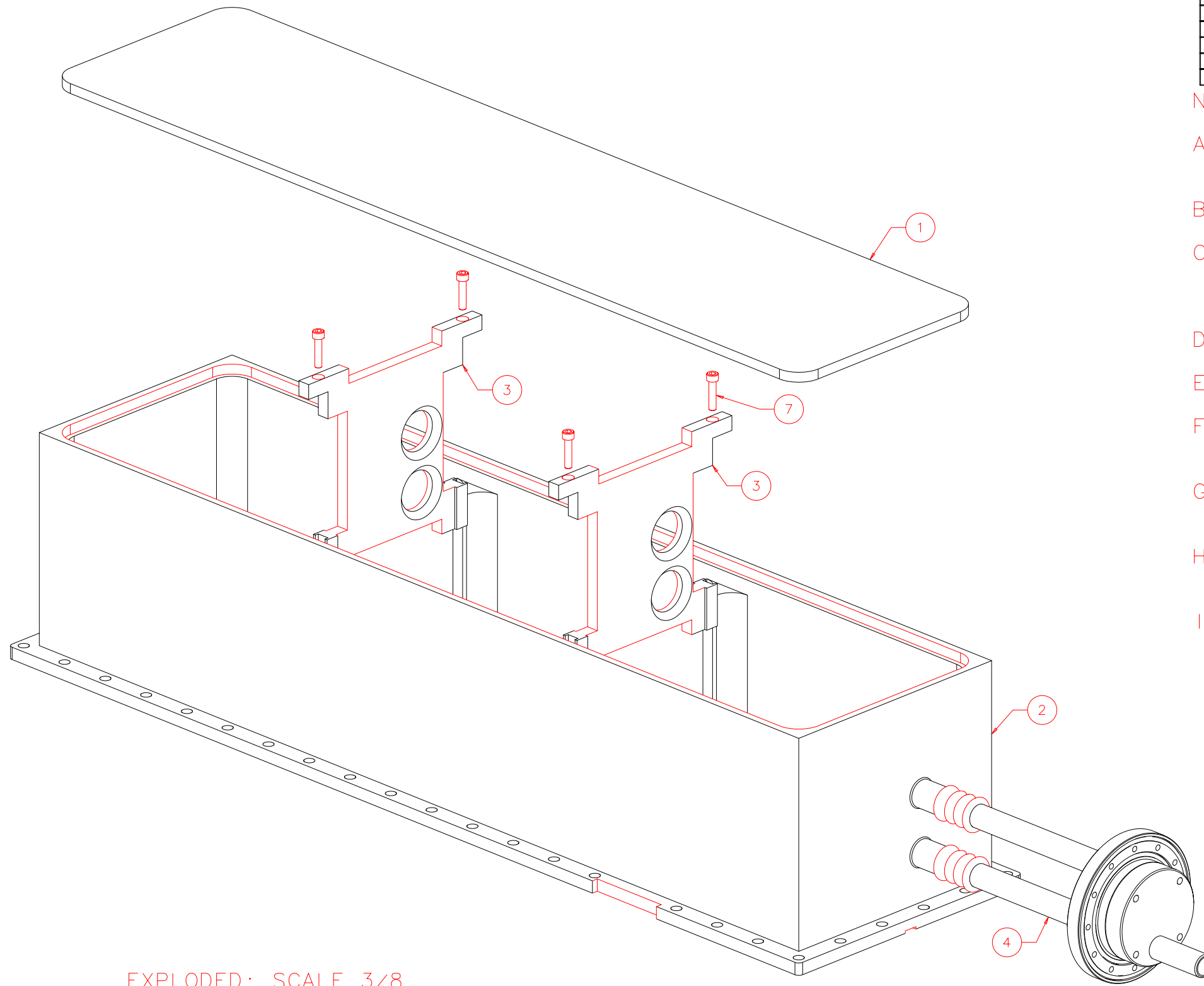


NOTES: UNLESS OTHERWISE NOTED
 1. MACHINED SURFACE ROUGHNESS 64
 O-RING GROOVES AND SURFACES 32
 2. REMOVE ALL BURRS/SHARP CORNERS



EXPLODED: SCALE 3/8

BILL OF MATERIAL				
NO.	REQ'D	REF DRW	DESCRIPTION	MATERIAL
N/A	1	SL0-001B	CRYOGEN CAN	N/A
1	1	SL0-022A	E.B.WELDED LID	ALU 2219
2	1	SL0-021B	HOGGED CRYOGEN CAN	ALU 2219
3	2	SL0-020A	INTERNAL DIFFUSER	ALU 2219
4	1	SL3-001A	FILL NECK (ASSEMBLY)	N/A
5	1	SL3-013A	EVACUATION ADAPTOR	ALU 6061-T6
6	2	N/A	O-RING 2-112	BUNA-N
7	4	N/A	SOCKET HEAD CAP 8-32 X .75	STAINLESS

NOTES:

- A) ELECTRON BEAM WELDED JOINTS TO HAVE STANDARD CLEARANCE AS REQUIRED.
- B) ALUMINUM ALLOY 2219, SUPPLY CERTIFICATES OF ALLOY
- C) LEAK TEST REQUIRED LESS THAN 1×10^{-8} C.C./SEC OF HELIUM, SUPPLY TEST REPORT.
- D) COSMETIC DOUBLE PASS REQUIRED.
- E) POLISH AS PER DETAIL DRAWINGS.
- F) BOLT INTERNAL DIFFUSERS IN PLACE PRIOR TO E.B.WELDING
- G) ALL PARTS TO BE ULTRASONICALLY CLEANED PRIOR TO E.B.WELDING
- H) SANDBLAST AS PER DETAIL DRAWINGS PRIOR TO E.B.WELDING
- I) REPOLISH AFTER WELDING

ITEM 4 IS AN EXISTING ASSEMBLY: DO NOT INCLUDE IN QUATATION

REVDATE: 08/28/98	REVISION: ADD EVACUATION ADAPTOR SL3-013A
REVDATE: N/A	REVISION: N/A
DATE: 03/25/97	INSTITUTE FOR ASTRONOMY
DESIGN: STAHLBERGER	2680 WOODLAWN DR. HONOLULU, HI 96822
DRAWN: STAHLBERGER	INSTRUMENT: SPEX - CROSS DISPERSED SPECTROGRAPH
APPR'D: J. RAYNER	PART NAME: CRYOGEN CAN
TOLERANCES	TELESCOPE: IRTF
X.X +/- .015	DRW NO: SL0-001B
X.XX +/- .005	SCALE: N/A
X.XXX +/- .002	SIZE: B
ANGLE +/- 30 min	JOS NO: 725
FRACTION +/- 1/32	SHEET: 1 OF 2

S00-001B	NEXT ASSY
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