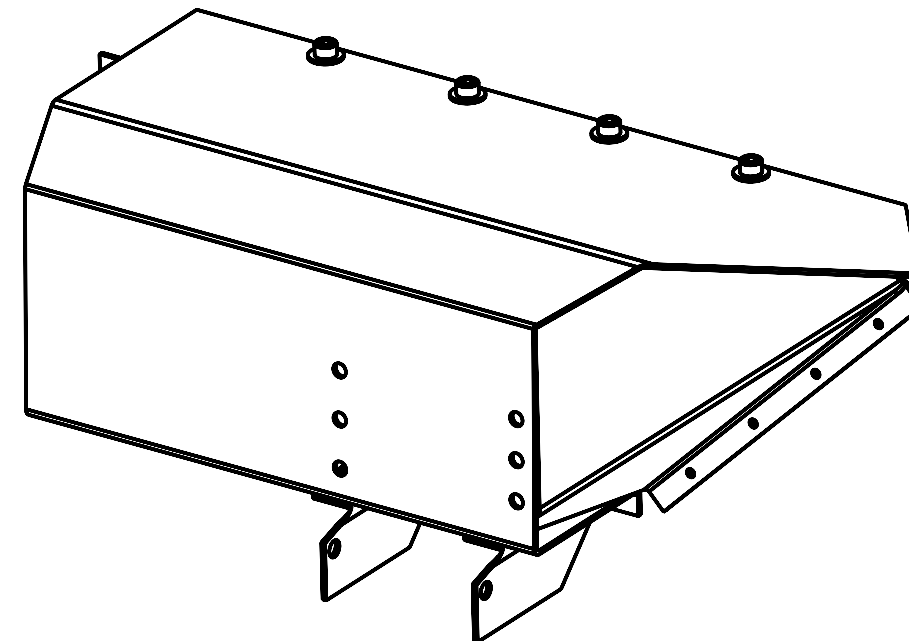
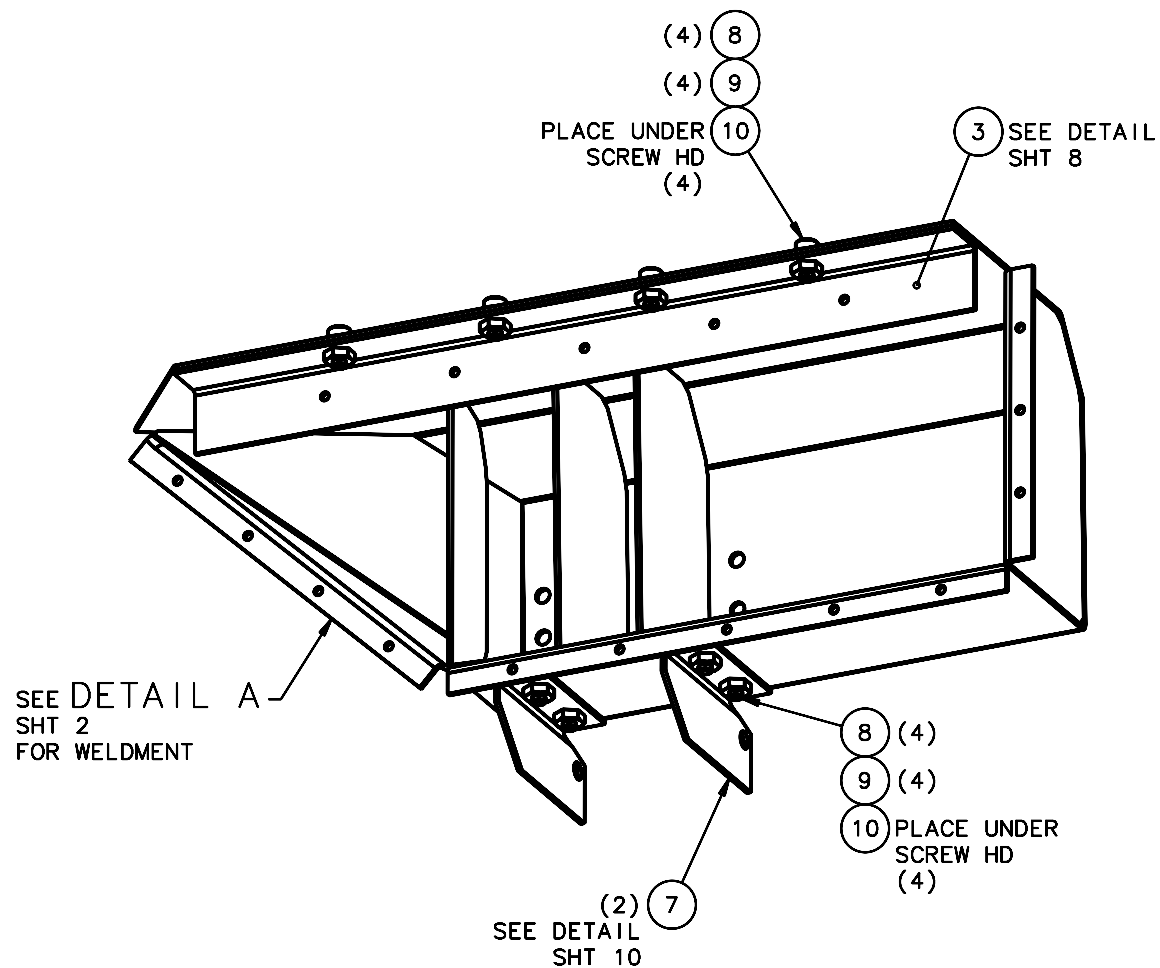


REVISIONS				
LTR	DESCRIPTION	DATE	REVISED BY	APPROVED
A	INITIAL RELEASE	03/29/05	J. BRENNAN	G. LANDIS
B	REVISED NOTE 8; ADDED NOTES 9 & 10	4/18/05	R. NAGY	R. WARNER
C	ADDED FLAT PATTERNS; WAS 20 SHTS (REDUCED VIEW SCALES & COMBINED SEVERAL VIEWS PER SHT); <u>NO</u> DESIGN CHANGES	6/29/05	J. BRENNAN/ R. NAGY	R. WARNER



**ISO VIEWS**  
SCALE NTS  
WELDMENT FABRICATION &  
ADDITIONAL VIEWS ON SHTs 2 THRU 11

NOTES:

- BREAK SHARP EDGES & DEBURR HOLES.
- MACHINED SURFACE FINISH TO BE 125 RMS OR BETTER.
- ZINC CHROMATE PER ASTM-B-633-98, TYPE II, BLACK THE FOLLOWING:
  - WELDMENT PER DETAIL A, SHT 2.
  - ITEMS 3 & 7 BRACKETS.
- DIMENSIONS BEFORE ZINC CHROMATE.
- ALL INSIDE BEND RADII TO BE NO GREATER THAN R.06 WITH BEND RELIEFS AS REQUIRED.
- METHOD OF CONSTRUCTION OPTIONAL.
- WELDS TO BE SKIP WELDS 0.5-1.0 STAGGERED ON EACH SIDE TO MINIMIZE WARPAGE.
- HEAT TREATMENT:
  - HEAT TREAT AT 315°C FOR 60 MINUTES IN AIR.
  - COOL TO ROOM TEMPERATURE IN AIR.
  - HOLD AT 95°C FOR 49 HOURS IN AIR.
  - COOL TO ROOM TEMPERATURE IN AIR.
- OWNER RESPONSIBLE FOR HARDWARE.

QTY PER ASSY	QTY PER ASSY	QTY PER ASSY	PART NUMBER	PART DESCRIPTION	MANUFACTURER of MAT'L SPEC	ITEM NO.
	8	98019A333	WASHER .500 X .036 THK	McMASTER CARR	10	
	8	92196A240	.190-24 UNC X .375 SHCS	McMASTER CARR	9	
	8	91841A011	.190-24 UNC HEX NUT	McMASTER CARR	8	
	2	14267-17	INJECTION OPTICS MOUNTING BOX PLATE 7		7	
	1	14267-15	INJECTION OPTICS MOUNTING BOX PLATE 6		6	
	2	14267-13	INJECTION OPTICS MOUNTING BOX PLATE 5		5	
	1	14267-11	INJECTION OPTICS MOUNTING BOX PLATE 4		4	
	1	14267-9	INJECTION OPTICS MOUNTING BOX PLATE 3		3	
	1	14267-7	INJECTION OPTICS MOUNTING BOX PLATE 2		2	
	1	14267-5	INJECTION OPTICS MOUNTING BOX PLATE 1		1	

DO NOT SCALE DRAWING	THIS DRAWING CREATED IN:			Steward Observatory, University of Arizona 933 N. Cherry Avenue, Tucson, AZ 85721 (520)621-7659			
INTERPRET DIMENSIONS AND TOLERANCES IN ACCORDANCE WITH ASME Y14.5M-94	ACAD <input type="checkbox"/>	MECH <input type="checkbox"/>	IDEAS <input checked="" type="checkbox"/>	DESIGNED BY: D. DEAN	DATE: 10/27/04	CATEGORY: MMT	
TOLERANCES UNLESS OTHERWISE SPECIFIED LINEAR .X = NA .XX = ±.03 .XXX = ±.010 ANGULAR ± 1° DIAMETRICAL SEE SPEC S-002				DRAWN BY: R. ABALDO	10/27/04	PROJECT: MAESTRO	
				CHECKED BY: G. LANDIS	10/27/04	TITLE: INJECTION OPTICS MOUNTING BOX	
				APPROVED: M. REED	10/27/04		
MATERIAL INVAR 36 ALLOY, 16 B.G. (.0625)	14269	MMT-MAESTRO	APPROVED:			PLOT SIZE SCALE: D -	DRAWING NUMBER: 14267
FINISH <b>3</b>	NEXT ASSY	USED ON	APPROVED:				REVISION: C
ASSEMBLY APPLICATION	CURRENT TIME/DATE/FILE LOCATION:				DRAWING ARCHIVE LOCATION: <a href="http://dovinc1.es.arizona.edu/ocod/default.html">http://dovinc1.es.arizona.edu/ocod/default.html</a>		

LAST LETTER USED: F