

Flat Pattern

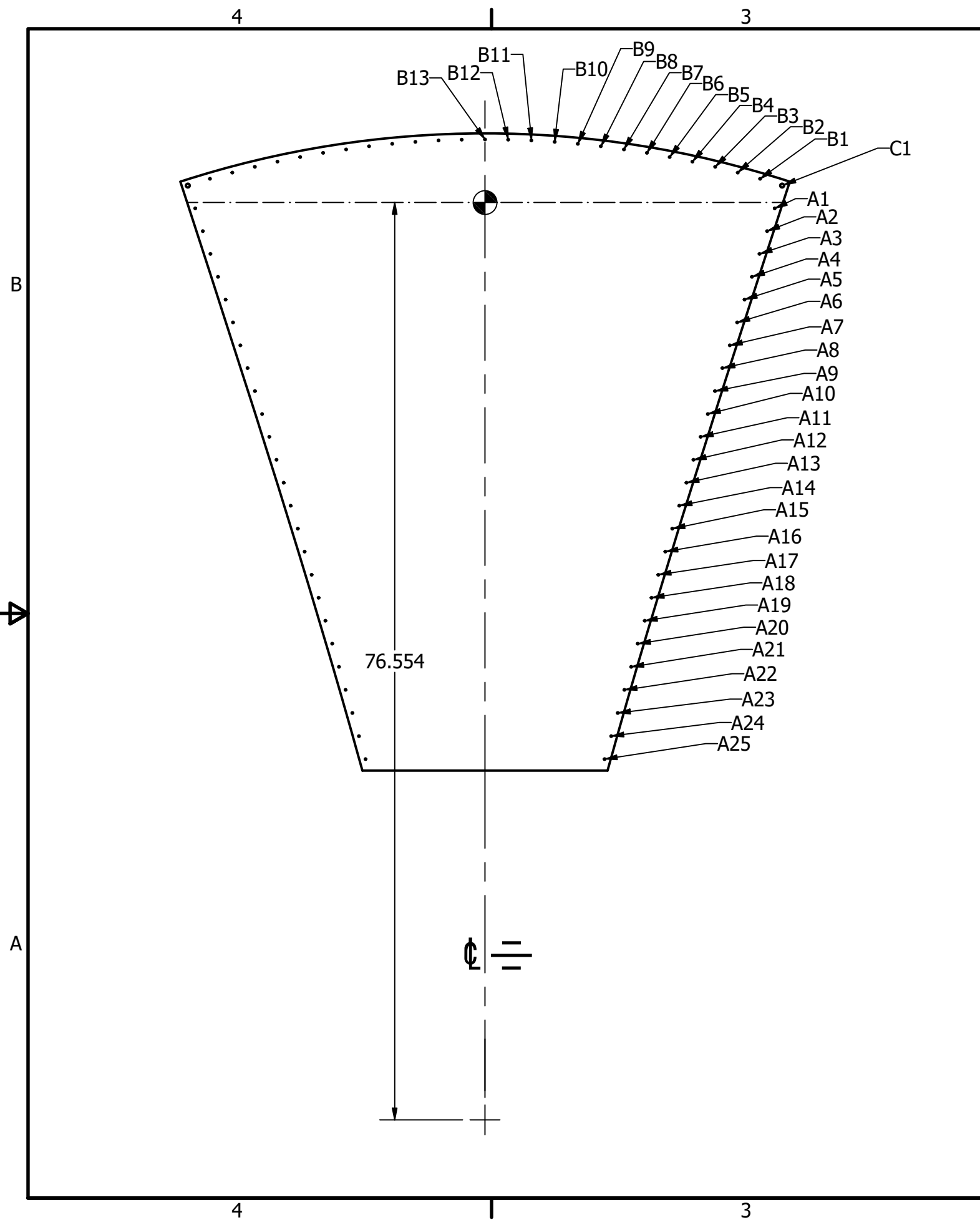
Hole Table on Sheet 2
Bend shown on Sheet 3

Note:
The Bottom Will Need to be Fitted & Trimmed During Assembly

The $\frac{5}{16}$ Clearance Holes in the Upper Corners Should Aline with the Shell

It may be Preferable to Cut the Sides Straight and Oversize;
then Bend and Trim on the Assembled Shell

DRAWN Gary Swift TUNL	10/8/2019	SoLID HGC		
1-919-660-2668				
Material: 2024-T3 or Alum 6061-T6		TITLE Proto Assembly Shell Back Window		
Unless Otherwise Specified Tolerances are: .xx = ± .01 Angles = ± 0.1' .xxx = ± .005	Break Sharp Edges: 0.010			
Dim in Inches		SIZE B	DWG NO SP-10-01-16	REV
		SCALE 0.1 : 1	SHEET 1 OF 3	



HOLE TABLE			
HOLE	XDIM	YDIM	DESCRIPTION
C1	24.808	1.415	Ø.332 THRU
B1	22.967	1.976	Ø.125 THRU Pilot Hole
B2	21.099	2.499	
B3	19.219	2.977	
B4	17.328	3.410	
B5	15.427	3.799	
B6	13.518	4.142	
B7	11.601	4.439	
B8	9.677	4.692	
B9	7.748	4.898	
B10	5.815	5.059	
B11	3.879	5.174	
B12	1.940	5.243	
B13	.000	5.266	

HOLE TABLE			
HOLE	XDIM	YDIM	DESCRIPTION
A1	24.190	-.488	Ø.125 THRU Pilot Hole
A2	23.554	-2.389	
A3	22.923	-4.292	
A4	22.295	-6.196	
A5	21.671	-8.102	
A6	21.050	-10.008	
A7	20.434	-11.916	
A8	19.821	-13.825	
A9	19.212	-15.735	
A10	18.607	-17.647	
A11	18.005	-19.560	
A12	17.408	-21.473	
A13	16.814	-23.388	
A14	16.224	-25.305	
A15	15.637	-27.222	
A16	15.055	-29.140	
A17	14.476	-31.060	
A18	13.901	-32.981	
A19	13.330	-34.903	
A20	12.762	-36.826	
A21	12.199	-38.750	
A22	11.639	-40.675	
A23	11.083	-42.602	
A24	10.531	-44.529	
A25	9.982	-46.458	

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Dim in Inches		DWG NO SP-10-01-16	
		SCALE 0.1 : 1	SHEET 2 OF 3

4

3

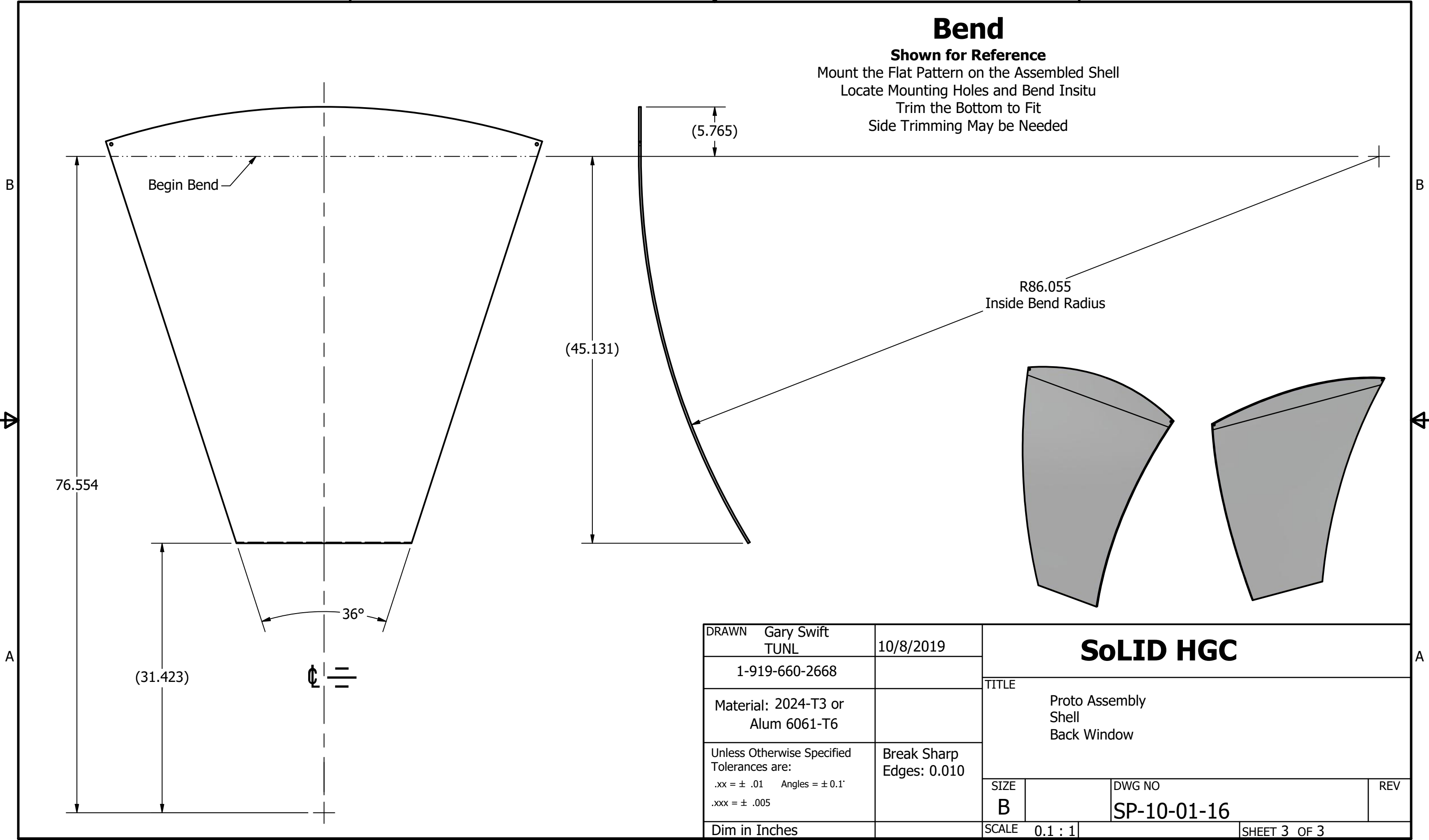
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1

Bend

Shown for Reference

Mount the Flat Pattern on the Assembled Shell
 Locate Mounting Holes and Bend Insitu
 Trim the Bottom to Fit
 Side Trimming May be Needed



DRAWN Gary Swift TUNL	10/8/2019	SOLID HGC		
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Dim in Inches		SCALE 0.1 : 1	SHEET 3 OF 3	