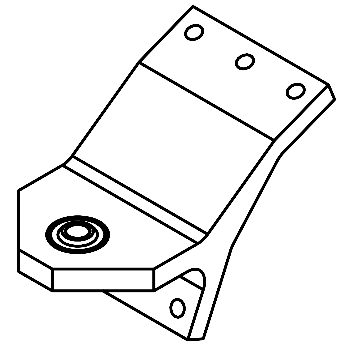
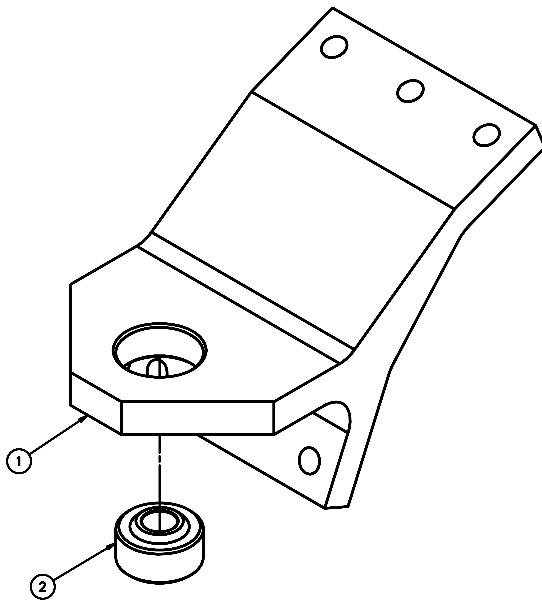


REVISIONS				
LTR	DESCRIPTION	DATE	REVISED BY	APPROVED
A	INITIAL RELEASE	04/22/06	J. BRENNAN	-
B	ADDED REQUIRED CLARITY	04/18/06	J. BRENNAN	-



2 SUBASSEMBLIES REQUIRED.

NOTES:

1. THE USE OF AN ARBOR PRESS OR HYDRAULIC PRESS IS RECOMMENDED FOR THE PRESSING INSTALLATION.
2. ALL FORCE IS TO BE APPLIED TO THE BEARING RACE (NOT THE BALL).
3. BEFORE THE STAKING OPERATION, POSITION BEARING SYMMETRICAL ABOUT HOUSING CENTERLINE.
4. ALIGN BEARING WITH STAKING TOOL.
5. A TRIAL STAKE ASSEMBLY SHOULD BE MADE TO DETERMINE STAKING FORCE NECESSARY TO MEET THRUST LOAD REQUIREMENTS.
6. AFTER FIRST STAKE IS COMPLETED ROTATE ASSEMBLY 90° AND RE-APPLY.
7. REPEAT OPERATION THROUGH A MINIMUM OF THREE ROTATIONS TO INSURE 360° UNIFORMITY OF STAKE.
8. A SLIGHT GAP BETWEEN RACE LIP AND HOUSING CHAMFER MAY NOT BE CAUSE FOR REJECTION.

1	M1B-4T	SPHERICAL BEARING .6084 X .2500 X .375	AURORA	2
1	14405	DEWAR SPPT FTG UPR AFT BLOCK ASSEMBLY	X	1
1	14477	M1T-MAESTRO		

DO NOT SCALE DRAWING		THIS DRAWING CREATED IN:		Steward Observatory, University of Arizona	
SCALE	UNITS	ACAD	INCH	10/04	933 N. Cherry Avenue, Tucson, AZ 85721 (520)621-7600
<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	
TOLERANCES		DESIGNED BY		DATE	
UNLESS OTHERWISE SPECIFIED		S. MATHEWS		10/04	
FRACTIONS		DRAWN BY		PROJECT	
DECIMALS		J. BRENNAN		MAESTRO	
ANGLES		CHECKED BY		TITLE	
MINIMUM		D. BEAN		DEWAR	
MAXIMUM		J. BECHTOLD		SPPT FTG UPR AFT	
MINIMUM		APPROVED BY		BLOCK ASSEMBLY	
MAXIMUM		R. WANKNER		04/22/06	
MATERIAL		PART NUMBER		PLATE OR DIE NO.	
14477		M1T-MAESTRO		D	
NEXT ASSY		USED ON		DRAWING NUMBER	
				14801	
FINISH		ASSEMBLY APPLICATION		REVISION	
				B	