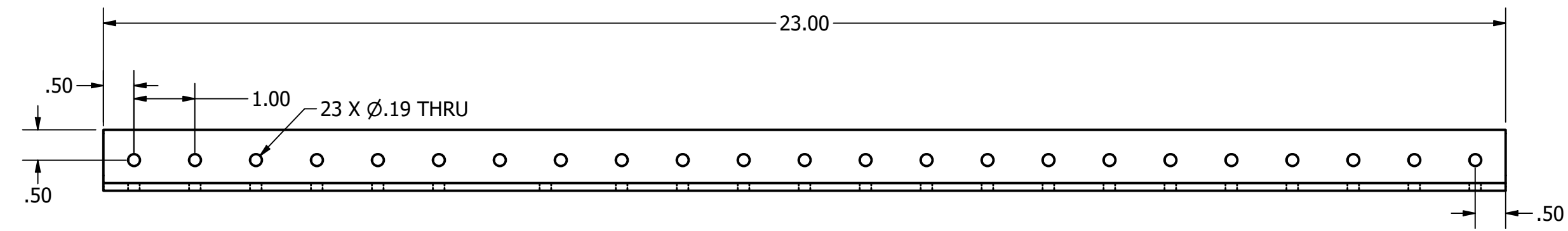
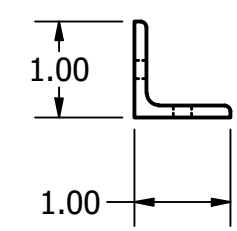
DRAWN groteh	1/25/2023	LAFAYETTE ECE DIVISION		
CHECKED		TITLE		
QA		BASE FABRICATION INSTRUCTIONS		
MFG				
APPROVED ctroner		SIZE D	QTY: 2	DWG NO 21
		SCALE 1 / 2		REV 1
		SHEET 20 OF 30		



INSTRUCTIONS:
CUT TO LENGTH, DRILL THROUGH HOLES, DRILL AND THREAD HOLES ON OTHER FACE

MCMASTER SUPPLIED L-STOCK, 1"x1"x8' (8982K4-8982K21)

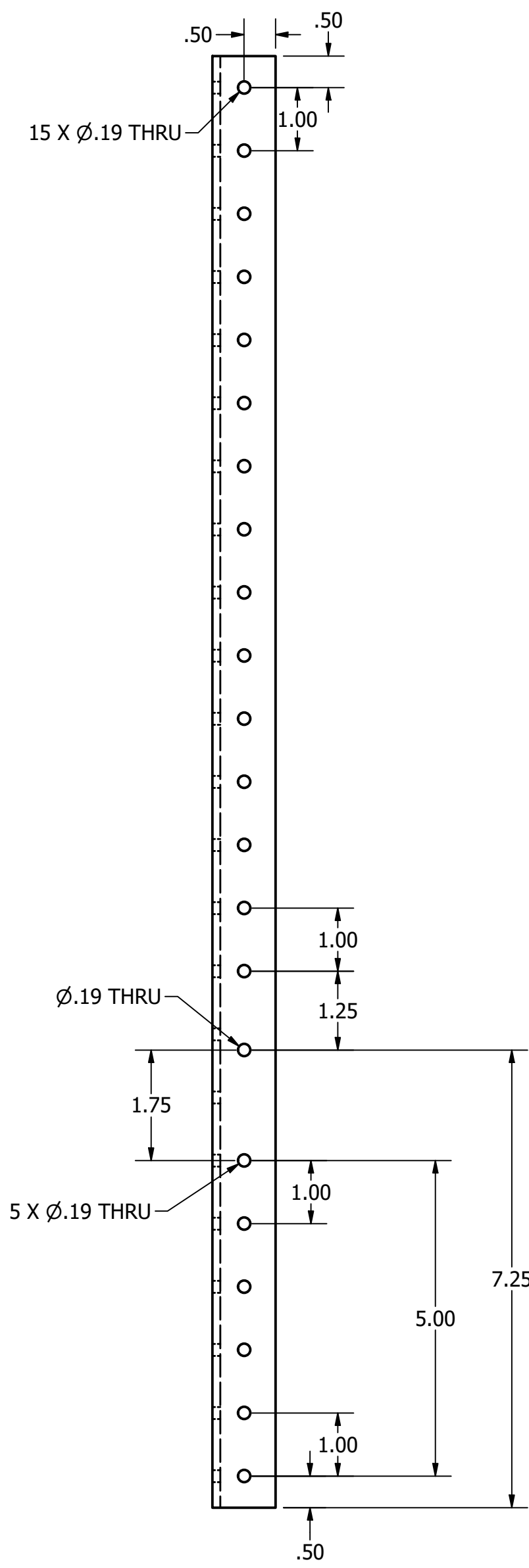
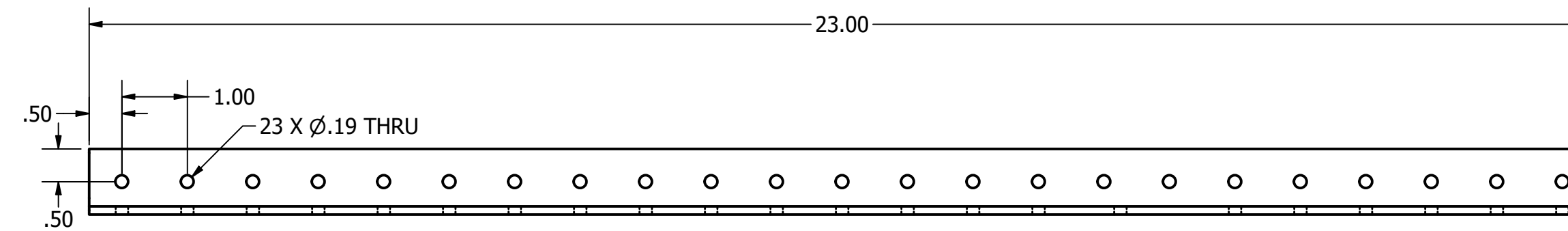
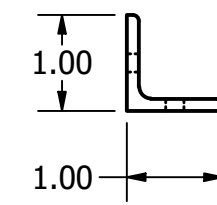
DRAWN groteh	1/25/2023	LAFAYETTE ECE DIVISION		
CHECKED		TITLE		
QA		BASE FABRICATION INSTRUCTIONS		
MFG		SIZE	QTY: 2	DWG NO
APPROVED ctroner		D	21	REV 1
		SCALE	1 / 2	SHEET 21 OF 30



INSTRUCTIONS:
CUT TO LENGTH, DRILL HOLES

MCMASTER SUPPLIED L-STOCK, 1"x1"x8' (8982K4-8982K21)

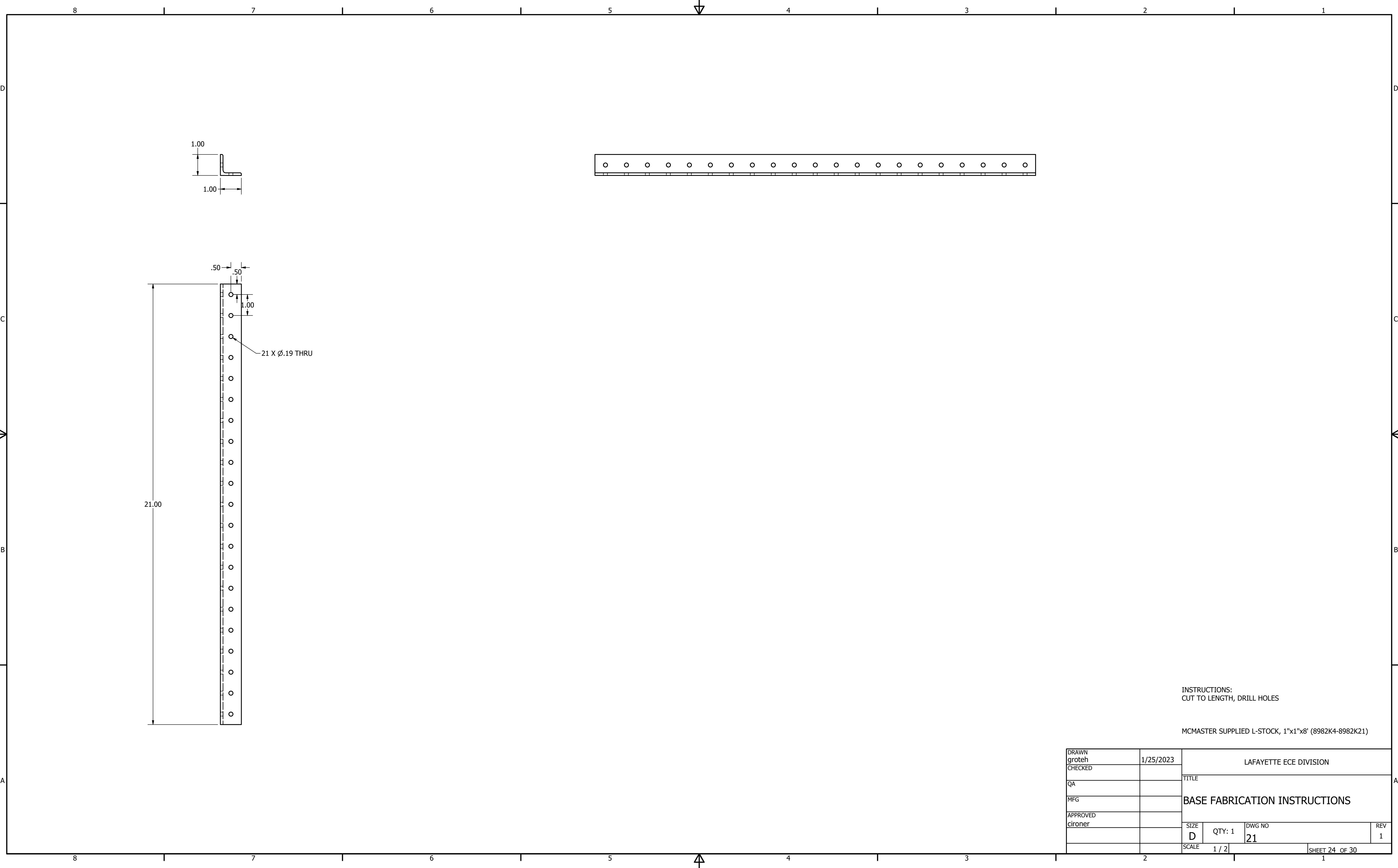
DRAWN groteh	1/25/2023	LAFAYETTE ECE DIVISION			
CHECKED		TITLE			
QA		BASE FABRICATION INSTRUCTIONS			
MFG					
APPROVED ctroner		SIZE D	QTY: 1	DWG NO 21	REV 1
		SCALE 1 / 2	SHEET 22 OF 30		



INSTRUCTIONS:
CUT TO LENGTH, DRILL HOLES

MCMASTER SUPPLIED L-STOCK, 1"x1"x8' (8982K4-8982K21)

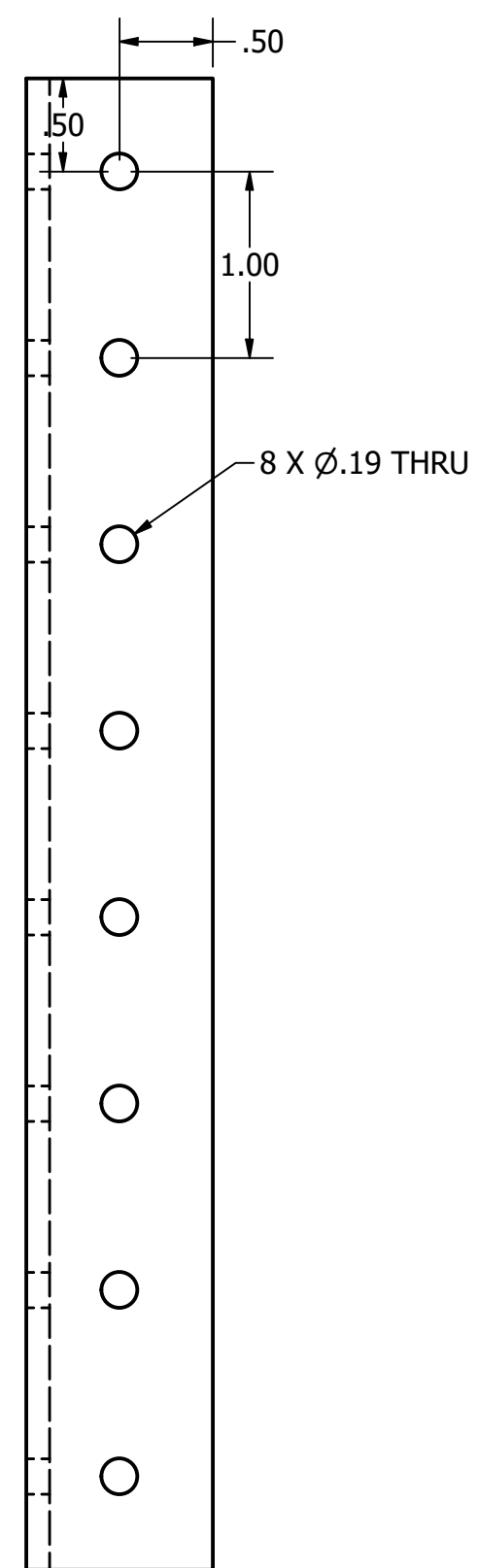
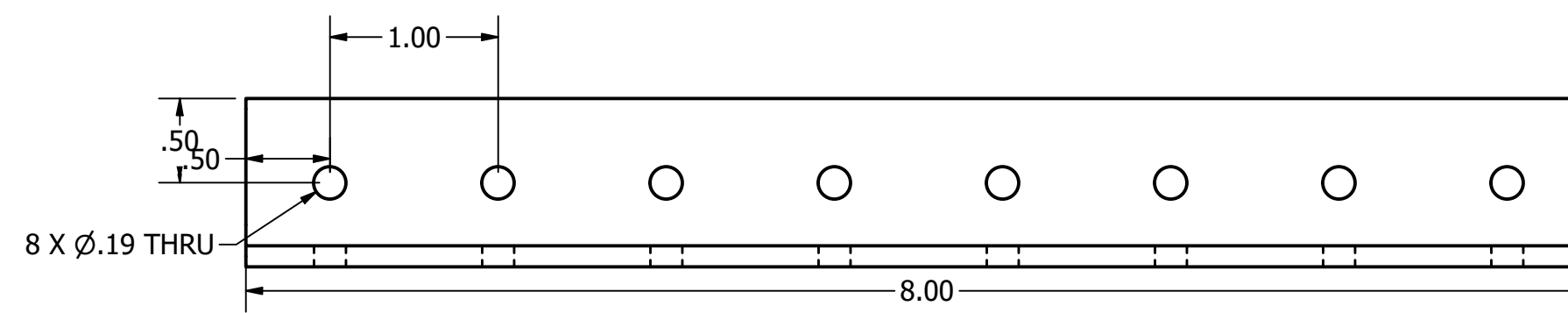
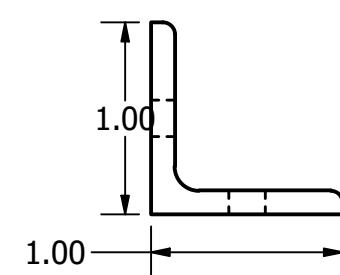
DRAWN groteh	1/25/2023	LAFAYETTE ECE DIVISION			
CHECKED		TITLE			
QA		BASE FABRICATION INSTRUCTIONS			
MFG					
APPROVED ctroner		SIZE D	QTY: 1	DWG NO 21	REV 1
		SCALE 1 / 2	SHEET 23 OF 30		



INSTRUCTIONS:
CUT TO LENGTH, DRILL HOLES

MCMASTER SUPPLIED L-STOCK, 1"x1"x8' (8982K4-8982K21)

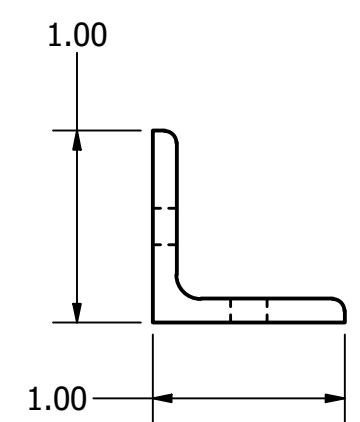
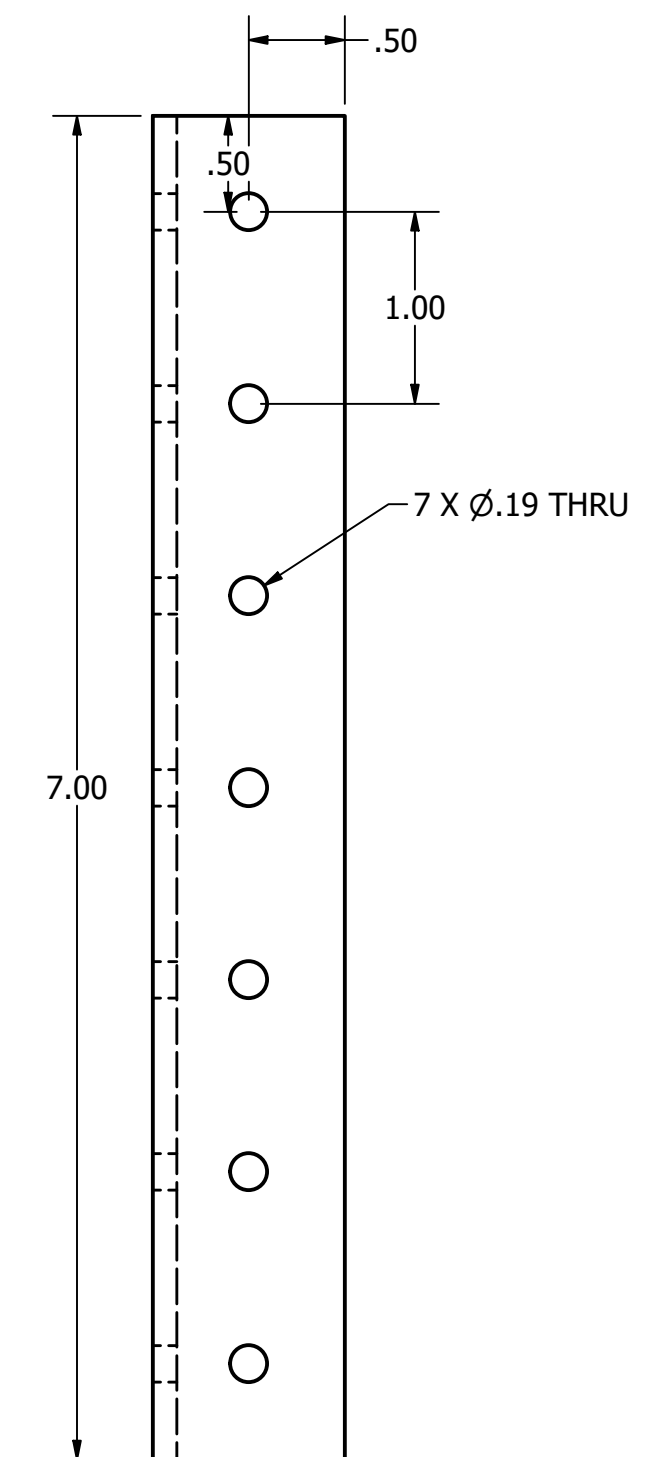
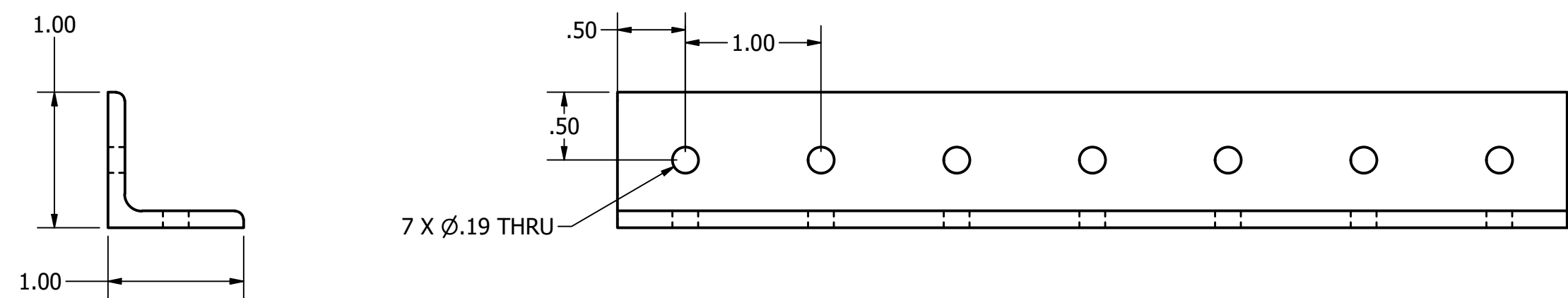
DRAWN groteh	1/25/2023	LAFAYETTE ECE DIVISION			
CHECKED		TITLE			
QA		BASE FABRICATION INSTRUCTIONS			
MFG					
APPROVED ctroner		SIZE D	QTY: 1	DWG NO 21	REV 1
		SCALE 1 / 2			SHEET 24 OF 30



INSTRUCTIONS:
CUT TO LENGTH, DRILL HOLES

MCMASTER SUPPLIED L-STOCK, 1"x1"x8' (8982K4-8982K21)

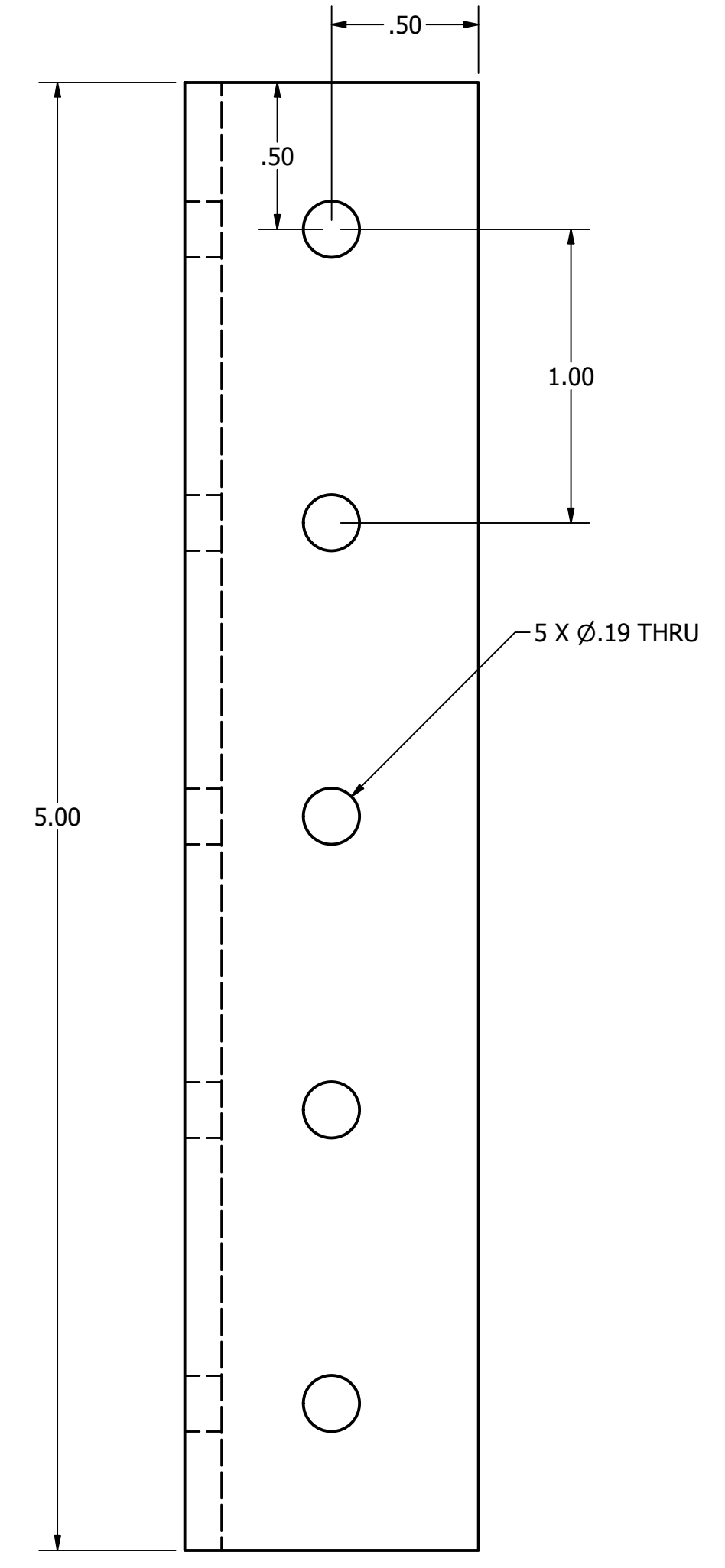
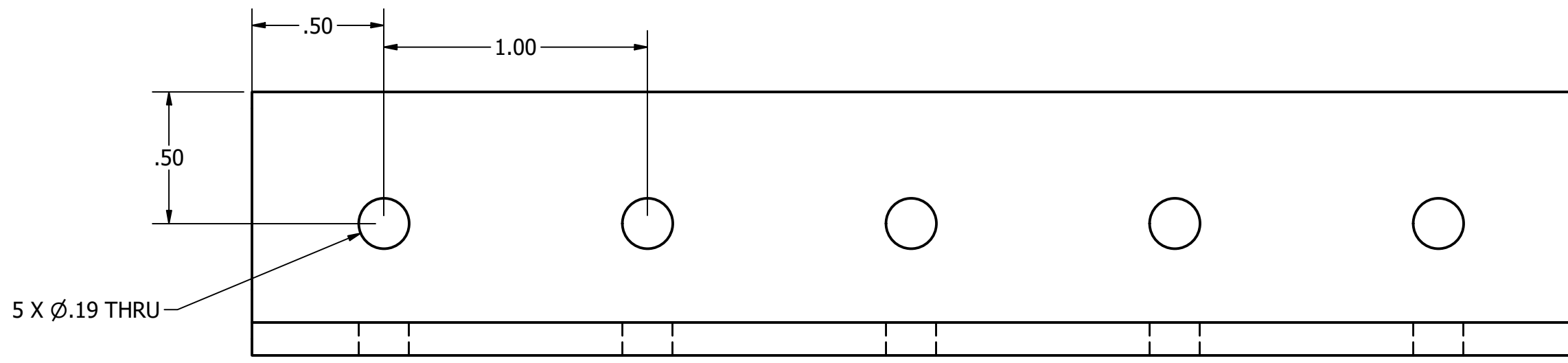
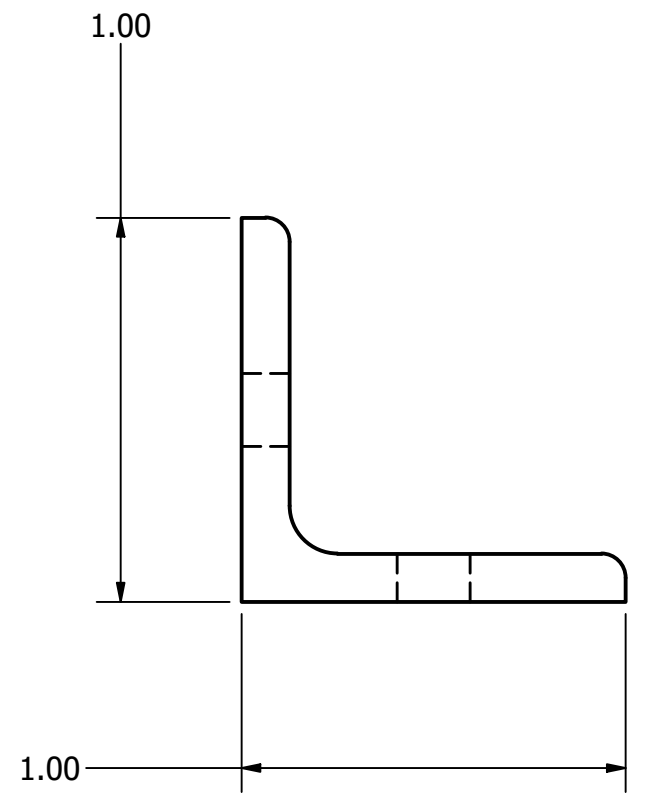
DRAWN groteh	1/25/2023	LAFAYETTE ECE DIVISION			
CHECKED		TITLE			
QA		BASE FABRICATION INSTRUCTIONS			
MFG					
APPROVED ctroner		SIZE D	QTY: 2	DWG NO 21	REV 1
		SCALE 1 : 1			SHEET 25 OF 30



INSTRUCTIONS:
CUT TO LENGTH, DRILL HOLES

MCMASTER SUPPLIED L-STOCK, 1"x1"x8' (8982K4-8982K21)

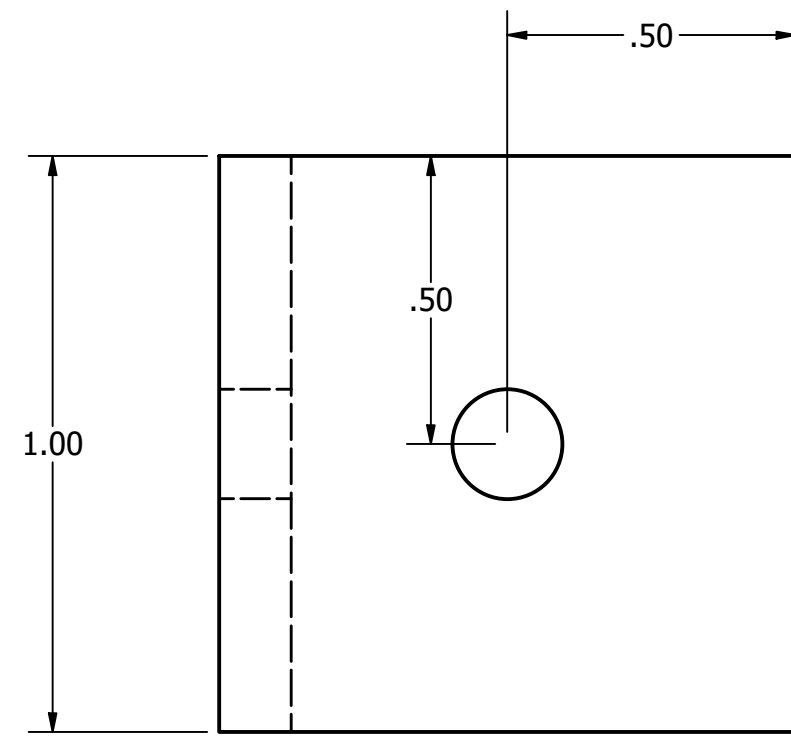
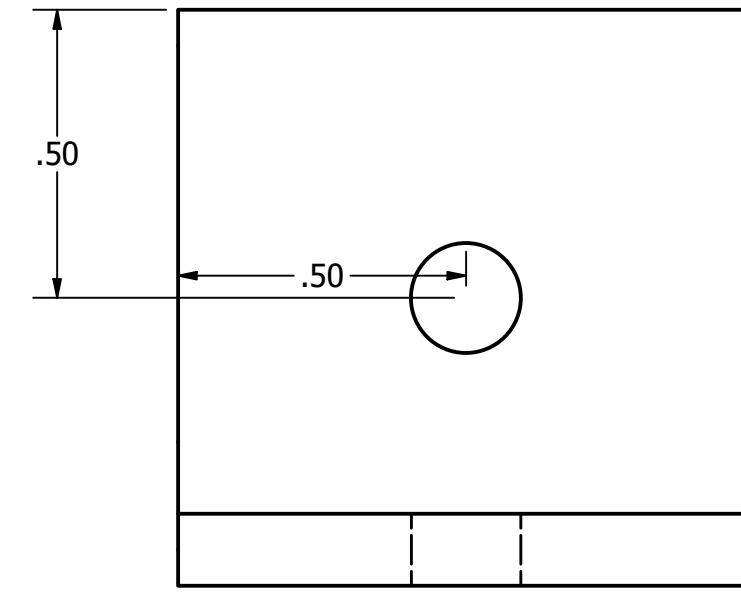
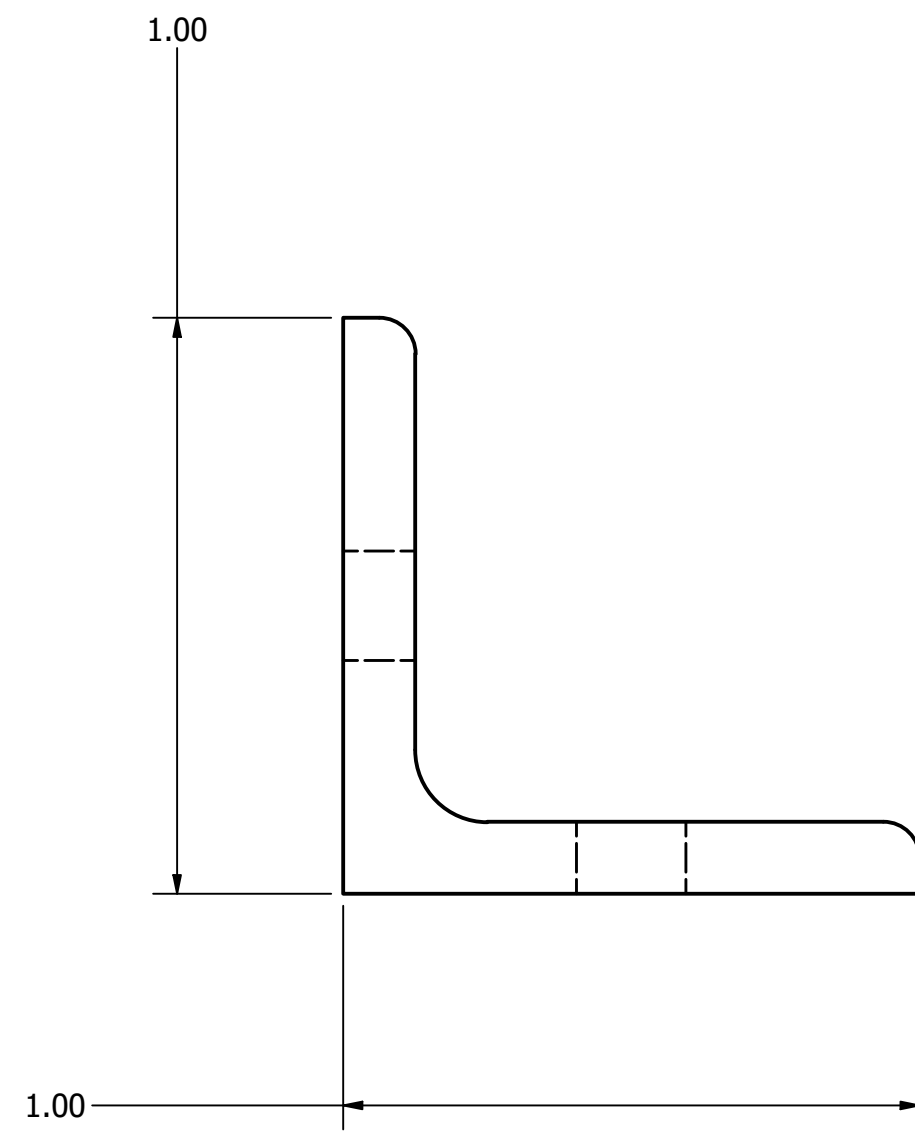
DRAWN groteh	1/25/2023	LAFAYETTE ECE DIVISION			
CHECKED		TITLE			
QA		BASE FABRICATION INSTRUCTIONS			
MFG					
APPROVED ctroner		SIZE D	QTY: 1	DWG NO 21	REV 1
		SCALE 1 : 1	SHEET 26 OF 30		



INSTRUCTIONS:
CUT TO LENGTH, DRILL HOLES

MCMASTER SUPPLIED L-STOCK, 1"x1"x8' (8982K4-8982K21)

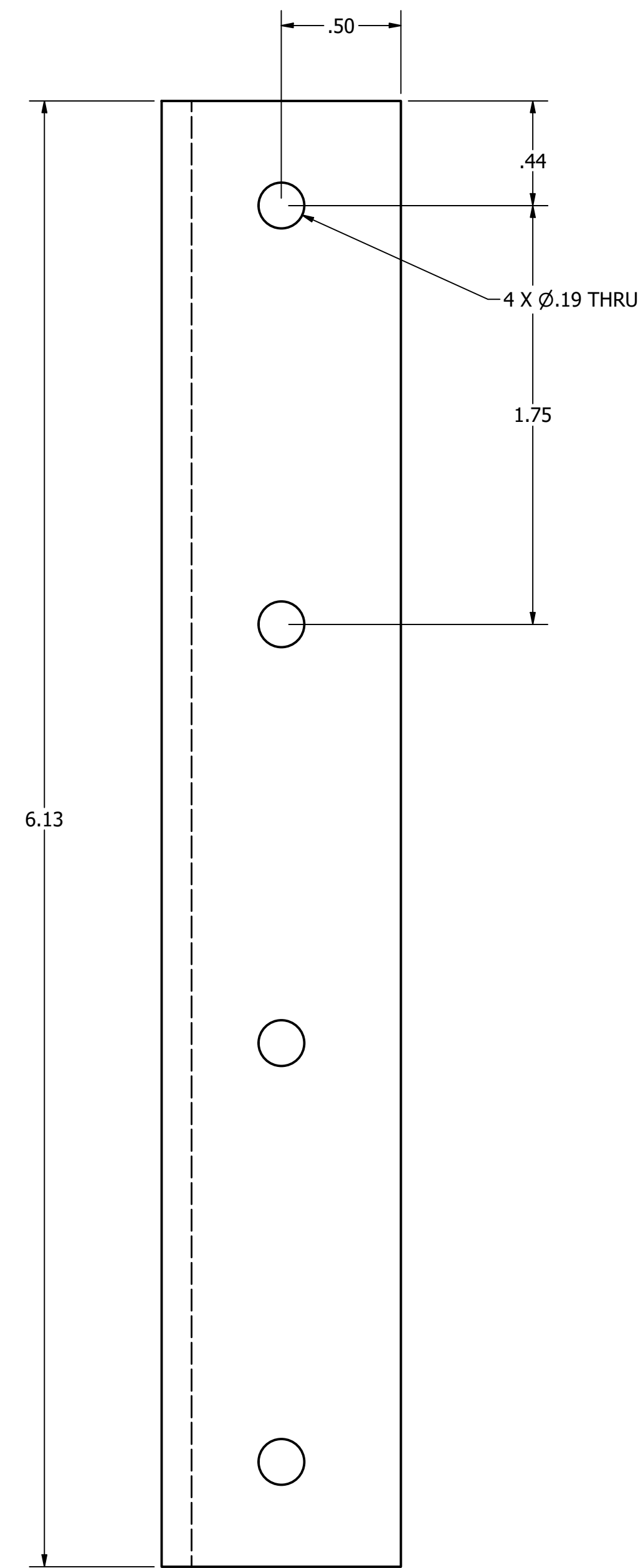
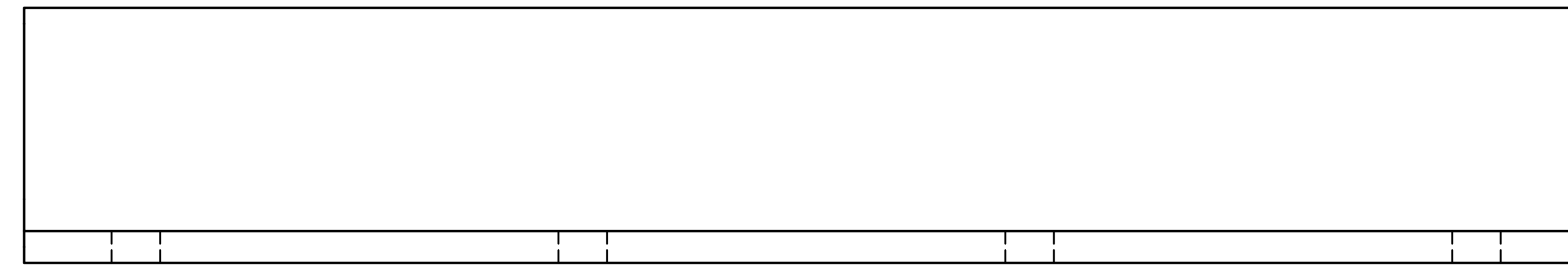
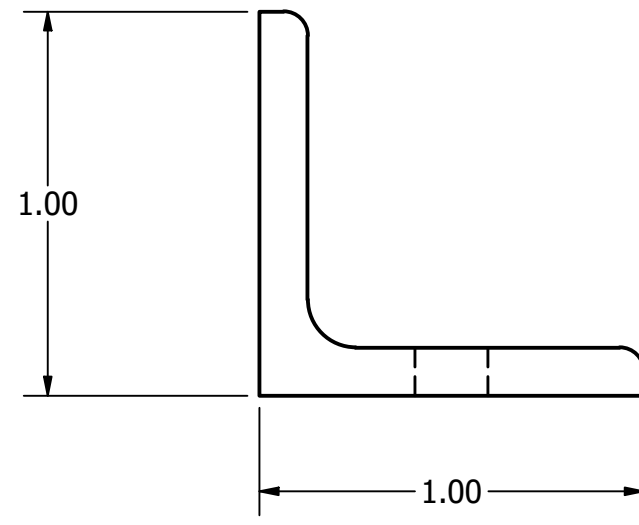
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CHECKED		TITLE		
QA		BASE FABRICATION INSTRUCTIONS		
MFG		SIZE	QTY: 2	DWG NO
APPROVED ctroner		D	21	REV 1
		SCALE	2 : 1	SHEET 27 OF 30



INSTRUCTIONS:
CUT TO LENGTH, DRILL HOLE

MCMASTER SUPPLIED L-STOCK, 1"x1"x8' (8982K4-8982K21)

DRAWN groteh	1/25/2023	LAFAYETTE ECE DIVISION			
CHECKED		TITLE			
QA		BASE FABRICATION INSTRUCTIONS			
MFG					
APPROVED ctroner		SIZE D	QTY: 1	DWG NO 21	REV 1
		SCALE 3 : 1	SHEET 28 OF 30		



INSTRUCTIONS:
CUT TO LENGTH, DRILL HOLES

MCMASTER SUPPLIED L-STOCK, 1"x1"x8' (8982K4-8982K21)

DRAWN groteh	1/25/2023	LAFAYETTE ECE DIVISION		
CHECKED		TITLE		
QA		BASE FABRICATION INSTRUCTIONS		
MFG				
APPROVED ctroner		SIZE D	QTY: 1	DWG NO 21
		SCALE 2 : 1		REV 1
				SHEET 29 OF 30

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INSTRUCTIONS:
instructions

MCMaster SUPPLIED part, dimensions (partnumber)

DRAWN groteh	1/25/2023	LAFAYETTE ECE DIVISION		
CHECKED		TITLE		
QA		BASE FABRICATION INSTRUCTIONS		
MFG				
APPROVED cironer		SIZE D	QTY: 1	DWG NO 21
		SCALE		REV 1
				SHEET 30 OF 30