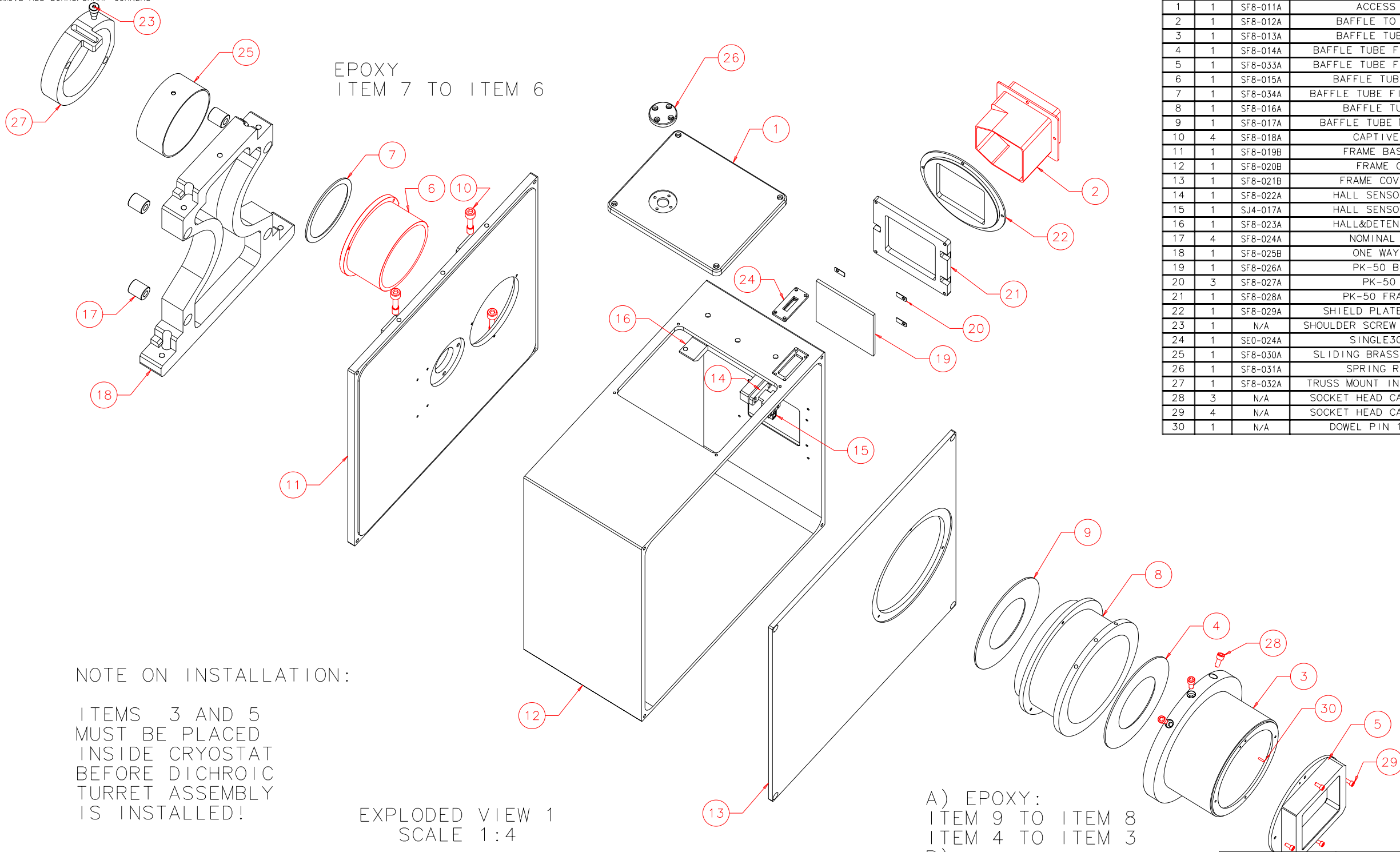


NOTES: UNLESS OTHERWISE NOTED

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



EPOXY
ITEM 7 TO ITEM 6

NOTE ON INSTALLATION:

ITEMS 3 AND 5
MUST BE PLACED
INSIDE CRYOSTAT
BEFORE DICHOIC
TURRET ASSEMBLY
IS INSTALLED!

EXPLODED VIEW 1
SCALE 1:4

A) EPOXY:
ITEM 9 TO ITEM 8
ITEM 4 TO ITEM 3
B)
PRESSFIT ITEM 30
TO ITEM 3

BILL OF MATERIAL

NO.	REQ'D	REF DRW	DESCRIPTION	MATERIAL
N/A	1	SF8-001B	FRAME	N/A
1	1	SF8-011A	ACCESS COVER	ALU 6061-T6
2	1	SF8-012A	BAFFLE TO TIP/TILT	ALU 6061-T6
3	1	SF8-013A	BAFFLE TUBE FEMALE	ALU 6061-T6
4	1	SF8-014A	BAFFLE TUBE FEMALE INSERT	ALU 6061-T6
5	1	SF8-033A	BAFFLE TUBE FEMALE NOZZLE	ALU 6061-T6
6	1	SF8-015A	BAFFLE TUBE FIXED 2	ALU 6061-T6
7	1	SF8-034A	BAFFLE TUBE FIXED 2 INSERT	ALU 6061-T6
8	1	SF8-016A	BAFFLE TUBE MALE	ALU 6061-T6
9	1	SF8-017A	BAFFLE TUBE MALE INSERT	ALU 6061-T6
10	4	SF8-018A	CAPTIVE SCREW	STAINLESS
11	1	SF8-019B	FRAME BASE PLATE	ALU 6061-T6
12	1	SF8-020B	FRAME CENTER	ALU 6061-T6
13	1	SF8-021B	FRAME COVER PLATE	ALU 6061-T6
14	1	SF8-022A	HALL SENSOR BRACKET	ALU 6061-T6
15	1	SJ4-017A	HALL SENSOR CARRIER	ALU 6061-T6
16	1	SF8-023A	HALL&DETENT SUPPORT	ALU 6061-T6
17	4	SF8-024A	NOMINAL SPACER	ALU 6061-T6
18	1	SF8-025B	ONE WAY MOUNT	ALU 6061-T6
19	1	SF8-026A	PK-50 BLOCKER	GLASS
20	3	SF8-027A	PK-50 CLIP	PHOS.BRONZE
21	1	SF8-028A	PK-50 FRAMBaffle	ALU 6061-T6
22	1	SF8-029A	SHIELD PLATE -Y INSERT	ALU 6061-T6
23	1	N/A	SHOULDER SCREW PZ-20-3(BERG)	STAINLESS
24	1	SE0-024A	SINGLE30 MOUNT	ALU 6061-T6
25	1	SF8-030A	SLIDING BRASS TUBE BAFFLE	HARD BRASS
26	1	SF8-031A	SPRING RETAINER	ALU 6061-T6
27	1	SF8-032A	TRUSS MOUNT INTERFACE PLATE	ALU 6061-T6
28	3	N/A	SOCKET HEAD CAP 8-32 x 3/8	STAINLESS
29	4	N/A	SOCKET HEAD CAP 4-40 x 1/4	STAINLESS
30	1	N/A	DOWEL PIN 1/16 x 1/4	STAINLESS

REVDATE: 10/09/99	REVISION: UPDATE MISC.BAFFLES
REVDATE: N/A	REVISION: N/A
DATE: 01/05/99	INSTITUTE FOR ASTRONOMY
DESIGN: STAHLBERGER	2680 WOODLAWN DR. HONOLULU, HI 96822
DRAWN: STAHLBERGER	INSTRUMENT: SPEX - CROSS DISPERSED SPECTROGRAPH
APPR'D: J. RAYNER	PART NAME: FRAME
TOLERANCES	
X.X	+/- .015
X.XX	+/- .005
X.XXX	+/- .002
ANGLE	+/- 30 min
FRACTION	+/- 1/32

SF0-001B	DRW NO: SF8-001B	SCALE: NOTED
NEXT ASSY	SIZE: B	JOS NO: 725
		SHEET: 1 OF 2