

# GENERAL SPECIFICATIONS AND INSTRUCTIONS

## MATERIAL SPECIFICATIONS

- Material: Stainless Steel Smooth Plate
- Thickness: 16 Gauge, 12 Gauge, or 10 Gauge
- Size: 4 ft x 10 ft

## SPECIAL MANUFACTURING INSTRUCTIONS

- All bends are parallel to the horizontal.
- Ensure that all cuts and bends are precise and clean.
- Deburr all edges after cutting.
- Label each piece after cutting and bending.
- For prototype, dimensions do not need to be exact but as close as possible. No need to sweat it.

## KEY

t = GAUGE THICKNESS (mm)

## PANEL 1

### BENDING INSTRUCTIONS

- Bend A
  - Location: 1160.37mm perpendicular from the short (4 ft) edge
  - Type: Straight bend
  - Angle: 19.850°
- Bend B
  - Location: 1160.37mm perpendicular from Bend A
  - Type: Straight bend
  - Angle: 80.075°

### CUTTING INSTRUCTIONS

- Cut A
  - Start: 250mm along the short edge from upper-left corner
  - Length: 1177.48mm
  - Angle: 80.221° below the horizontal
- Cut B
  - Start: 250mm along the short edge from upper-left corner
  - Length: 704.75mm
  - Angle: 2.030° below the horizontal
- Cut C
  - Start: End of Cut B
  - Length: 1152.14mm
  - Angle: 80.221° above the horizontal
- Cut D
  - Start: End of Cut A
  - Length: 1177.48 - 1.03t mm
  - Angle: 80.221° below the horizontal
- Cut E
  - Start: End of Cut C
  - Length: 1177.48mm
  - Angle: 80.221° below the horizontal (mirrored to Cut D)
- Cut F
  - Start: End of Cut E
  - Length: 700mm
  - Angle: 90° to the horizontal
- Cut G
  - Start: End of Cut D
  - Length: 700 + 0.175t mm
  - Angle: 90° to the horizontal
- Cut H
  - Start: End of Cut F or G
  - Length: 700 + 0.175t mm
  - Angle: 0° to the horizontal

## PANEL 2

### BENDING INSTRUCTIONS

- Bend A
  - Location: 704.73 + 0.139t mm perpendicular from the short (4 ft) edge
  - Type: Straight bend
  - Angle: 78.075°
- Bend B
  - Location: 1135.40mm perpendicular from Bend A
  - Type: Straight bend
  - Angle: 19.850°

### CUTTING INSTRUCTIONS

- Cut F
  - Start: 250mm along the short edge from upper-left corner
  - Length: 704.75 + 0.143t mm
  - Angle: 90.350° below the horizontal
- Cut G
  - Start: 950mm along the short edge from upper-left corner
  - Length: 704.75 + 0.143t mm
  - Angle: 90.350° below the horizontal (mirrored to Cut F)
- Cut A
  - Start: End of Cut F
  - Length: 1152.14mm
  - Angle: 99.779° below the horizontal
- Cut B
  - Start: End of Cut G
  - Length: 1152.14mm
  - Angle: 99.779° below the horizontal (mirrored to Cut A)
- Cut C
  - Start: End of Cut A
  - Length: 1177.48mm
  - Angle: 80.221° below the horizontal
- Cut D
  - Start: End of Cut B
  - Length: 1177.48mm
  - Angle: 80.221° below the horizontal (mirrored to Cut C)
- Cut E
  - Start: End of Cut C or D
  - Length: 700 mm
  - Angle: 0° to the horizontal

## PANEL 3

### BENDING INSTRUCTIONS

- Bend A
  - Location: 1160.37mm perpendicular from the short (4 ft) edge
  - Type: Straight bend
  - Angle: 19.850°

### CUTTING INSTRUCTIONS

- Cut A
  - Start: 250mm along the short edge from upper-left corner
  - Length: 1177.48mm
  - Angle: 80.221° below the horizontal
- Cut B
  - Start: 250mm along the short edge from upper-left corner
  - Length: 704.75mm
  - Angle: 2.030° below the horizontal
- Cut C
  - Start: End of Cut B
  - Length: 1152.14mm
  - Angle: 80.221° below the horizontal (mirrored to Cut A)
- Cut D
  - Start: End of Cut A
  - Length: 1177.48mm
  - Angle: 80.221° below the horizontal
- Cut E
  - Start: End of Cut C
  - Length: 1177.48mm
  - Angle: 80.221° below the horizontal (mirrored to Cut D)
- Cut F
  - Start: End of Cut B
  - Length: 700.00mm
  - Angle: 0° to the horizontal

## PANEL 4

### BENDING INSTRUCTIONS

- Bend A
  - Location: 1160.37 - 0.871t mm perpendicular from the short (4 ft) edge
  - Type: Straight bend
  - Angle: 19.850°

### CUTTING INSTRUCTIONS

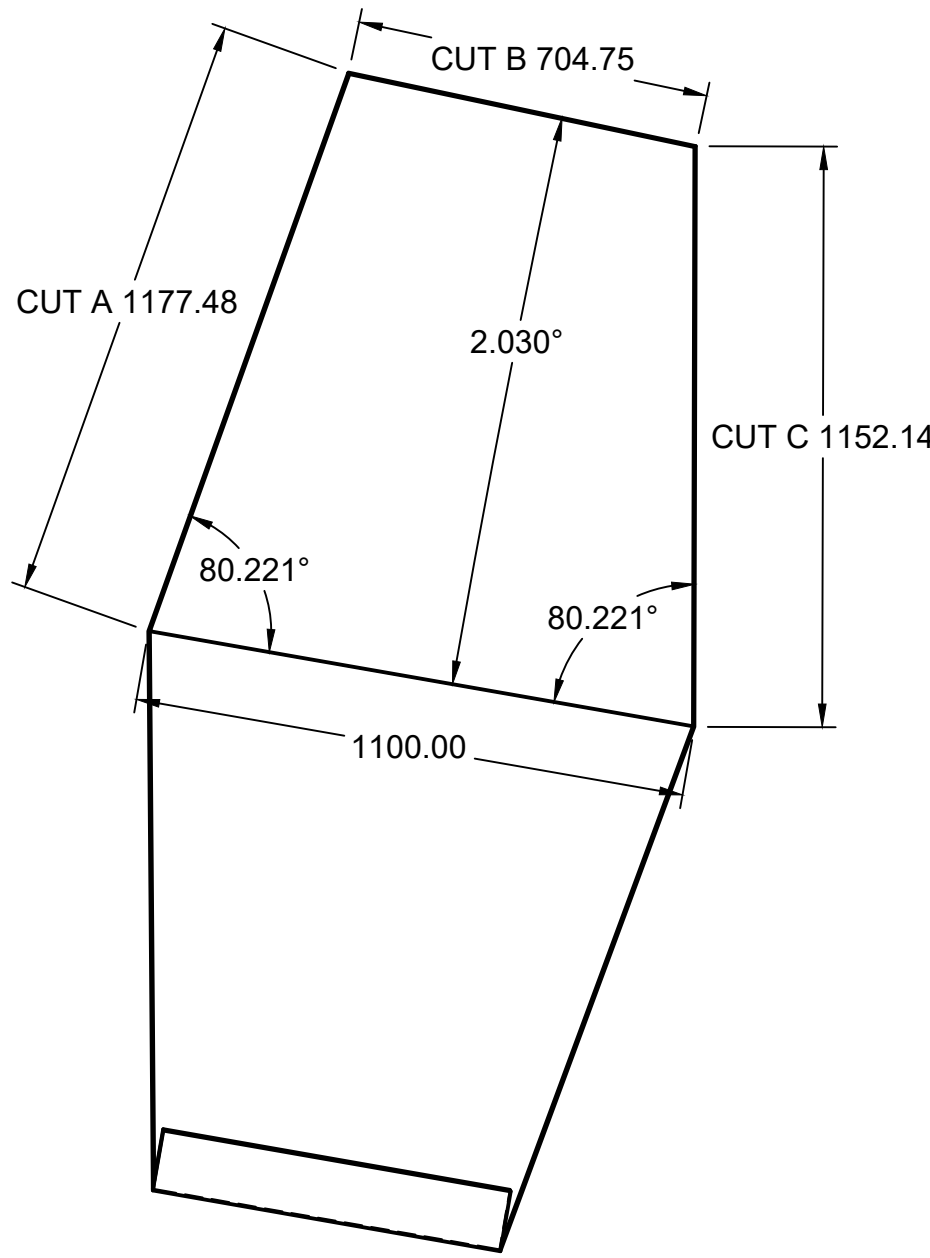
- Cut A
  - Start: 240mm along the short edge from upper-left corner
  - Length: 1177.48 - 0.884t mm
  - Angle: 80.221° below the horizontal
- Cut B
  - Start: 940 + 0.347t mm along the short edge from upper-left corner
  - Length: 1177.48 - 0.884t mm
  - Angle: 80.221° below the horizontal (mirrored to Cut A)
- Cut C
  - Start: End of Cut A
  - Length: 1177.48 - 0.854t mm
  - Angle: 80.221° below the horizontal
- Cut D
  - Start: End of Cut B
  - Length: 1177.48 - 0.854t mm
  - Angle: 80.221° below the horizontal (mirrored to Cut C)
- Cut E
  - Start: End of Cut C or Cut D
  - Length: 700 + 0.35t mm
  - Angle: 0° to the horizontal
- Window Frame
  - Refer to drawing
  - All cuts are flush to Face 4A
  - All measurements are to outmost edges
- Door Handle Slot
  - Refer to detailed view
  - Slot is parallel to the horizontal, not to any faces (for prototype does not need to be exact)

## REVISION LOG

7/30/24

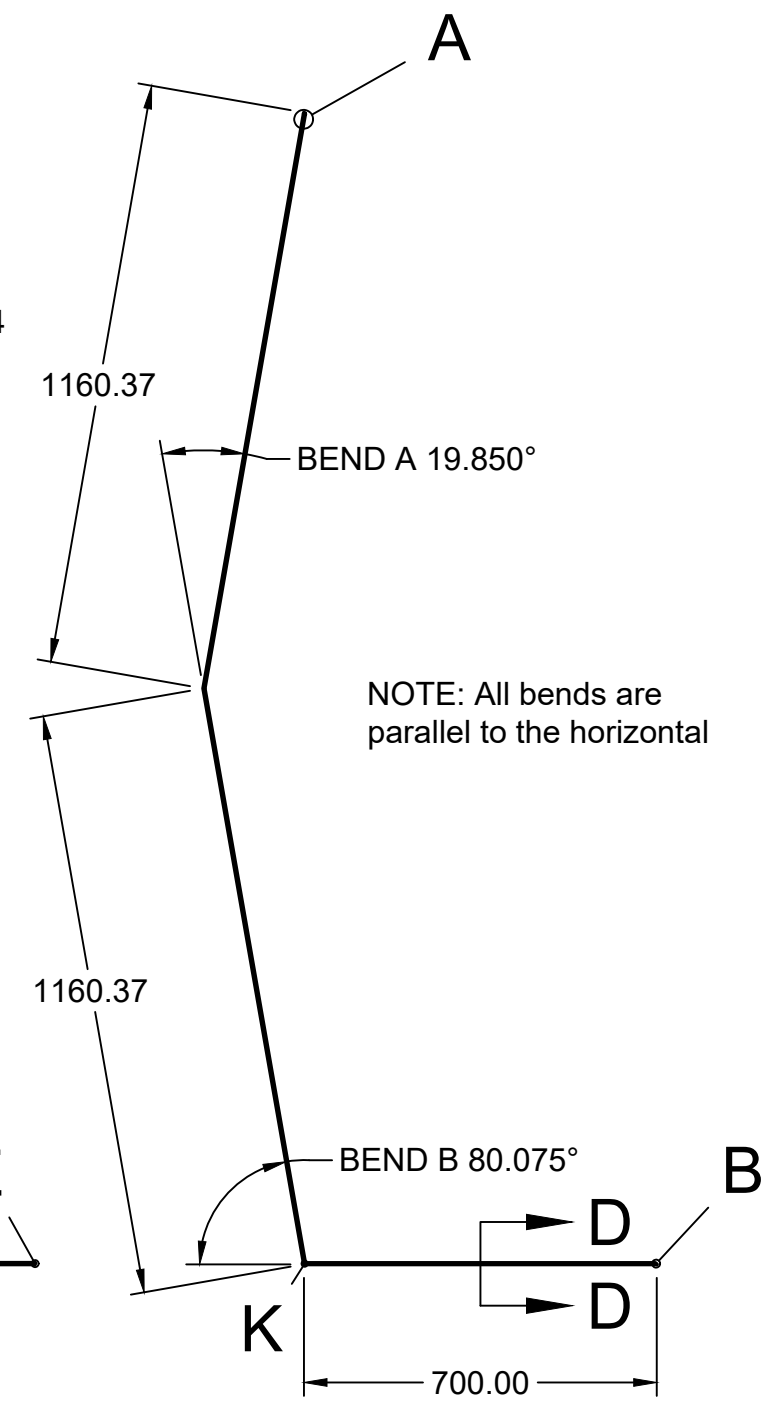
- Initial Issue

APPROVED MICHAEL BARBINE		PROJECT			
		STARPHONE			
CHECKED		TITLE			
		SPECIFICATIONS AND MANUFACTURING INSTRUCTIONS			
DRAWN PATRICK MODIN 7/27/2024		SIZE	CODE	DWG NO	REV
		C	N/A	1	-
		SCALE N/A	WEIGHT	SHEET 1/5	



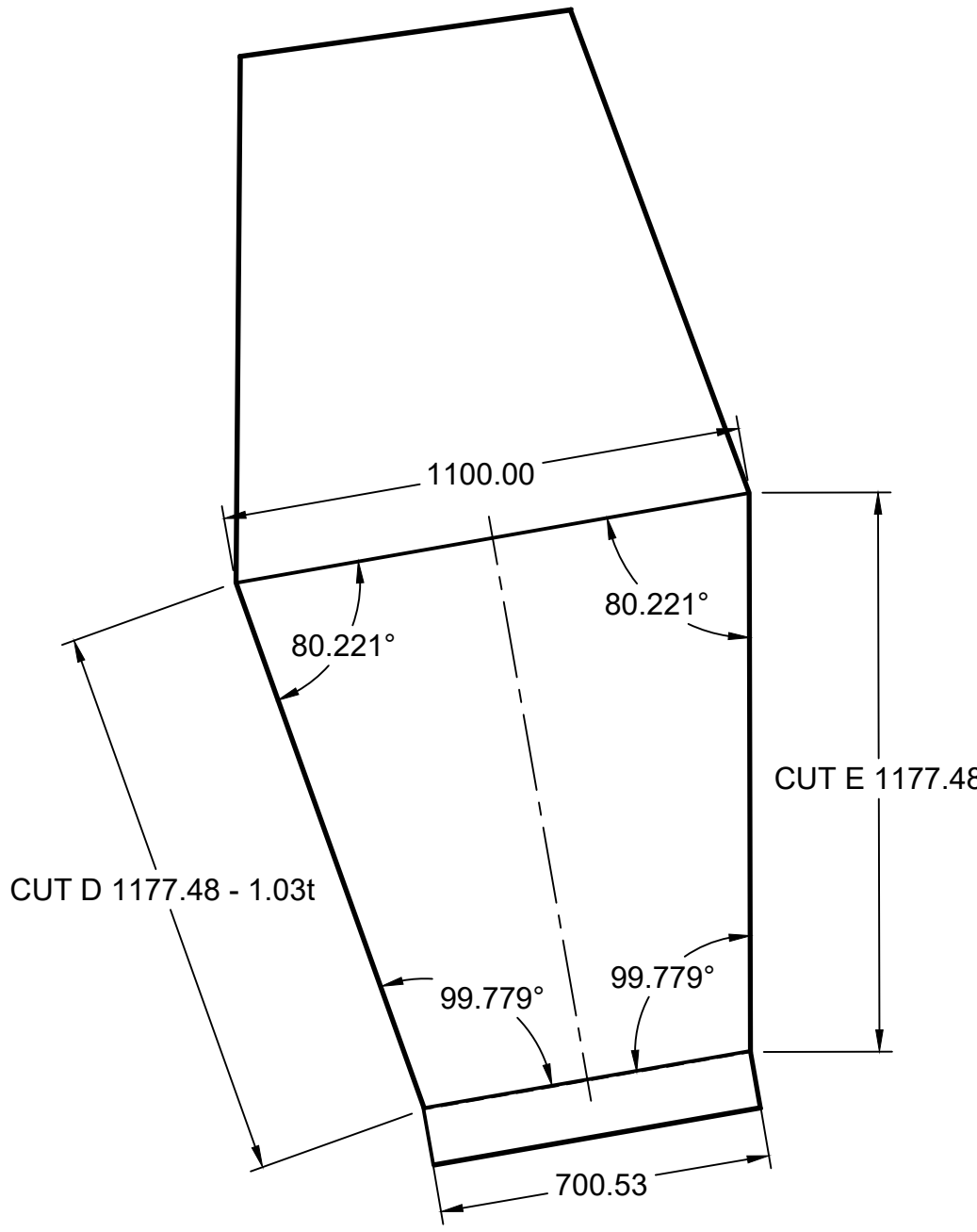
**FACE 1A  
(RIGHT SIDE)**

SECTION D-D  
SCALE 1:15

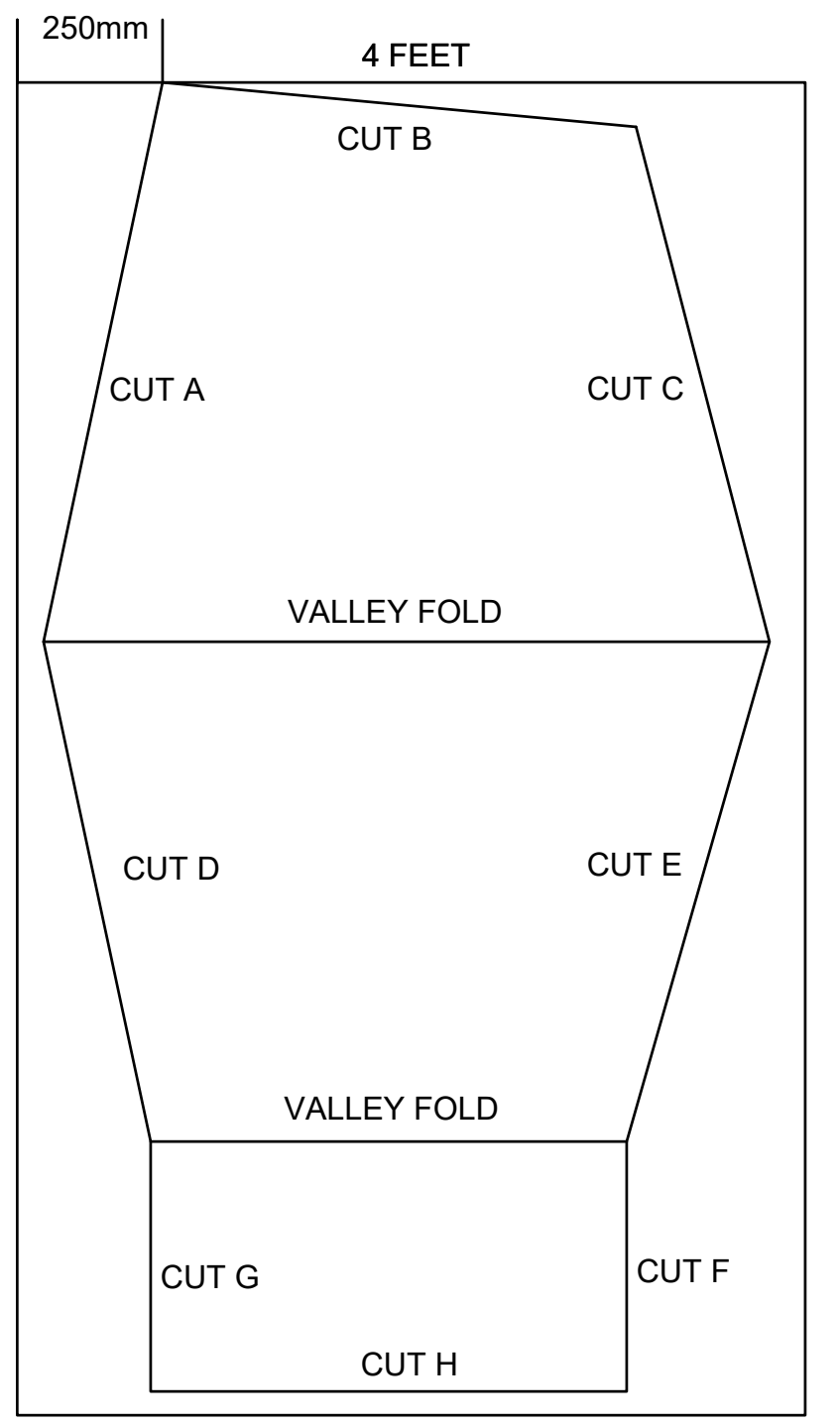


**FRONT**

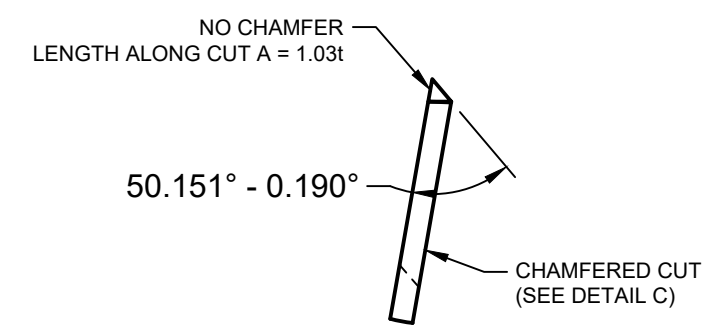
NOTE: All bends are parallel to the horizontal



**FACE 1B  
(RIGHT SIDE)**

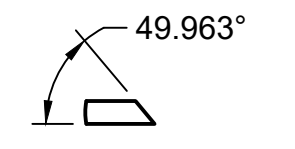


**RIGHT SIDE FLAT LAYOUT (NOT TO SCALE)**



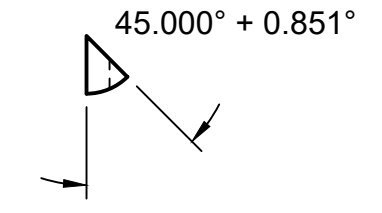
**DETAIL A  
SCALE 1:1**

NOTE: Chamfer along Cut B is 49.961°



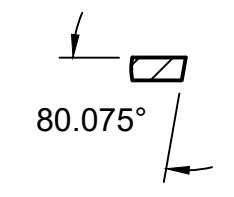
**DETAIL B  
SCALE 1:1**

NOTE: Chamfers are same along Cut F and Cut H



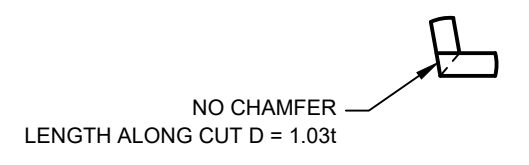
**DETAIL C  
SCALE 1:1**

NOTE: Chamfers along individual Cuts A, C, D, and E are 45.851° and face inward

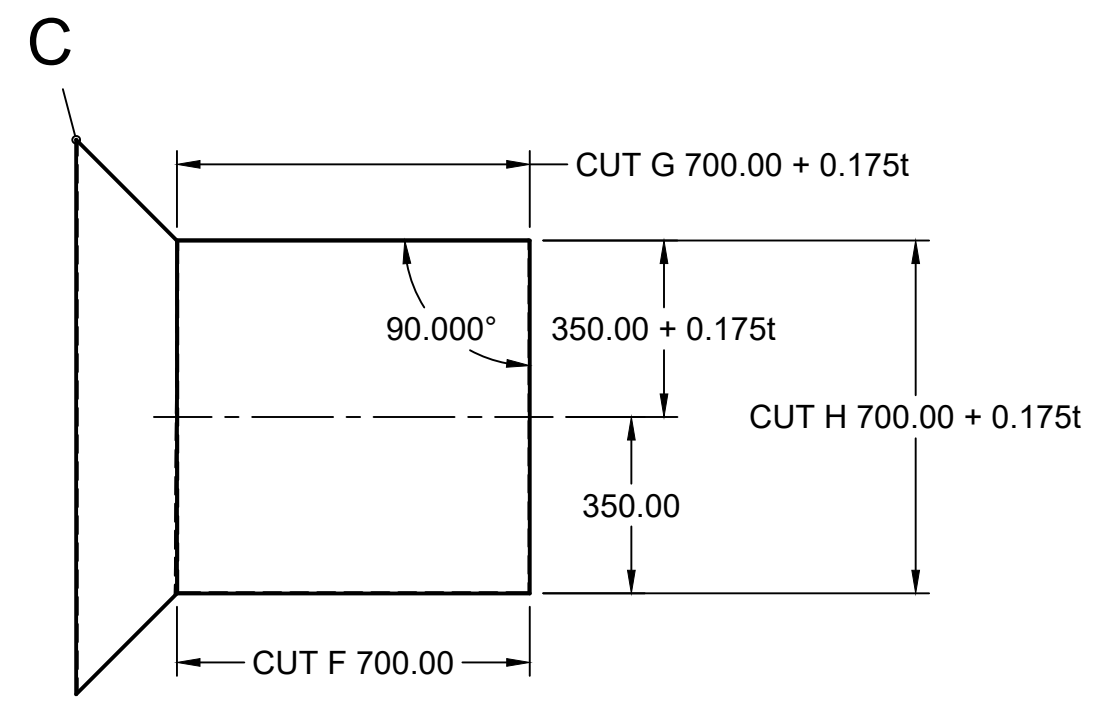


**DETAIL E  
SCALE 1:1**

NOTE: Chamfer along Cut G



**DETAIL K  
SCALE 1:1**



**FACE 1C  
(BOTTOM)**

**KEY**  
t = GAUGE THICKNESS (mm)

PROJECT		STARPHONE		
TITLE		PANEL 1 LEFT SIDE AND FLOOR		
APPROVED	MICHAEL BARBINE	SIZE	CODE	DWG NO
CHECKED		C	N/A	1
DRAWN	PATRICK MODIN 7/27/2024	SCALE	1:15	WEIGHT N/A
				SHEET 2/5
				REV -

4

3

2

1

D

D

C

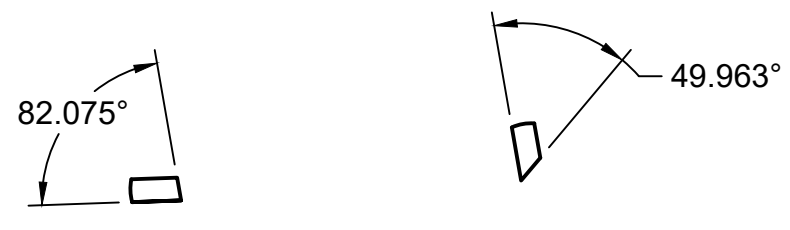
C

B

B

A

A

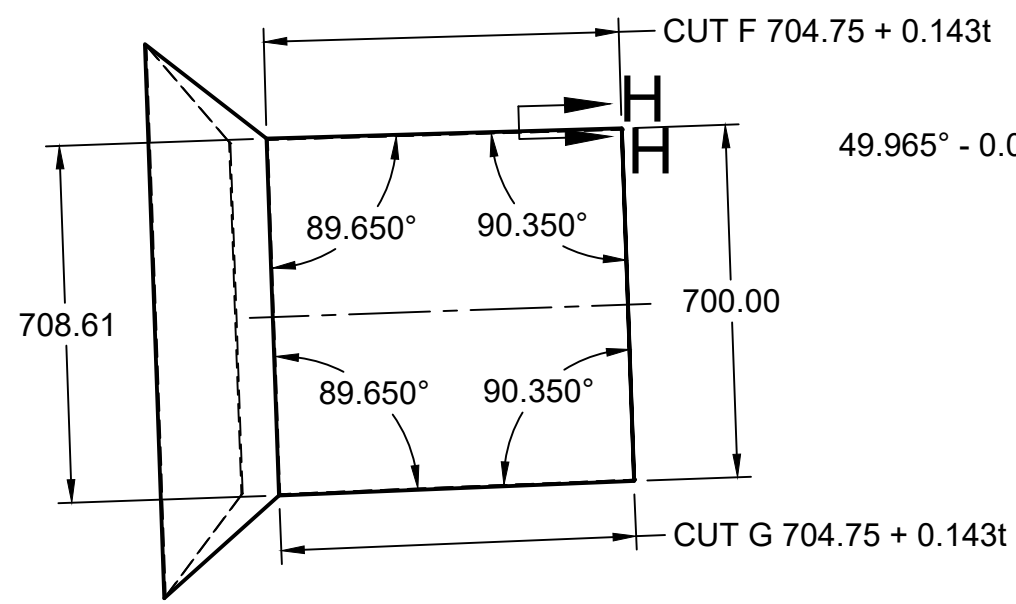


DETAIL F SCALE 1:1

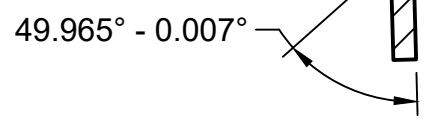
NOTE: Chamfer along upper edge adjacent to Cuts F and G

DETAIL G SCALE 1:1

NOTE: Chamfer along upper edge adjacent to Cuts F and G

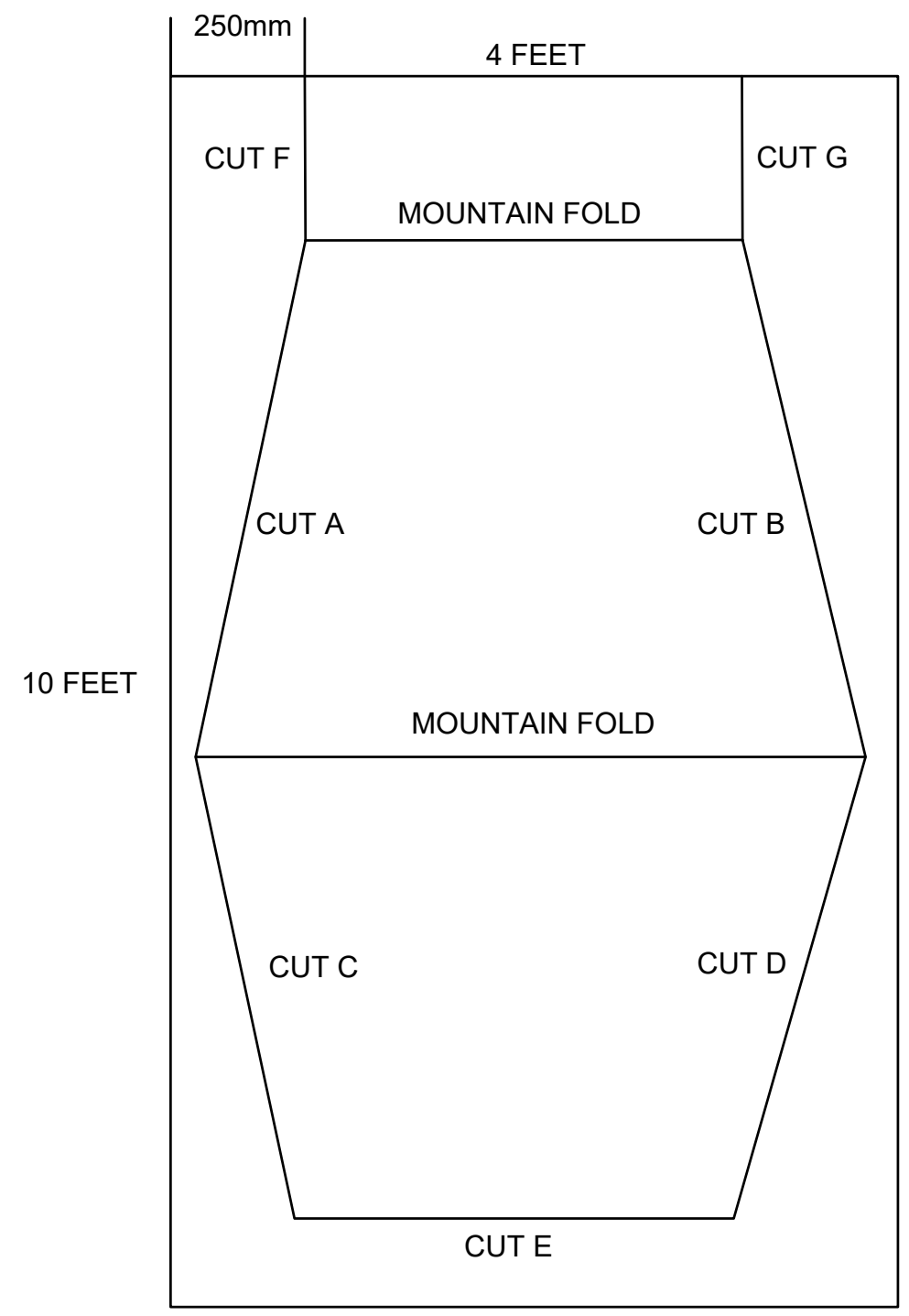


FACE 2C (TOP)

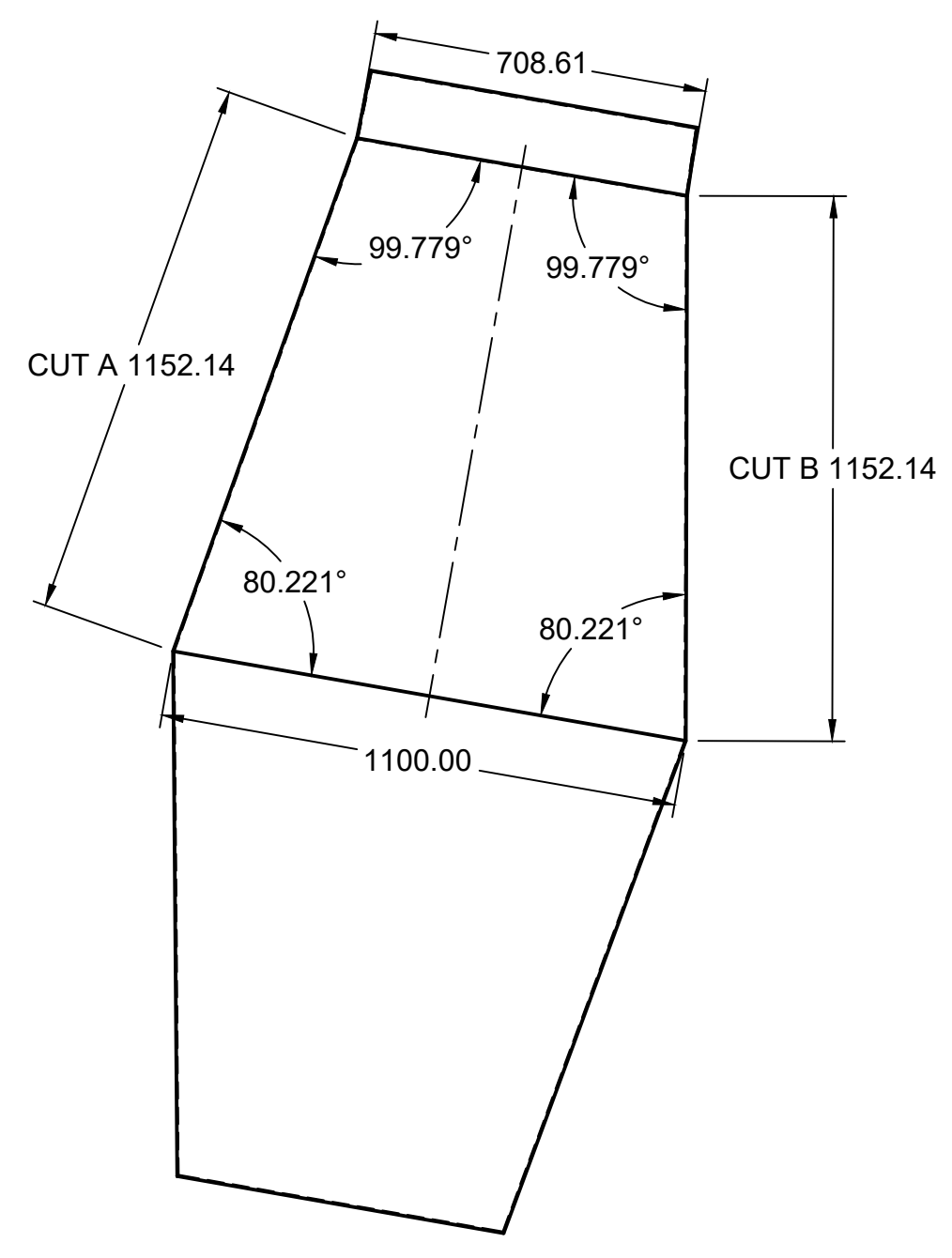


SECTION H-H SCALE 1:1

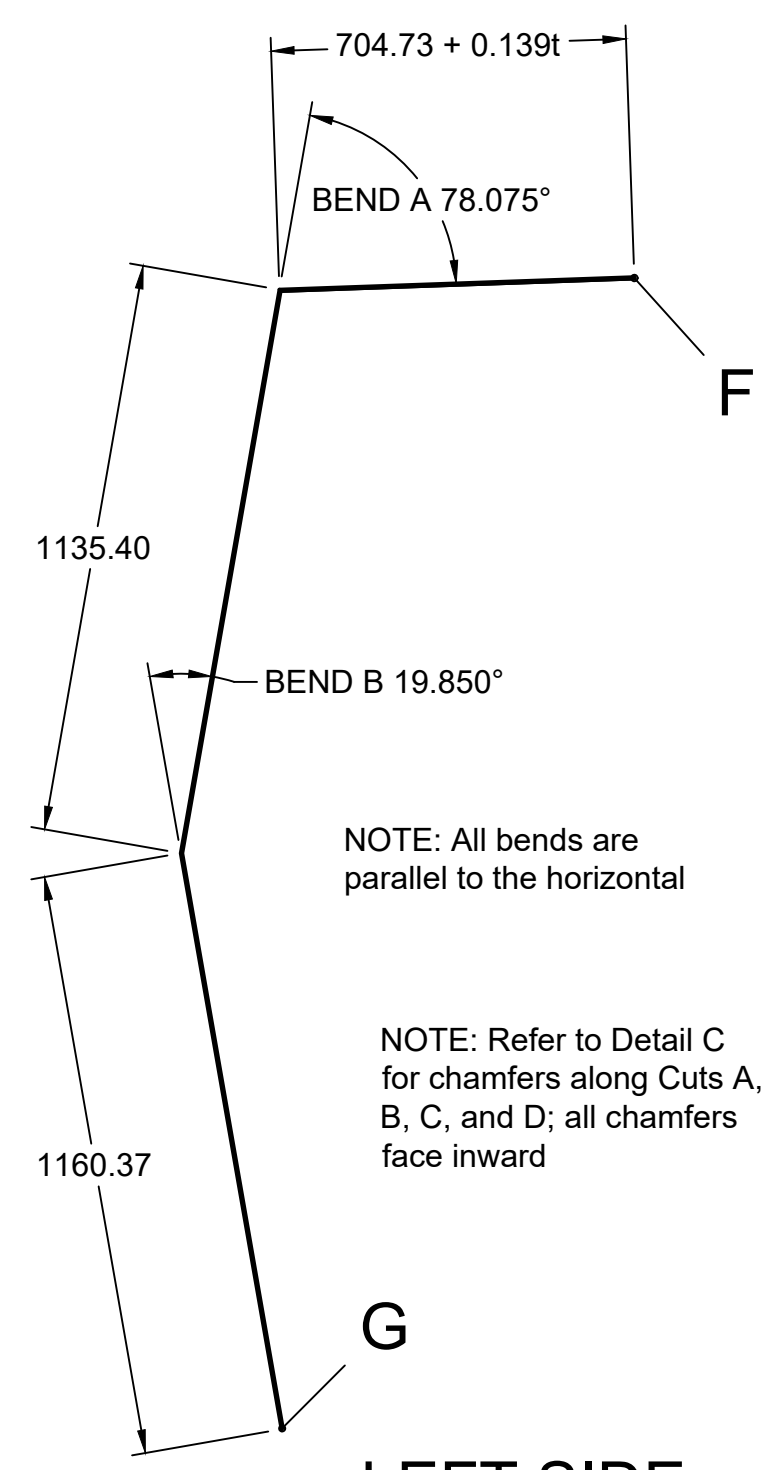
NOTE: Chamfer along Cuts F and G is 49.958°



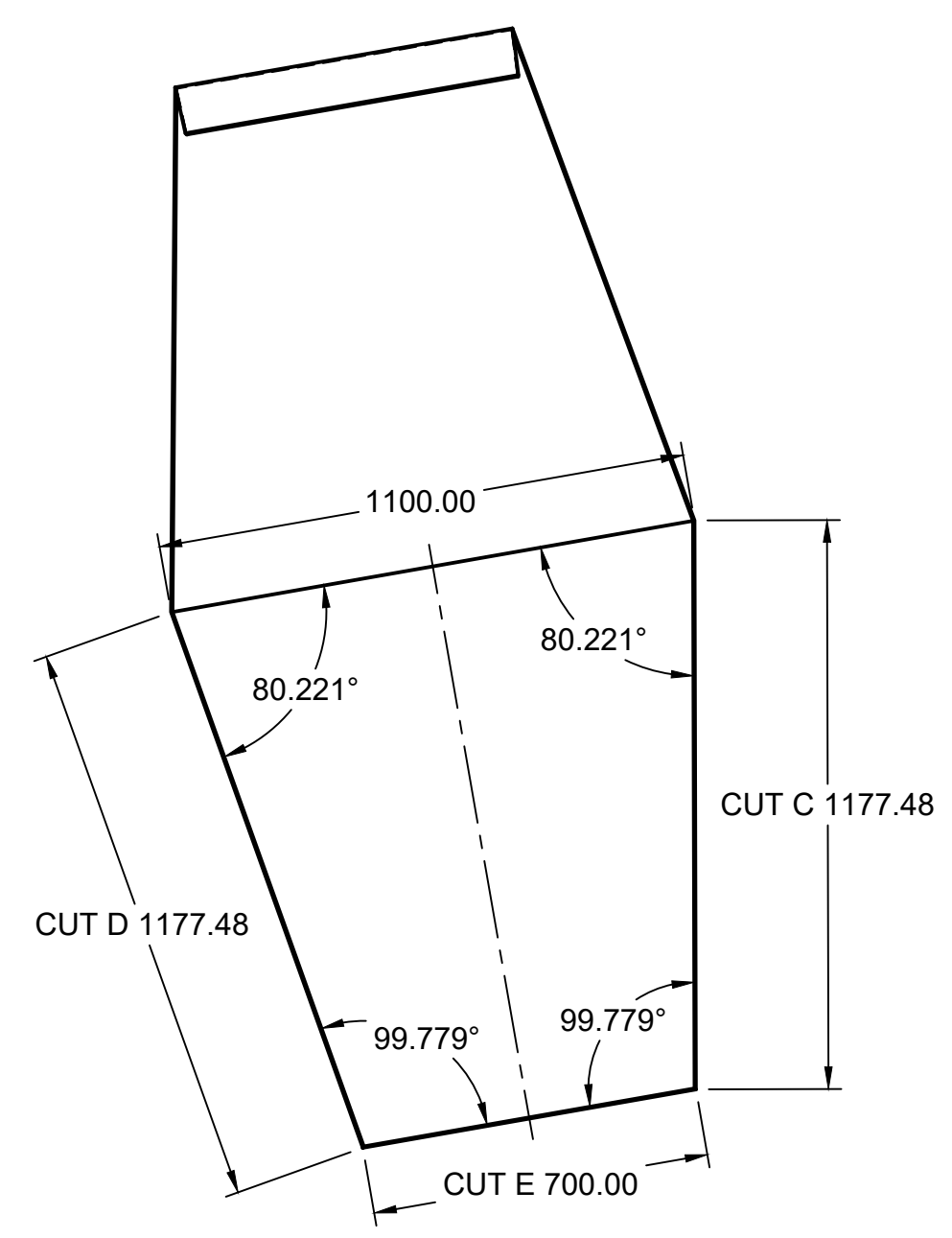
BACK FLAT LAYOUT (NOT TO SCALE)



FACE 2A (BACK)



LEFT SIDE



FACE 2B (FRONT)

KEY  
t = GAUGE THICKNESS (mm)

PROJECT		STARPHONE		
TITLE		PANEL 2 BACK SIDE AND ROOF		
APPROVED	MICHAEL BARBINE	SIZE	CODE	DWG NO
CHECKED		C	N/A	1
DRAWN	PATRICK MODIN 7/27/2024	SCALE	1:15	WEIGHT N/A
				SHEET 3/5

4

3

2

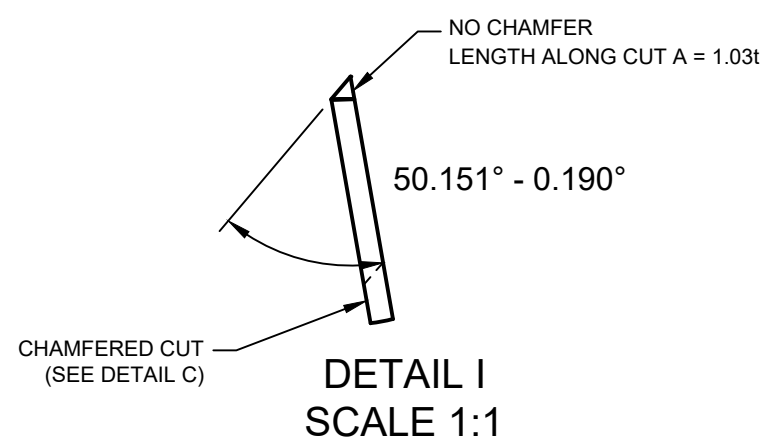
1

4

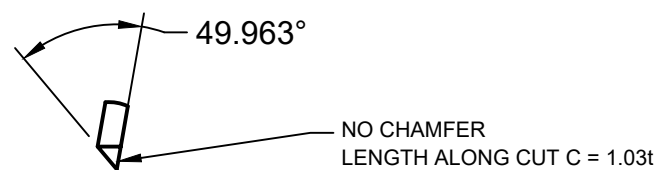
3

2

1



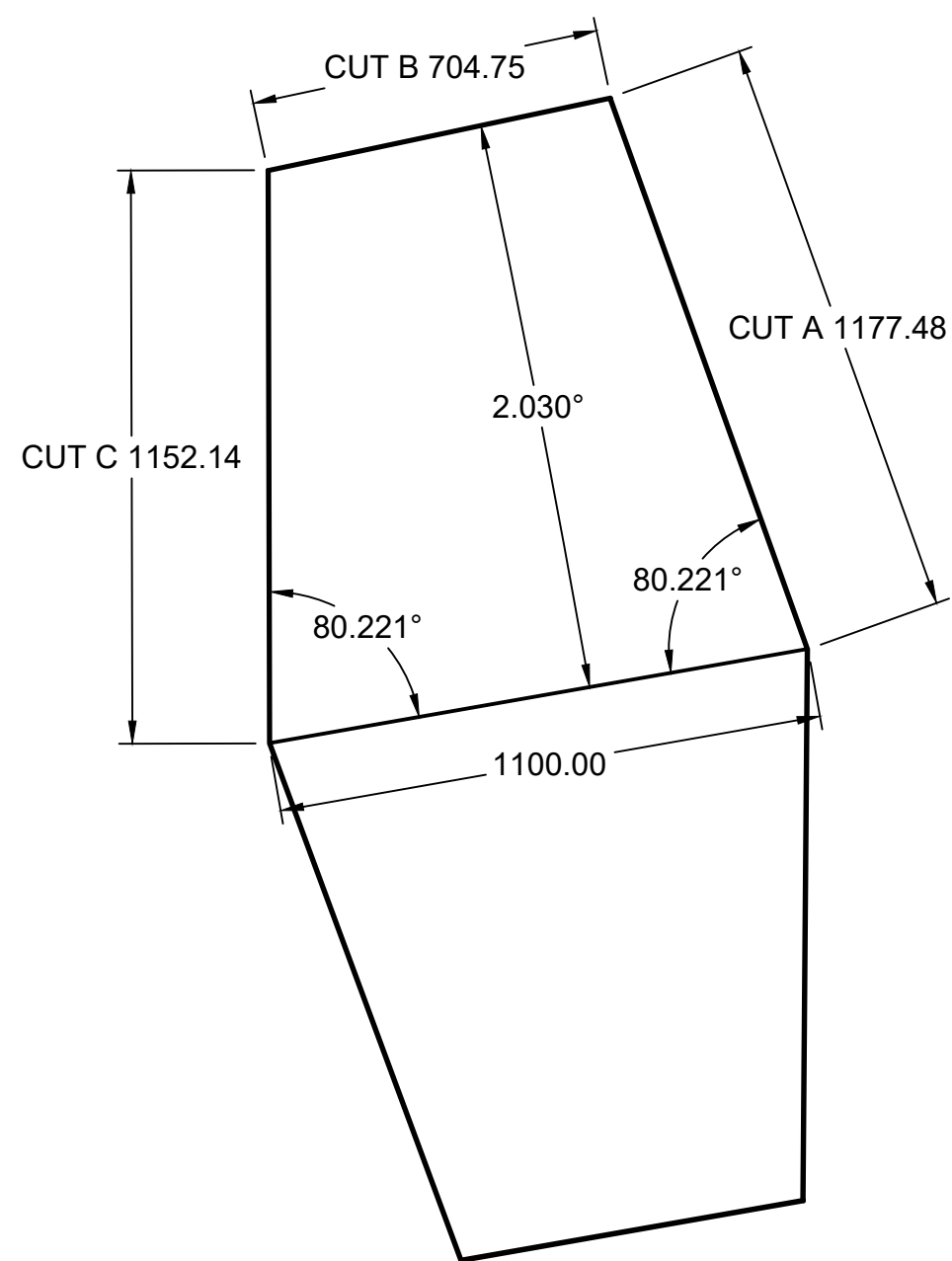
NOTE: Chamfer along Cut B is 49.961°



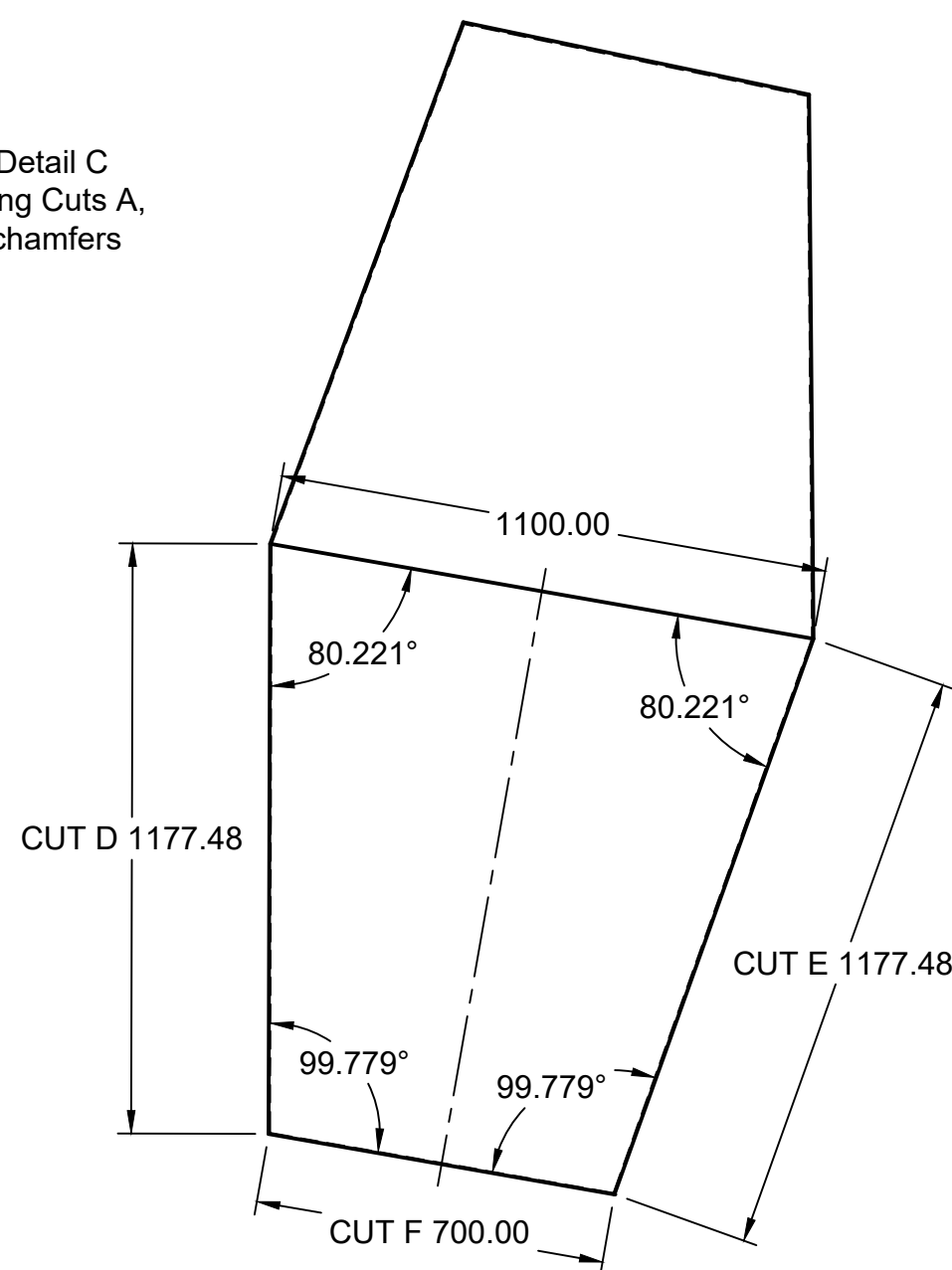
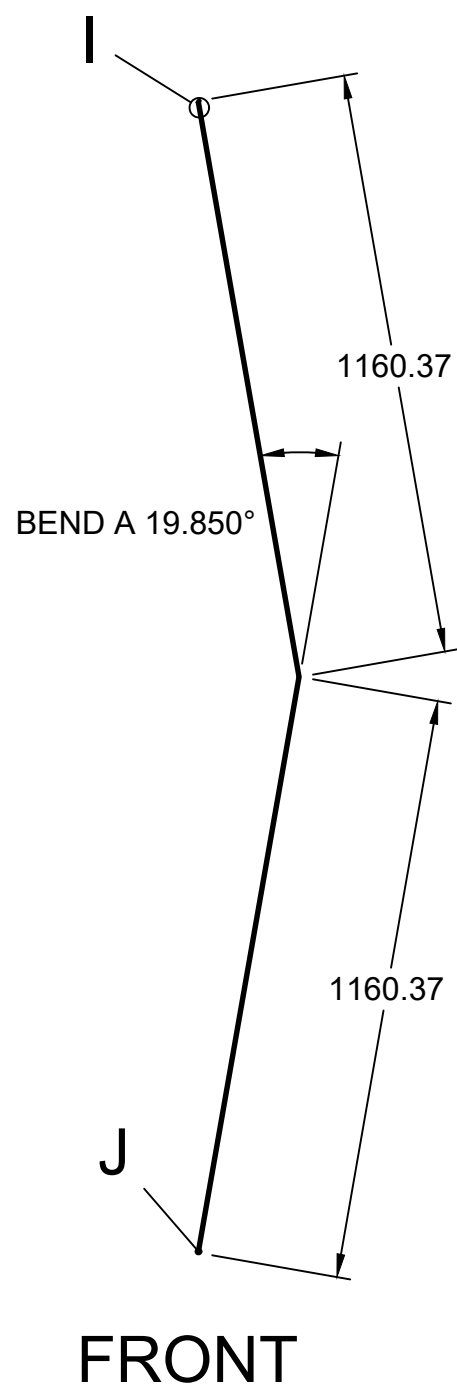
NOTE: Chamfer along Cut E

NOTE: All bends are parallel to the horizontal

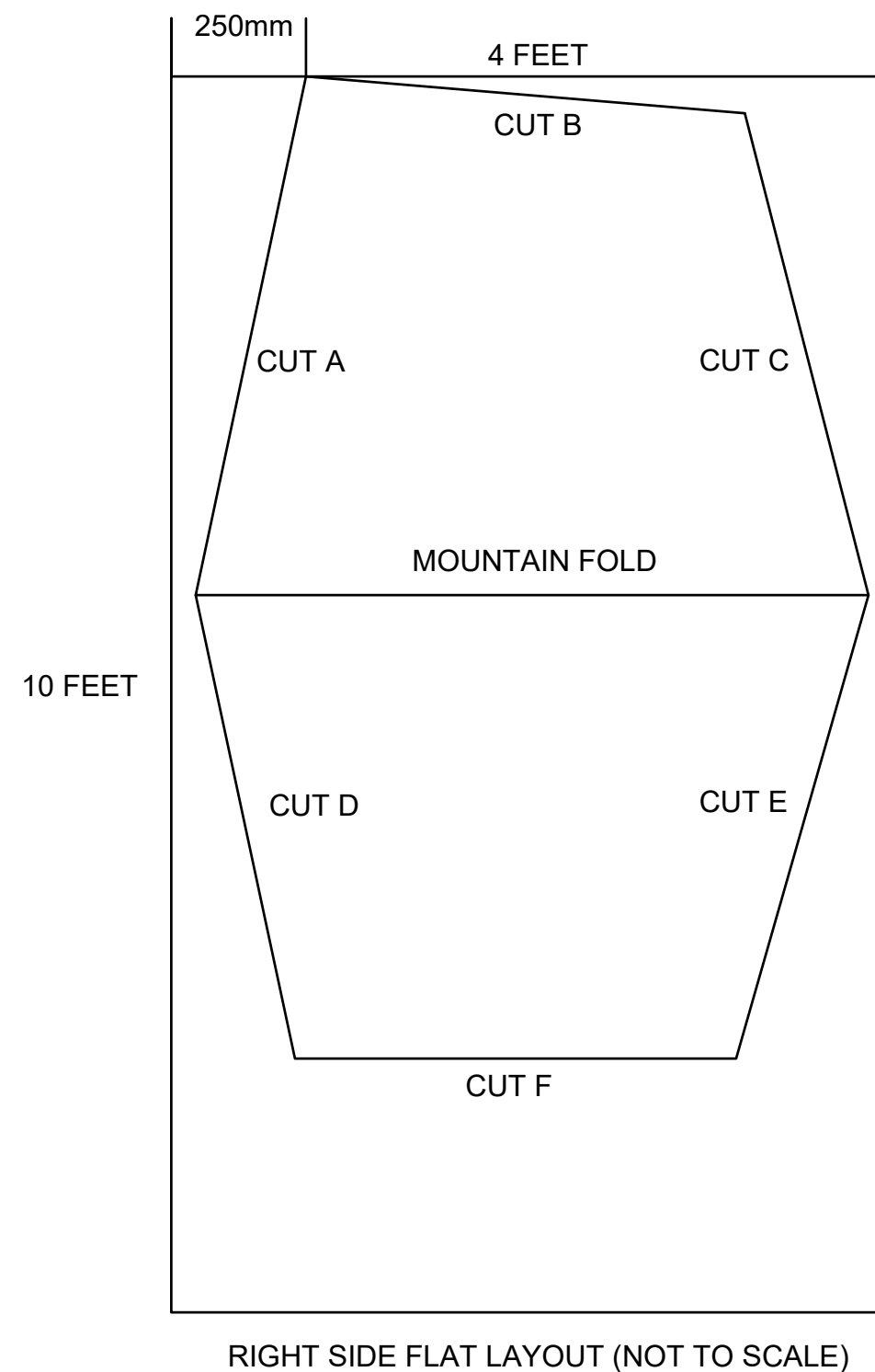
NOTE: Refer to Detail C for chamfers along Cuts A, C, D, and E; all chamfers face inward



**FACE 3A**  
(LEFT SIDE)



**FACE 3B**  
(RIGHT SIDE)



**KEY**  
t = GAUGE THICKNESS (mm)

APPROVED MICHAEL BARBINE		PROJECT <b>STARPHONE</b>			
		TITLE <b>PANEL 3 RIGHT SIDE</b>			
CHECKED	SIZE C	CODE N/A	DWG NO 1	REV -	
DRAWN PATRICK MODIN 7/27/2024		SCALE 1:15	WEIGHT	SHEET 4/5	

4

3

2

1

D

D

C

C

B

B

A

A

4

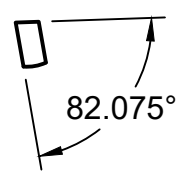
3

2

1

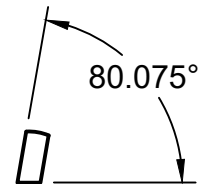
D

D



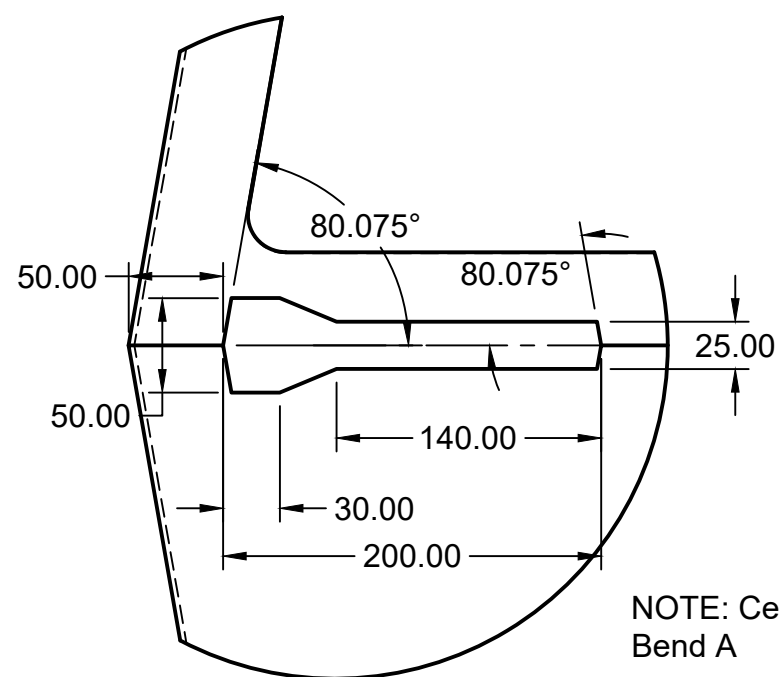
DETAIL L  
SCALE 1:1

NOTE: Chamfer along upper edge



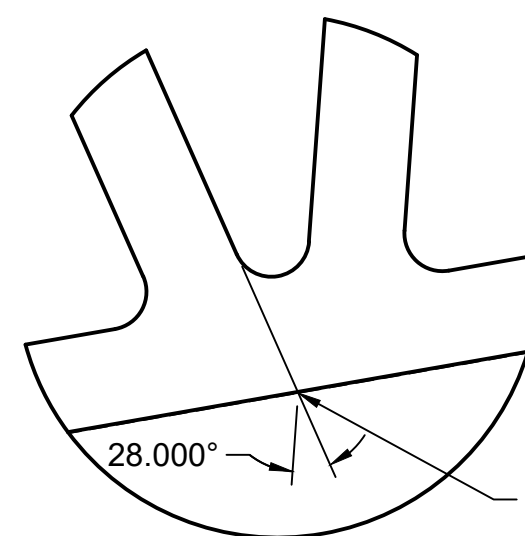
DETAIL M  
SCALE 1:1

NOTE: Chamfer along Cut E



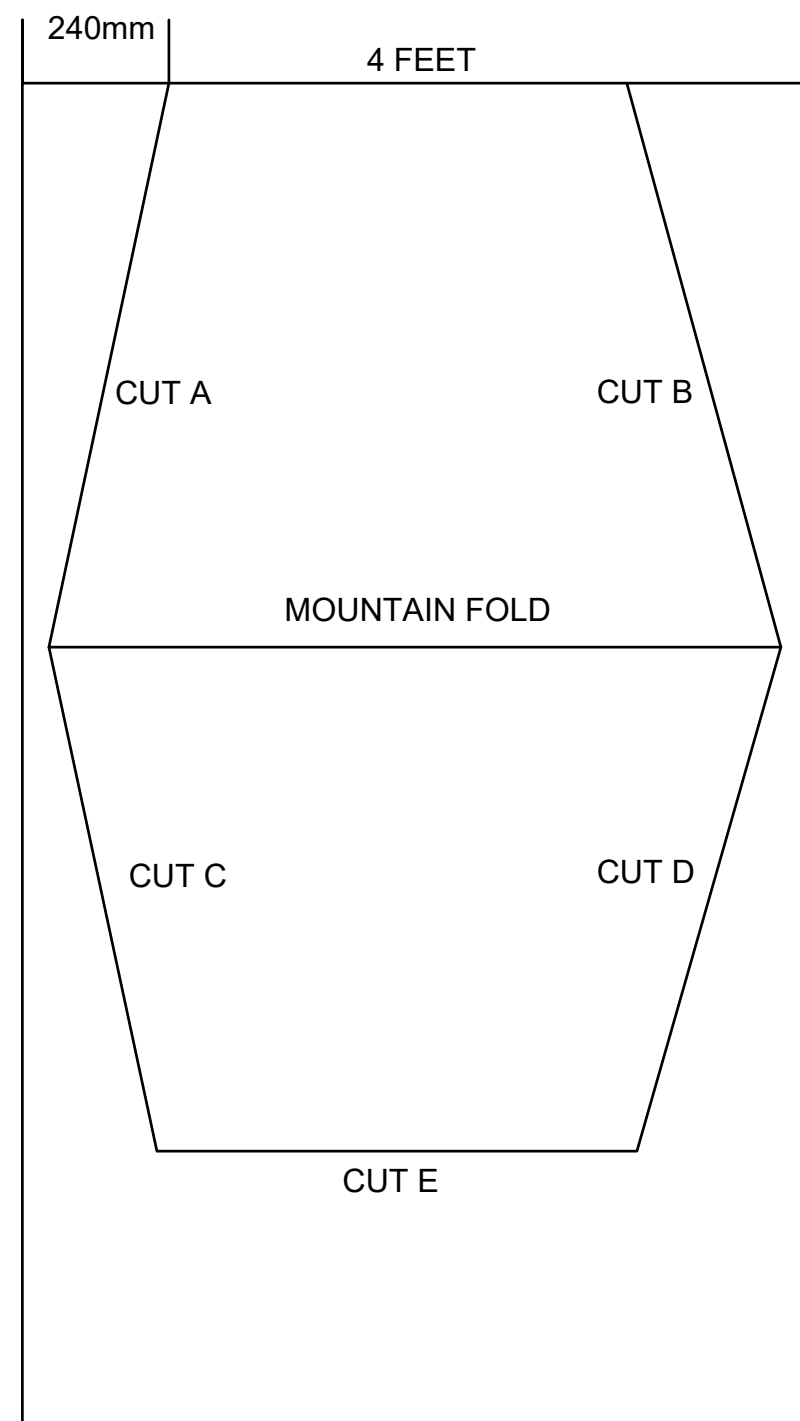
DETAIL N  
SCALE 1:4

NOTE: Centered on Bend A



DETAIL O  
SCALE 1:4

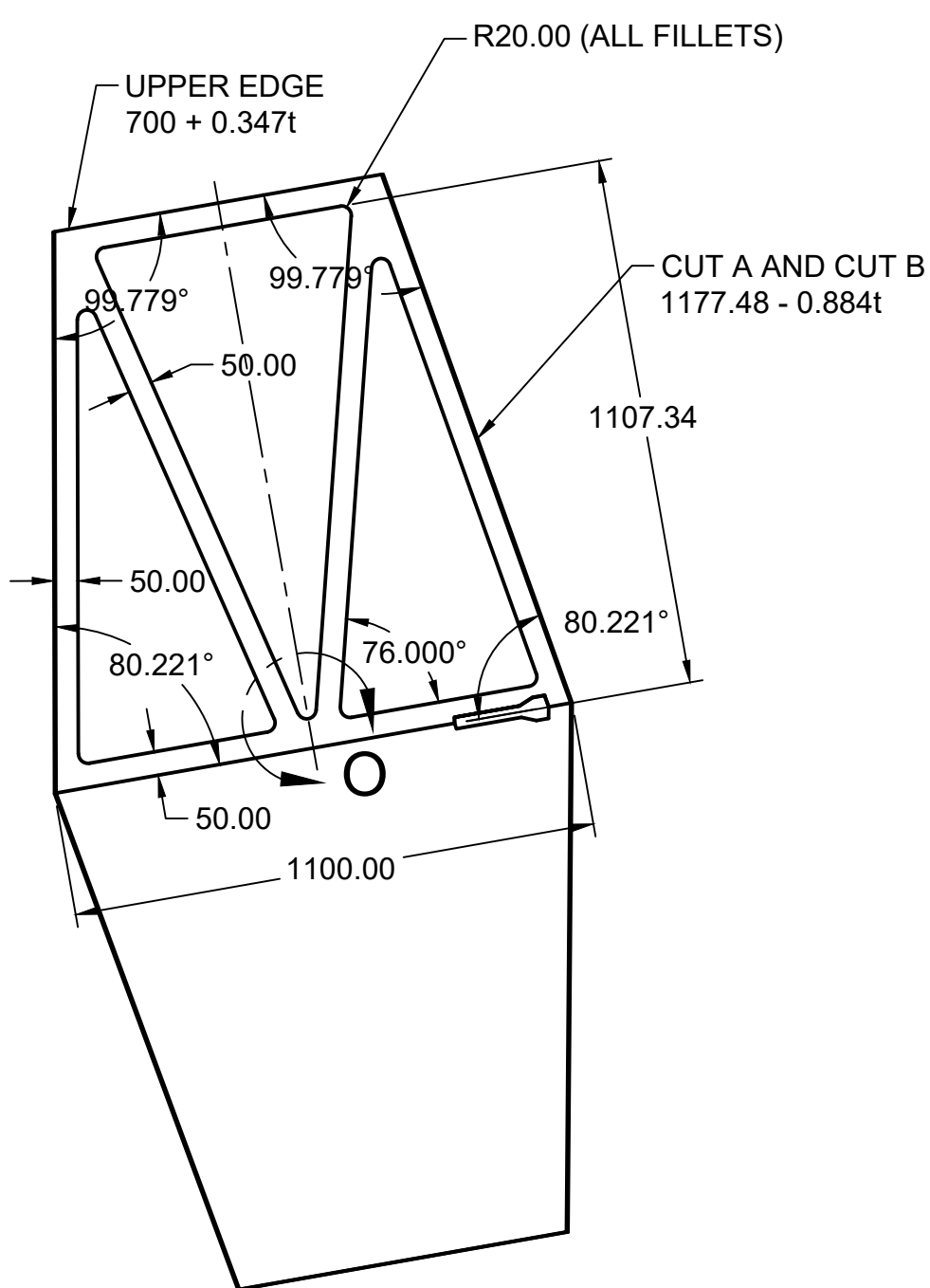
INNER FRAME EDGES CONVERGE AT OUTER BEND



FRONT FLAT LAYOUT (NOT TO SCALE, WINDOW FRAME AND DOOR HANDLE SLOT NOT SHOWN)

C

C



FACE 4A  
(BACK)

NOTE: All bends are parallel to the horizontal

LENGTH =  $1160.37 - 0.871t$

19.850°

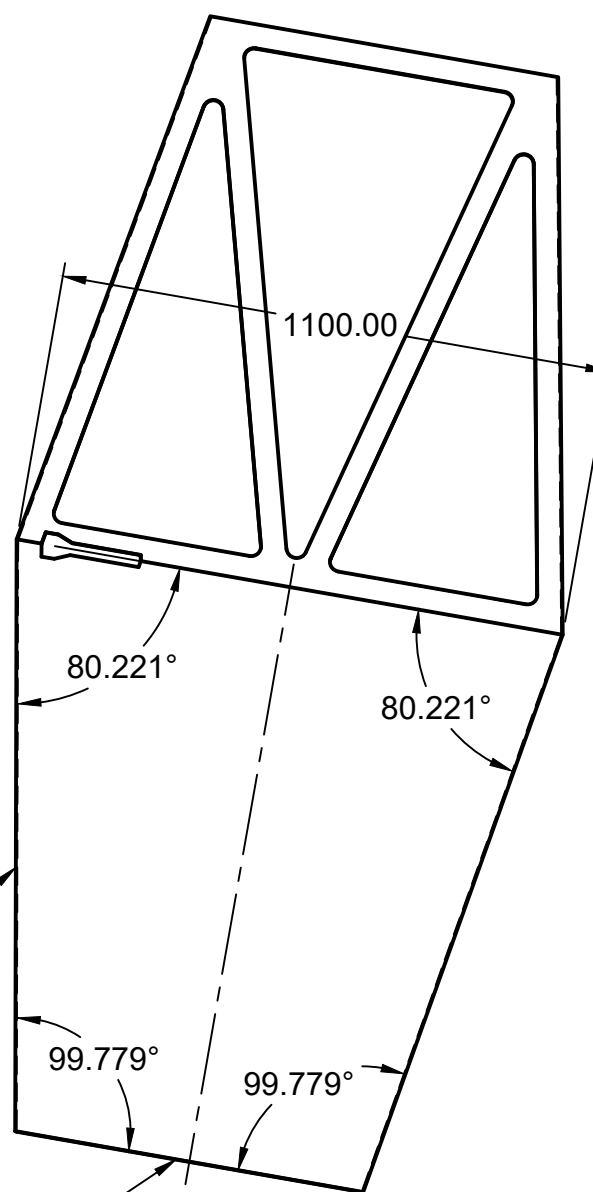
NOTE: Refer to Detail C for chamfers along Cuts A, B, C, and D; all chamfers face inward

LENGTH =  $1160.37 - 0.842t$

M

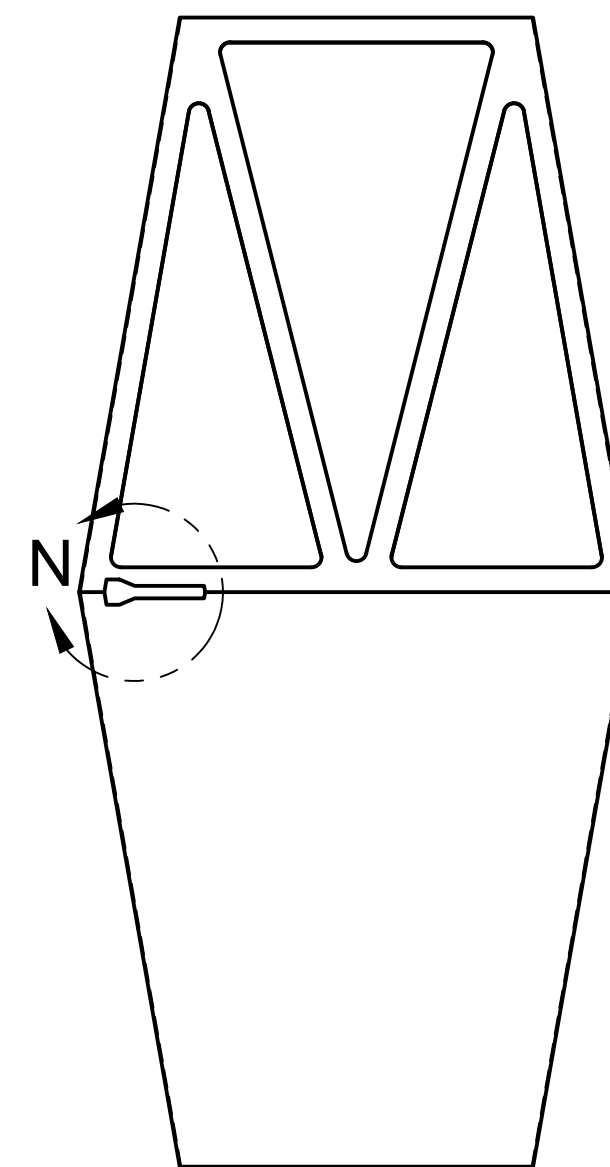
LEFT SIDE

CUT C AND CUT D  
 $1177.48 - 0.854t$



FACE 4B  
(FRONT)

CUT E  $700 + 0.35t$



FRONT

A

A

**KEY**  
t = GAUGE THICKNESS (mm)

PROJECT		STARPHONE		
TITLE		PANEL 4 DOOR		
APPROVED MICHAEL BARBINE	SIZE	CODE	DWG NO	REV
CHECKED	C	N/A	1	-
DRAWN PATRICK MODIN 7/27/2024	SCALE 1:15	WEIGHT	SHEET 5/5	

4

3

2

1