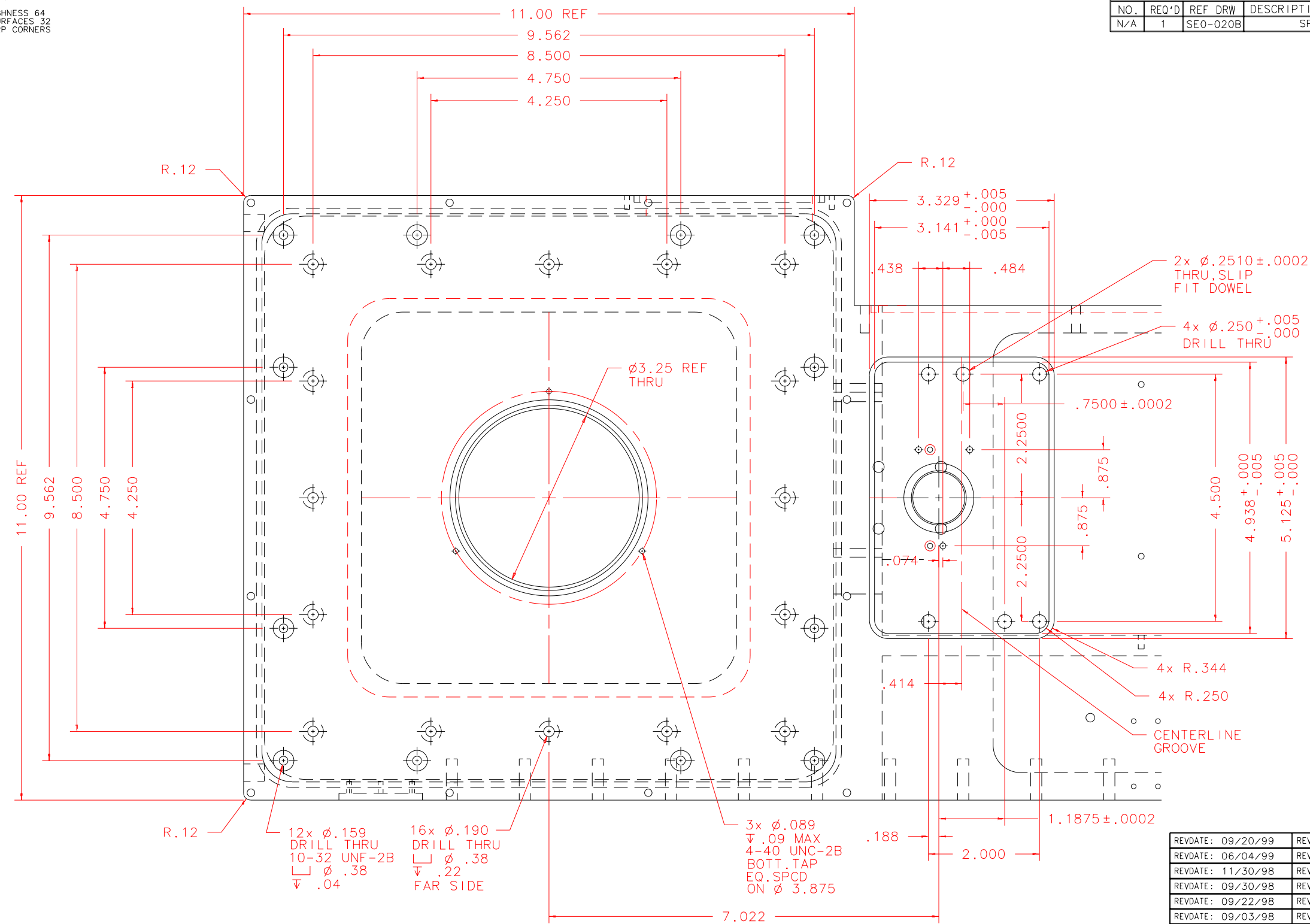


NOTES: UNLESS OTHERWISE NOTED  
 1. MACHINED SURFACE ROUGHNESS 64  
 O-RING GROOVES AND SURFACES 32  
 2. REMOVE ALL BURRS/SHARP CORNERS

BILL OF MATERIAL				
NO.	REQ'D	REF DRW	DESCRIPTION	MATERIAL
N/A	1	SEO-020B	SPECTROGRAPH BOX	ALU 6061-T6



12x  $\phi$ .159  
 DRILL THRU  
 10-32 UNF-2B  
 $\perp$   $\phi$ .38  
 $\nabla$  .04

16x  $\phi$ .190  
 DRILL THRU  
 $\perp$   $\phi$ .38  
 $\nabla$  .22  
 FAR SIDE

3x  $\phi$ .089  
 $\nabla$  .09 MAX  
 4-40 UNC-2B  
 BOTT TAP  
 EQ.SPCD  
 ON  $\phi$  3.875

2x  $\phi$ .2510  $\pm$ .0002  
 THRU, SLIP  
 FIT DOWEL

4x  $\phi$ .250  $\pm$ .005  
 DRILL THRU

4x R.344

4x R.250

CENTERLINE  
 GROOVE

DETAIL J: SCALE 1:2

REVDATE: 09/20/99	REVISION: 3.500 DIA WRONG PLC.-ADJUSTED
REVDATE: 06/04/99	REVISION: ADD DETAIL K, SHEET 1
REVDATE: 11/30/98	REVISION: ADD 8.232, 9.991 AND 3.031 DIMS
REVDATE: 09/30/98	REVISION: CHANGED RADII IN SHEET 1 AND 3
REVDATE: 09/22/98	REVISION: ADD 5.500 DIM SECTION E-E SHEET 9
REVDATE: 09/03/98	REVISION: ADD DIM. .50 12.522 5.500 GREEN
REVDATE: 04/06/98	REVISION: SHT 10, DIMS .17 IS 5.171TOL
REVDATE: N/A	REVISION: N/A
DATE: 10/21/97	<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: SPECTROGRAPH BOX
<b>TOLERANCES</b>	
X.X	+/- .015
X.XX	+/- .005
X.XXX	+/- .002
ANGLE	+/- 30 min
FRACTION	+/- 1/32
DRW NO: SEO-020B	SCALE: NOTED
SIZE: B	JOS NO: 725
SHEET: 11 OF 13	