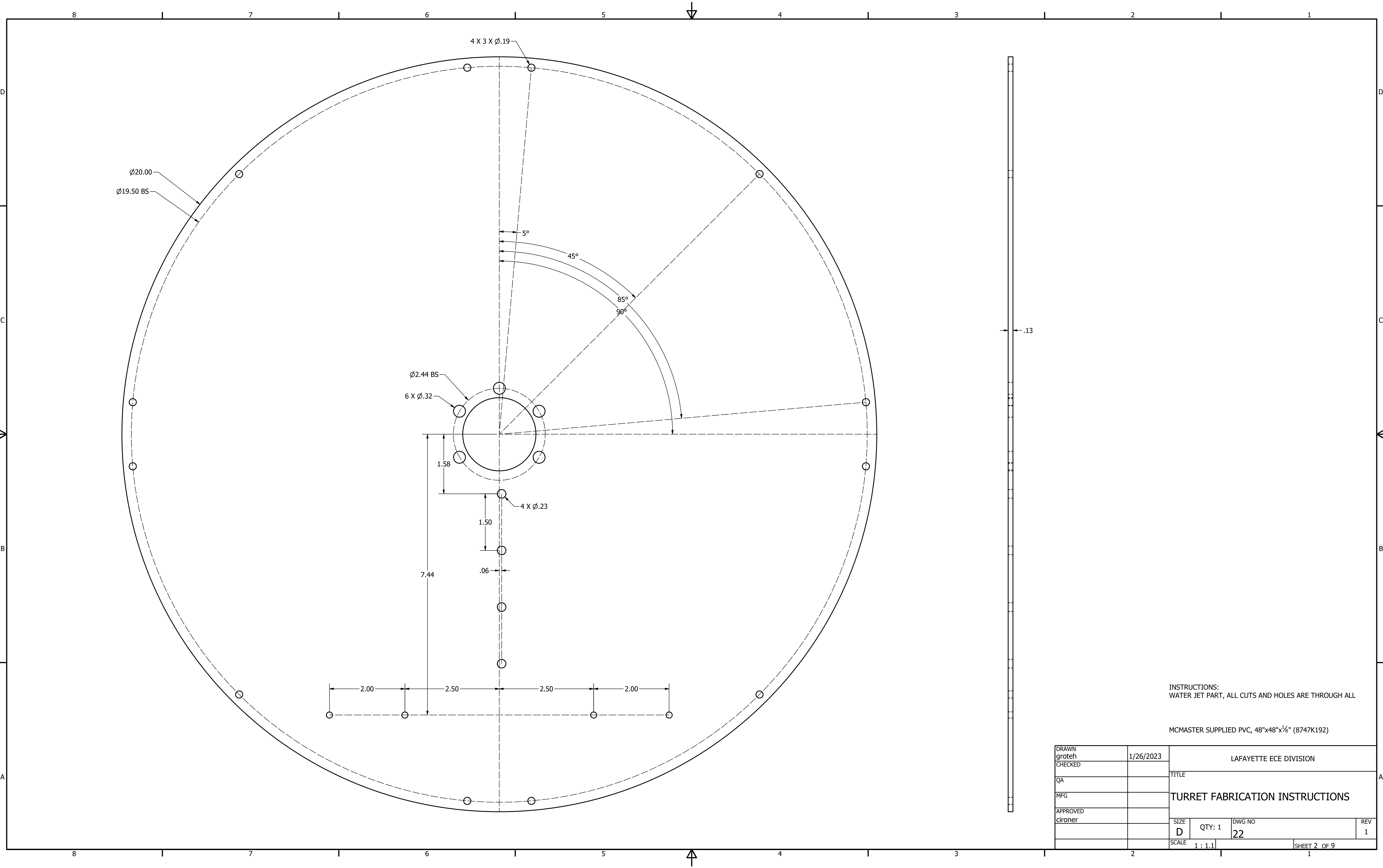


TABLE					
ITEM	QTY	PART NAME	DESCRIPTION	MATERIAL	INSTRUCTIONS
1	1	TURRET RING	BASE OF TURRET SUBASSEMBLY	MCMASTER SUPPLIED PVC, 48"x48"x1/8" (8747K192)	WATER JET PART, ALL CUTS AND HOLES ARE THROUGH ALL
2	4	TURRET MOUNTED TURRET SLIDERS	ARCS OF PLASTIC THAT SUPPORT TURRET	MCMASTER SUPPLIED UHMW, 24"x24"x3/16" (8752K412)	WATER JET PART THEN COUNTERSINK HOLES THE COUNTERSINK IS DRAWN AS THE DIMENSIONS OF THE SCREW WHICH IS INTENDED TO BE FLUSH MOUNTED.
3	2	MAST CROSSBAR T BRACKET	T BRACKETS TO MOUNT CROSSBAR AND MAIN MAST TOGETHER	MCMASTER SUPPLIED ALUMINUM SHEET, 24"x24"x1/8" (89015K48)	CUT TO SIZE, FILLET, DRILL HOLES
4	2	LINEAR ACTUATOR BOTTOM BRACKET	BRACKETS THAT MOUNT LINEAR ACTUATOR TO TURRET	MCMASTER SUPPLIED ALUMINUM SHEET, 24"x24"x1/8" (89015K48)	CUT TO SIZE, FILLET, DRILL HOLES
5	1	CROSSBAR	CROSSBAR THAT SUPPORTS SOLAR PANEL	MCMASTER SUPPLIED ALUMINUM TUBE, 1"x2"x2' 1/16" WALL (6546K2)	CUT TO LENGTH, DRILL HOLES
6	1	MAIN MAST	MAST THAT SUPPORTS CROSSBAR	MCMASTER SUPPLIED ALUMINUM TUBE, 2"x2"x2' 1/16" WALL (6546K8)	CUT TO LENGTH, DRILL HOLES
7	1	SOLAR PANEL PIN	PIN TO HOLD IN SOLAR PANEL	MCMASTER SUPPLIED TUBE, 1#4" OD, 1' LENGTH (9056K61)	MCMASTER SUPPLIED UHMW, 24"x24"x3/16" (8752K412)

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

DRAWN groteh	1/26/2023	LAFAYETTE ECE DIVISION		
CHECKED		TITLE		
QA		TURRET FABRICATION INSTRUCTIONS		
MFG				
APPROVED cironer		SIZE D	DWG NO 22	REV 1
		SCALE	SHEET 1 OF 9	

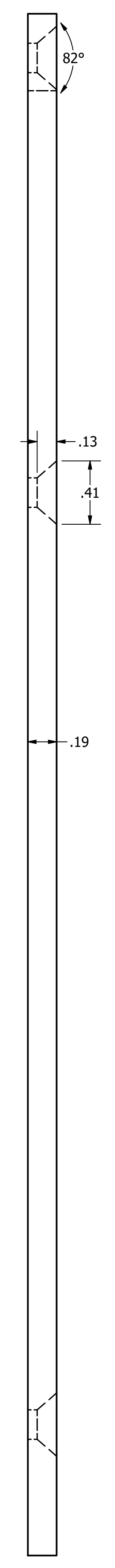
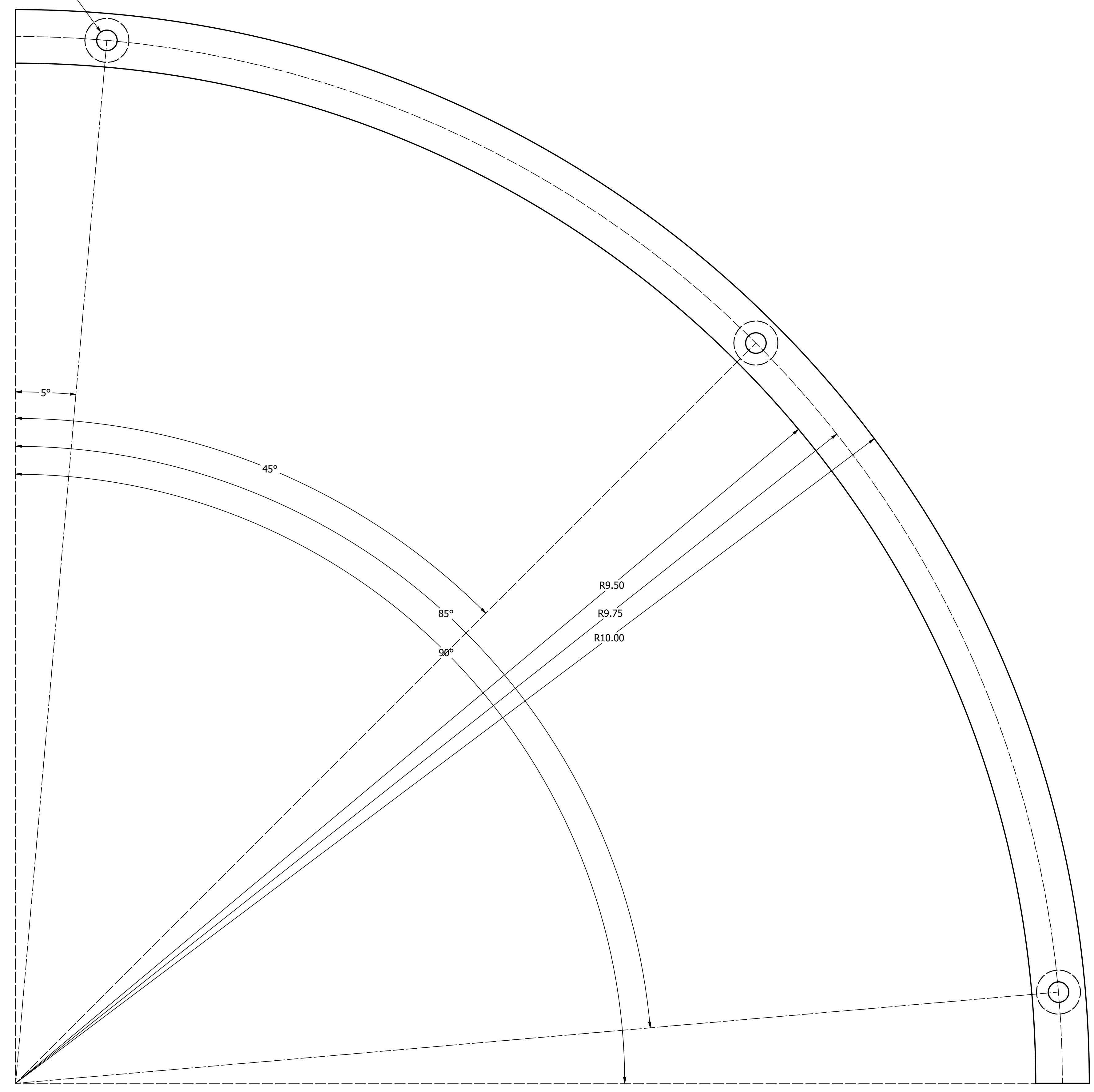


INSTRUCTIONS:
 WATER JET PART, ALL CUTS AND HOLES ARE THROUGH ALL

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

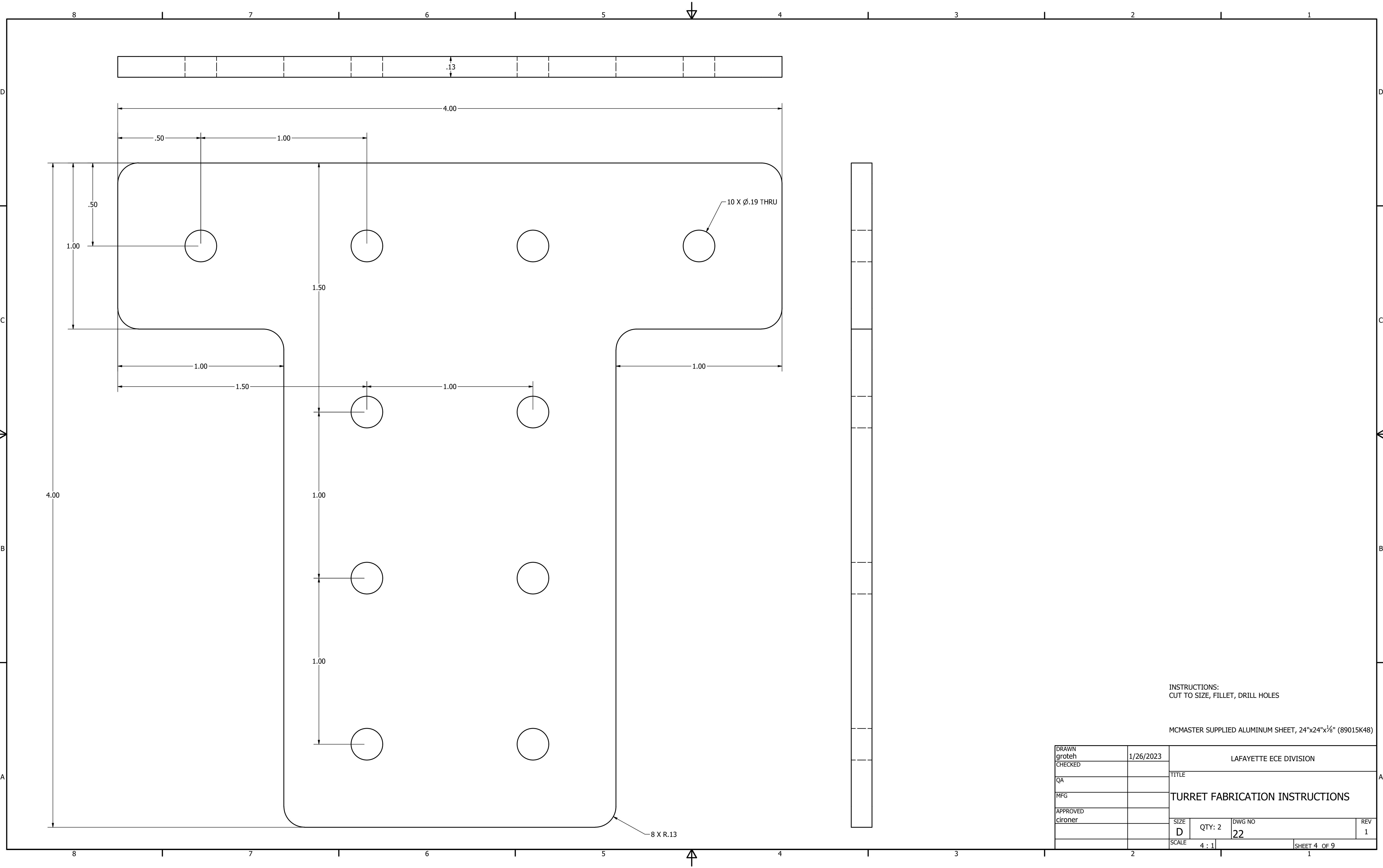
DRAWN groteh	1/26/2023	LAFAYETTE ECE DIVISION		
CHECKED		TITLE		
QA		TURRET FABRICATION INSTRUCTIONS		
MFG		SIZE	QTY: 1	DWG NO
APPROVED ctroner		D	22	REV 1
SCALE		1 : 1.1		SHEET 2 OF 9

3 X Ø.19 THRU
 ✓ Ø.41 X 82°



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, 24"x24"x $\frac{3}{16}$ " (8752K412)

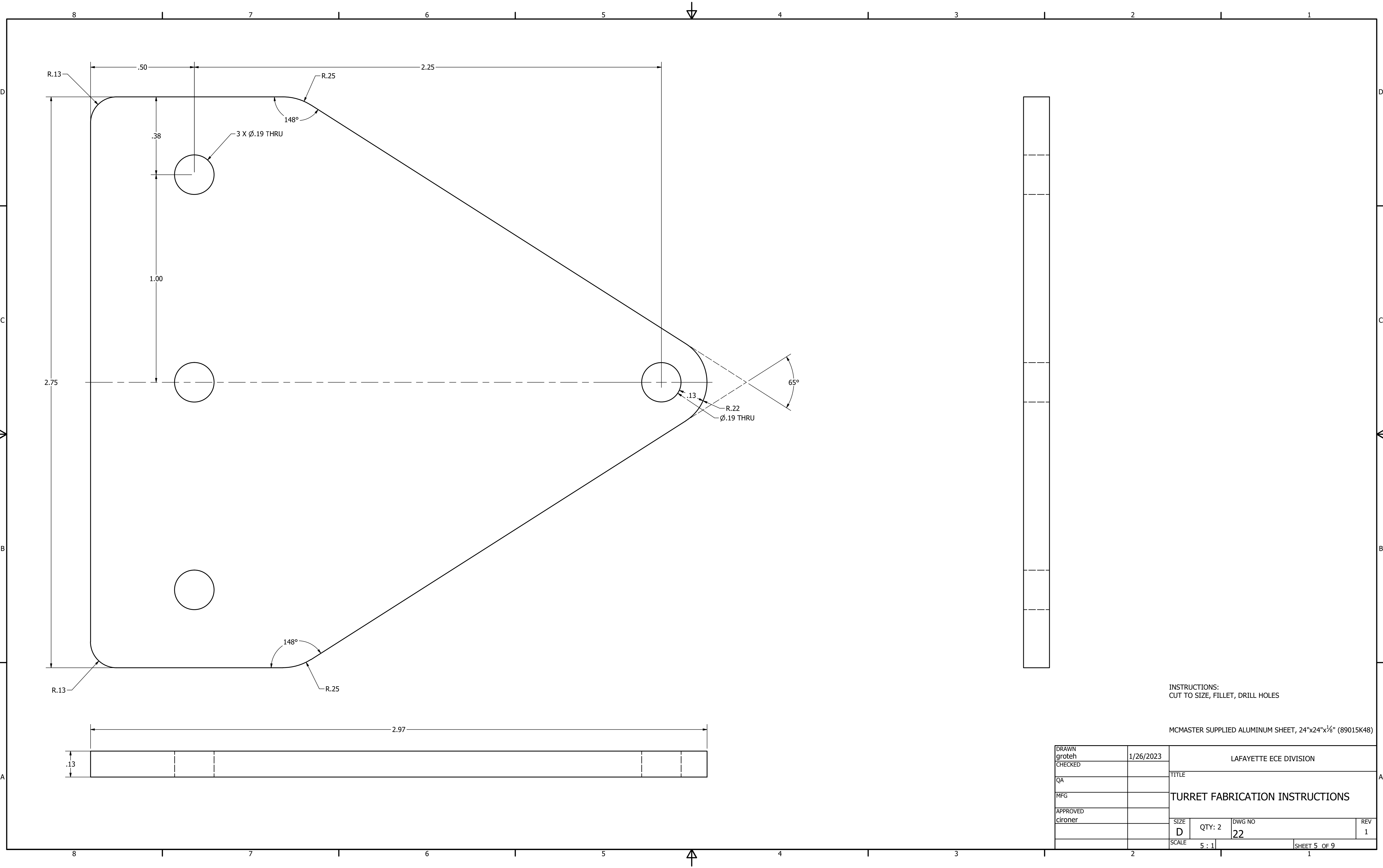
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CHECKED		TITLE		
QA		TURRET FABRICATION INSTRUCTIONS		
MFG		SIZE	QTY: 4	DWG NO
APPROVED cironer		D	22	REV
		SCALE	2 : 1.1	1
				SHEET 3 OF 9



INSTRUCTIONS:
CUT TO SIZE, FILLET, DRILL HOLES

MCMASTER SUPPLIED ALUMINUM SHEET, 24"x24"x1/8" (89015K48)

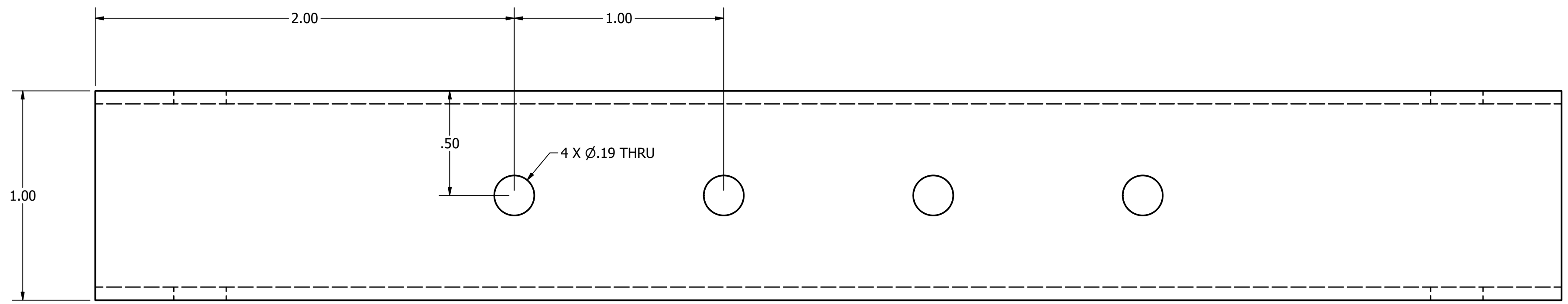
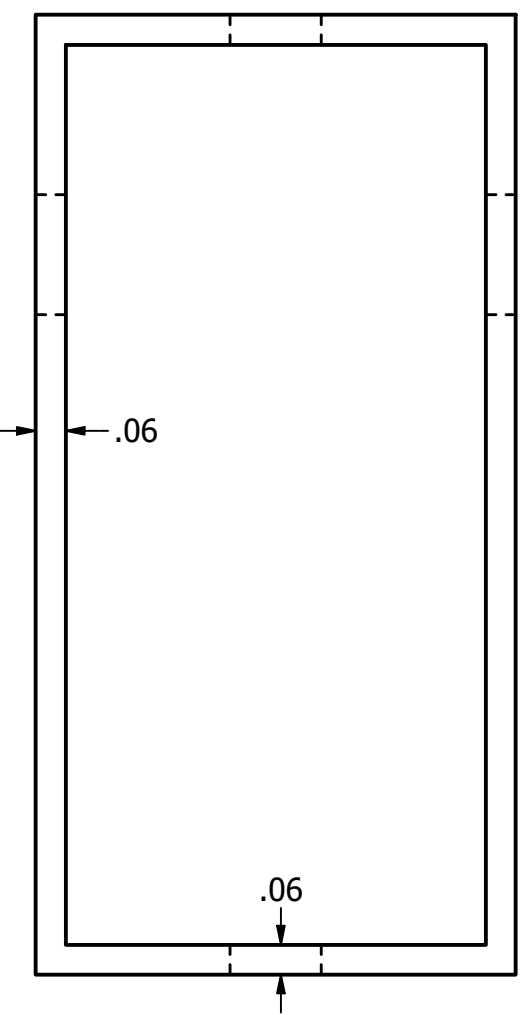
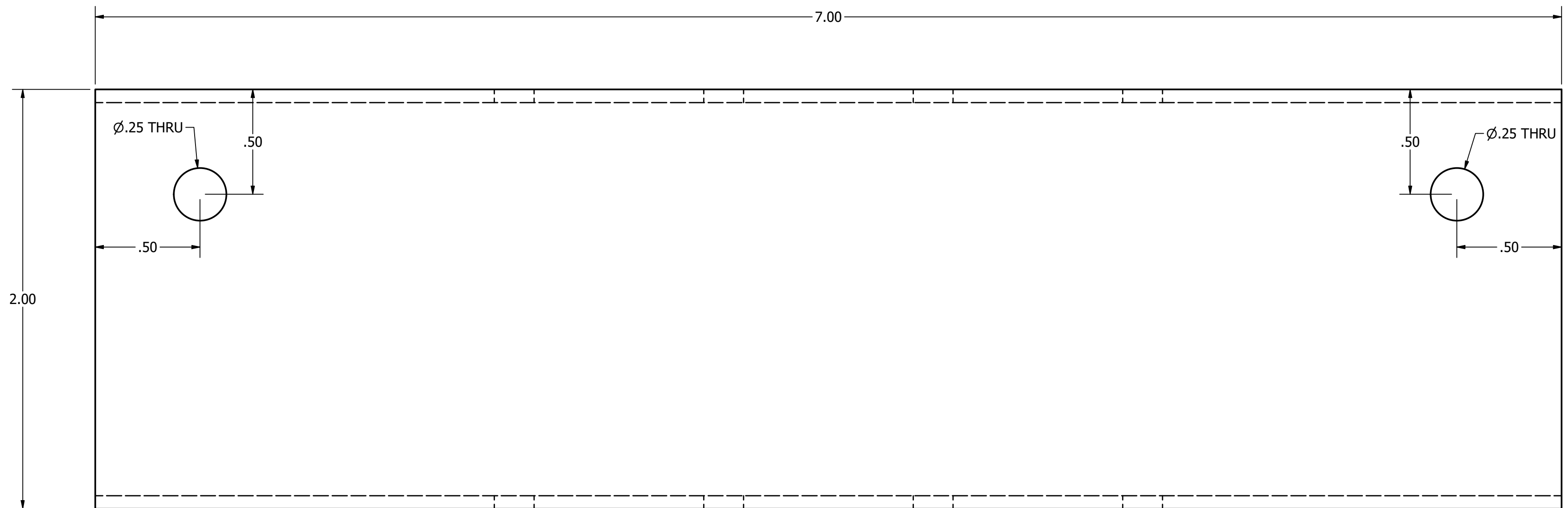
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CHECKED		TITLE		
QA		TURRET FABRICATION INSTRUCTIONS		
MFG		SIZE	QTY: 2	DWG NO
APPROVED ctroner		D	22	REV
		SCALE	4 : 1	1
		SHEET 4 OF 9		



INSTRUCTIONS:
CUT TO SIZE, FILLET, DRILL HOLES

MCMaster SUPPLIED ALUMINUM SHEET, 24"x24"x1/8" (89015K48)

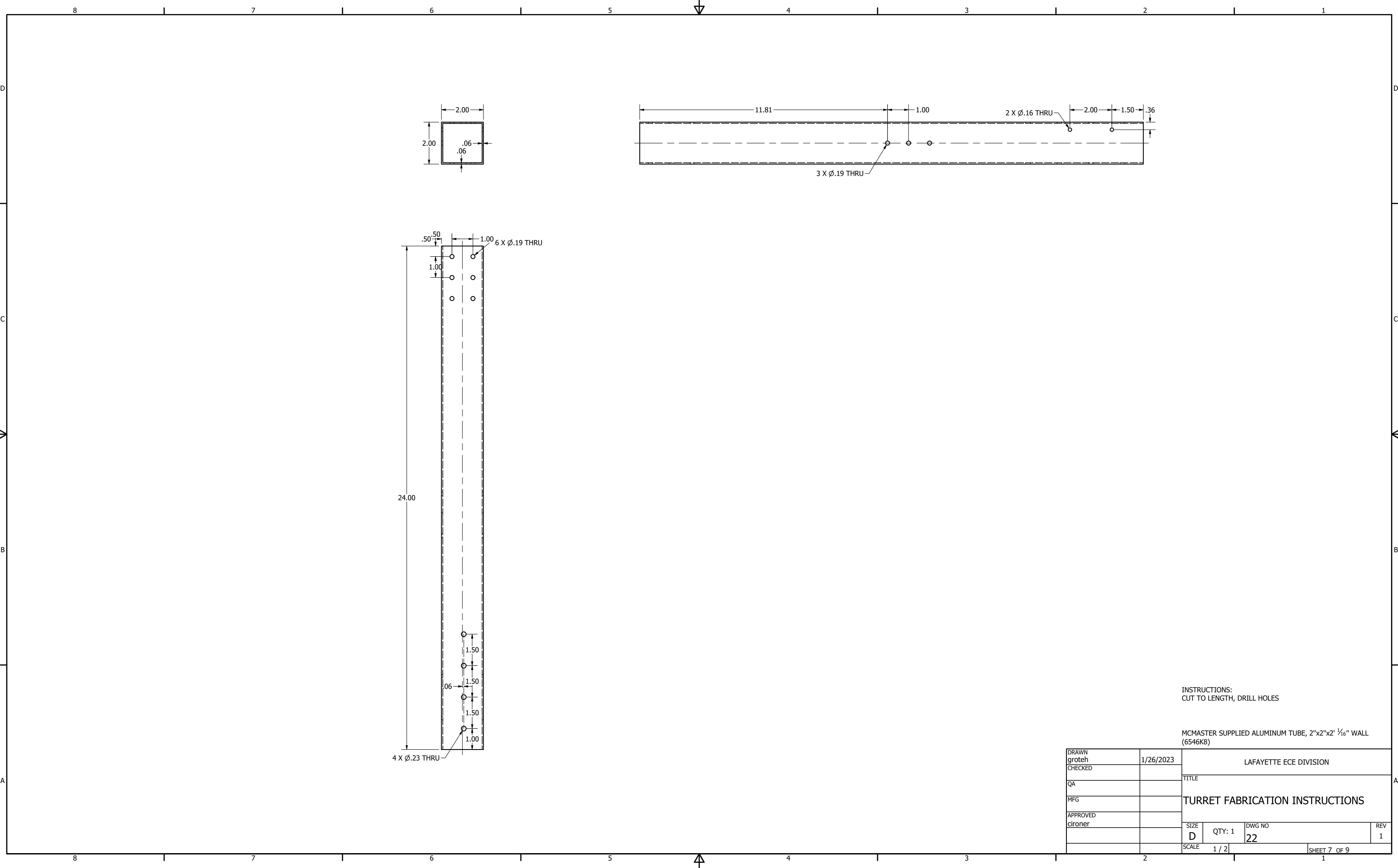
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CHECKED		TITLE		
QA		TURRET FABRICATION INSTRUCTIONS		
MFG		SIZE	QTY: 2	DWG NO
APPROVED cironer		D	22	REV 1
SCALE		5 : 1	SHEET 5 OF 9	



INSTRUCTIONS:
CUT TO LENGTH, DRILL HOLES

MCMASTER SUPPLIED ALUMINUM TUBE, 1"x2"x2' 1/16" WALL
(6546K2)

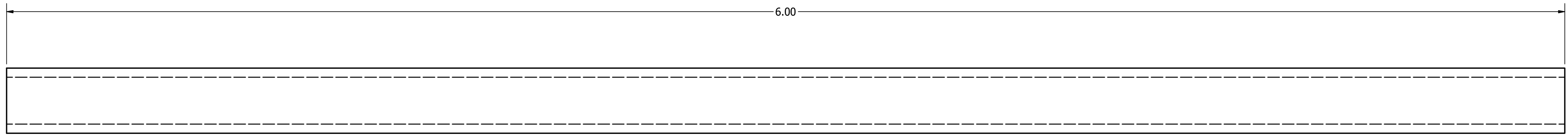
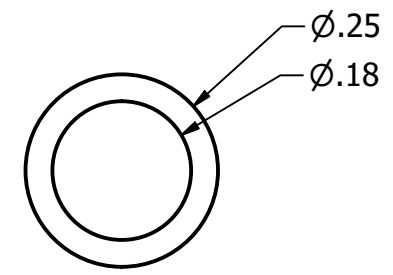
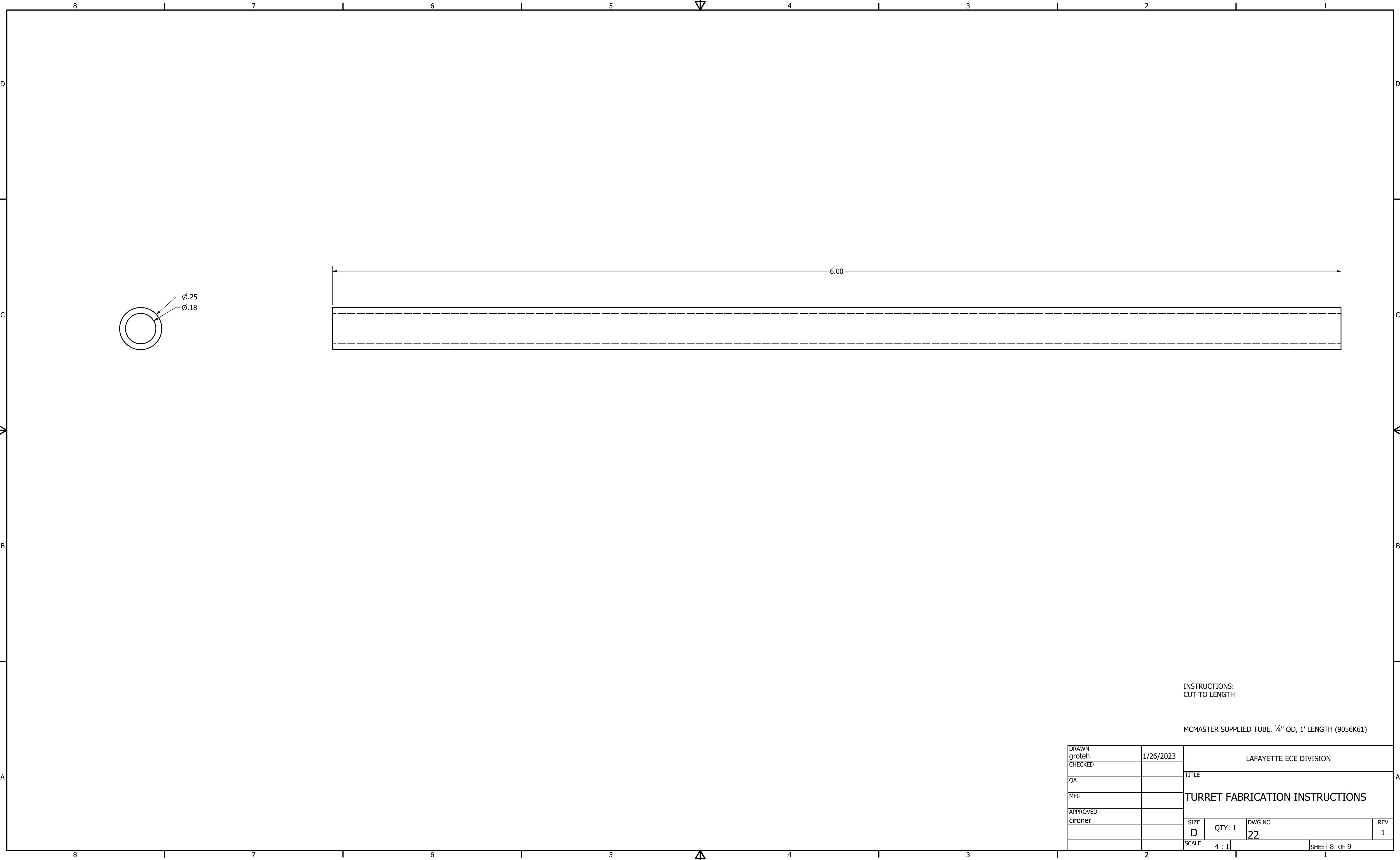
DRAWN groteh	1/26/2023	LAFAYETTE ECE DIVISION		
CHECKED		TITLE		
QA		TURRET FABRICATION INSTRUCTIONS		
MFG		SIZE	QTY: 1	DWG NO
APPROVED ctroner		D	22	REV 1
		SCALE	2.5 : 1	SHEET 6 OF 9



INSTRUCTIONS:
CUT TO LENGTH, DRILL HOLES

MCMASTER SUPPLIED ALUMINUM TUBE, 2"x2"x2' 1/16" WALL
(6546K8)

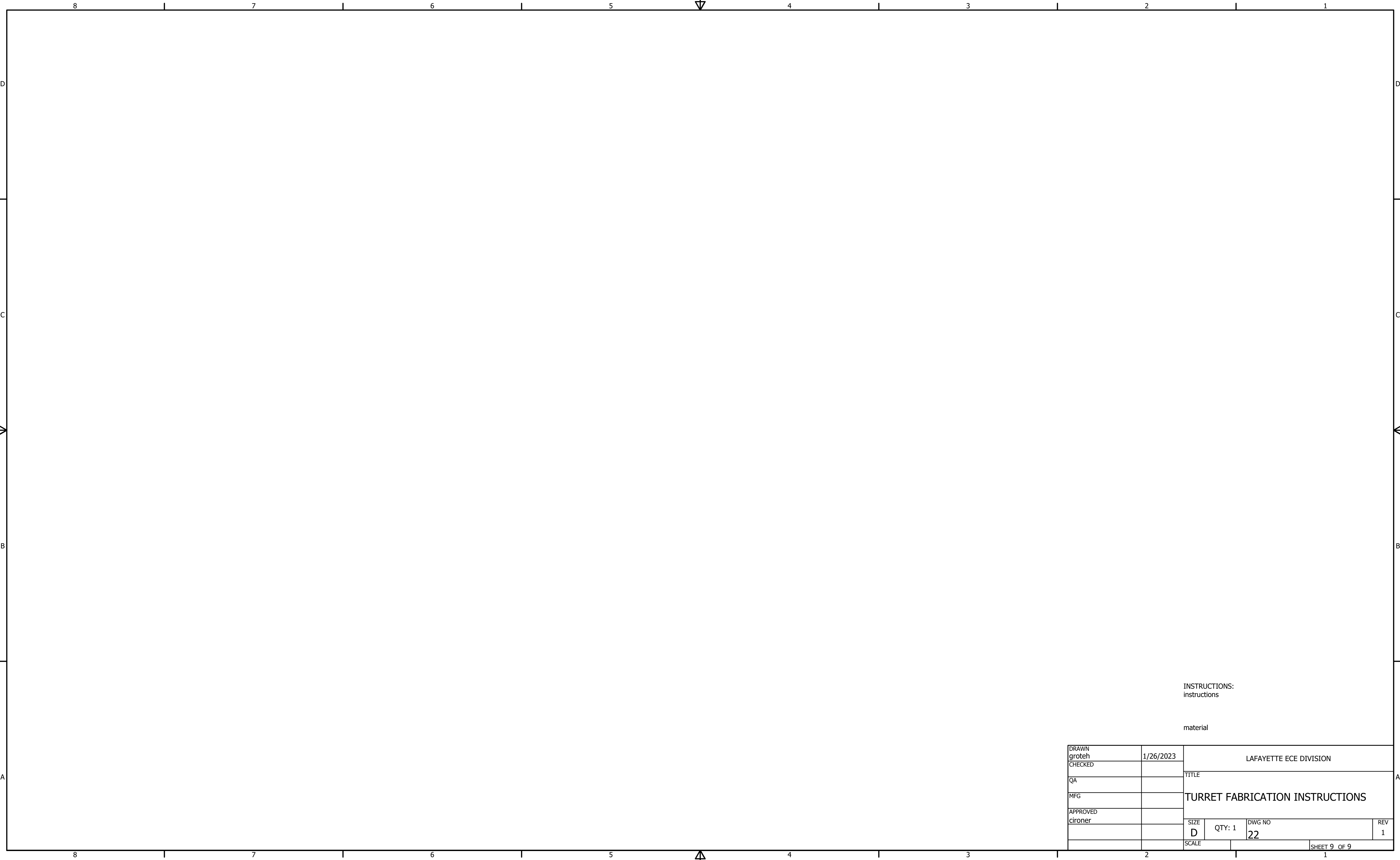
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CHECKED		TITLE		
QA		TURRET FABRICATION INSTRUCTIONS		
MFG				
APPROVED ctroner		SIZE D	QTY: 1	DWG NO 22
		SCALE 1 / 2		REV 1
		SHEET 7 OF 9		



INSTRUCTIONS:
CUT TO LENGTH

MCMASTER SUPPLIED TUBE, 1/4" OD, 1' LENGTH (9056K61)

DRAWN groteh	1/26/2023	LAFAYETTE ECE DIVISION		
CHECKED		TITLE		
QA		TURRET FABRICATION INSTRUCTIONS		
MFG				
APPROVED ctroner		SIZE D	QTY: 1	DWG NO 22
		SCALE 4 : 1		REV 1
				SHEET 8 OF 9



INSTRUCTIONS:
instructions

material

DRAWN groteh	1/26/2023	LAFAYETTE ECE DIVISION		
CHECKED		TITLE		
QA		TURRET FABRICATION INSTRUCTIONS		
MFG				
APPROVED ctroner		SIZE D	QTY: 1	DWG NO 22
		SCALE		REV 1
				SHEET 9 OF 9