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NOTES:
1. COMPONENT TO BE FREE FROM EXCESSIVE AIR POCKETS.
2. ETCH PART NUMBER WHERE SHOWN.
3. MOLDED PART GENERAL TOLERANCE ±.25.
4. REFERENCE WEIGHT SPECIFICATION: 2245g ±30g.
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Scale 0.500

2X 20°x45° Chamf.

75.5

10.0

3.0x45° Chamf.

77.0

1. REMOVE BURRS AND BREAK SHARP EDGES.
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<td>3. THREAD TO CONFORM TO BS3643</td>
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| ALL DIMENSIONS IN MILLIMETRES UNLESS OTHERWISE STATED. |
| MATERIAL | STAINLESS STEEL | DRAWN | M. BURLEIGH |
| FINISH | SEE NOTE 1 | DATE | 3 APRIL 1998 |
| TREATMENT | N/A | CHECKED/APPROVED |
| USED ON | SCALE | STANDARD PART |

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NOTES:
1. COMPONENT TO BE FREE FROM EXCESSIVE AIR POCKETS.
2. ETCH PART NUMBER WHERE SHOWN.
3. GENERAL TOLERANCE FOR MOLDED PART ±2, EXCEPT FOR HOLE CENTERS.
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---

SECTION A-A

- **R3.4 TYP**
- **R2.0 TYP**
- **R2.4 TYP**
- **R3.4 TYP**
- **4x Ø7.9 THRU**
- **4x Ø5.2 THRU**
- **S.T.I. TAP M3 X .5 THRU**
- **INSTALL HELICOIL M3 X .5 X 4.5**
- **FLUSH WITH THIS FACE**

---

SECTION B-B

- **22 Ø3.2 THRU**
- **S.T.I. TAP M3 X .5 THRU**
- **INSTALL HELICOIL M3 X .5 X 4.5**
- **FLUSH WITH THIS FACE**

---

NOTES:

1. REMOVE BURRS AND BREAK SHARP EDGES.
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NOTES:
1. REMOVE BURRS AND BREAK SHARP EDGES.
2. NICKEL PLATE .012" MAX. AFTER MACHINING AND HEAT TREAT.
3. DIMENSIONAL LIMITS AND TOLERANCES APPLY WITH PLATING.

Copyright 2007 First Technology Safety Systems, Inc.
NOTES:
1. REMOVE BURRS AND BREAK SHARP EDGES.
2. NICKEL PLATE .012 MAX. AFTER MACHINING, AND AFTER HEAT TREAT IF SPECIFIED.
3. DIMENSIONAL LIMITS AND THREADED HOLE SIZES APPLY AFTER FINISH.
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**NOTES:**

1. REMOVE BURRS AND BREAK SHARP EDGES.
2. SURFACE FINISH TO BE \( \frac{16}{63} \) OR BETTER ALL OVER UNLESS OTHERWISE STATED.
3. STAMP OR ETCH PART NUMBER WHERE SHOWN.
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NOTES:
1. REMOVE ALL FLASHING.
2. PVC SHORE A HARDNESS 50 ±5
3. THICKNESS = 5 mm
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<td>B</td>
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<tr>
<td>C</td>
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<td>D</td>
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Scale: 1.000

NOTES:
1. REMOVE BURRS AND BREAK SHARP EDGES.

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**NOTES:**
1. REMOVE BURRS AND BREAK SHARP EDGES.
2. SURFACE FINISH

**ITEM NO.** | **QTY** | **PART NO.** | **DESCRIPTION**
--- | --- | --- | ---
020-0001 | I | 020-0001 | HEAT ASSEMBLY

**STANDARD BUILD LEVEL:** NA

**APPROVALS:**
- M. BURLEIGH 27-Jan-04

**BRACKET IR-TRACC ATTACHMENT**

**MATERIAL:**
- SS 304

**DO NOT SCALE DRAWING**

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NOTES:
1. REMOVE ALL BURRS AND BREAK ALL SHARP EDGES.
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SECTION A-A

NOTES:

1. PRE-LOAD SPINE MOLDING BY 1/2 TURN OF NUT.
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Notes:
1. Remove all flashing.
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DO NOT SCALE

NOTES
1. SURFACE FINISH TO BE $3.2$ OR BETTER
2. REMOVE ALL SHARP EDGES AND BURRS
3. THREAD TO CONFORM TO BS3643

ALL DIMENSIONS IN MILLIMETRES UNLESS OTHERWISE STATED.

UNLESS OTHERWISE STATED, THE FOLLOWING TOLERANCES APPLY:
0 DEC. PLACE $\pm 0.5$
1 DEC. PLACE $\pm 0.1$
2 DEC. PLACE $\pm 0.05$
ANGULAR DIMS $\pm 0.5^\circ$

MATERIAL: STAINLESS STEEL
FINISH: DULL
TREATMENT: N/A
USED ON: STANDARD PART

DRAWN: A S BARNES
DRAWING NUMBER: 000-2000

M3 T-INSERT

ENGLAND THE NETHERLANDS

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DRG. No.: 000/2000

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DO NOT SCALE

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NOTES
1. SURFACE FINISH TO BE $3.2$ OR BETTER
2. REMOVE ALL SHARP EDGES AND BURRS
3. THREAD TO CONFORM TO BS3643

MATERIAL
STAINLESS STEEL

FINISH
SEE NOTE 1

TREATMENT
N/A

USED ON
STANDARD PART

TITLE
M6 T-INSERT

DRAWN
A S BARNES

DATE
8 OCTOBER 1998

CHECKED/APPROVED

CONFIDENTIAL © 1998

DRG. No.
000/2003

ISSUE
DATE
DRAWN
CHK'D
REMARKS

A

B

C

D

ASSY.

CONFIDENTIAL © 1998

DRG. No.
000/2003

ISSUE
DATE
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CHK'D
REMARKS

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000/2003

ISSUE
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REMARKS

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000/2003

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ISSUE
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REMARKS

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UNIT
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NOTES:
1. REMOVE ALL FLASHING.
2. COMPONENT TO BE FREE FROM EXCESSIVE AIR POCKETS.
3. VIBRO ETCH PART NUMBER WHERE SHOWN.

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NOTES:
1. ETCH PART NUMBER WHERE SHOWN.
2. MATERIAL: SKIN PCV FILLED WITH PU ELASTOMER.

SCALE 0.500

SECTION A-A

SEE NOTE 1

PART LIST

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<td>020-9303 Humanus Left Arm</td>
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</table>

UPPER LEFT ARM ASSEMBLY

TOTAL QUALITY CHECK

CHECKS

FIRST TECHNOLOGY SAFETY SYSTEMS

DO NOT SCALE DRAWING

APPROVALS

DATE

Upper Left Arm Assembly

A2

ENG No. 020-9301

1 OF 1

PRO/ENGINEER
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1. MATERIAL: 5mm THICK DOUBLE LINED NEOPRENE, COLOR YELLOW, LINING BLACK.
2. PANELS TO BE STITCHED TOGETHER WITH 15mm BLACK TAPE.
3. ALL LETTERING TO BE BLACK.
4. FOR ACTUAL DIMENSIONS, SEE MASTER TEMPLATES.
5. PART MARK WITH INDELIBILE PEN AND SERIAL NUMBER WHERE SHOWN.

SEE NOTE 5
(WASH ON REAR OF SUIT)
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1. **Q1 / Q1.5 / Q3**: Head form is assembled as shown in Sheet 1.
2. **Q6**: Replace existing 033-2308 Interface plate (part of 033-2306 Q6 Neck Assy) with TE-2650-15. Assemble with existing M5 x 0.8 x 14 FHCS (also part of 033-2306). Otherwise, assemble according to Sheet 1 View.
3. **Q10**: Assemble TE-010-2015 in place of TE-2650-9 & TE-2650-14 in place of TE-2650-2. Otherwise, assemble headform as shown in Sheet 1.
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NOTES:

1. FOR LUMBAR TESTING ASSEMBLY, ASSEMBLE HEADFORM ACCORDING TO ABOVE LEFT VIEW. NOTE ORIENTATION OF CENTRAL BLOCK IS UPSIDE DOWN COMPARED TO NECK TESTING CONFIGURATION. DISKS ARE IN SAME ORIENTATION BUT NOW USE A SECOND HOLE PATTERN. OTHERWISE ASSEMBLE ACCORDING TO SHEET 1.

2. Q1 / Q1.5: ASSEMBLE TE-2650-13 IN PLACE OF TE-2650-2. (PARTS ARE EQUIVALENT IN SIZE & MATERIAL BUT HAVE DIFFERENT HOLE PATTERNS.)

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NOTES:
1. ALL DIMENSIONS EQUAL ABOUT C
2. REMOVE ALL SHARP EDGES
3. SURFACE FINISH TO BE 1.0 OR BETTER
4. MATERIAL: Ciba tool or similar model board, MDF, NYLON or DELRIN

SECTION A-A

2x R25

R32

R23.0 ± 0.5

81.0 ± 0.5

81.0 ± 0.5

T2.0 ± 0.5

88.0 ± 1.0

2x Ø18.60 μ 23

50.0 ± 0.1

Copyright 2003 First Technology Safety Systems, Inc.
NOTE:
1. MATERIAL: POLYURETHANE
   DUROMETER: 75 ±5 SHORE D
2. REMOVE ALL CAST FLASHING
3. ALL CAST DIMENSION TOLERANCE ±2%
   BUT NO SMALLER THAN 0.5mm
4. NO SPLIT OR DEFECTS ARE ALLOWED
   IN THE MOLDING

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Innovative Solutions, Inc. Humanetics reserves the right to legally pursue any
party for damages that is known to have copied or duplicated its drawings or
hardware for design or manufacturing purposes.
NOTES:
1. MATERIAL: POLYURETHANE
   DUROMETER: 75 ±5 SHORE D
2. REMOVE ALL CAST FLASHING
3. ALL CAST DIMENSION TOLERANCE ±2%
   BUT NO SMALLER THAN 0.5mm
4. NO SPLIT OR DEFECTS ARE ALLOWED IN
   THE MOLDING
1) ITEM 4, SENSOR SLEEVE, IS NOT TO BE USED IN COMBINATION WITH ITEMS 2 & 3, SENSOR REPLACEMENTS, BUT IS INTENDED TO BE USED IN COMBINATION WITH APTS SENSOR/BLADDER (NOT SHOWN, PURCHASED SEPARATELY). ITEMS 2 & 3 ARE REPLACEMENTS FOR APTS SENSOR AND SLEEVE COMBINATION AND USED IN CERTIFICATION.
NOTES:

1. MATERIAL: POLYURETHANE FOAM
2. WEIGHT: 0.074 kg ±0.02 kg (PROVISIONAL).
3. REMOVE ALL MOLD FLASHING.
4. ALL MOULD DIMENSION TOLERANCE ±1%/±4%
   BUT NO SMALLER THAN 1mm UNLESS OTHERWISE STATED
5. SERIALIZE AT LOCATION SHOWN.

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NOTES:
1. MATERIAL: POLYURETHANE FOAM
2. WEIGHT: 0.074 kg ±0.02 kg (PROVISIONAL).
3. REMOVE ALL MOLD FLASHING.
4. ALL MOULD DIMENSION TOLERANCE +1%/−4%
   BUT NO SMALLER THAN 1mm UNLESS OTHERWISE STATED
5. SERIALIZE AT LOCATION SHOWN.

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NOTES:
1. MATERIAL: PVC SKIN WITH POLYURETHANE FOAM FILL.
   COLOR: BROWN
   DUROMETER: 45 ± 5 SHORE "A"
2. WEIGHT: 0.573 kg ± 0.0045 kg (PROVISIONAL).
3. THIS PART DIFFERS FROM STANDARD PRODUCTION PART DUE TO 2X Ø45 POCKETS WITH WIRE SLOTS.
4. REMOVE ALL MOLD FLASHING
5. ALL MOLD DIMENSION TOLERANCE ±1%/14%
   BUT NO SMALLER THAN 1mm UNLESS OTHERWISE STATED
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NOTES:
1. MATERIAL: POLYURETHANE
   COLOR: NATURAL
   DUROMETER: 55 A5 SHORE "A"
2. REMOVE ALL MOLD FLASHING
3. ALL DIMENSION ±3

PROVISIONAL VERSION AWAITING FINAL APPROVAL
BY GRSP INFORMAL GROUP ON CRS
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NOTES:
1. SURFACE FINISH TO BE .8μ
2. DIMENSIONS ARE SYMMETRICAL ABOUT CL UNLESS OTHERWISE STATED