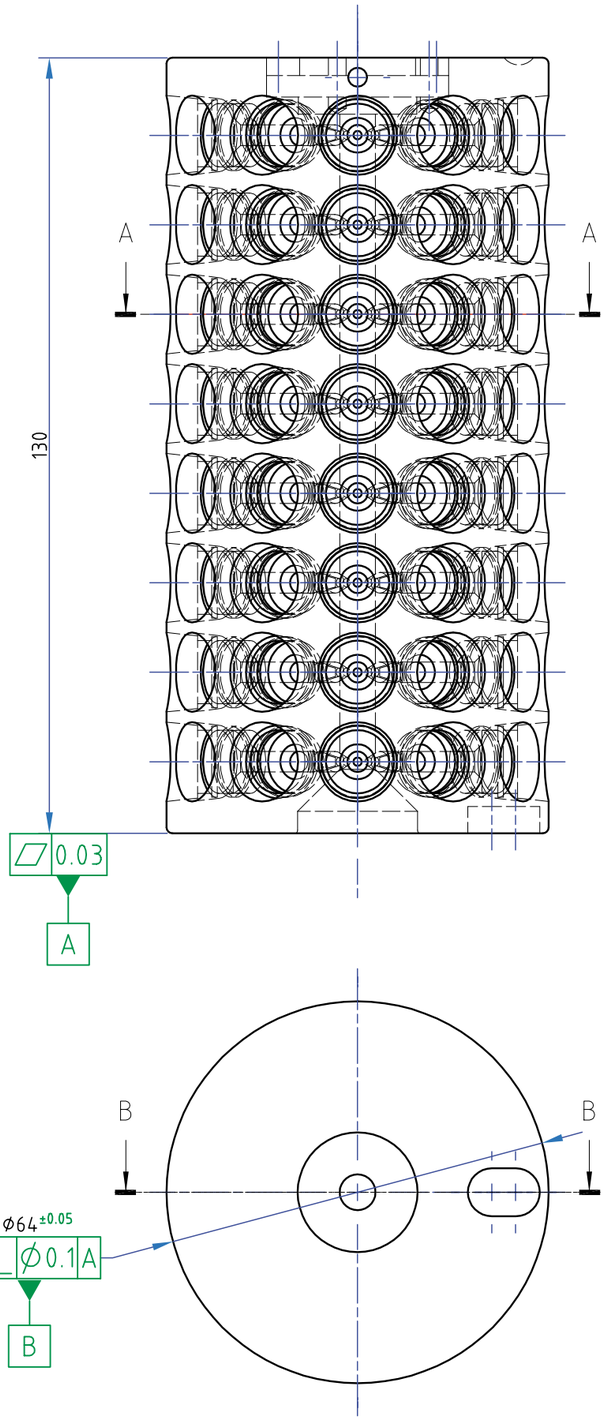
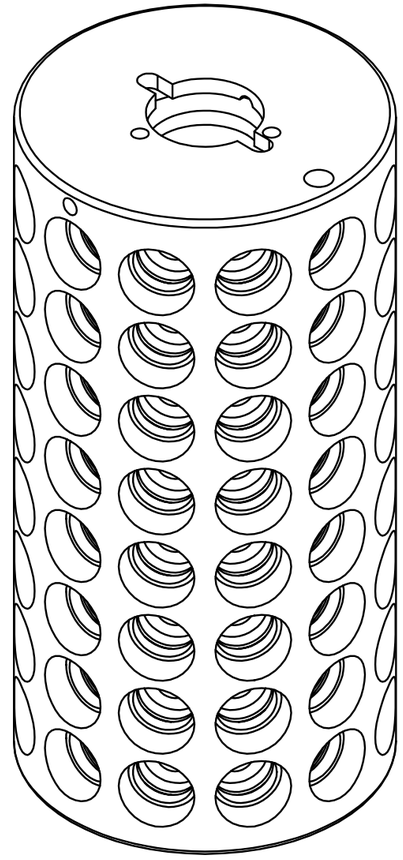


NOTES:

1. THE CASSETTE IS TO MADE OF ALUMINUM 6061-T651
2. THE CASSETTE IS TO BE HARD ANODIZED (0.002" THICK).
3. THERE ARE A TOTAL OF 96 CAVITIES IN THE CASSETTE
4. THE CAVITIES BOTTOMS DO NOT NEED TO BE FLAT, BUT THE CAVITIES MUST NOT BREAK THROUGH TO THE TO THE CENTER Ø6 HOLE OR TO ADJACENT CAVITIES.
5. IT IS O.K. IF THE BOTTOMS OF THE CAVITIES ARE NOT ANODIZED TO THE FULL 0.002" THICKNESS OF THE EXTERIOR OF THE CASSETTE
6. THE BOTTOM DATUM SURFACE (A) IS TO HAVE A SURFACE FINISH OF 0.8 MICROMETERS OR BETTER
7. PART IS TO BE FREE OF BURRS AND ALL EXPOSED SHARP EDGES ARE TO BE BROKEN 0.13 mm MIN 0.35 mm MAX.
8. AFTER ANODIZATION
   a) TWO M3x8 STAINLESS DOWEL PINS ARE TO BE PRESS FIT INTO THE TOP OF THE CASSETTE. (WE USED OLANDER DOWEL PINS AND FOUND THEM A BIT UNDERSIZED. WE OBTAINED A NICE PRESS FIT USING A 0.1190" REAMER AND NOT PLUGGING THE HOLE DURING ANODIZATION.)
   b) SUPPLIED Ni COATED RING MAGNETS ARE TO BE INSERTED INTO EACH CAVITY WITH THEIR NORTH POLE FACING OUT AND RETAINED VIA THE SUPPLIED TEFLON RETAINING RINGS (WASHERS). THE SSRL MAGNET INSERTION TOOL AIDS IN ALIGNING THE MAGNET POLE AND COMPRESSING THE WASHER.



THIRD ANGLE

- DO NOT SCALE -
IF IN DOUBT, ASK.
UNLESS NOTED OTHERWISE,
ALL DIMENSIONS ARE IN MILLIMETERS
AND ALL TOLERANCES ARE ±0.1 mm.

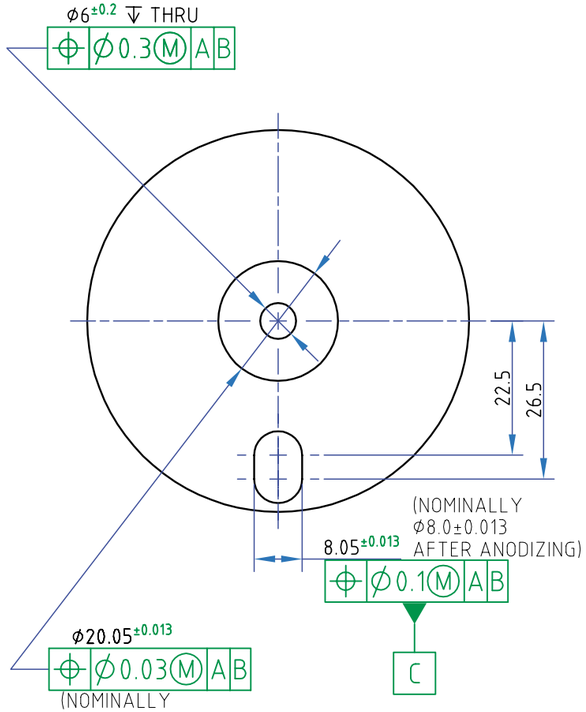
FILE NAME	Cassette-Al-6-MD6.dwg
CONTRACT NO	-
DRAWN	02.19.2002 Mitch Miller
CHECK	
APPR.	
ISSUED	

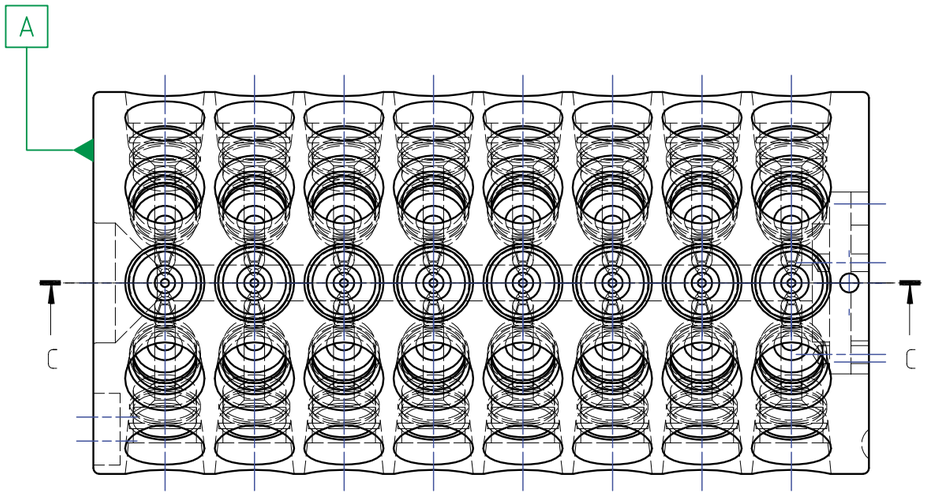
JCSG / SMB / SSRL / SLAC

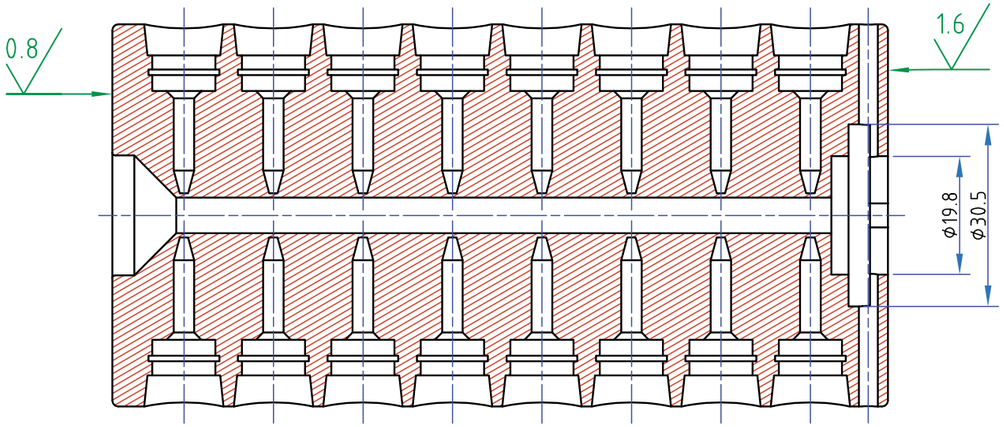
SSRL PX SAMPLE CASSETTE

Aluminum version for SMB/JCSG Robots

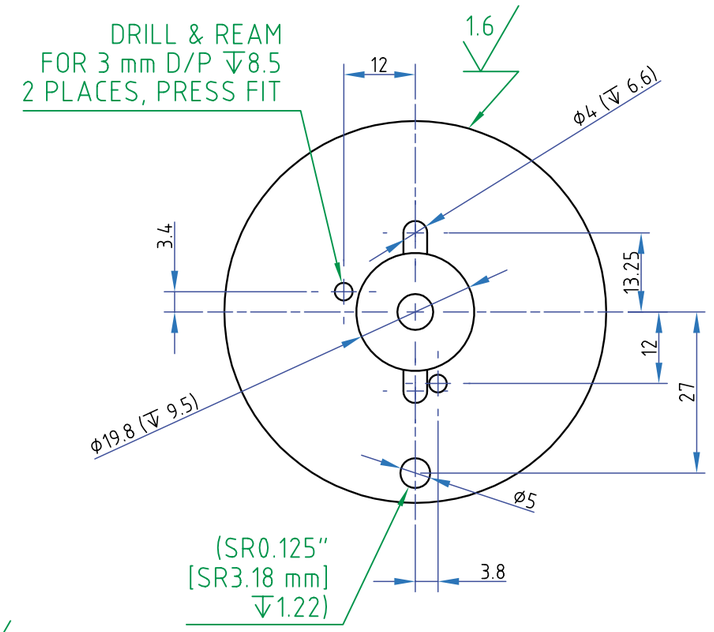
SIZE	FSCM NO	DWG NO	REV
B	-	-	
SCALE 1:1	WEIGHT	SHEET 1 OF 4	







Section C-C



THIRD ANGLE

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APPR.	
ISSUED	

JCSG / SMB / SSRL / SLAC

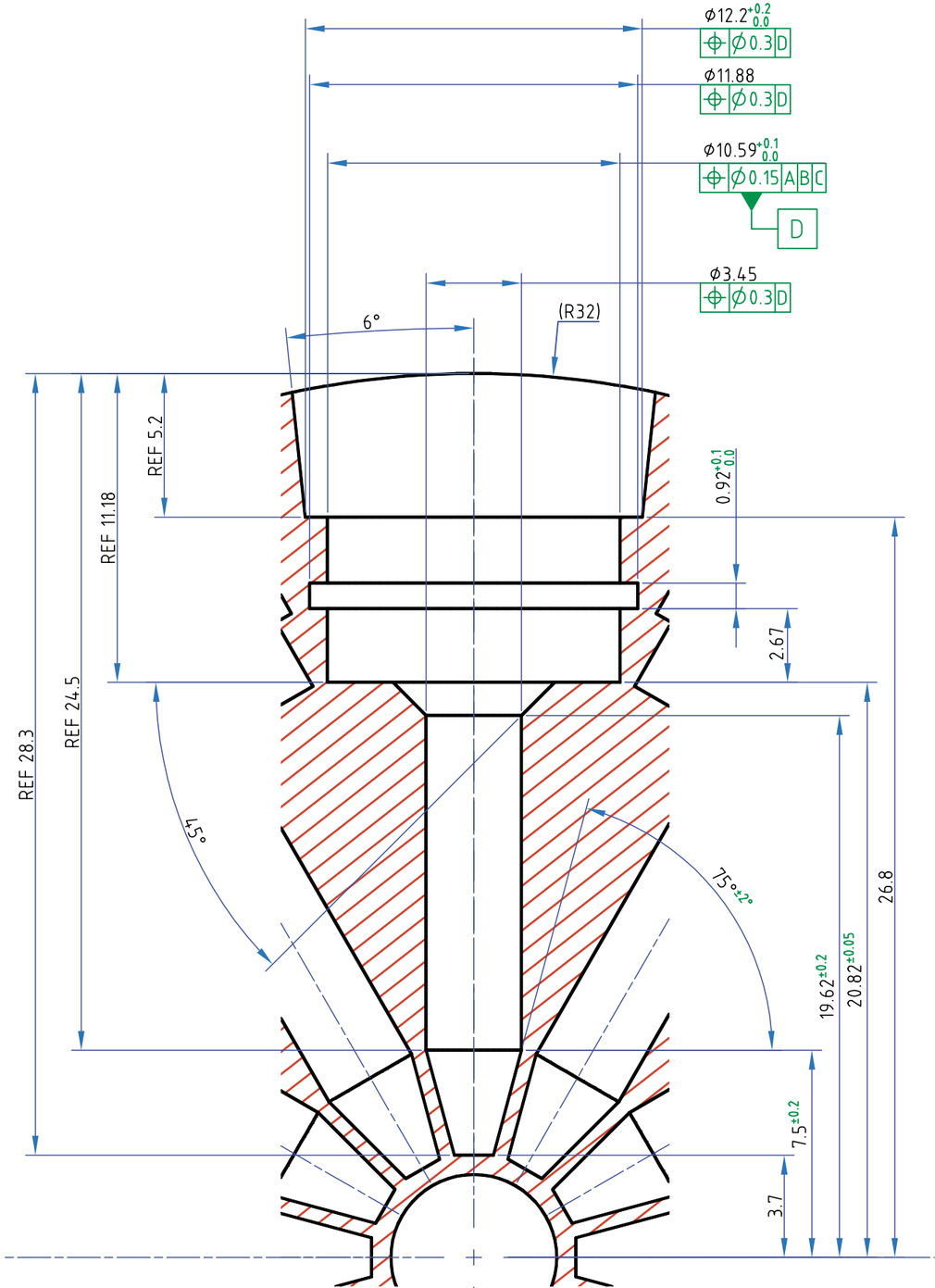
SSRL PX SAMPLE CASSETTE

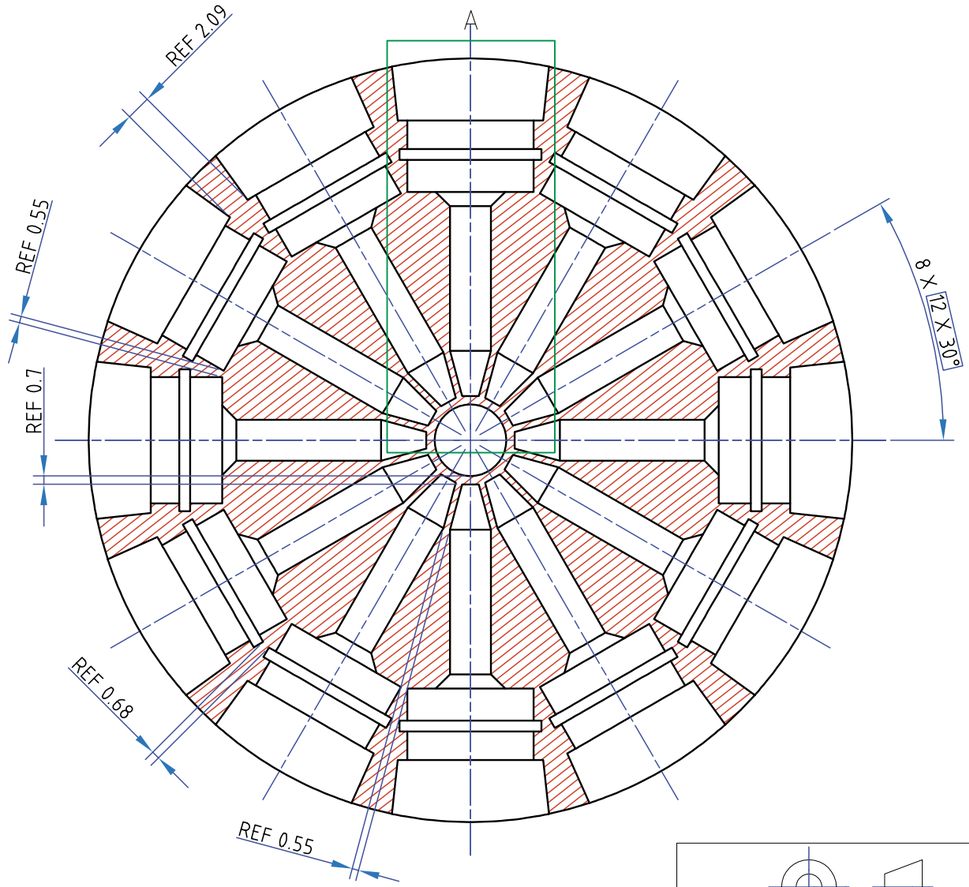
Aluminum version for SMB/JCSG Robot

SIZE	FSCM NO	DWG NO	REV
B	-	–	

SCALE	WEIGHT	SHEET
1:1		2 OF 4

DETAIL A (5:1)
96 PLACES





SECTION A-A

THIRD ANGLE

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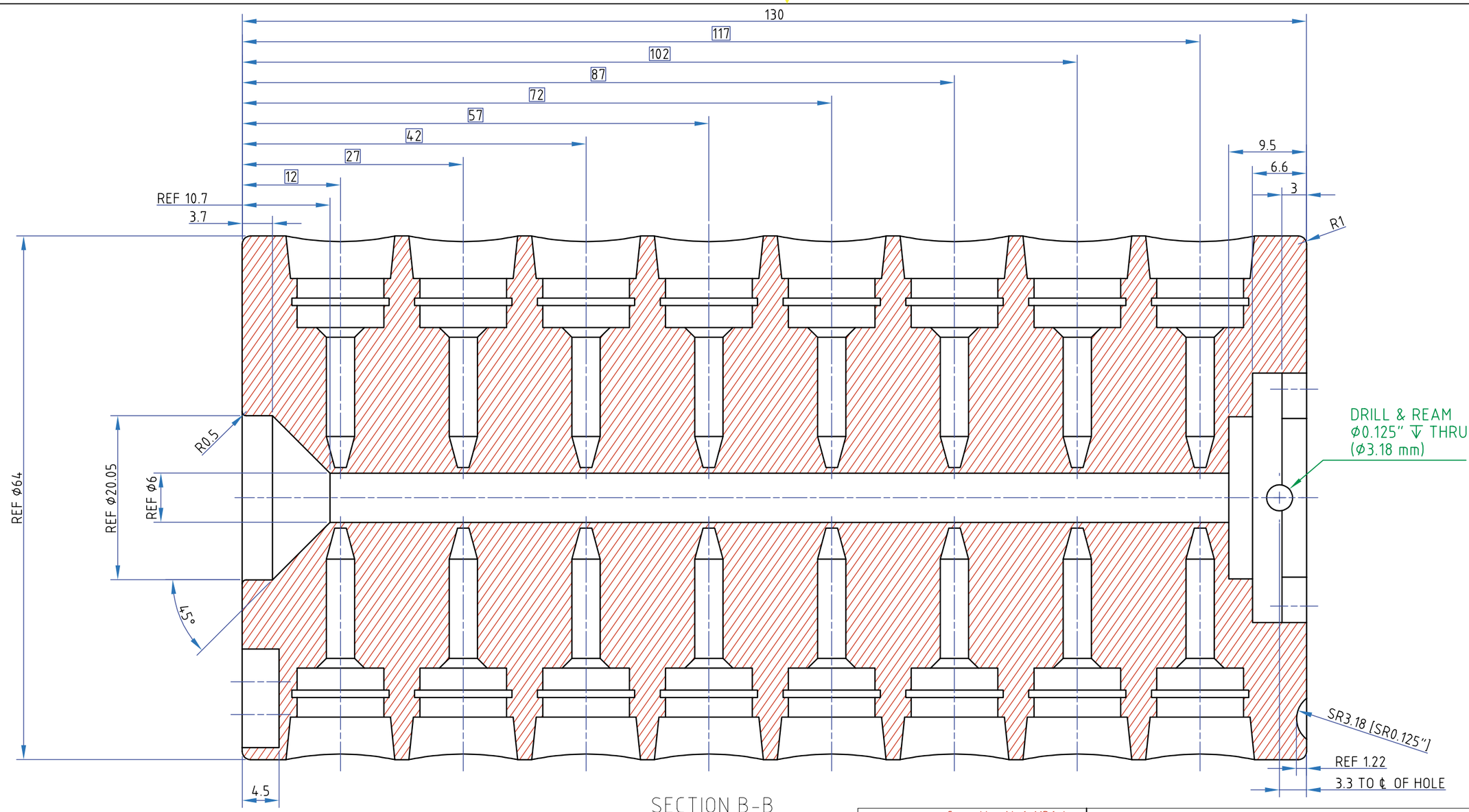
APPR.	
ISSUED	

JCSG / SMB / SSRL / SLAC

SSRL PX SAMPLE CASSETTE

Aluminum version for SMB/JCSG Robots

SIZE	FSCM NO	DWG NO	REV
B	-	-	
SCALE 2:1	WEIGHT	SHEET 3 OF 4	



SECTION B-B

THIRD ANGLE

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AND ALL TOLERANCES ARE ±0.1 mm.

FILE NAME	Cassette-Al-6-MD6.dwg
CONTRACT NO	-
DRAWN	02.19.2002 Mitch Miller
CHECK	
APPR.	
ISSUED	

JCSG / SMB / SSRL / SLAC

SSRL PX SAMPLE CASSETTE

Aluminum version for SMB/JCSG Robots

SIZE	FSCM NO	DWG NO	REV
B	-	-	

SCALE	WEIGHT	SHEET
2:1		4 OF 4