NOTES: UNLESS OTHERWISE NOTED

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

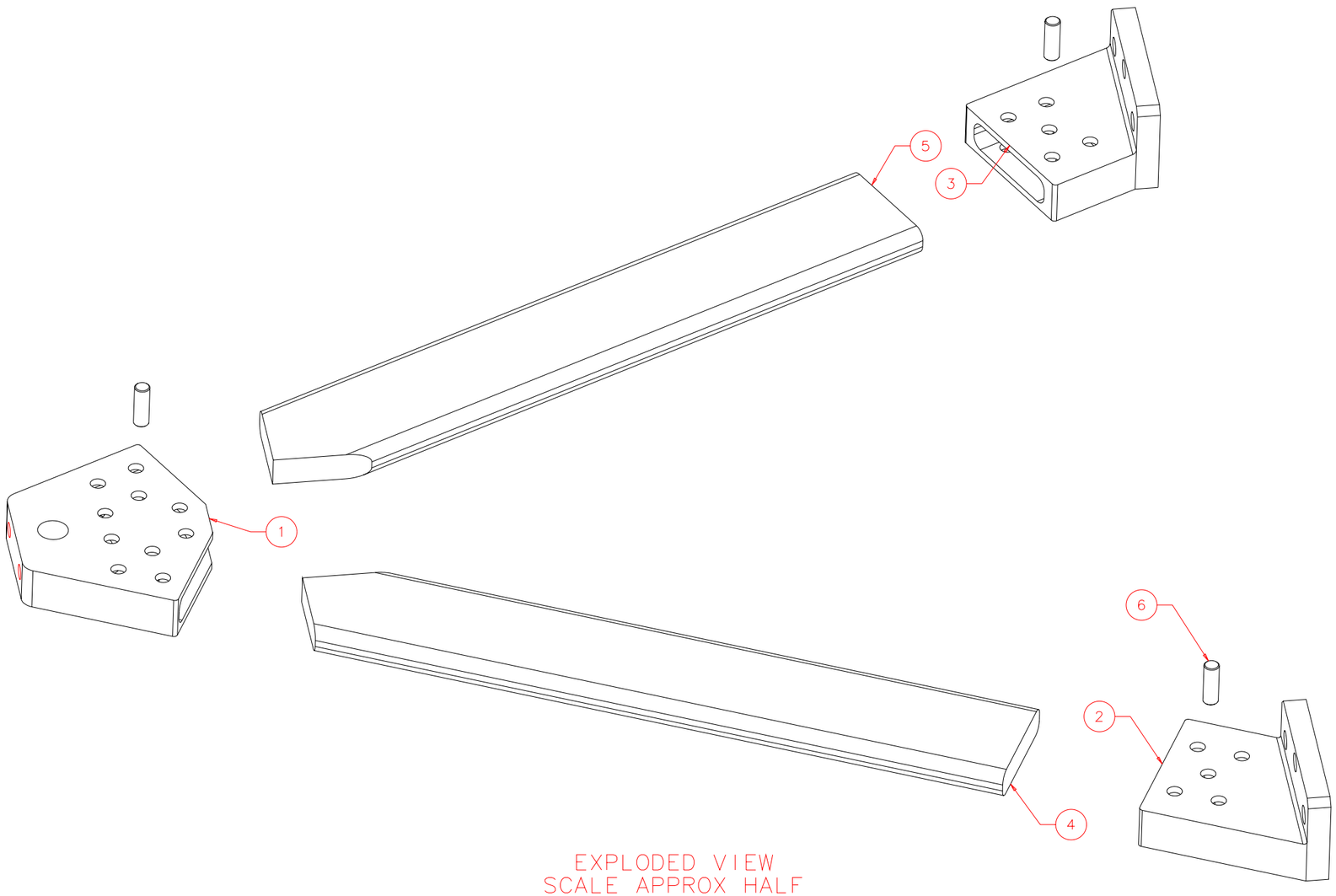
POLISH EXTERIOR
METAL SURFACES
TO 10 MICRON FINISH

BILL OF MATERIAL				
NO.	REQ'D	REF DRW	DESCRIPTION	MATERIAL
N/A	4	SE1-001B	TRUSS LEG	N/A
1	4	SE1-011A	APEX SHOE	STAINLESS 303
2	4	SE1-012A	SHOE LEFT	STAINLESS 303
3	4	SE1-013A	SHOE RIGHT	STAINLESS 303
4	4	SE1-014A	TRUSS LEG LEFT	G-10-CR
5	4	SE1-015A	TRUSS LEG RIGHT	G-10-CR
6	80	N/A	DOWEL PIN D28-6(BERG)	STAINLESS 416

NOTE: TRUSS LEG WILL BE
ASSEMBLED BY INSTITUTE
FOR ASTRONOMY MACHINE
SHOP

ASSEMBLY PROCEDURE:

A) CHECK CLEARANCE BETWEEN
   TRUSS LEG AND SHOES,
   SHOULD BE .002-.005 INCH.
B) CLEAN PARTS WITH ACETONE.
C) MOUNT SHOES ON BASE & APEX
   DUPLICATING CONDITIONS
   IN VACUUM JACKET SETUP.
D) EPOXY, USE ECCOBOND 286.
   CURE FOR 24 HRS.
E) DRILL AND REAM FOR
   1/4 DOWEL PIN.(PRESS FIT)
F) INSERT DOWELS



EXPLODED VIEW
SCALE APPROX HALF

REVDATE: N/A	REVISION: N/A	
DATE: 03/18/97	INSTITUTE FOR ASTRONOMY	
DESIGN: STAHLBERGER	2680 WOODLAWN DR. HONOLULU, HI 96822	
DRAWN: STAHLBERGER	INSTRUMENT: SPEX - CROSS DISPERSED SPECTROGRAPH	
APPR'D: J. RAYNER	PART NAME: TRUSS LEG	
TOLERANCES	TELESCOPE: IRTF	
X.X +/- .015	DRW NO: SE1-001B	SCALE: NOTED
X.XX +/- .005	SIZE: B	JOS NO: 725
X.XXX +/- .002		SHEET: 2 OF 2
ANGLE +/- 30 min		
FRACTION +/- 1/32		

SE0-001B	
NEXT ASSY	

PLOT: 10/19/99