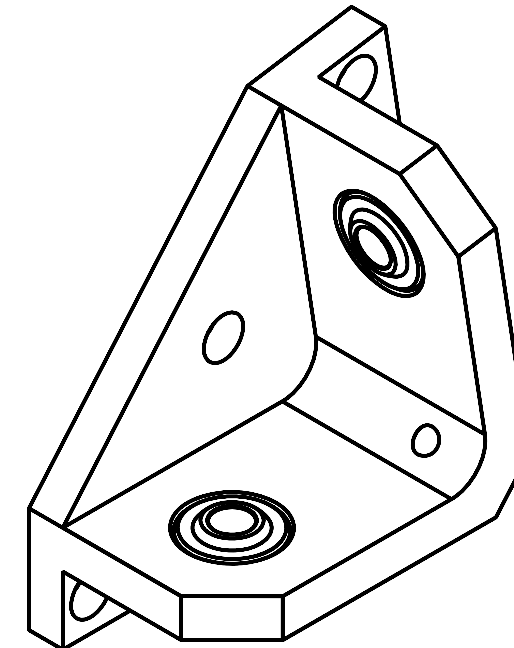
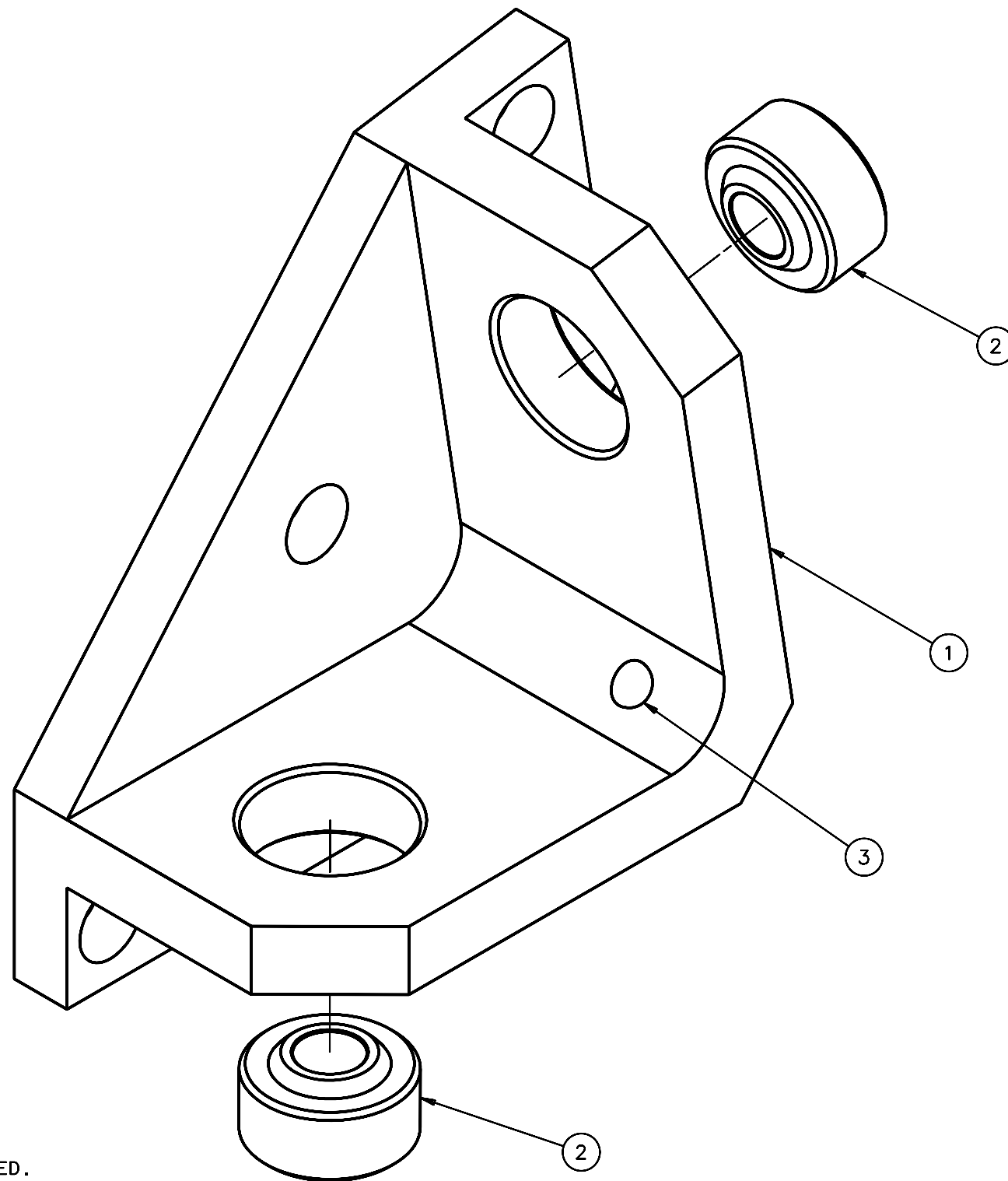


REVISIONS				
LTR	DESCRIPTION	DATE	REVISED BY	APPROVED
A	INITIAL RELEASE	04/22/05	J. BRENNAN	G. LANDIS
B	ADDED ITEM 3	04/25/05	J. BRENNAN	-
C	ADDED REQUIRED QUANTITY	05/18/05	J. BRENNAN	-



1 SUBASSEMBLY REQUIRED.

NOTES:

1. THE USE OF AN ARBOR PRESS OR HYDRAULIC PRESS IS RECOMENDED 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 REQUIERMENTS.
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.

QTY PER ASSY	-3	-2	-1	PART NUMBER	PART DESCRIPTION	MANUFACTURER or MAT'L SPEC	ITEM NO.
				1 90296A551	8-32 .328 18-8 S.S. HELICAL INSERT SCREW LOCK	McMASTER CARR	3
				2 MIB-4T	SPHERICAL BEARING .6094 X .2500 X .375	AURORA	2
				1 14483	DEWAR SPPT FTG LWR FWD RING BLOCK	X	1

LIST OF MATERIALS

DO NOT SCALE DRAWING INTERPRET DIMENSIONS AND TOLERANCES IN ACCORDANCE WITH ASME Y14.5M-94		THIS DRAWING CREATED IN: ACAD <input type="checkbox"/> MECH <input type="checkbox"/> IDEAS <input checked="" type="checkbox"/>		Steward Observatory, University of Arizona 933 N. Cherry Avenue, Tucson, AZ 85721 (520)621-7659			
TOLERANCES UNLESS OTHERWISE SPECIFIED LINEAR .XX ANGULAR .XXX DIAMETRICAL SEE SPEC S-002		DESIGNED BY: S. MATHEWS DATE: 10/04		CATEGORY: MMT		PROJECT: MAESTRO	
MATERIAL		DRAWN BY: J. BRENNAN CHECKED BY: D. DEAN APPROVED: J. BECHTOLD APPROVED: R. WARNER		DATE: 04/05 04/22/05 04/22/05 04/22/05		TITLE: DEWAR SPPT FTG LWR FRD RING BLOCK ASSEMBLY	
FINISH		14477 MMT-MAESTRO		APPROVED:		PLOT SIZE SCALE: D NA	
ASSEMBLY APPLICATION		NEXT ASSY USED ON		APPROVED:		DRAWING NUMBER: 14803	
CURRENT TIME/DATE/FILE LOCATION:		DRAWING ARCHIVE LOCATION: http://devincl.as.arizona.edu/ccad/default.html		REVISION: C		SHEET 1 OF 1	