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## Parts Grouping for Weight

### Head

<table>
<thead>
<tr>
<th>PART NUMBER</th>
<th>QTY</th>
</tr>
</thead>
<tbody>
<tr>
<td>S619-0125M9</td>
<td>5</td>
</tr>
<tr>
<td>S619-0125M9</td>
<td>5</td>
</tr>
<tr>
<td>NECK ASSEMBLY, Q30</td>
<td>1</td>
</tr>
<tr>
<td>FRONT CABLE, HEAD, FRONT, FRONT WIRE</td>
<td>1</td>
</tr>
<tr>
<td>UPPER BUSHING FRONT, Q32</td>
<td>1</td>
</tr>
<tr>
<td>LOWER BUSHING FRONT, Q32</td>
<td>1</td>
</tr>
<tr>
<td>BUSHING AXLE, Q32</td>
<td>4</td>
</tr>
<tr>
<td>BUSHING AXLE, Q32</td>
<td>4</td>
</tr>
</tbody>
</table>

### Neck

<table>
<thead>
<tr>
<th>PART NUMBER</th>
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</tr>
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<tbody>
<tr>
<td>S619-0280M9</td>
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</tr>
<tr>
<td>NECK ASSEMBLY, Q20</td>
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</tr>
<tr>
<td>NECK EXTENSION PART, Q20</td>
<td>1</td>
</tr>
<tr>
<td>ADJUSTABLE MOUNT, Q20</td>
<td>1</td>
</tr>
</tbody>
</table>

### Upper Torso

<table>
<thead>
<tr>
<th>PART NUMBER</th>
<th>QTY</th>
</tr>
</thead>
<tbody>
<tr>
<td>S619-0350W0</td>
<td>1</td>
</tr>
<tr>
<td>COIL, ENCLOSURE BUSHING, QUARTER, Q30</td>
<td>1</td>
</tr>
<tr>
<td>SCREW BUSHING, Q32</td>
<td>4</td>
</tr>
<tr>
<td>BEND CLAMP, CURT, CURT, PRELIM NUTS/WASHERS</td>
<td>8</td>
</tr>
<tr>
<td>SCREW BUSHING, Q32</td>
<td>4</td>
</tr>
<tr>
<td>SCREW BUSHING, Q32 W, ZINC</td>
<td>4</td>
</tr>
<tr>
<td>SCREW BUSHING, Q32 W, ZINC</td>
<td>4</td>
</tr>
<tr>
<td>SCREW BUSHING, Q32 W, ZINC</td>
<td>4</td>
</tr>
<tr>
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<td>4</td>
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<tr>
<td>SCREW BUSHING, Q32 W, ZINC</td>
<td>4</td>
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<tr>
<td>SCREW BUSHING, Q32 W, ZINC</td>
<td>4</td>
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<td>4</td>
</tr>
<tr>
<td>SCREW BUSHING, Q32 W, ZINC</td>
<td>4</td>
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<tr>
<td>SCREW BUSHING, Q32 W, ZINC</td>
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### Upper Arm Left

<table>
<thead>
<tr>
<th>PART NUMBER</th>
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</tr>
</thead>
<tbody>
<tr>
<td>S619-0385M9</td>
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</tr>
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### Upper Arm Right

<table>
<thead>
<tr>
<th>PART NUMBER</th>
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</tr>
</thead>
<tbody>
<tr>
<td>S619-0385M9</td>
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</tr>
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</table>

### Lower Arm Left

<table>
<thead>
<tr>
<th>PART NUMBER</th>
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</tr>
</thead>
<tbody>
<tr>
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### Lower Arm Right

<table>
<thead>
<tr>
<th>PART NUMBER</th>
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</tr>
</thead>
<tbody>
<tr>
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</tr>
</tbody>
</table>

### Lower Leg Left

<table>
<thead>
<tr>
<th>PART NUMBER</th>
<th>QTY</th>
</tr>
</thead>
<tbody>
<tr>
<td>S619-0385M9</td>
<td>1</td>
</tr>
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</table>

### Lower Leg Right

<table>
<thead>
<tr>
<th>PART NUMBER</th>
<th>QTY</th>
</tr>
</thead>
<tbody>
<tr>
<td>S619-0385M9</td>
<td>1</td>
</tr>
</tbody>
</table>

### Suit

<table>
<thead>
<tr>
<th>PART NUMBER</th>
<th>QTY</th>
</tr>
</thead>
<tbody>
<tr>
<td>S619-0385M9</td>
<td>1</td>
</tr>
</tbody>
</table>

**Assembly Weights (lbs)**

<table>
<thead>
<tr>
<th>WEIGHT</th>
<th>QTY</th>
</tr>
</thead>
<tbody>
<tr>
<td>HEAD</td>
<td>2.86</td>
</tr>
<tr>
<td>Neck</td>
<td>0.65</td>
</tr>
<tr>
<td>Upper Arm Left</td>
<td>0.65</td>
</tr>
<tr>
<td>Lower Arm Left</td>
<td>0.65</td>
</tr>
<tr>
<td>Upper Arm Right</td>
<td>2.72</td>
</tr>
<tr>
<td>Lower Arm Right</td>
<td>2.72</td>
</tr>
<tr>
<td>Upper Leg Left</td>
<td>2.80</td>
</tr>
<tr>
<td>Lower Leg Left</td>
<td>2.80</td>
</tr>
<tr>
<td>Upper Leg Right</td>
<td>2.80</td>
</tr>
<tr>
<td>Lower Leg Right</td>
<td>2.80</td>
</tr>
<tr>
<td>Weight</td>
<td>15.90</td>
</tr>
</tbody>
</table>

Total Weight: 15.90 lbs

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SECTION A-A

NOTE:
1. THE TOLERANCES SHOWN ARE BASED ON NOMINAL SIZE
   THEY DO NOT ACCOUNT FOR BENDING/COMPRESSION OR
   STANDING IN DUMMY TOLERANCES

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NOTES:
1. URETHANE COLORED BROWN HARDNESS 80.5 SHORE A
2. GENERAL DIMENSIONS x 2

PARTIAL X-SECTION VIEW

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NOTES:
1. SKULL CAP - HARD POLYURETHANE
2. ENSURE SKIN IS BONDED TO SKULL CAP
3. GENERAL TOLERANCES ± 1 EXCEPT FOR HOLE CENTERS
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NOTES:
1. SKIN - URETHANE COLORED BROWN HARDNESS 80±5 SHORE A
2. GENERAL TOLERANCES ± 2 EXCEPT FOR HOLE CENTERS
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NOTES:
1. APPLY TORQUE TO ITEM #6, 010-2006, 1.5 IN. LBS. (.17 Nm).
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NOTES:
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NOTES:
1. DIMENSIONS SYMMETRIC ABOUT z, UNLESS OTHERWISE SPECIFIED.
2. THE TWO ELLIPSES BLEND AT THE z.
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NOTES:
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NOTES:
1. MATERIAL: NATURAL RUBBER, BLACK, DUROMETER 70/80 SHORE "A"
2. PART MARK AND ADD SERIAL NUMBER WHERE SHOWN
SCALE 2:1

1. MATERIAL: ALUMINUM BRONZE, YIELD STRENGTH 650MPa

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NOTES:
1. ELECTROLESS NICKEL PLATE 0.003mm - 0.008mm MAX. AFTER MACHINING.
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NOTES:

1. ITEM 2 (LIFTING STRAP) MADE OF POLYPROPYLENE.

2. STRAP THICKNESS CANNOT BE GREATER THAN 2.1 mm THICK OR IT WILL NOT FIT THROUGH ITEM 1 (INTERFACE PLATE).

3. CUT WEBBING, POLYPROPYLENE TO 238 mm AND LOOP THROUGH SLOT, OVERLAP WEBBING 40 mm AS SHOWN AND STITCH OVERLAP.

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SCALE 1 : 1

NOTES:
1. SWAGE END FITTINGS
2. CABLE END FITTINGS ARE 303SE STAINLESS STEEL OR EQUIVALENT.
3. CABLE IS 6mm STAINLESS STEEL WIRE ROPE, 7 x 19 CONSTRUCTION.
4. CABLE END MUST BE FLUSH TO END SURFACE, GRIND IF NECESSARY.
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NOTES:

1. ALL DIMENSIONS ARE SYMMETRIC TO Φ UNLESS OTHERWISE NOTED.
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NOTES
1. THREADED END FITTING IS 303 STAINLESS STEEL OR EQUIVALENT
2. BALL END FITTING (PURCHASED) STAINLESS STEEL
3. CABLE IS 1/8" STAINLESS STEEL WIRE ROPE 7 x 7 CONSTRUCTION
4. CABLE ENDS MUST BE FLUSH TO END SURFACES

SCALE 1 : 1

SØ 8.0 AFTER SWAGING

2x 0.5 x 45° CHAMFER

M6 x 1 THREAD

CABLE END FITTING
SEE NOTE 3

BALL END FITTING
SEE NOTE 2

THREADED END FITTING
SEE NOTE 1
SCALE .5:1

NOTES:

1. DIMENSIONS SYMMETRIC ABOUT 4, UNLESS OTHERWISE SPECIFIED.

2. MATERIAL: POLYURETHANE 60 SHORE D.

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NOTES:

1. GENERAL TOLERANCE ± 1 EXCEPT FOR HOLE DIAMETERS, CENTERS OR IF OTHERWISE STATED.
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NOTES:

1. DIMENSIONS SYMMETRIC ABOUT \( \xi \), UNLESS OTHERWISE SPECIFIED.
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Notes
1. Material: Natural Rubber Hardness 75 ± 5
2. General Tolerance ± 1
GRIND THREADED INSERT FITTING AFTER MOLDING
FITTING PROTRUSION TO BE 0.5 MAX

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NOTES
1. MATERIAL: NATURAL RUBBER, HARDNESS 75 ±5 SHORE A
2. GENERAL TOLERANCE ±1
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SCALE 1 / 2

SECTION C-C
SCALE 1:1

SECTION A-A
SCALE 1:1

NOTES:
1. MATERIAL: PU FOAM FILLED PVC SKIN
2. ALL DIMENSIONS ARE ±0.5 MM FROM NOMINAL.

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Notes:
1. Dimensions symmetric about θ, unless otherwise specified.
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NOTES:
1. RIB CAGE SKIN TO BE BONDED TO RIB CAGE MOLDING
2. TOLERANCE ±2, UNLESS OTHERWISE NOTED.

<table>
<thead>
<tr>
<th>ITEM</th>
<th>QTY</th>
<th>PART NUMBER</th>
<th>DESCRIPTION</th>
</tr>
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<tbody>
<tr>
<td>2</td>
<td>1</td>
<td>010-4102un</td>
<td>RIB CAGE SKIN, Q10</td>
</tr>
<tr>
<td>1</td>
<td>1</td>
<td>010-4101un</td>
<td>RIB CAGE, MOLDED, Q10</td>
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HUMANETICS

REV: A
DATE: 07/10/2015

PARTS LIST

RIBCAGE, Q10

Drawing Control Information

Revision

Drawing

Design

Release

Drawing Number

Scale

ECP

REV

DESCRIPTION

BY

DATE
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NOTES:
1. MATERIAL: PVC, BROWN, DIAMETER 50.5 SHORE A.
2. DIMENSIONS SYMMETRIC ABOUT X, UNLESS OTHERWISE NOTED.
3. THICKNESS 3mm.
4. SHAPE TO MATCH OUTER RIB PROFILE ON 010-4131.
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NOTES:
1. CUT ITEM 1 WIRE INSERT (M3 x 0.5 x 3 SELF LOCKING) FROM 3MM LENGTH TO 2 MM BEFORE INSTALL.

<table>
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<tr>
<td>2</td>
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<td></td>
<td>WIRE INSERT M5 X .8 X 5 SELF LOCKING</td>
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<tr>
<td>1</td>
<td>1</td>
<td></td>
<td>WIRE INSERT M3 X .8 X 3 SELF LOCKING</td>
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</tbody>
</table>

PARTS LIST

HUMANETICS
303 STAINLESS STEEL M. BURLEIGH 28/11/2014
IR SENSOR ADAPTOR Q10
A31 or 1 010-4105sun A
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NOTES:
1. DIMENSIONS ARE SYMMETRICAL ACROSS CENTERLINE.
2. TRIM WIRE INSERTS TO 3mm BEFORE INSTALLATION.
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NOTES:
1. DIMENSIONS SYMMETRIC ABOUT L, UNLESS OTHERWISE NOTED
2. MATERIAL: RIGID PLASTIC
   MINIMUM DUROMETER: 60D

SECTION A-A
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NOTES:
1. MAKE FROM M4 .7 X 8 SHCS, MODIFY AS SHOWN.
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SCALE 1 / 2

NOTES:
1. MATERIAL: PVC SKIN WITH POLYURETHANE FOAM FILL
2. GENERAL TOLERANCES ± .02 UNLESS OTHERWISE STATED
NOTES:

1. MATERIAL: LYCRA
2. ALL FABRIC EDGES TO BE INSIDE FINISHED SLEEVE. SHINY SIDE OF FABRIC TO FACE OUT.
3. PROPERTIES OF DRAWSTRING IS AT DISCRETION OF VENDOR. MIN. LENGTH OF DRAWSTRING 250 MM.

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NOTE:

1) ITEM 3, SENSOR SLEEVE, IS NOT TO BE USED IN COMBINATION WITH ITEM 2, SENSOR REPLACEMENT, BUT IS TO BE USED IN COMBINATION WITH APTS SENSOR/BLADDER (NOT SHOWN, PURCHASED SEPARATELY). ITEM 2 IS A REPLACEMENT FOR APTS SENSOR AND SLEEVE COMBINATION AND USED IN CERTIFICATION.

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<td>SENSOR SLEEVE, FABRIC W/STRING TIE</td>
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<td>2</td>
<td>2</td>
<td>010-4307un</td>
<td>SENSOR REPLACEMENT, FOAM</td>
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<td>010-4311un</td>
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REVISION HISTORY

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<th>REV</th>
<th>DESCRIPTION</th>
<th>BY</th>
<th>ENG'R.</th>
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NOTES:
1. PRE-LOAD SPINE MOLDING BY 1/2 TURN OF NUT.
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hardware for design or manufacturing purposes.

NOTES:
1. MATERIAL: NATURAL RUBBER, DUROMETER 79±2 SHORE "A".
2. ALL DIMENSIONS ARE SYMMETRICAL ABOUT t UNLESS OTHERWISE NOTED.
3. PART MARK AND ADD SERIAL NUMBER WHERE SHOWN
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NOTES:
1. ALL DIMENSIONS ARE SYMMETRICAL ABOUT $\xi$, UNLESS OTHERWISE NOTED.
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NOTES:
1. SWAGE END FITTINGS ONTO WIRE TO Ø7.95.
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NOTES:

1. MATERIAL: Ø5MM, 7 X 19 WIRE ROPE, 316 SS.
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NOTES:
1. ALL DIMENSIONS ARE CENTERED ABOUT ø UNLESS OTHERWISE NOTED.

4X ø3.30 THRU MMx0.7 TAP THRU

1 X 45.0° CHAMFER ALL AROUND

ø19.00 THRU M20x1 TAP THRU

ø50

ø33.73 ± 0.05

22.90

11.50

25.70

2X 15.30

2X 16.40

(70°)

(80°)

(40°)

(35°)
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NOTES:

1. MATERIAL: ALUMINUM BRONZE (YIELD STRENGTH 650MPa MIN)

2. ALL DIMENSIONS ARE CENTERED ABOUT \( \frac{1}{4} \) UNLESS OTHERWISE NOTED.
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NOTES:
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NOTES:
1. INSERT ROLL PIN INTO BALL FROM SIDE WITH CHAMFER ON HOLE.

SECTION A-A
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NOTES:
1. MATERIAL: NATURAL RUBBER DUROMETER 60 ±5 SHORE A.
2. RUBBER BONDED TO PLATES ON MOLDING
3. PARTS IS SYMMETRICAL ABOUT ✡ UNLESS OTHERWISE NOTED.
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NOTES:
1. MATERIAL: POLYURETHANE
   DUROMETRIC: 25 ± 5 SHORE 'A'
2. REMOVE ALL MOLD FLASHING
3. ALL DIMENSIONS ± 3

PROVISIONAL VERSION AWAITING FINAL APPROVAL
BY GRSP INFORMAL GROUP ON CRS
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NOTES:
1. INSTALL DOWEL PINS AFTER PLATING.
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NOTES:
1. OUTER EDGE RADIUS 2 MM.
2. MATERIAL: POLYURETHANE
3. GENERAL TOLERANCES ± 1 EXCEPT FOR HOLE DIAMETERS AND POSITIONS

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NOTES:
1. MATERIAL: 5mm THICK DOUBLE LINED POLYCHLOROPRENE FOAM
   COLOR YELLOW, LINING BLACK.
2. WEIGHT TO BE 630 GRAMS ± 100
3. PANELS TO BE STITCHED TOGETHER WITH 15mm WHITE TAPE. STITCH EDGES WITH RED OR BLACK TAPE
4. THIS PAGE ONLY, PART IS SHOWN NOT TO SCALE.

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NOTES:
1. PARTS ARE SHOWN IN 1:1 SCALE
2. GENERAL TOLERANCE ± 3
NOTES:
1. PARTS ARE SHOWN IN 1:1 SCALE
2. GENERAL TOLERANCE ± 3

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NOTES:
1. PARTS ARE SHOWN IN 1:1 SCALE
2. GENERAL TOLERANCE ± 3
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NOTES:
1. CUT HOOK LOCKING PATCH TO DIMENSIONS SHOWN
2. ATTACH TO PART IN APPROXIMATE LOCATION
3. GENERAL TOLERANCE ± 1
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NOTES:
1. CUT HOOK LOCK TO DIMENSIONS SHOWN
2. ATTACH HOOK LOCK TO PART IN APPROXIMATE LOCATION
3. GENERAL TOLERANCE ± 1

<table>
<thead>
<tr>
<th>ITEM</th>
<th>QTY</th>
<th>PART NUMBER</th>
<th>DESCRIPTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td></td>
<td>010-8002un</td>
<td>HOOK LOCK-SELF ADHESIVE BACKED</td>
</tr>
</tbody>
</table>

DIMENSIONS
- R4
- ALL VELCRO DIMENSIONS ± 2 mm
- 47° ± 2°
- 64° ± 2°
- 74 mm
- 54 mm
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NOTES:
1. BOND 010-9110 INTO SLOTS ON KNEE AS SHOWN, USING CYANOACRYLATE ADHESIVE.
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NOTES:
1. PVC SKIN FILLED WITH POLYURETHANE ELASTOMER
2. GENERAL TOLERANCE ± 0.002
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NOTES:
1. MATERIAL: NITRILE RUBBER: SHORE A 70
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NOTES:
1. BOND 010-8110 INTO SLOTS ON KNEE AS SHOWN, USING CYANACRYLATE ADHESIVE

SCALE 1 : 1
(UPPER LEG FLESH OMITTED FROM VIEW)
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NOTES:
1. FLESH: URETHANE 50+/-5 SHORE A, PEWTER TO BROWN
2. BOND SEAL ITEM 4 TO END OF BONE WITH HIGH STRENGTH GLUE
3. GENERAL TOLERANCES ±2 UNLESS OTHERWISE SPECIFIED
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SECTION A-A

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NOTES:
1. PVC SKIN FILLED WITH POLYURETHANE ELASTOMER.
2. GENERAL TOLERANCE ± 2
0.0 LOCATION PIN CAN BE ADDED TO ENSURE ALIGNMENT REMOVE AFTER WELDING

(250.6)

(93.5)

INSTALL WIRE INSERT 2mm BELOW SURFACE

SECTION A-A
SCALE 1 : 1

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NOTES:
1. WELD MATING SURFACES AS NOTED
2. WELDING DIMENSION TOLERANCE ±0.5mm
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NOTES:
1. WELD MATING SURFACES AS NOTED
2. HEAT TREAT: NORMALIZE
3. WELDING DIMENSION TOLERANCE ±0.5mm
   SEE TITLE BLOCK FOR MACHINED TOLERANCE
4. ALL PARTS ARE SYMMETRICAL ABOUT 1 UNLESS OTHERWISE NOTED
1. ALL DIMENSIONS ARE SYMMETRICAL ABOUT T UNLESS OTHERWISE NOTED.
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NOTES:

1. ALL DIMENSIONS ARE SYMMETRICAL ABOUT 4 UNLESS OTHERWISE NOTED.
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NOTES:

1. MAKE FROM SET SCREW NYLON TIPPED M8X1.25X20
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NOTES:

1. MADE FROM STEEL SCREW, SHSS M10 X 35
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SCALE 3/4
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NOTES:
1. BOND END STOPS, ITEM 2 INTO RECESS USING CYANOACRYLATE ADHESIVE
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NOTES:
1. ALL DIMENSIONS ARE SYMMETRICAL ABOUT T UNLESS OTHERWISE NOTED.
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NOTES:
1. FLESH: URETHANE PIGMENTED BROWN 50I5 SHORE A.
2. GENERAL TOLERANCES ± 2 UNLESS OTHERWISE STATED.
SECTION A-A

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NOTES:
1. REMOVE ONE COIL FROM ITEM 1 PRIOR TO INSTALLATION.
2. WIRE INSERT WILL NEED TO BE TRIMMED TO BE FITTED 0.5 BELOW SURFACE.
EXPLODED VIEW
SCALE 1:2
(UPPER ARM FLESH OMITTED FROM VIEW)

SECTION A-A
SCALE 2 : 1

NOTES:
1. FLESH URETHANE PIGMENTED BROWN 28-33 SHORE A
2. PRESS SHOULDER BEARING, ITEM 5, INTO ARM BONE
3. GENERAL TOLERANCE ON FLESH ± 2

STEEL INSERTS MUST NOT
PROTRUDE ABOVE
THOSE SURFACES

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NOTES:

1. MATERIAL: RUBBER, 40-60 SHORE A DUROMETER

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NOTES:
1. MODIFY PART AS SHOWN
M6x1.0x40 SHCS CLASS 12.9
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NOTES:
1. MODIFY PART AS SHOWN FROM STANDARD PART M8x1.25x16 SOCKET SET SCREW PLASTIC TIP
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NOTES:
1. BOND END STOPS, ITEM 2 INTO RECESS USING CYANOACRYLATE ADHESIVE
NOTES:
1. ALL DIMENSIONS ARE SYMMETRICAL ABOUT Ε UNLESS OTHERWISE NOTED.
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NOTES:
1. FLESH: URETHANE PIGMENTED BROWN 50±5 SHORE A.
2. GENERAL TOLERANCE ± 2 ON FLESH UNLESS OTHERWISE STATED.
EXPLODED VIEW
SCALE 1:2
(UPPER ARM FLESH SHOWN FROM VIEW)

SECTION A-A
SCALE 2:1

THES SURFACES TO BE FLUSH

STEEL INSERTS MUST NOT PROTRUDE ABOVE THESE SURFACES

74.3

291.2

57.1

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1. ELECTROLESS NICKEL PLATE
2. ALL DIMENSIONS ARE SYMMETRICAL ABOUT Θ UNLESS OTHERWISE NOTED.
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NOTES:
1. DIMENSIONS SYMMETRIC ABOUT , UNLESS OTHERWISE NOTED.
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NOTES:
1. MATERIAL: CIBA TOOL OR SIMILAR MODEL BOARD, MDF, NYLON, OR ACETAL.
2. IF MANUFACTURED IN TWO PIECES, PIECES MUST BE SCREWED TOGETHER.
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NOTES:
1. PRESS ITEM 2 INTO ITEM 1 AS SHOWN ON DRAWING.
2. MASS OF ITEMS 1 THRU 13 (NOT INCLUDING RELEASE WIRE) TO BE 8.591 kg ± 0.100 kg.
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NOTES:

1. MASS TO BE 6.535 ± 0.05 Kg.

2. DIMENSIONS SYMMETRIC ABOUT t, UNLESS OTHERWISE NOTED.

SEE Q6 DRAWING PACKAGE FOR TE-033- PARTS
CDM CONFIDENTIAL

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NOTES:
1. MASS TO BE 855 ± 5 GRAMS.
2. ADJUST MASS AS NECESSARY BY MACHINING FACE NOTED.
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NOTES:

1. MAKE FROM SEAMLESS TUBE 100 OD X 15 WALL SPEC 6060 OR 6082 ALUMINUM.
2. MASS TO BE 6.337 ± 40 GRAMS. TRIM MASS IF NECESSARY BY WIDENING 20 mm WIDE UNDER CUTS
3. DIMENSIONS SYMMETRICAL ABOUT t, UNLESS OTHERWISE NOTED.