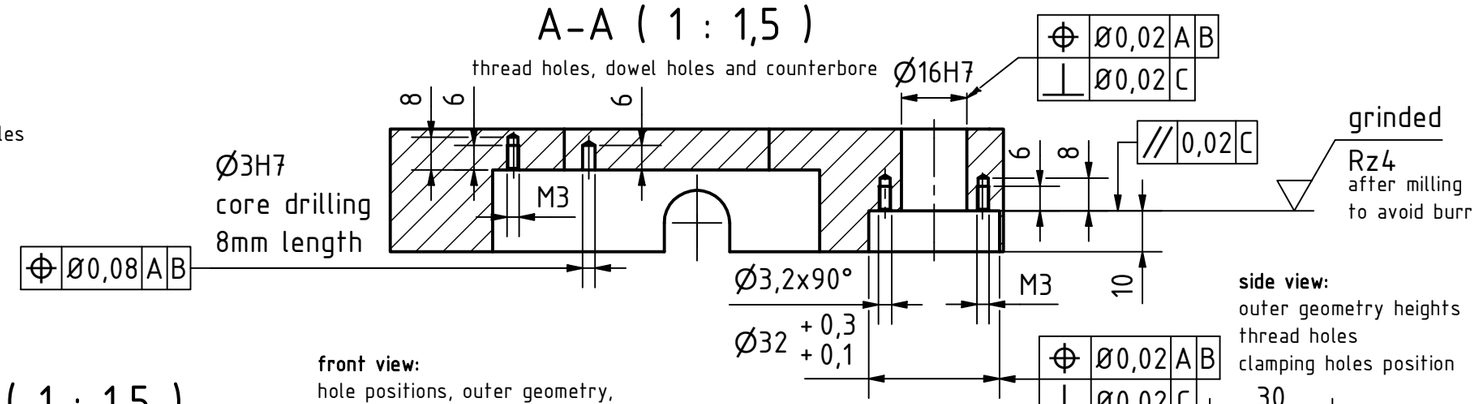
fit	allowance
Ø3H7	+10µm
Ø5H7	+12µm
Ø7H7	+15µm
Ø9,5H7	+15µm
Ø16H7	+18µm

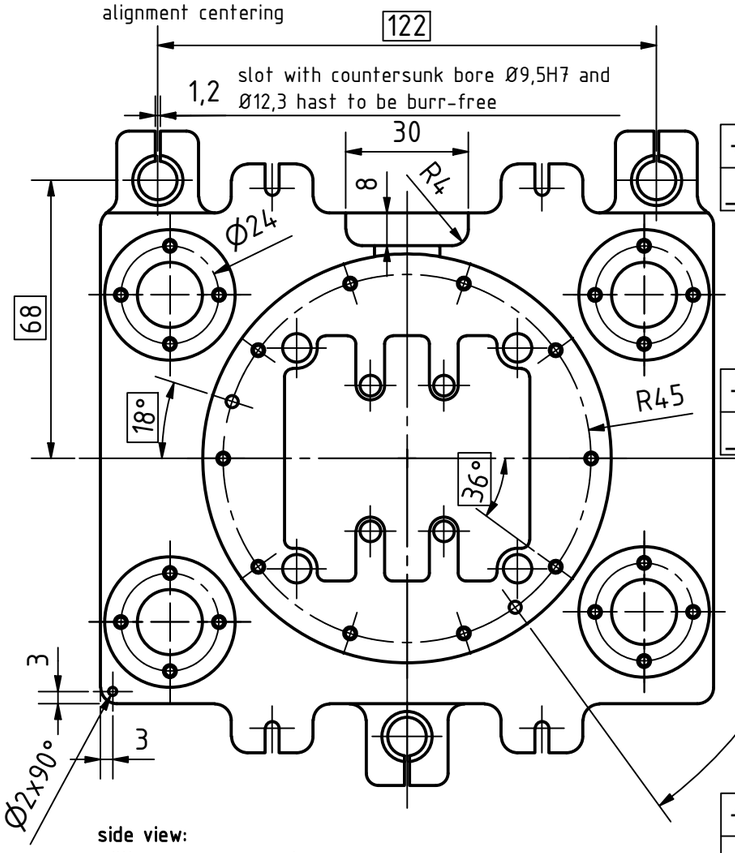
important:
entire backside geometry with its
milling pokets like, bores, thread holes and dowel holes
manufactured in same clamping operation
due to claimed geometric dimensioning!

A-A (1 : 1,5)

thread holes, dowel holes and counterbore

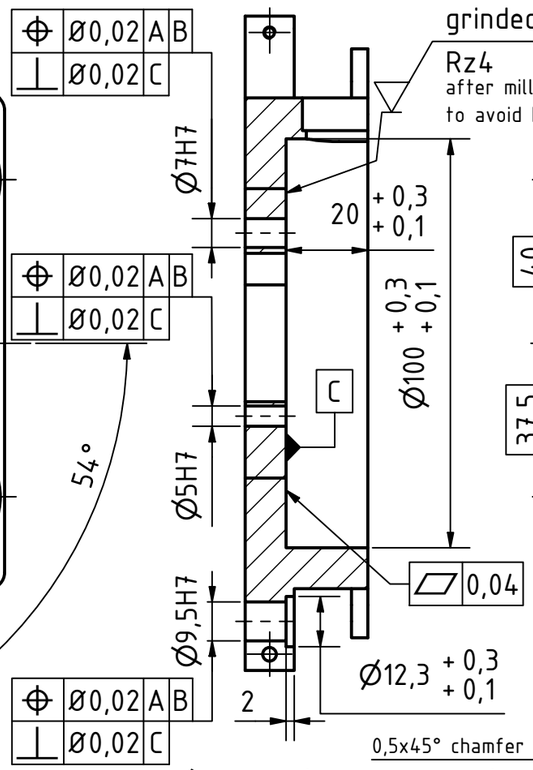


back view:
gland dowel hole pattern
gland thread hole pattern
clamping holes + clamping slot
alignment centering

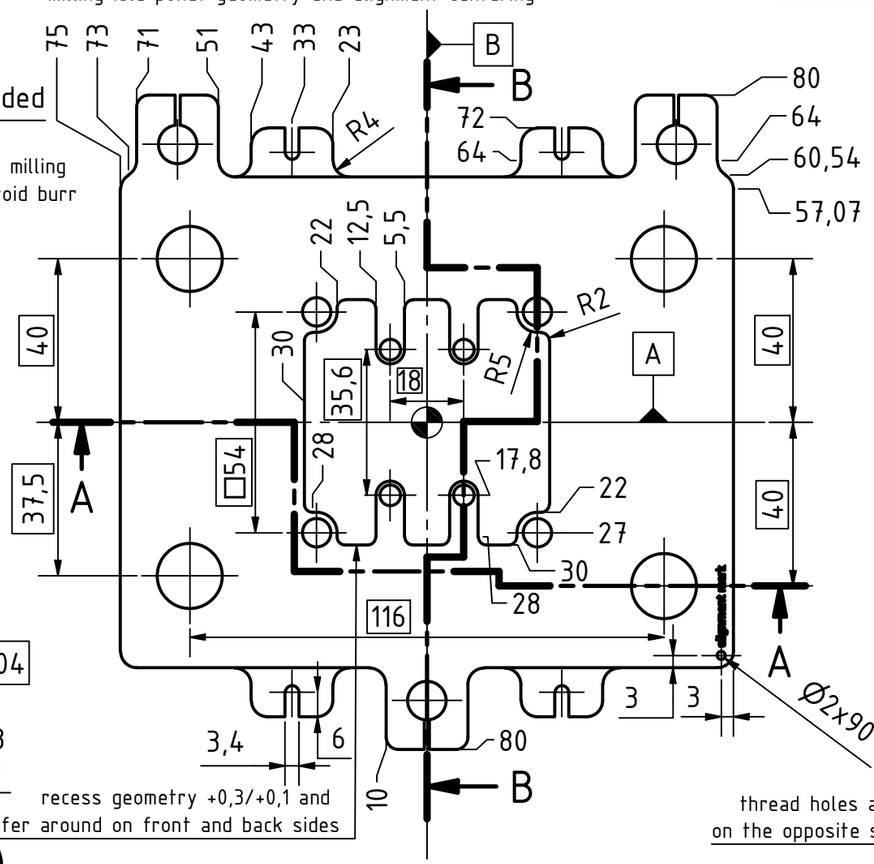


B-B (1 : 1,5)

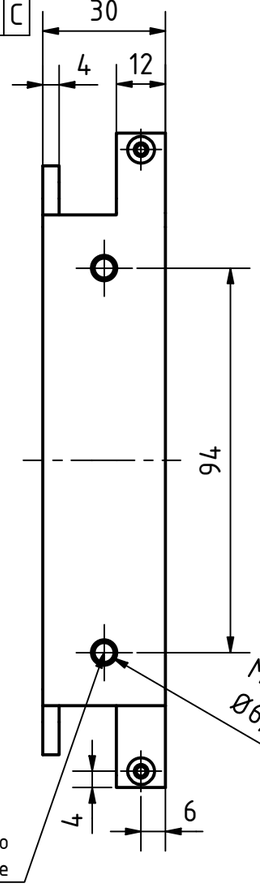
circular poket
dowel holes



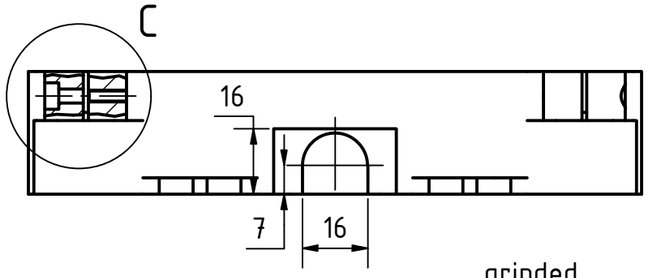
front view:
hole positions, outer geometry,
milling isle poket geometry and alignment centering



side view:
outer geometry heights
thread holes
clamping holes position

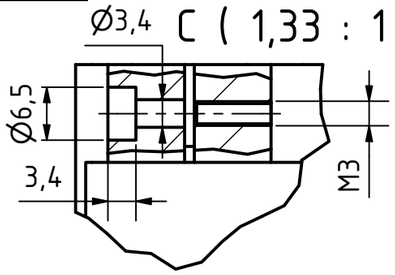


side view:
milling recess geometry
clamping hole section



C (1,33 : 1)

clamping hole



-0,2 +0,2
debured edges

Rz10 (grinded Rz4)

passivation (Surtec 650)
after machining

geometric dimensioning and tolerancing DIN EN ISO 1101	workpiece edges DIN ISO 13715	general tolerances DIN ISO 2768-f/H surfaces DIN ISO 1302

rev.	alteration	date	name

	date	name
designed:	20.01.2020	R.Widera
approved:	28.05.2020	Kanngießer
status:	released	
part rev.:	1.0	draw.rev.: A

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Friedrich-Hund-Platz 1
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amount: 1	scale: 1 : 1,5
material: AlMg4,5Mn0,7 (cast)	pre-product: -

Base Body Flex Jig

part number: ITPT.02.00.001
field of application: ITkPix Tool
project: Atlas

sheet 1/1 A3