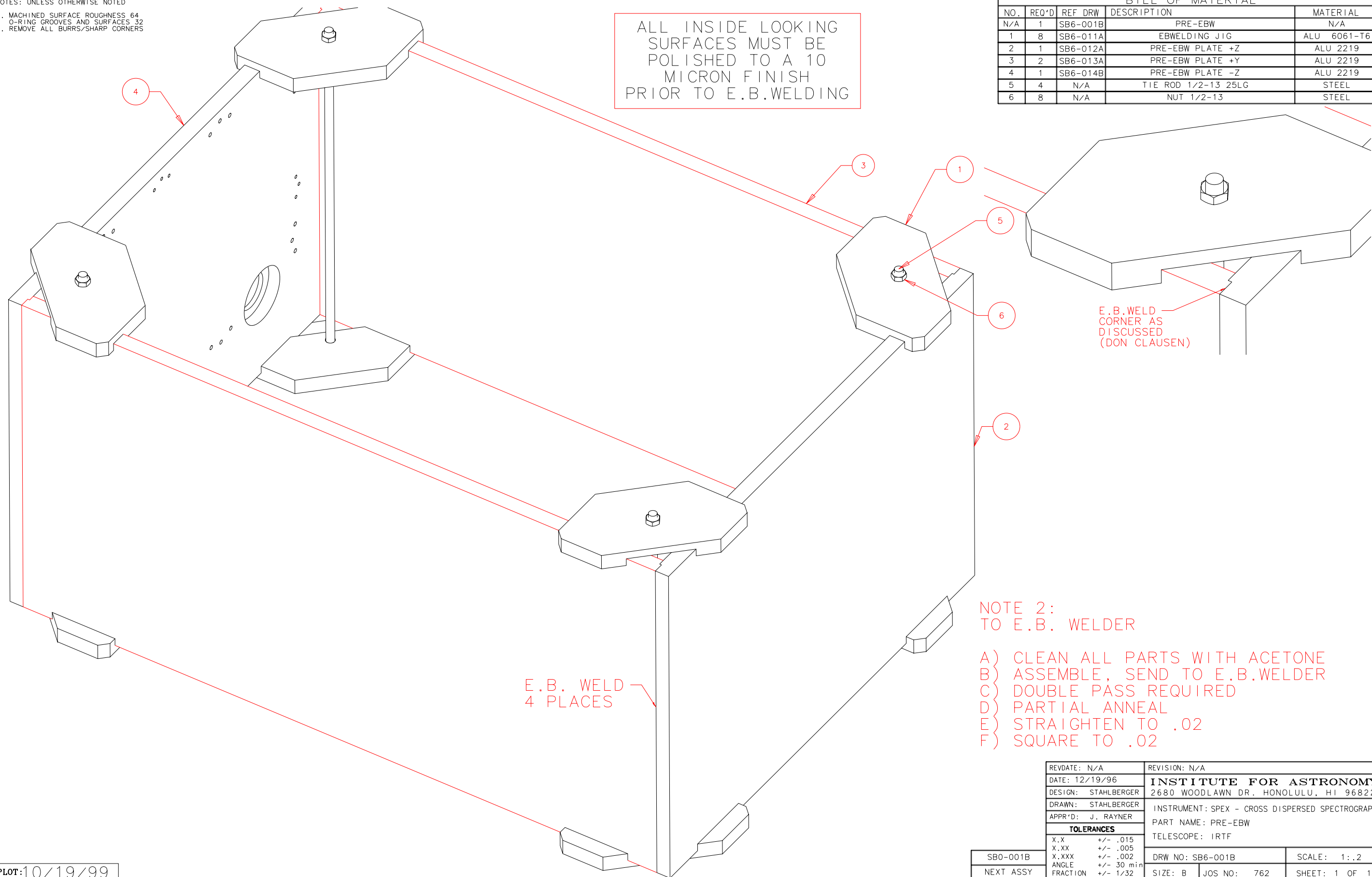


NOTES: UNLESS OTHERWISE NOTED
 1. MACHINED SURFACE ROUGHNESS 64
 O-RING GROOVES AND SURFACES 32
 2. REMOVE ALL BURRS/SHARP CORNERS

ALL INSIDE LOOKING SURFACES MUST BE POLISHED TO A 10 MICRON FINISH PRIOR TO E.B.WELDING

BILL OF MATERIAL					
NO.	REQ'D	REF DRW	DESCRIPTION	MATERIAL	
N/A	1	SB6-001B	PRE-EBW	N/A	
1	8	SB6-011A	EBWELDING JIG	ALU 6061-T6	
2	1	SB6-012A	PRE-EBW PLATE +Z	ALU 2219	
3	2	SB6-013A	PRE-EBW PLATE +Y	ALU 2219	
4	1	SB6-014B	PRE-EBW PLATE -Z	ALU 2219	
5	4	N/A	TIE ROD 1/2-13 25LG	STEEL	
6	8	N/A	NUT 1/2-13	STEEL	



NOTE 2:
TO E.B. WELDER

- A) CLEAN ALL PARTS WITH ACETONE
- B) ASSEMBLE, SEND TO E.B.WELDER
- C) DOUBLE PASS REQUIRED
- D) PARTIAL ANNEAL
- E) STRAIGHTEN TO .02
- F) SQUARE TO .02

REVDATE: N/A	REVISION: N/A
DATE: 12/19/96	INSTITUTE FOR ASTRONOMY
DESIGN: STAHLBERGER	2680 WOODLAWN DR. HONOLULU, HI 96822
DRAWN: STAHLBERGER	INSTRUMENT: SPEX - CROSS DISPERSED SPECTROGRAPH
APPR'D: J. RAYNER	PART NAME: PRE-EBW
TOLERANCES	
X.X	+/- .015
X.XX	+/- .005
X.XXX	+/- .002
ANGLE	+/- 30 min
FRACTION	+/- 1/32
SB0-001B	DRW NO: SB6-001B
NEXT ASSY	SCALE: 1: .2
	SIZE: B
	JOS NO: 762
	SHEET: 1 OF 1