

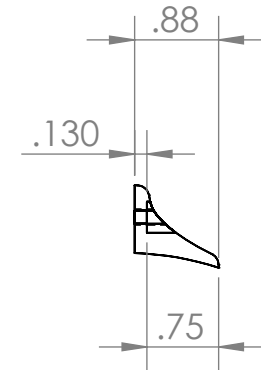
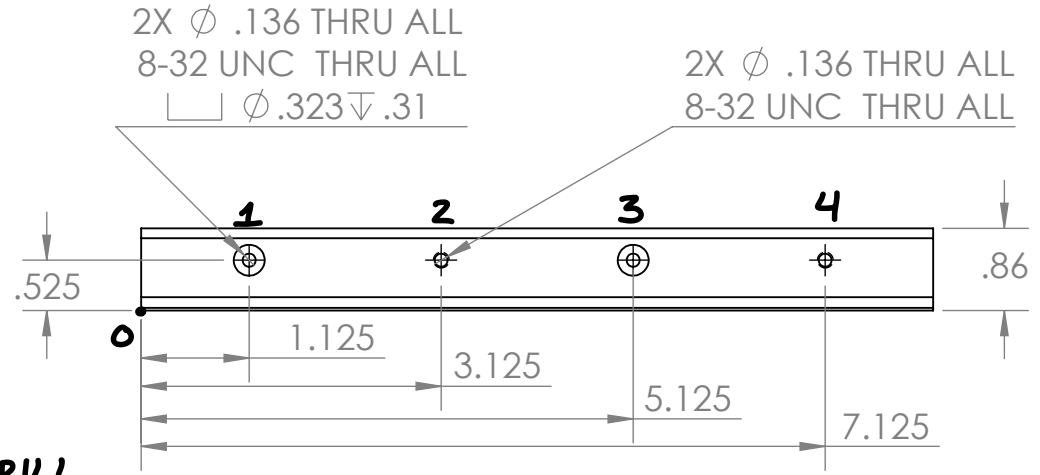
YOU WILL NEED:


- CENTER DRILL (#4 WORKS)
- #16, #29, AND Q DRILLS
- FLAT TIPPED Q DRILL (ASK TODD)

- ① PLACE PART IN VICE WITH .88" DIMENSION ORIENTED VERTICALLY
- ② EDGE FIND (SET POINT 0 AS (0,0))
- ③ SET A Y GO-TO TO .525 + AN X GO-TO AT 1.125, GO ALL THE WAY TO THE GO-TO

- ④ USING THE CENTER DRILL AT 1500 RPM, DRILL DIVOTS FOR ALL FOUR HOLES (MOVING YOUR X GO-TO AS NEEDED)
- ⑤ USING THE #29 DRILL AT 1500 RPM, DRILL THROUGH HOLES FOR HOLES 2+4
- ⑥ REPLACE THE #29 DRILL WITH THE REGULAR (POINTY) Q DRILL
- ⑦ SET Z ZERO W/ THE TIP OF THE DRILL ON TOP OF THE PART
- ⑧ AT 900 RPM, CAREFULLY DRILL DOWN TO Z = -.75 IN HOLES 1 + 3
- ⑨ USING THE #16 DRILL AT 1500 RPM, DRILL THROUGH HOLES 1+3
- ⑩ REPLACE THE #16 DRILL WITH THE FLAT-TIPPED Q DRILL

- ⑪ SET Z ZERO W/ THE TIP OF THE DRILL ON TOP OF THE PART
- ⑫ AT 900 RPM, VERY CAREFULLY DRILL DOWN TO Z = -.75 IN HOLES 1+3
- ⑬ HAND TAP HOLES 2+4 TO AN 8-32 FROM THE SIDE W/O COUNTERBORES, 1/4" IS ENOUGH



UNLESS OTHERWISE SPECIFIED:		KERB	DATE	MIT RT PART DRAWING		
DIMENSIONS ARE IN INCHES TOLERANCES: ANGULAR ± 0.1 TWO PLACE DECIMAL ±0.05 THREE PLACE DECIMAL ±0.005	DRAWN	connor_s	01/08/24	TITLE: Booster Fillet		
	CHECKED	Imayala	01/10/24			
	ENG APPR.	[kerb]	MM/DD/YY			
	PART APPR.	[kerb]	MM/DD/YY			
DEBURR ALL EDGES				SIZE	DWG. NO.	REV
MATERIAL	AL 6061 T6			A	001	
FINISH	AS MACHINED					
DO NOT SCALE DRAWING		SCALE: 1:2	WEIGHT: .188 LBS	SHEET 1 OF 1		