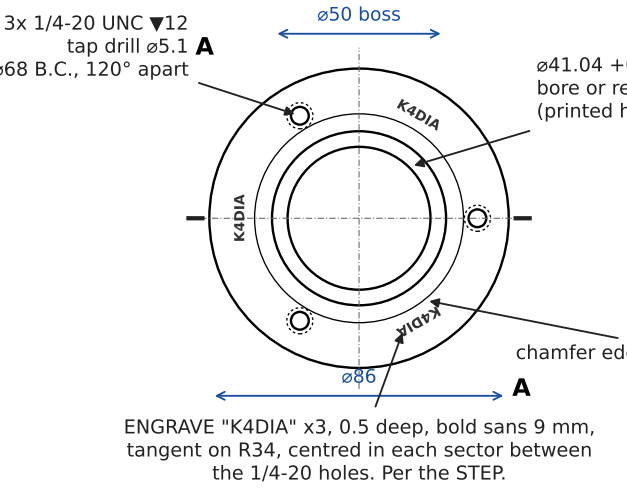
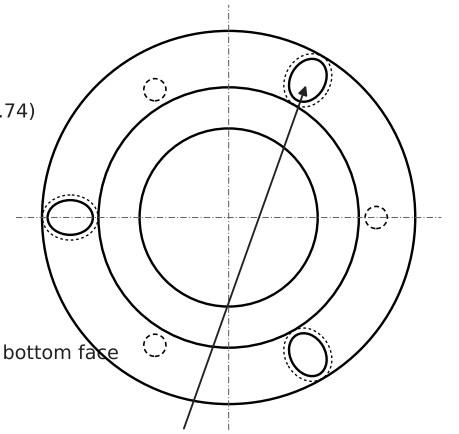
TRIPOD HUB, REV D: MACHINING DRAWING

Attach to the STEP when quoting. The STEP is geometry only; threads and finish are specified here.

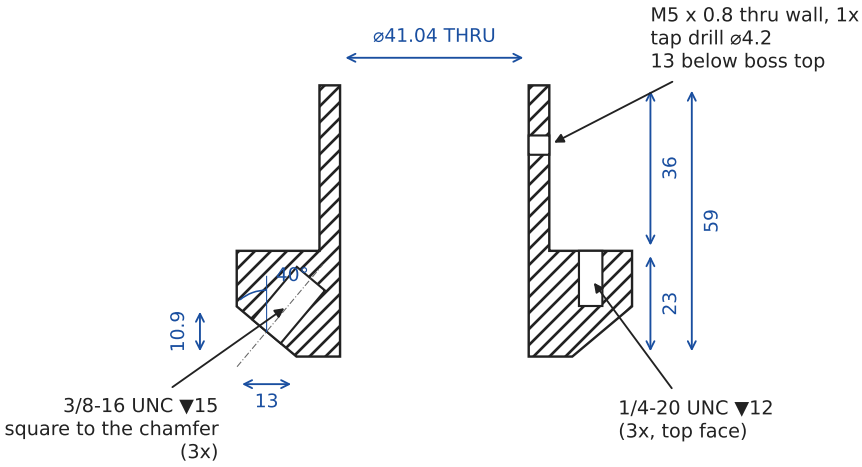
TOP VIEW



BOTTOM VIEW



SECTION A-A



NOTES

1. Material: 6061-T6 aluminum, one piece from 3-1/2 in round bar.
2. Bottom edge chamfer: 13 mm radial x 10.9 mm rise, 40° from the bottom face, full circumference. It is the seat for the legs.
3. The STEP file revD_tripod_hub_ALU.step shows every threaded hole at TAP-DRILL size. Thread per this drawing:
   3x 3/8-16 UNC, 15 mm deep, on the chamfer face at 120°, each axis square to the chamfer
   (40° from the hub axis). Tap drill ⌀8.0 = 5/16 in.
   3x 1/4-20 UNC, 12 mm deep, top face, ⌀68 bolt circle, 120° apart, midway between the leg holes. Tap drill ⌀5.1 = #7.
   1x M5 x 0.8 through the boss wall, radial, 13 mm below the boss top. Tap drill ⌀4.2.
4. Through bore ⌀41.04 +0.05/-0.00, bored or reamed, 1.6 µm or better. A 40.74 mm printed part slides in it.
5. Optional: spot-face ⌀13 x 1 mm square to each leg-hole axis for a full-contact seat. Break all edges 0.5 mm. Deburr threads.
6. Finish: chem film MIL-DTL-5541 Type II Class 3 (conductive), after all machining.
   Not anodize: anodize insulates and builds thread size. Chem film is conductive and adds no thickness,
   so it goes on after tapping, no masking. JLCCNC calls it "Conductive anodizing - Natural". No bead blast in the bore.
7. Engraving: "K4DIA" three times on the top face as modeled in the STEP, 0.5 mm deep, engrave or 3-axis mill. Do not fill.
8. Tolerances unless noted: ±0.2 mm linear, ±0.5° angular. Thread class 2B. Qty 1.

PART	Tripod hub, rev D
FILE	revD_tripod_hub_ALU.step
MATERIAL	6061-T6
FINISH	chem film, Class 3
UNITS	mm, third angle
MASS	286 g approx.
REV	D
DATE	2026-11-04