



NOTES:

- For machining, i.e. micro-machining as well as wave guide flange features, on Mixer Top and Bottom common reference is to be used.
- For taking common reference, provision of dowels are provided.
- Micro-machining will be carried out on face shown by MM2.
- Machining allowance of 0.2mm is given on base, MM2 as well as three faces shown using hatch.
- First machining at base is to be done and subsequently on MM2.
- Once machining is completed, both blocks are to be assembled using screws and machining is to be done on base (Shown using datum A) to maintain planarity on mounting face. subsequently a cut of 0.2 mm is to be taken on three faces shown by hatch including G1 & G2 to maintain planarity on faces.
- Tolerance on all hole locations and hole reference dimensions is ± 0.05 mm unless specified.
- To be cleaned and de-burr properly.
- Flatness for all surfaces & perpendicularity between two orthogonal surfaces is to be maintained within 10 micron-meter unless specified.
- Surface Finish (Ra) at marked location to be achieved better than 0.1 micron-meter.
- Dowel pins made of SS304/316 are to be provided. For dowel pin details refer drawing No. MMDD-TDP-230MIX-AL-TOP-01.
- @ Indicates that radius will be same as the cavity dimension.
- All micro machining features shown in detail A, are very critical. Perpendicularity, parallelism and flatness of these features need to be maintained to the best extent possible.
- All attempts shall be made to ensure that cavity depths and channel widths are not taper.
- UNC 4-40 thread is to be made during wave guide flange face machining (in assembled condition)

DEVIATION FOR NON TOLERENCED DIMENSIONS [ISI : 2102 MEDIUM]	PART No.	DESCRIPTION	SIZE / REF.	MATERIAL	No. OFF	REMARKS
DIAMETERS & LENGTHS UPTO & INCL. 6	1	MIXER_BOTTOM	REFER DRG. MMDD-TDP-230MIX-AL-P MB-01	Al6061 T651	-	A=35.21 cm ²
6 - 30	DO NOT SCALE THE DRAWING UNLESS OTHERWISE STATED DIMENSIONS ARE IN MM REMOVE SHARP CORNERS					TITLE
30 - 120						TDP MIXER BOTTOM
120 - 315						TOTAL REQD. WT. IN KGS. N/A
315 - 1000						DGN. AAYUSH
1000 - 2000						DRN. PRAVIN 31/05/24
2000 - 4000						DRG. CHD. ASHISH
4000 & ABOVE						APD. UBD
MACHINING FINISH IN MICRONS						SCALE
∇ 8 - 25						DRG. NO. MMDD-TDP-230MIX-AL-BOTTOM-01
$\nabla\nabla$ 0.025 - 1.6						NTS
$\nabla\nabla\nabla$ < 0.025						APD. SIGN DATE
						SHEET 01 OF 01

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