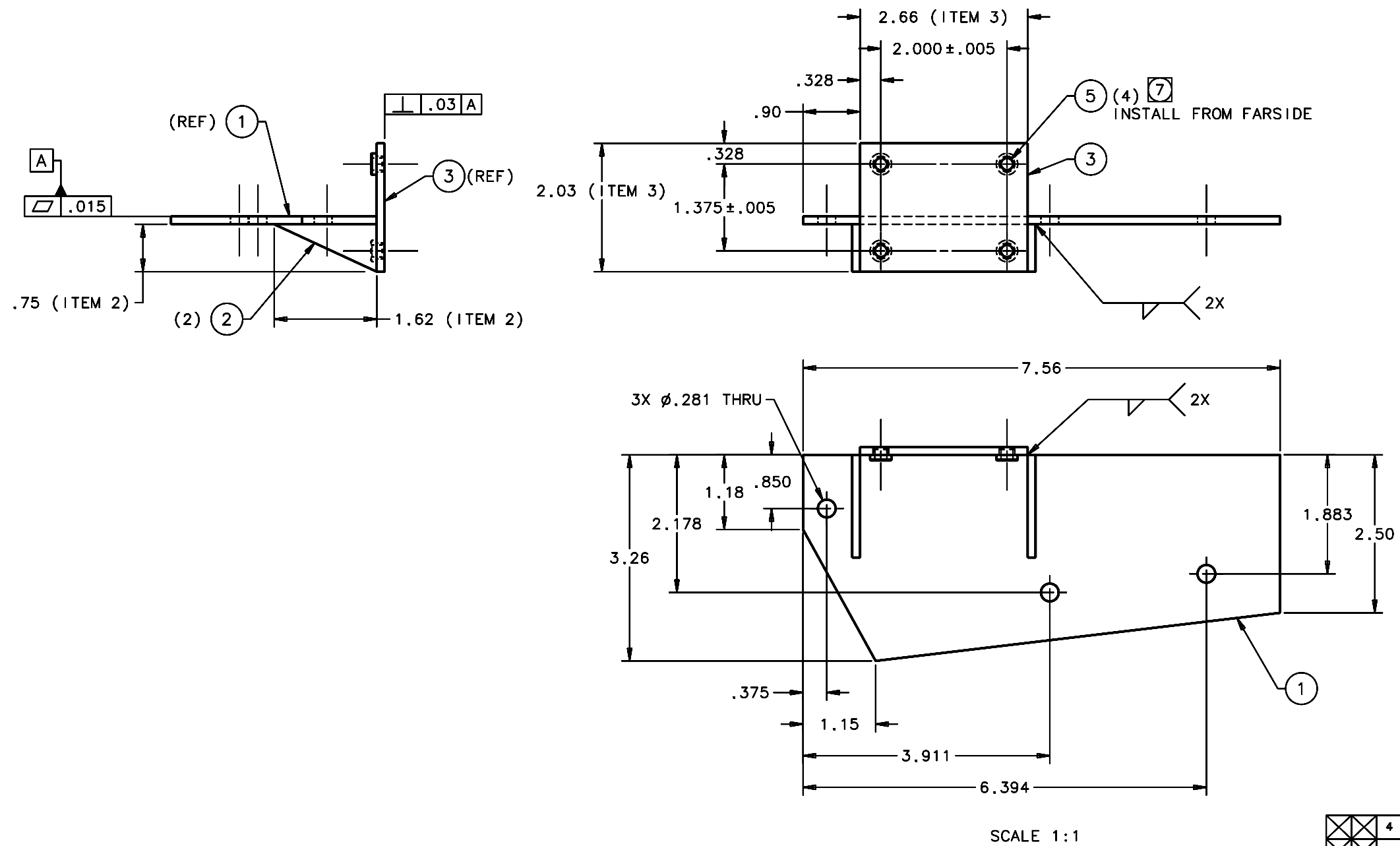


REVISIONS				
LTR	DESCRIPTION	DATE	REVISED BY	APPROVED
A	INITIAL RELEASE	3/22/05	R. NAGY	G. LANDIS



SCALE 1:1

NOTES:

1. BREAK SHARP EDGES & DEBURR.
2. MACHINED SURFACE FINISH TO BE 125 RMS OR BETTER.
3. WELDING REQUIREMENTS: ALL WELDS TO BE GAS TUNGSTEN ARC WELDING (GTAW) WITH INVAR FILLER ROD.
4. HEAT TREATMENT: A. HEAT TREAT AT 315°C FOR 60 MINUTES IN AIR.
B. COOL TO ROOM TEMPERATURE IN AIR.
C. HOLD AT 95°C FOR 49 HOURS IN AIR.
D. COOL TO ROOM TEMPERATURE IN AIR.
- 5 ZINC CHROMATE PER ASTM-B-633-98, TYPE II, GOLD.
6. DIMENSIONS ARE BEFORE ZINC CHROMATE.
- 7 INSTALL INSERTS PER MANUFACTURER'S DIRECTIONS.
8. (1) REQUIRED PER NEXT ASSEMBLY.

QTY PER ASSY	-3	-2	-1	PART NUMBER	PART DESCRIPTION	MANUFACTURER or MAT'L SPEC	ITEM NO.
				4 95185A191	PRESS-IN CAPTIVE NUT, .190-32 x .091 MIN PANEL THK, STL, Zn-PLT	McMASTER-CARR	5
				1 14187-9	MOUNTING PLATE		4
				2 14187-7	GUSSET		3
				1 14187-5	BASE PLATE		2
							1

DO NOT SCALE DRAWING INTERPRET DIMENSIONS AND TOLERANCES IN ACCORDANCE WITH ASME Y14.5M-94		THIS DRAWING CREATED IN: <input type="checkbox"/> ACAD <input type="checkbox"/> MECH <input checked="" type="checkbox"/> IDEAS		Steward Observatory, University of Arizona 933 N. Cherry Avenue, Tucson, AZ 85721 (520)621-7659			
TOLERANCES UNLESS OTHERWISE SPECIFIED LINEAR ANGULAR .X = .04 ±1° .XX = ±.03 .XXX = ±.010 DIAMETRICAL SEE SPEC S-002		DESIGNED BY: D. DEAN DATE: 9/28/04 DRAWN BY: R. NAGY 11/24/04 CHECKED BY: G. LANDIS 3/21/05 APPROVED: M. REED 3/22/05 APPROVED: J. BECHTOLD 3/22/05		CATEGORY: MMT PROJECT: MAESTRO TITLE: GRATING CELL PLATFORM STEPPER MOTOR MOUNT		PLOT SIZE SCALE: D - DRAWING NUMBER: 14187 REVISION: A	
MATERIAL INVAR 36 ALLOY, .125±.015		13718 MMT NEXT ASSY USED ON		CURRENT TIME/DATE/FILE LOCATION: DRAWING ARCHIVE LOCATION: http://devinci.as.arizona.edu/ocad/default.html			
FINISH 5		ASSEMBLY APPLICATION		SHEET 1 OF 1			