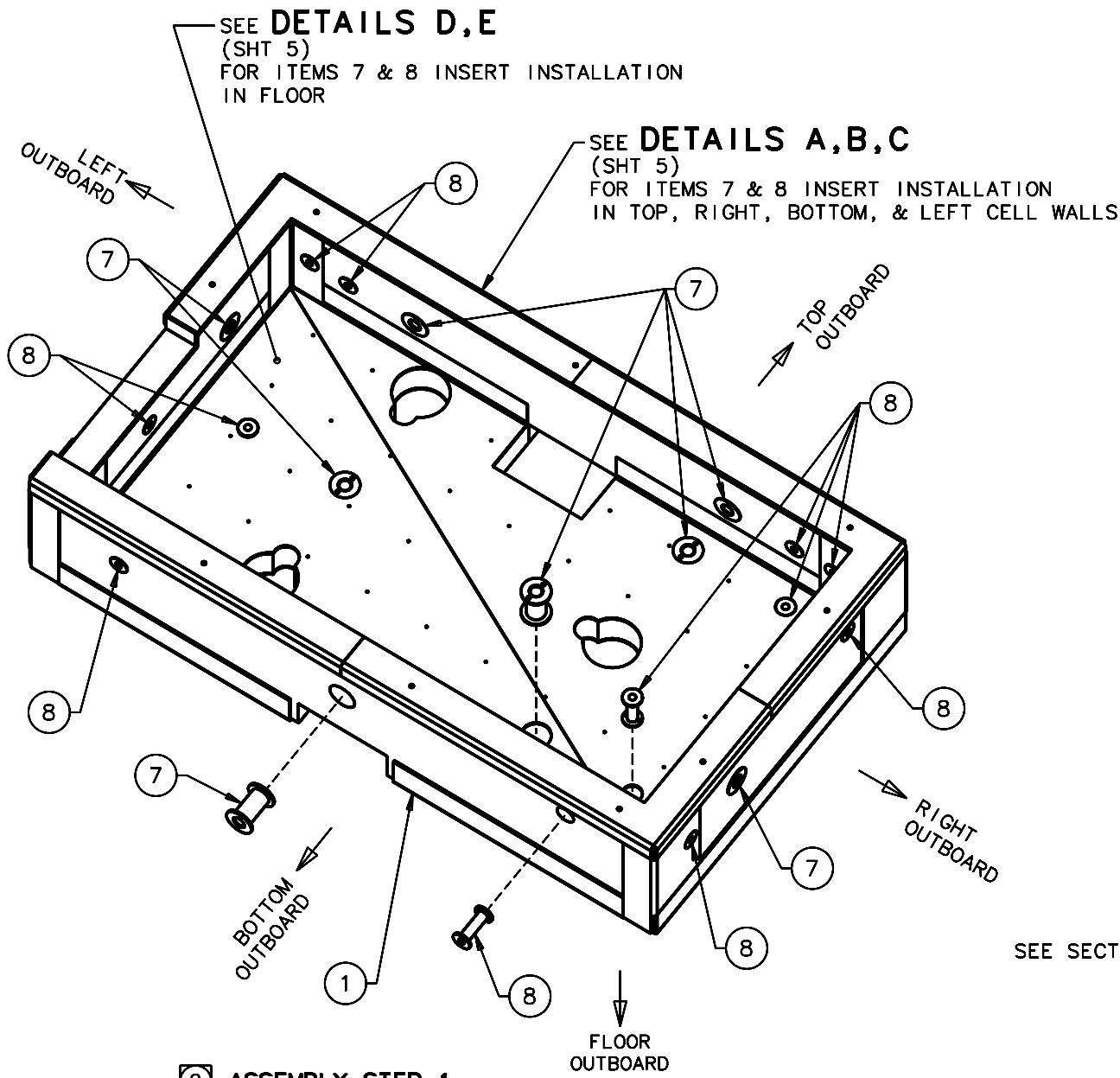
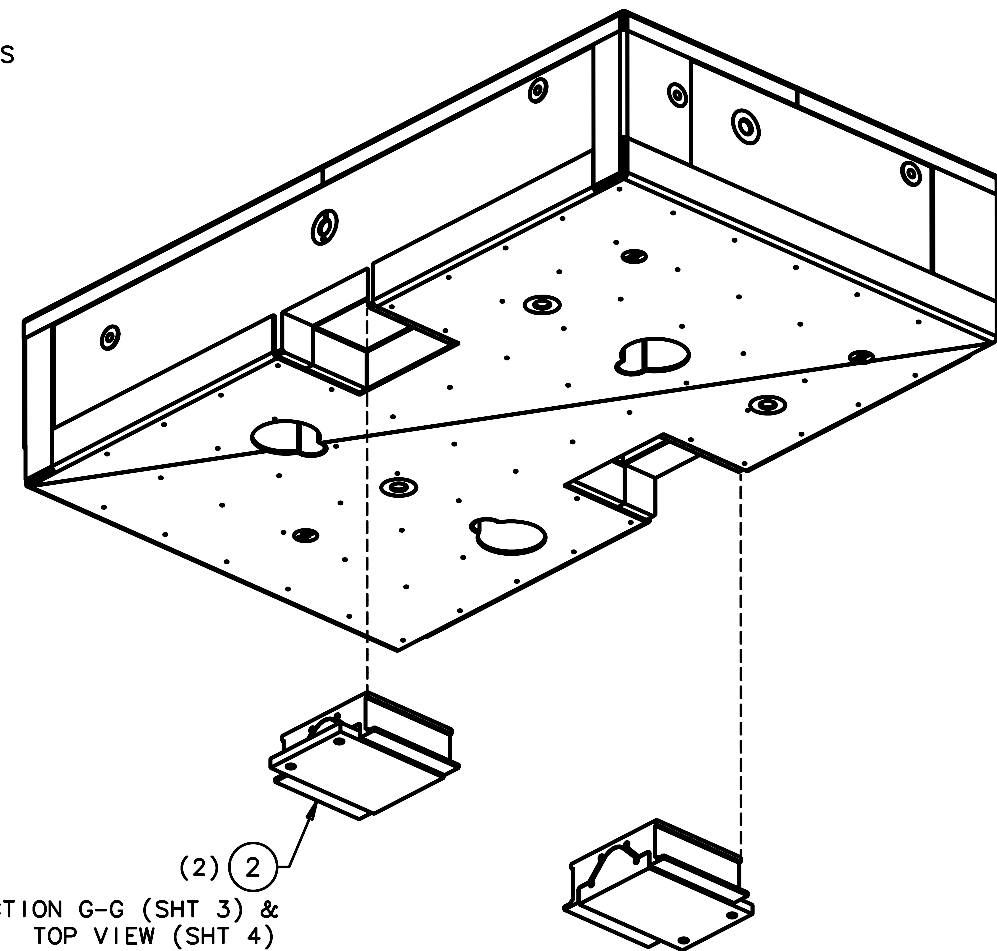


REVISIONS				
LTR	DESCRIPTION	DATE	REVISED BY	APPROVED
A	INITIAL RELEASE	05/11/05	J. BRENNAN	G. LANDIS



2 ASSEMBLY STEP 1



2 ASSEMBLY STEP 2

**ISO VIEWS**

SCALE NTS  
CONTINUED ON SHT 2;  
ADDITIONAL ASSEMBLY VIEWS ON SHT 3

NOTES:

1. REQUIRED DOCUMENTS:
  - A. SP14038 INSERT SPECIFICATION/INSTALLATION FOR MAESTRO COMPOSITE PANEL
2. POT ALL ITEMS IN PLACE USING ITEM 10.
3. SEAL EXPOSED EDGES USING ITEM 11.
4. AFTER ASSEMBLY & SEALING EXPOSED EDGES (SEE COMPLETED ASSEMBLY, SHT 3):  
ALL SURFACES ARE TO BE PRIMED WITH RED OXIDE PRIMER (RUST-OLEUM #7669 OR EQUIVALENT) & THEN PAINTED WITH KEL-GUARD 1700-069 WROUGHT IRON BLACK (NON-GLOSS) OR EQUIVALENT, EXCEPT AS FOLLOWS:  
A. PLUG ALL THREADED & THRU HOLES EXCEPT THOSE WHERE OVERSPRAY IS OKAY.  
B. MASK OFF BOTTOM OF ITEM 2 FLEX BLOCK.
5. TO MAINTAIN INDEXING OF ITEM 2 FLEX BLOCKS TO EACH OTHER & ITEM 3 HUBS TO EACH OTHER WHEN BONDING IN PLACE, FIXTURE AS REQUIRED AT EACH RESPECTIVE ASSEMBLY STEP DURING CURING.

QTY PER ASSY	-3	-2	-1	PART NUMBER	PART DESCRIPTION	MANUFACTURER or MAT'L SPEC	ITEM NO.
				AR	TBD	EPOXY ADHESIVE (FOR SEALING EDGES ONLY)	TBD
				AR	TBD	EPOXY ADHESIVE (FOR POTTING ALL ITEMS)	TBD
							9
				12	NAS1834A31120	INSERT, MOLDED IN, THRU HOLE, $\phi$ .195-.201 HOLE x 1.120 LG, ALUM	8
				8	NAS1833A6N1120	INSERT, MOLDED IN, THREADED, .375-24 UNJF x 1.120 LG, ALUM, NON-LOCKING	7
							6
				1	14188	STEPPER MOTOR SHAFT MOUNT	5
				3	13604	AXIAL ACTUATOR HUB CLOSEOUT	4
				3	13603	AXIAL ACTUATOR HUB	3
				2	13602	FLEX BLOCK	2
				1	13596	STRUCTURAL ASSEMBLY-MACHINED	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 .1 .XX .XXX ANGULAR NA .NA .NA		DESIGNED BY: S. MATHEWS	DATE: 9/14/04	CATEGORY: MMT	
DIAMETRICAL SEE SPEC S-002		DRAWN BY: R. NAGY	11/4/04	PROJECT: MAESTRO	
MATERIAL		CHECKED BY: G. LANDIS	03/21/05	TITLE: GRATING CELL STRUCTURAL ASSEMBLY	
FINISH 3		APPROVED: M. REED	05/11/05	DRAWING NUMBER: 13595	
NEXT ASSY USED ON		APPROVED: J. BECHTOLD	05/11/05	REVISION: A	
ASSEMBLY APPLICATION		APPROVED: R. WARNER	05/11/05	PLOT SIZE SCALE: D -	
CURRENT TIME/DATE/FILE LOCATION:		DRAWING ARCHIVE LOCATION: <a href="http://devinci.as.arizona.edu/ccad/default.html">http://devinci.as.arizona.edu/ccad/default.html</a>		SHEET 1 OF 5	