

## **Jib Transfer System – Manufacturing Instructions Aluminum Angle Runner Reinforcements**

**Before you begin you will need the following:**

✓ BOM Items:

<b>BOM Line Item</b>	<b>Description</b>	<b>Qty</b>
23	2” x 3/16” thick Aluminum Angle Stock	1

*(Note: this same piece of stock is also used for the securing mechanism. Make sure to cut the stock for the “Mfg\_SecuringMech\_AngleStock” instructions first)*

✓ Tools:

- |   |   |
|---|---|
| <input type="checkbox"/> Measuring Tape | <input type="checkbox"/> Hand Drill       |
| <input type="checkbox"/> T-Square       | <input type="checkbox"/> Drill Bit (3/16) |
| <input type="checkbox"/> Chop Saw       | <input type="checkbox"/> Permanent Marker |
| <input type="checkbox"/> File           |   |

✓ Drawings:

- Base\_Upright\_Support

### **Instructions:**

1. Using a measuring tape and permanent marker, mark four 5.00” sections on the angle stock
2. Use the chop saw to cut the four 5.00” lengths of aluminum angle stock
3. Use the file to de-burr the edges of the Al angle stock
4. Using the drawing Base\_Upright\_Support as a reference, drill the 10 holes in each piece of the aluminum stock – use the hand drill and 3/16 drill bit

\*You should now have four pieces of aluminum stock, each with 10 drilled holes\*