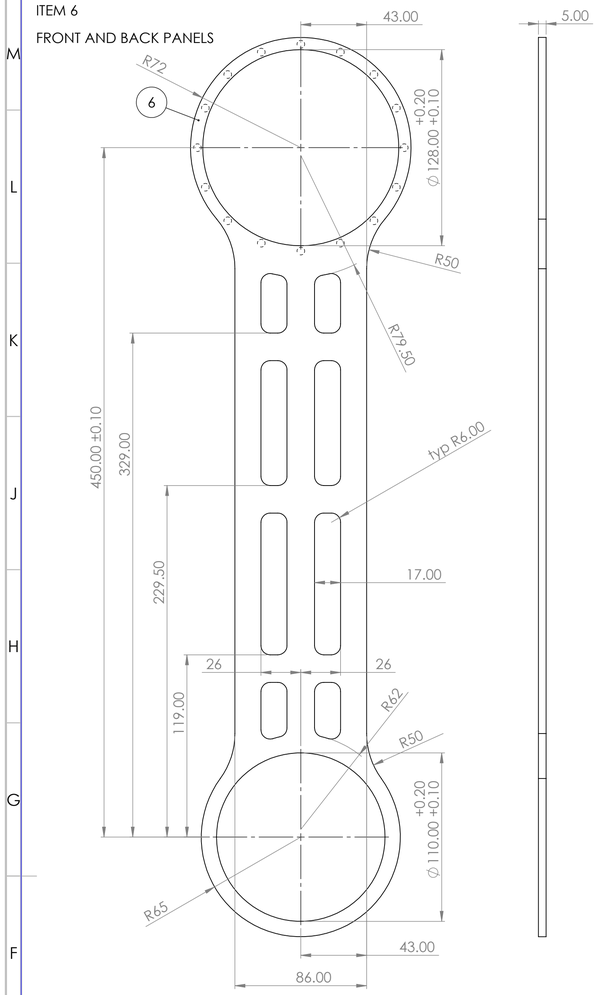
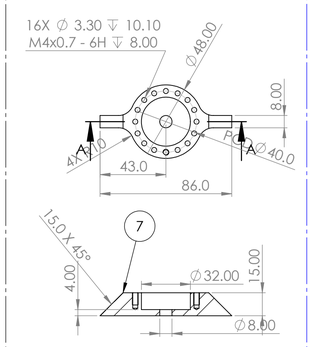
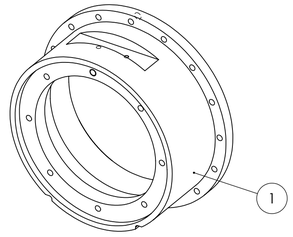
ITEM 6

FRONT AND BACK PANELS

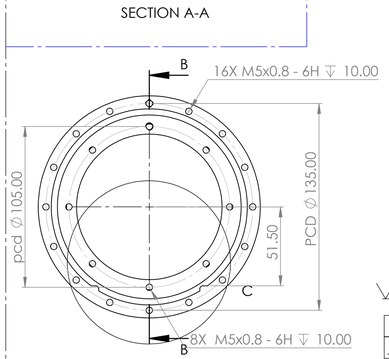


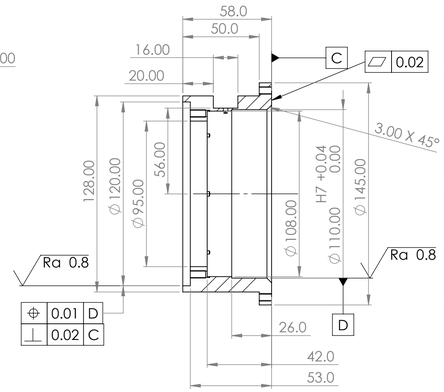


SECTION A-A

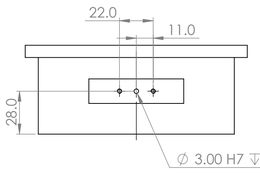


ITEM NO.	QTY.	DESCRIPTION	MATERIAL	NOTES
1	1	UPPER CYLINDER	C45	FINAL MACHINING OF PRECISION BORES AND TOLERANCE-CRITICAL SURFACES MUST BE DONE AFTER WELDING TO PREVENT WARPING OR DISTORTION DUE TO HEAT
2	1	LOWER CYLINDER	C45	FINAL MACHINING OF PRECISION BORES AND TOLERANCE-CRITICAL SURFACES MUST BE DONE AFTER WELDING TO PREVENT WARPING OR DISTORTION DUE TO HEAT
3	1	MIDDLE PLATE	E335	
4	2	LATERAL PLATES	E335	
5	6	REINFORCEMENT PLATES	E335	
6	2	BRACK/FRONT PLATE	E335	
7	1	S.A. SUPPORT	E335	
8	1	WEAR PLATE	E335	



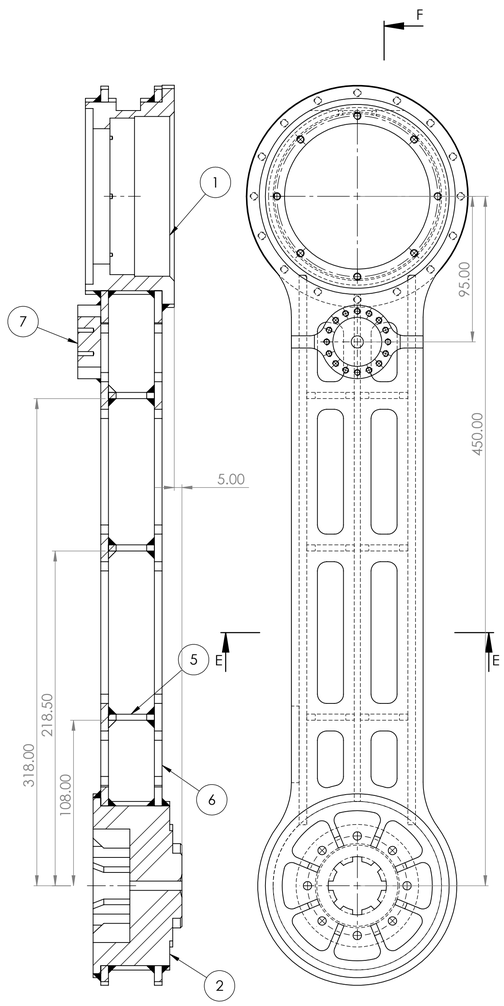


SECTION B-B

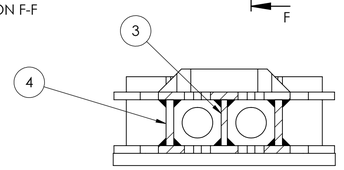


DETAIL C

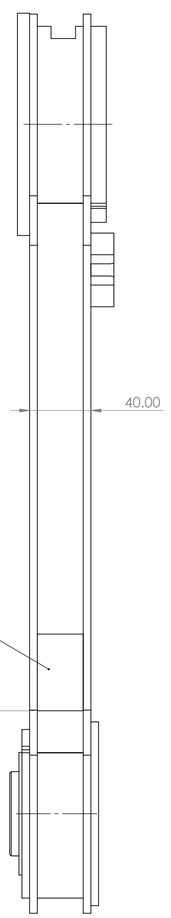
SCALE 2 : 3

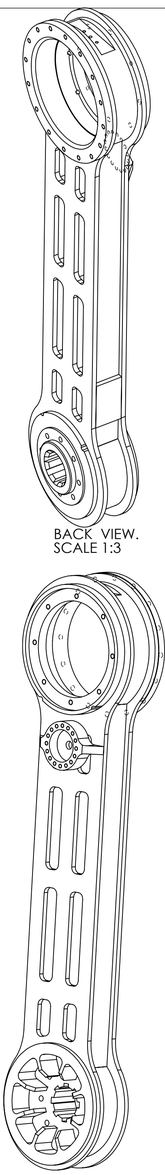


SECTION F-F



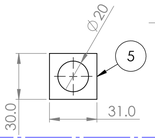
SECTION E-E

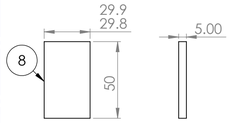


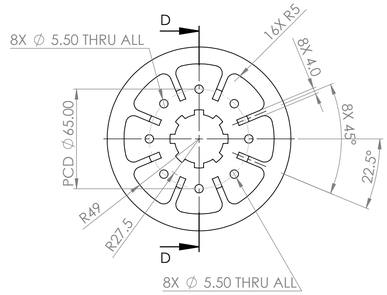


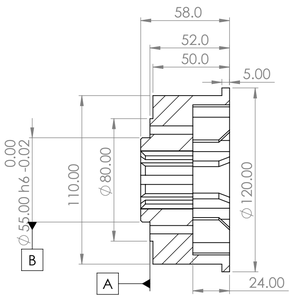
BACK VIEW.
SCALE 1:3

FRONT VIEW.
SCALE 1:3









SECTION D-D

NOTES:
1. PREHEAT C45 PARTS TO 150–250°C BEFORE WELDING. USE LOW-HYDROGEN ELECTRODES COMPATIBLE WITH BOTH MATERIALS.
2. ALLOW CONTROLLED COOLING TO AVOID CRACKING OR HARDENING.
3. FINAL MACHINING OF PRECISION BORES AND TOLERANCE-CRITICAL SURFACES MUST BE DONE AFTER WELDING TO AVOID WARPING.
4. AFTER WELDING AND FINAL MACHINING, APPLY INDUSTRIAL GRADE BLACK PAINT TO ALL EXTERNAL SURFACES EXCEPT PRECISION MACHINED AREAS.
5. UNLESS OTHERWISE SPECIFIED, ALL PLATE JOINTS TO BE WELDED WITH 4MM FILLET WELDS. STAGGERED INTERMITENT 30MM WELD LENGHT WITH 60MM PITCH, ON BOTH SIDES IF ACCESSIBLE.

UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN MILLIMETERS SURFACE FINISH: Ra 3.2 TOLERANCES: LINEAR: ISO 2768-m ANGULAR: ISO 2768-m	FINISH: INDUSTRIAL GRADE BLACK PAINT	DEBURR AND BREAK SHARP EDGES CHAMFER TAPPED HOLES TO DEPTH OF ONE THREAD	DO NOT SCALE DRAWING REVISION A
	NAME	SIGNATURE	DATE
DRAWN	R. REYES		27/06/2025
CHK'D	R. REYES		27/06/2025
APP'VD			
MFG			
Q.A			
Machine Name: Tennis Serve Machine			
Assembly Name: XY ARM.			

FIRST ANGLE PROJECTION

MATERIAL: Welded (see table)

WEIGHT: 7817.20

Cyberisner

TITLE: Elbow

DWG NO. TSM_ARM_001 A1

SCALE:1:2 SHEET 1 OF 1