



- NOTES:
- MACHINE BOTH SIDES WITH THE SAME PROFILE TO MINIMIZE EFFECTS OF THE INDUCED STRESSES FROM MACHINING. ANNEAL PART AFTER ROUGH MACHINING. UNLESS OTHERWISE NOTED, NO SHARP EDGES (< 0.30) SHALL BE LEFT ON MACHINED SURFACES.
  - THIS PART WILL SEE HIGH-VOLTAGE. CARE MUST BE TAKEN FOR THE SURFACE TO BE FREE FROM DEEP SCRATCHES AND GOUGES.
  - WHEN MACHINING THE SLOT IN THIS QUADRANT, IT IS OKAY TO CUT INTO THIS SECTION, AS SHOWN, IN ORDER TO SET UP THE CUTTER'S PATH. USE A MODIFIED WOODRUFF KEY CUTTER THAT HAS BEEN HOLLOW GROUND FOR MORE EFFICIENT CHIP REMOVAL AND REDUCED DISTORTION ON THE FINISHED PART.
  - ADDITIONALLY, USE HIGH PRESSURE AIR TO FACILITATE CHIP REMOVAL DURING THE MACHINING PROCESS.

| REV | DATE | CHK | DATE | DESCRIPTION                                  |
|-----|------|-----|------|--|
| 1   |      |     |      | STAINLESS STEEL, TYPE 304, 1.25" THK, Ø17.25 |
| 2   |      |     |      | DESIGN CHANGES                               |

  

| REV | DATE | CHK | DATE | DESCRIPTION    |
|-----|------|-----|------|----------------|
| 1   |      |     |      | DESIGN CHANGES |
| 2   |      |     |      | DESIGN CHANGES |

  

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