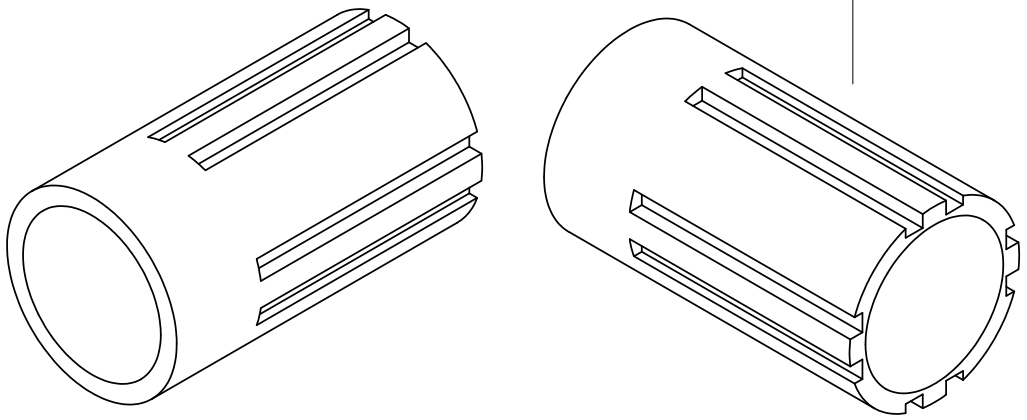
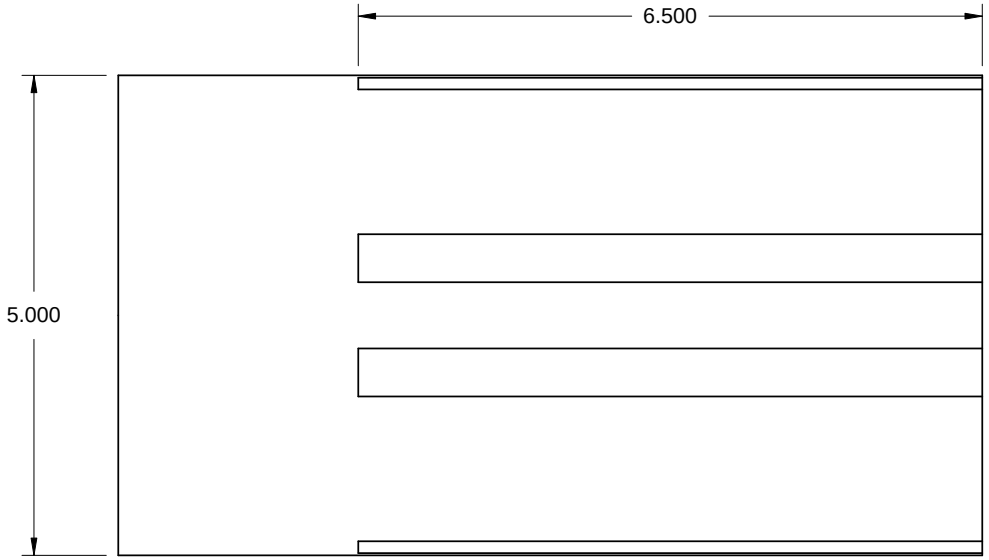
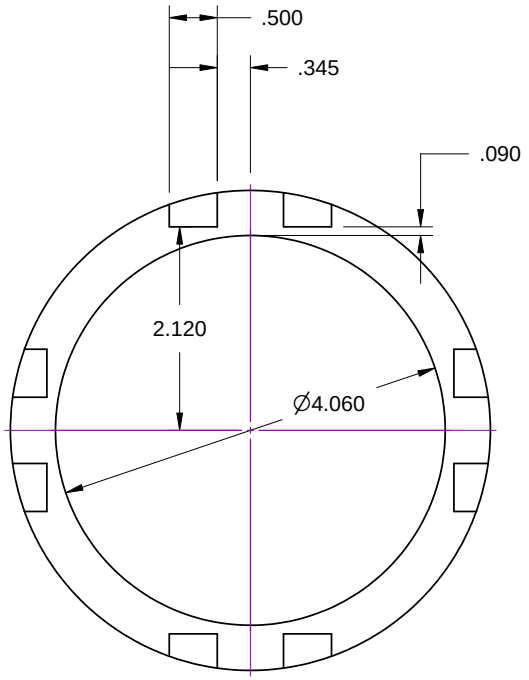
REVISIONS				
ZONE	REV	DESCRIPTION	DATE	APPROVED

External Fin Can Stage 1

8 cuts made with a 1/2" end mill form the fin tabs.







SIZE	FSCM NO.	DWG NO.	REV
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REVISIONS				
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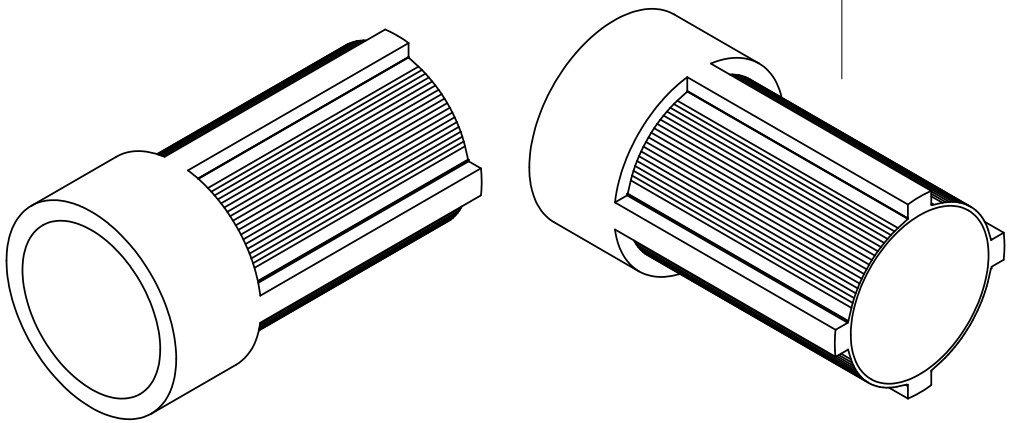
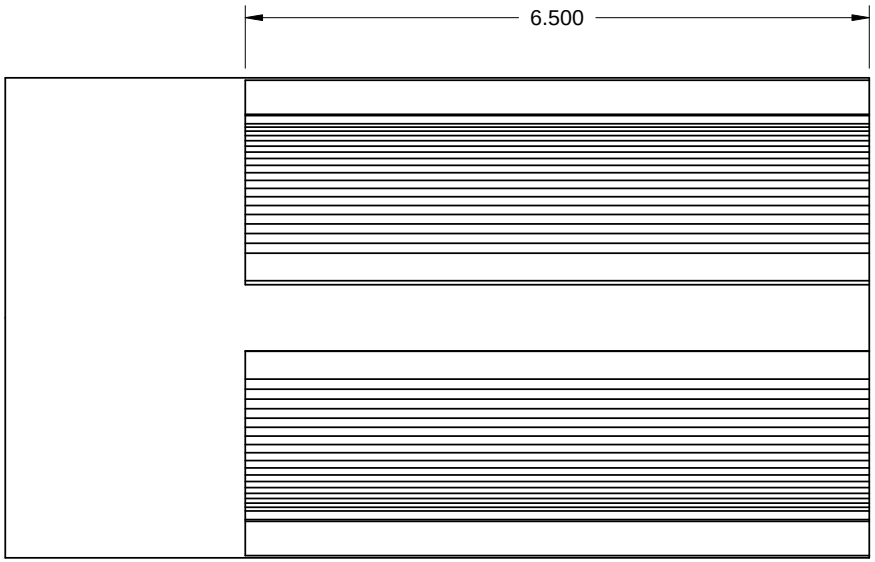
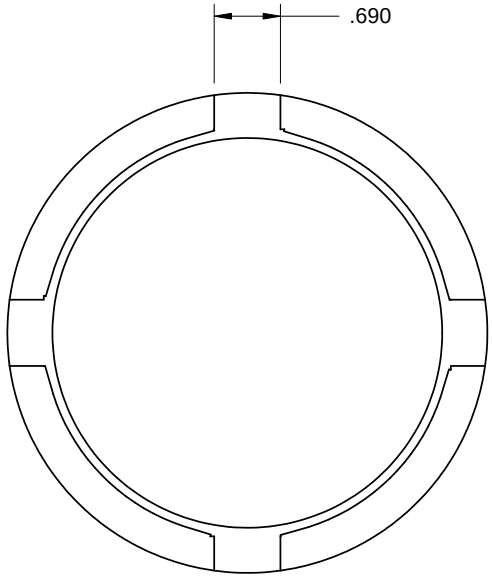
External Fin Can Stage 2



A 1/2" end mill is used to reduce the wall thickness between the tabs to .090". A cut every 2°-4° of rotarion will be necessary to achieve a reasonably smooth surface.





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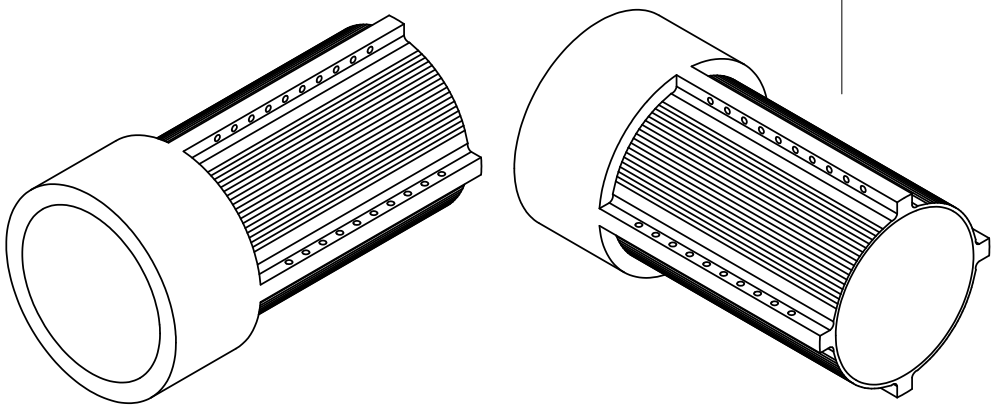
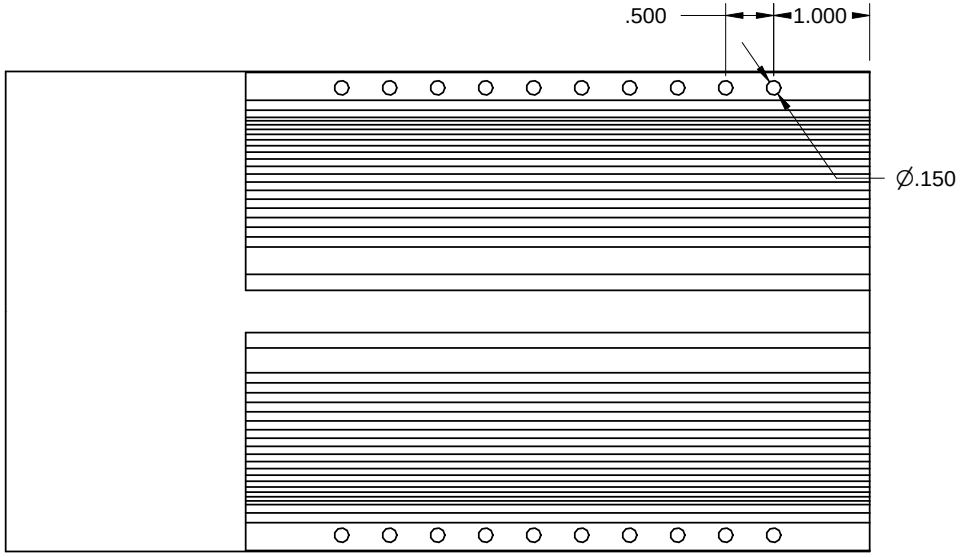
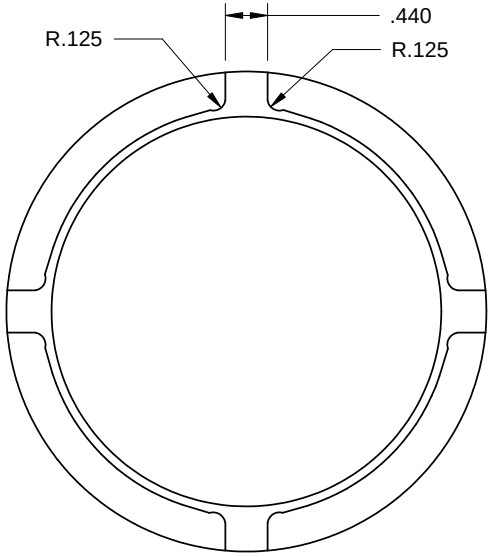
External Fin Can Stage 3



The 1/4" ball end mill is used to create fillets on the fin tabs. The Y-positions are set to +/- .345".
Then, 10x .150" holes are drilled in each tab for fin mounting.





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SCALE	B. Feretich & G. Saviers	SHEET	

REVISIONS				
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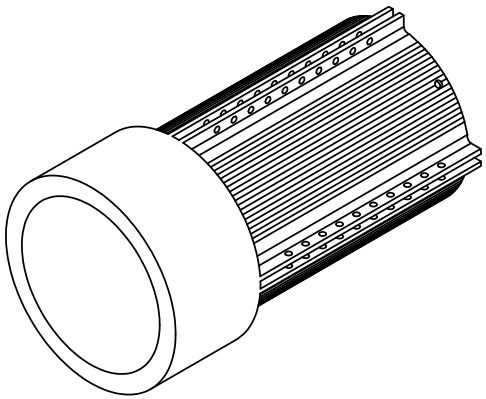
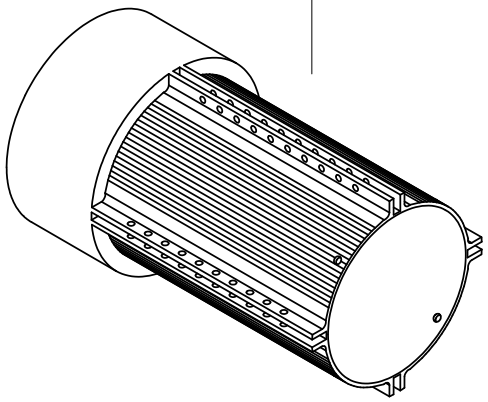
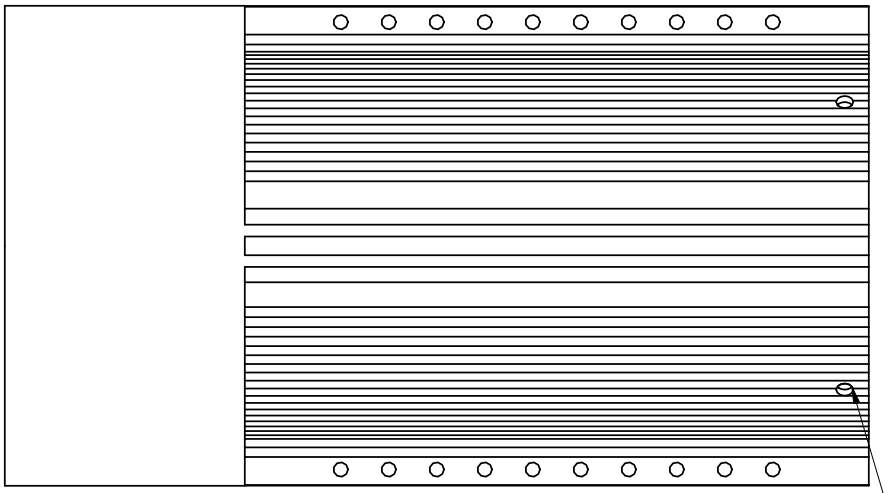
External Fin Can Stage 4

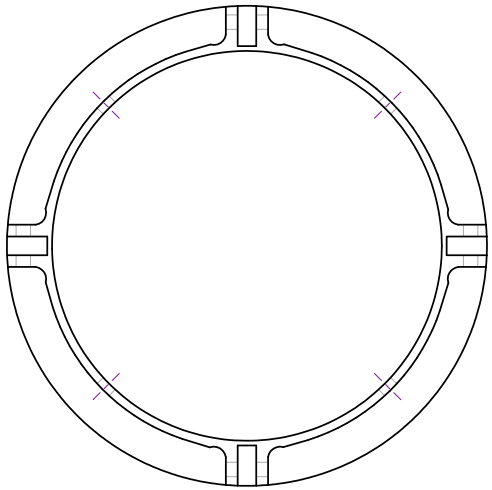




In this stage the fin tabs are slotted using a 3/16" end mill to a slot width of .192" and depth to leave a .040" under. Using a 3/16" end mill, Y-centers are +/- .0025".

Then the solid rod support is nearly removed, and the four motor retainer holes are drilled.





4x ∅.177" ↧ THRU
Motor retainer holes for 8-32 screws.
These holes are offset .250" from the edge and 45° from the tab centers.

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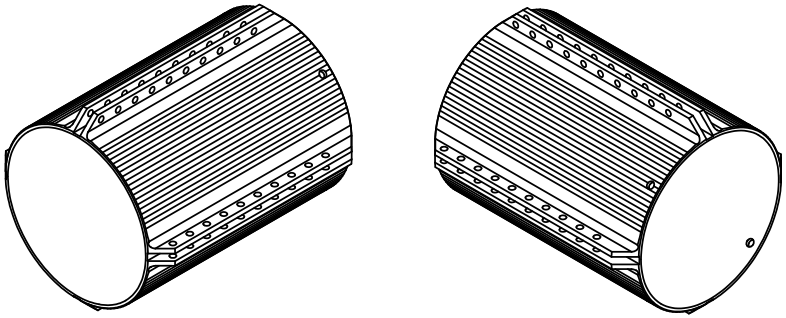
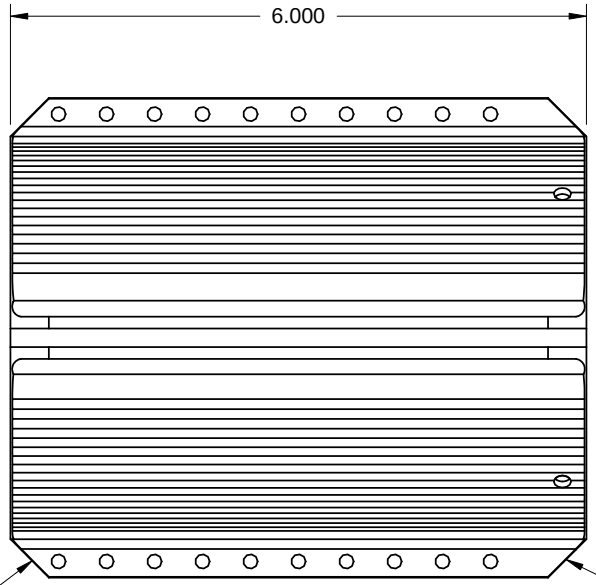
External Fin Can Stage 5

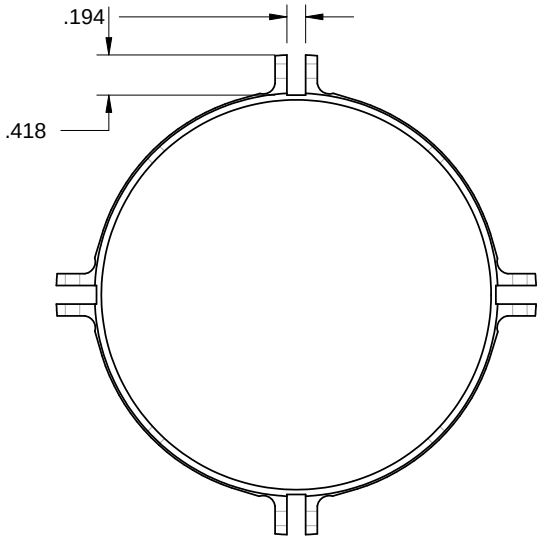


Complete the fin can by cutting it to 6" in length and chamfering the corners of the fin tabs.

The cut-off can be performed by a 1/4" end mill.
This cut can be performed with the support rod partially inserted.

A seperate setup is needed for accurate chamfering.





SIZE	FSCM NO.	DWG NO.	REV
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SCALE	B. Feretich & G. Saviers	SHEET	