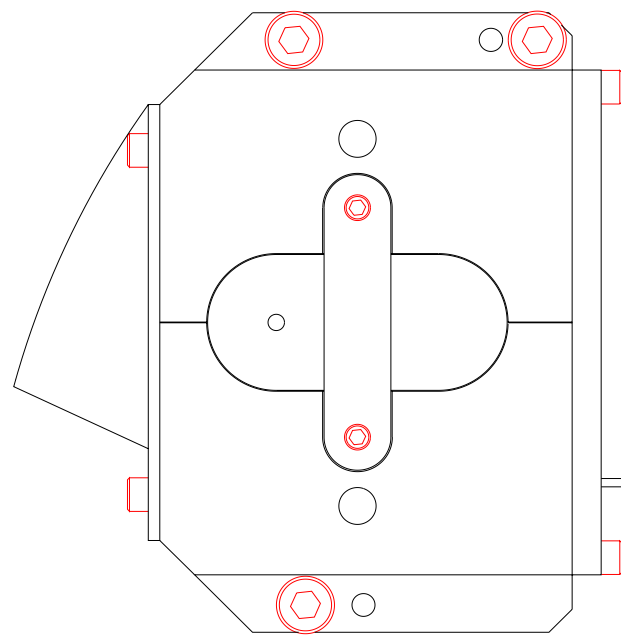
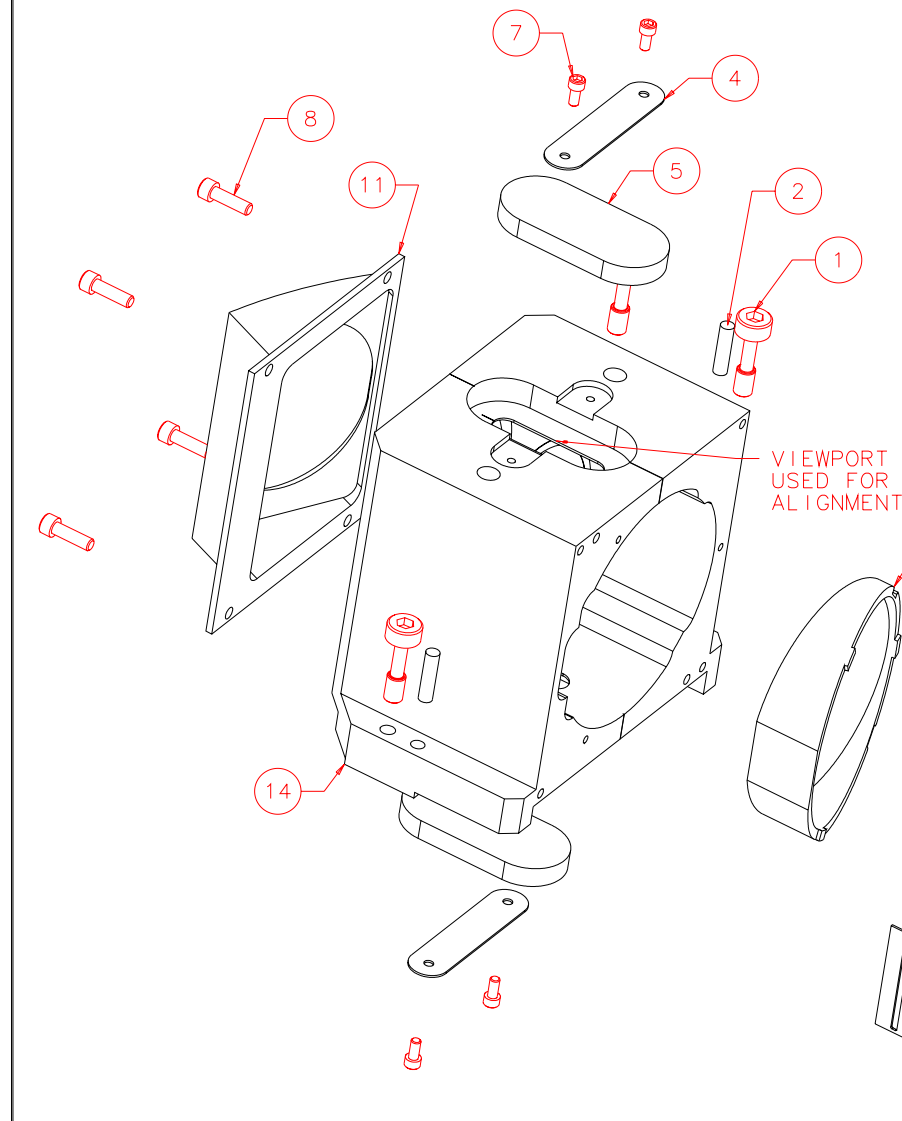
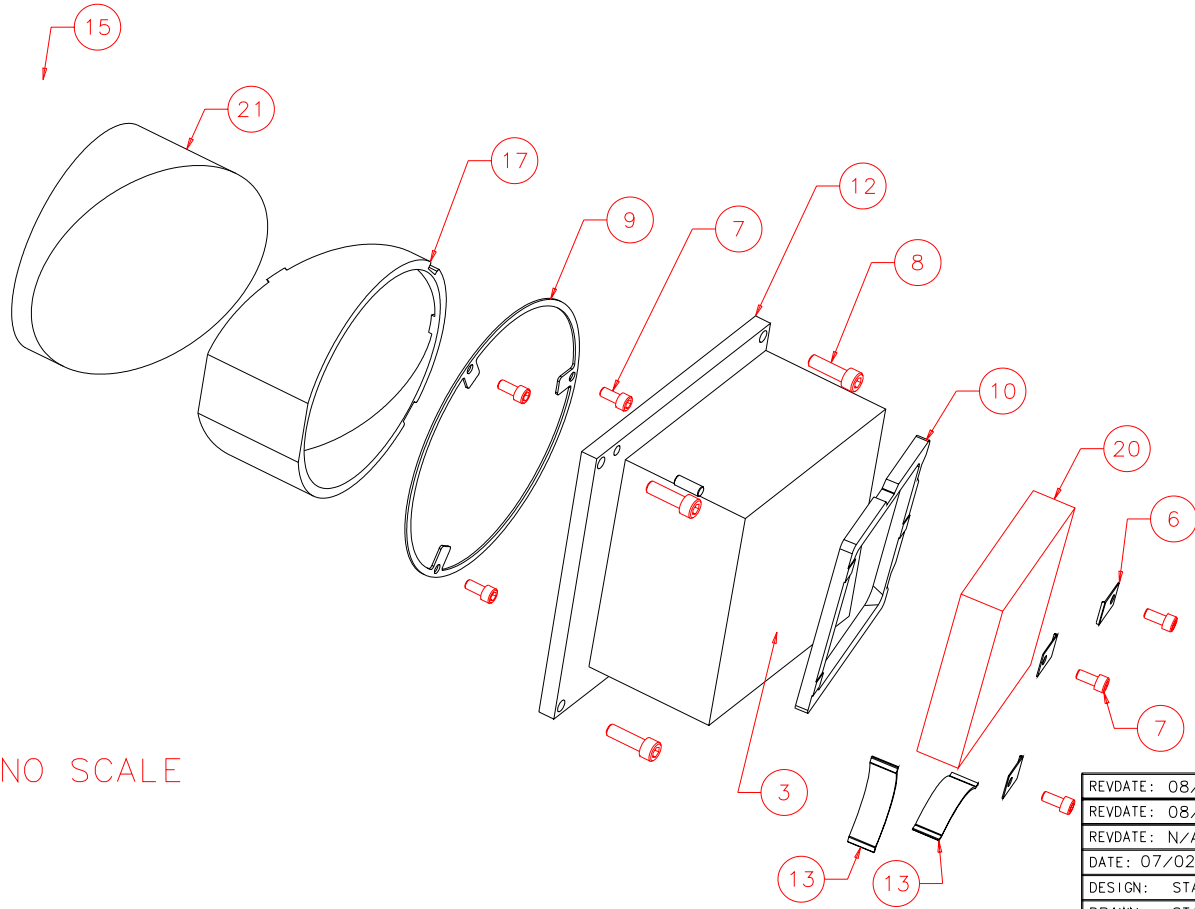


NOTES: UNLESS OTHERWISE NOTED  
 1. MACHINED SURFACE ROUGHNESS 64  
 O-RING GROOVES AND SURFACES 32  
 2. REMOVE ALL BURRS/SHARP CORNERS



TOP: SCALE 1:1



EXPLODED VIEW: NO SCALE

OPTICAL ALIGNMENT:

TO ALIGN 19 AND 21 USE OPTICAL COMPARATOR IN IFA MACHINE SHOP. PRISMS HAVE FIDUCIAL LINES ENGRAVED ON OUTSIDE DIAMETER. USE VIEWPORT IN 14 FOR THIS PURPOSE.

BILL OF MATERIAL

NO.	REQ'D	REF DRW	DESCRIPTION	MATERIAL
N/A	1	SK5-001B	SXD1 MOUNT	N/A
1	3	N/A	CAPTIVE SCREW Z12-6-H(BERG)	STAINLESS
2	2	N/A	DOWEL PIN D14-10(BERG)	STAINLESS
3	2	N/A	DOWEL PIN D13-6(BERG)	STAINLESS
4	2	SK5-024A	FIDUCIAL CLAMP	PHOS.BRONZE
5	2	SK5-025A	FIDUCIAL COVER	ALU 6061-T6
6	3	SK5-026A	GRATING CLIP	PHOS.BRONZE
7	10	N/A	HEX SOCKET HEAD 2-56 x 3/16	STAINLESS
8	8	N/A	HEX SOCKET HEAD 4-40 x 3/8	STAINLESS
9	1	SK5-011A	SXD1 AXIAL SPRING	PHOS.BRONZE
10	1	SK5-012A	SXD1 AXIAL SUPPORT/MASK	ALU 6061-T6
11	1	SK5-013A	SXD1 FRONT BAFFLE	ALU 6061-T6
12	1	SK5-014B	SXD1 GRATING MOUNT	ALU 6061-T6
13	2	SK5-015A	SXD1 GRATING SPRING RADIAL	PHOS.BRONZE
14	1	SK5-023B	SXD1 PRISM MOUNT	ALU 6061-T6
15	1	SK5-016A	SXD1 PRISM SPACER	PHOS.BRONZE
16	1	SK5-017A	SXD1 RADIAL SPRING	PHOS.BRONZE
17	1	SK5-018A	SXD1 SPACER BACK	ALU 6061-T6
18	1	SK5-019A	SXD1 SPACER FRONT	ALU 6061-T6
19	1	SQ6-012A	SXD1-FS-PRISM(ROUND)	FUSED SILICA
20	1	SK5-021A	SXD1-GRATING	GLASS
21	1	SQ6-011A	SXD1-ZN-PRISM(ROUND)	ZNSE

REVDATE: 08/16/99	REVISION: UPDATE DRAWING
REVDATE: 08/03/99	REVISION: UPDATE DRAWING
REVDATE: N/A	REVISION: N/A
DATE: 07/02/99	<b>INSTITUTE FOR ASTRONOMY</b>
DESIGN: STAHLBERGER	2680 WOODLAWN DR. HONOLULU, HI 96822
DRAWN: STAHLBERGER	INSTRUMENT: SPEX - CROSS DISPERSED SPECTROGRAPH
APPR'D: J. RAYNER	PART NAME: SXD1 MOUNT
<b>TOLERANCES</b>	TELESCOPE: IRTF
X.X +/- .015	
X.XX +/- .005	
X.XXX +/- .002	
ANGLE +/- 30 min	
FRACTION +/- 1/32	

SKO-001B	DRW NO: SK5-001B	SCALE: NOTED
NEXT ASSY	SIZE: B	JOS NO: 725
		SHEET: 2 OF 3