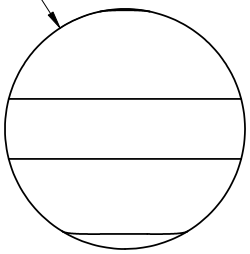
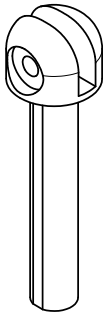
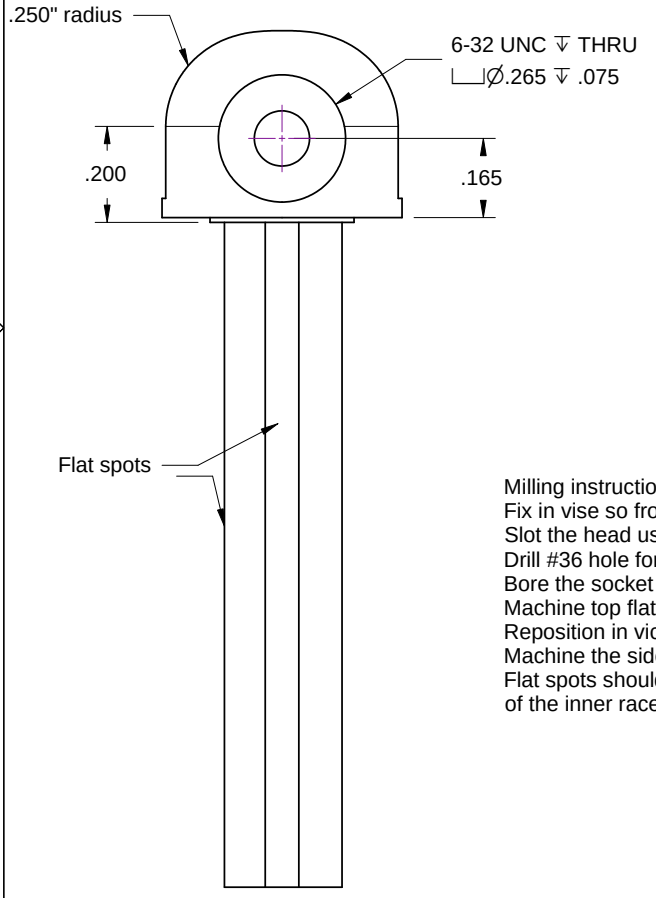
REVISIONS				
ZONE	REV	DESCRIPTION	DATE	APPROVED

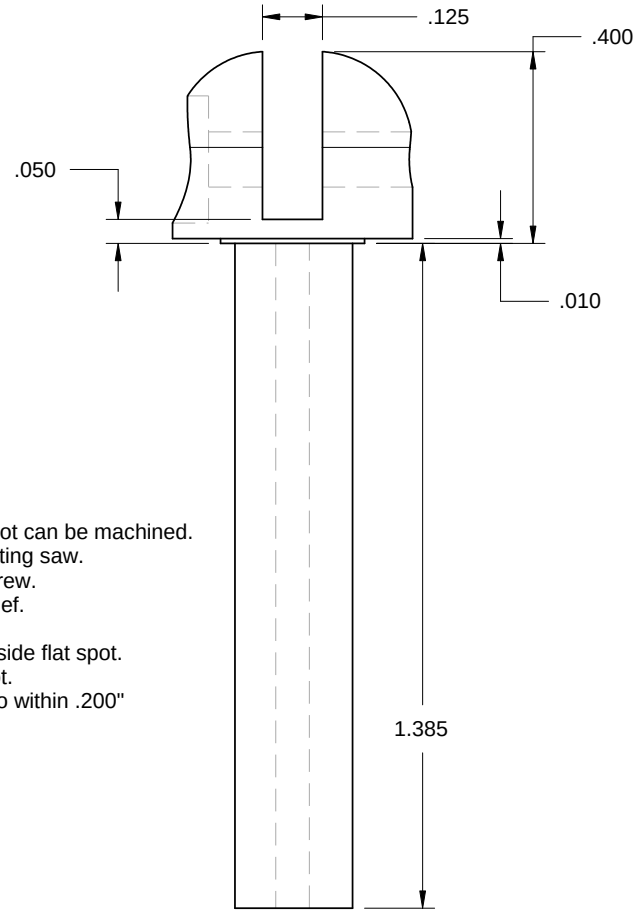
Attitude Stability System
Canard Shaft



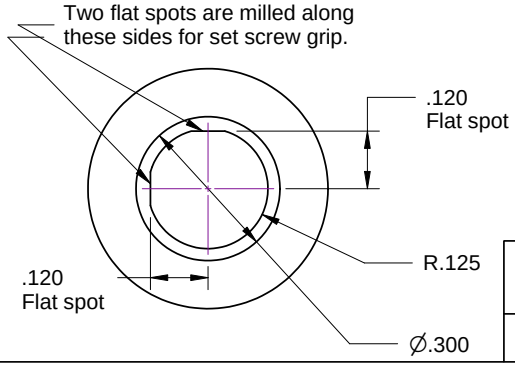
Lathe results:
Initial material is 1/2" dia rod.
Top .250" is rounded into a hemisphere.
Next .190" is left at 1/2" dia,
Next .010" is cut to .300" dia for
bearing inner race seat.
Next 1.385" is cut to .250" dia. +.000 -.003
(slip fit inside bearing inner race)
This end will brace against cup
bearing.







Milling instructions:
Fix in vise so front flat spot can be machined.
Slot the head using a sloting saw.
Drill #36 hole for 6-32 screw.
Bore the socket head relief.
Machine top flat spot.
Reposition in vice to cut side flat spot.
Machine the side flat spot.
Flat spots should come to within .200"
of the inner race lip.



SIZE	FSCM NO.	DWG NO.	REV
A			
SCALE	B. Feretich	SHEET	