

## Jib Transfer System - Manufacturing Instructions Securing Mechanism – Angle Stock

Before you begin you will need the following:

✓ BOM Items:

BOM Line Item	Description	Qty
23	2" x 3/16" thick Aluminum Angle Stock	1

✓ Tools:

- Chop Saw (with metal cutting blades)
- File
- Hand drill
- Drill Bits (X, 3/16)
- Permanent Marker
- Tape Measure

✓ Drawing:

- Base\_AngleStock

### Instructions:

*Note: You will need two of these pieces for the securing mechanism*

1. Use the chop saw to cut the Al angle stock into two pieces both 6.75" long (*You may be able to get the stock cut to the 6.75" length from the store you purchased it at; ask before you purchase it to save yourself this step*)
2. Use the file to de-burr the edges of the Al angle stock
3. Using a tape measure, measure and mark the location of the six holes (reference the drawing *Base\_AngleStock* for hole locations)
4. Using the X drill bit and hand drill, drill the two outermost holes in the stock (these are the larger holes in the *Base\_AngleStock* drawing)
5. Using the 3/16 drill bit and hand drill, drill the remaining four holes into the stock (these are the smaller holes in the *Base\_AngleStock* drawing)

The completed pieces should look like this:

