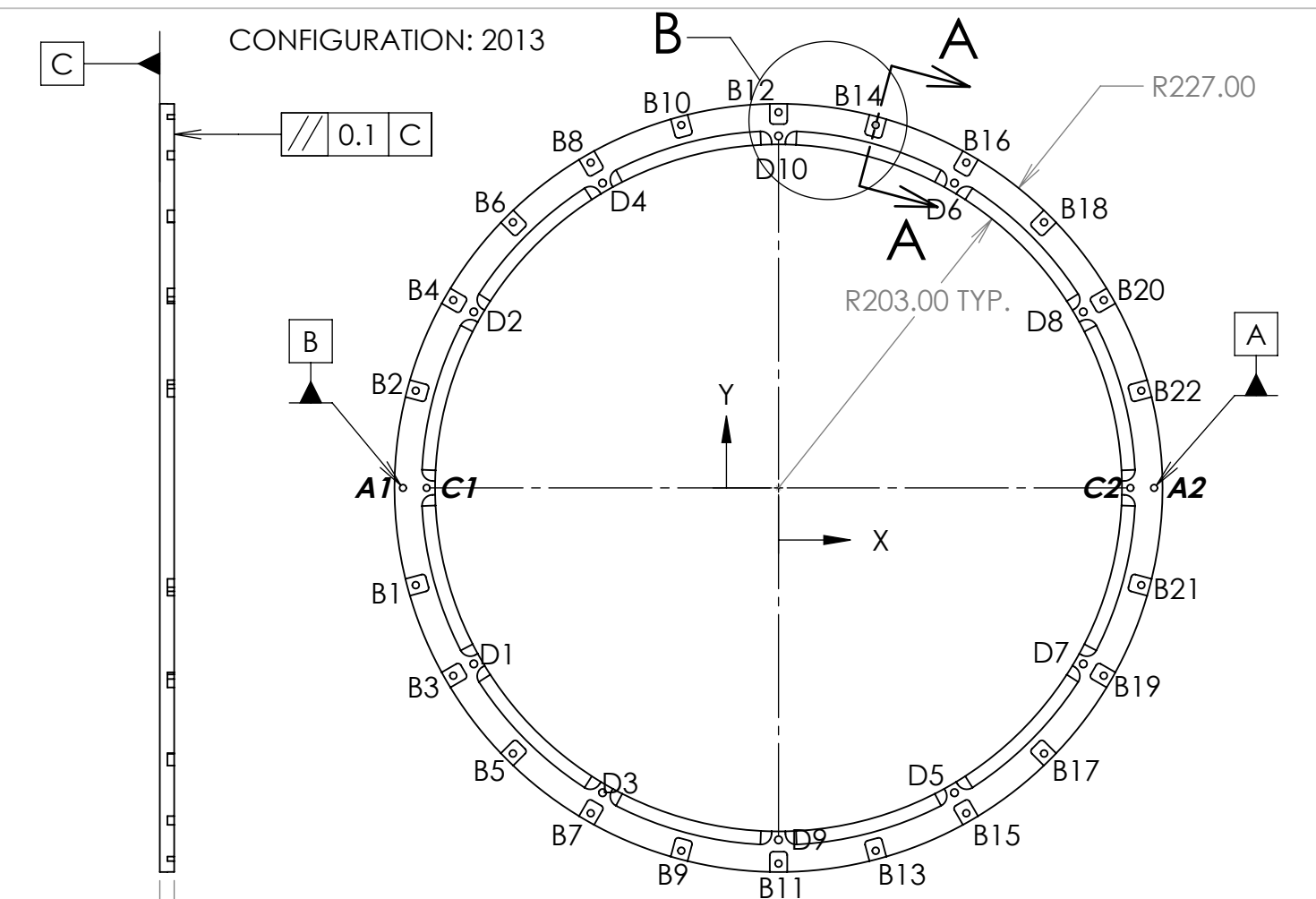


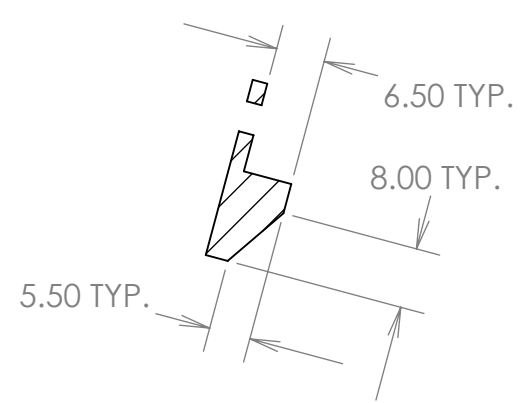
CONFIGURATION: 2013

REVISIONS				
REV	DWG	CHK	DATE	DESCRIPTION
0	JHS		2011-07-14	Initial drawing
1	JHS		2011-08-01	Correct thickness to as-built (approx 8.5mm)
0005	JHS		2013-05-03	Removal of projecting fingers, make inner chamfer, fit-up dummy drawn

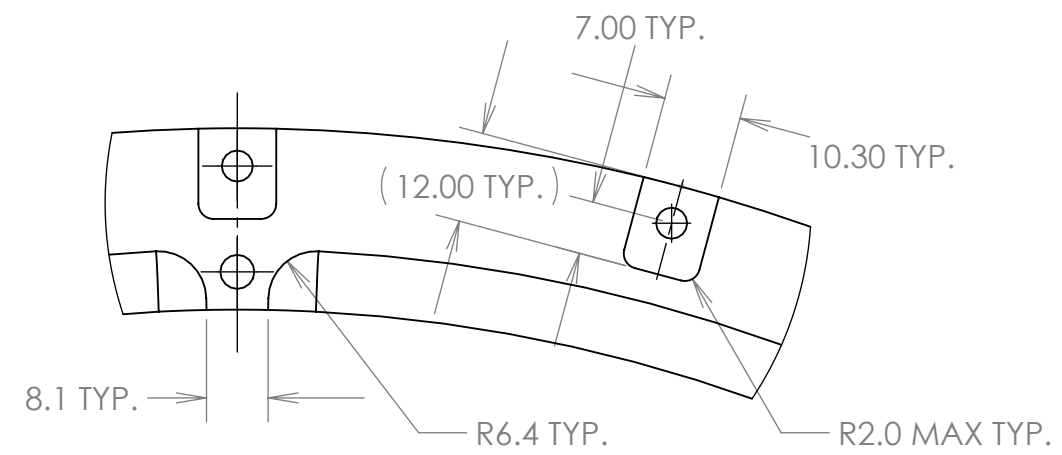


TAG	X LOC	Y LOC	SIZE
A1	-222.000	0.000	ϕ 4.000 H7/g6 THRU
A2	222.000	-0.000	ϕ 0.04 A B
B1	-214.436	-57.458	ϕ 4.10 THRU ALL
B2	-214.436	57.458	
B3	-192.258	-111.000	
B4	-192.258	111.000	
B5	-156.978	-156.978	
B6	-156.978	156.978	
B7	-111.000	-192.258	
B8	-111.000	192.258	
B9	-57.458	-214.436	
B10	-57.458	214.436	
B11	0.000	-222.000	
B12	0.000	222.000	
B13	57.458	-214.436	
B14	57.458	214.436	
B15	111.000	-192.258	
B16	111.000	192.258	
B17	156.978	-156.978	
B18	156.978	156.978	
B19	192.258	-111.000	
B20	192.258	111.000	
B21	214.436	-57.458	
B22	214.436	57.458	

TAG	X LOC	Y LOC	SIZE
C1	-208.000	0.000	ϕ 4.000 H7/g6 THRU
C2	208.000	-0.000	ϕ 0.04 A B
D1	-180.133	-104.000	ϕ 4.50 THRU ALL
D2	-180.133	104.000	
D3	-104.000	-180.133	
D4	-104.000	180.133	
D5	104.000	-180.133	
D6	104.000	180.133	
D7	180.133	-104.000	
D8	180.133	104.000	
D9	0.000	-208.000	
D10	0.000	208.000	



SECTION A-A
SCALE 1 : 1



DETAIL B
SCALE 1 : 1

MATERIAL	CN80 Carbon Fiber Laminate
SURFACE TREATMENT	
DIMENSIONS IN MM. UNLESS OTHERWISE SPECIFIED:	
TOLERANCES	
X.X ± 0.5	FRAC. ± 1/64
X.XX ± 0.1	ANGLES ± 1.00°
X.XXX ± 0.05	FINISH $\sqrt[3.2]{\mu\text{m}}$

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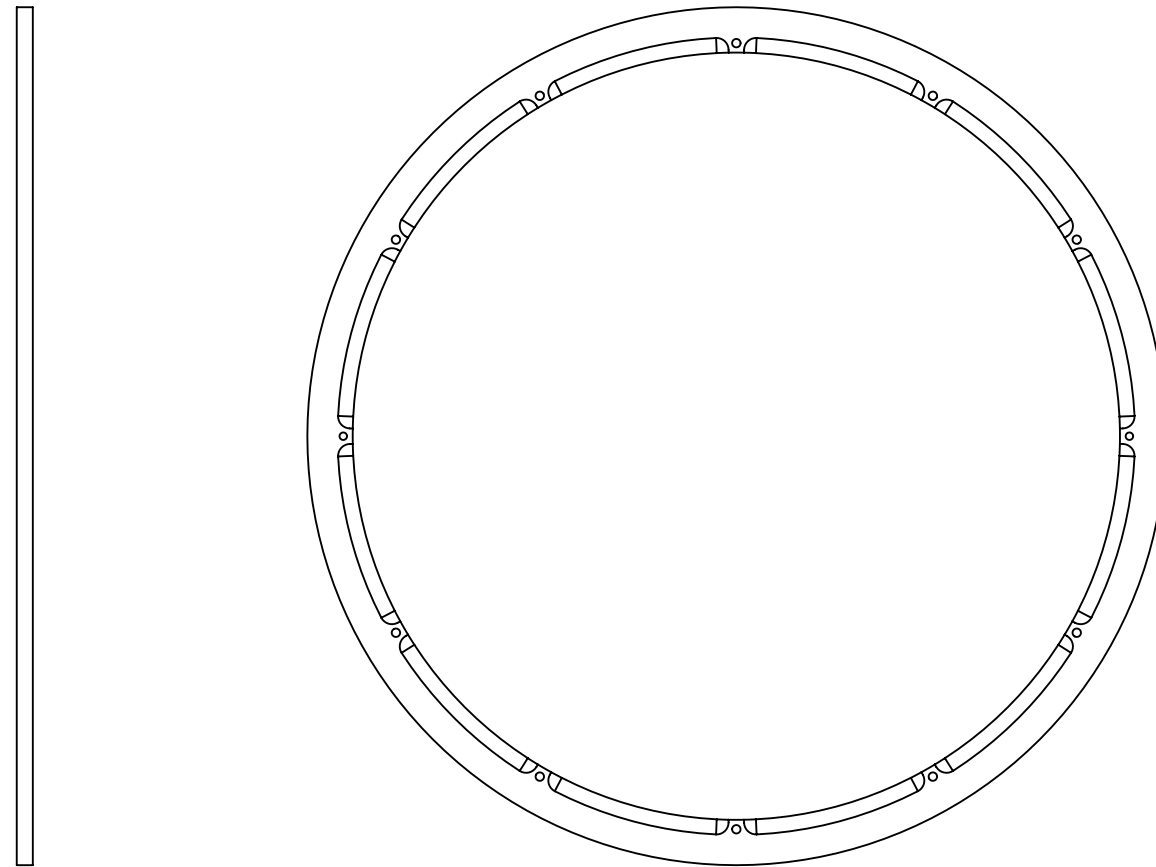
HFT
IDS Small Ring (EAST)

DWG BY	J.H. Silber	DATE	2011-07-14
CHK BY		DATE	
APR BY		DATE	

THREADS ARE CLASS 2
CHAMFER ENDS OF ALL SCREW THREADS 30°
CUT ROUND, 1.5 THREAD RELIEF ON MACHINED THREADS
BREAK EDGES .016 MAX. ON MACHINED WORK
REMOVE BURRS, WELD SPLATTER & LOOSE SCALE
IN ACCORDANCE WITH ASME Y14.5M & B46.1

SER NO.		SCALE:	1:4	SHEET 1 OF 2	
PROJECT NO.		PROJECT NAME		DWG NO.	
		CATEGORY CODE		SIZE	B
				REV.	0005

CONFIGURATION: 2013 IST Fit-up Dummy



Comparison to 2013 config:

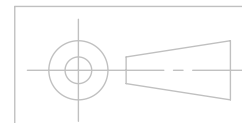
1. Material 6061 aluminum.
2. Same inner holes (C1-C2, D1-D10).
3. Same inner chamfer features.
4. No outer holes.
5. No outer pockets.
6. All other features and tolerances the same.

MATERIAL 6061

SURFACE TREATMENT

DIMENSIONS IN MM. UNLESS OTHERWISE SPECIFIED:

TOLERANCES	X.X ± 0.5	FRAC. ± 1/64
	X.XX ± 0.1	ANGLES ± 1.00°
	X.XXX ± 0.05	FINISH $\sqrt[3.2]{\text{um}}$



THREADS ARE CLASS 2
 CHAMFER ENDS OF ALL SCREW THREADS 30°
 CUT ROUND, 1.5 THREAD RELIEF ON MACHINED THREADS
 BREAK EDGES .016 MAX. ON MACHINED WORK
 REMOVE BURRS, WELD SPLATTER & LOOSE SCALE
 IN ACCORDANCE WITH ASME Y14.5M & B46.1

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HFT

IDS Small Ring (EAST)

DWG BY	DATE
CHK BY	DATE
APR BY	DATE

SER NO.	SCALE: 1:4	SHEET 2 OF 2			
PROJECT NO.	PROJECT NAME	CATEGORY CODE	DWG NO.	SIZE	REV.
			-	B	0005