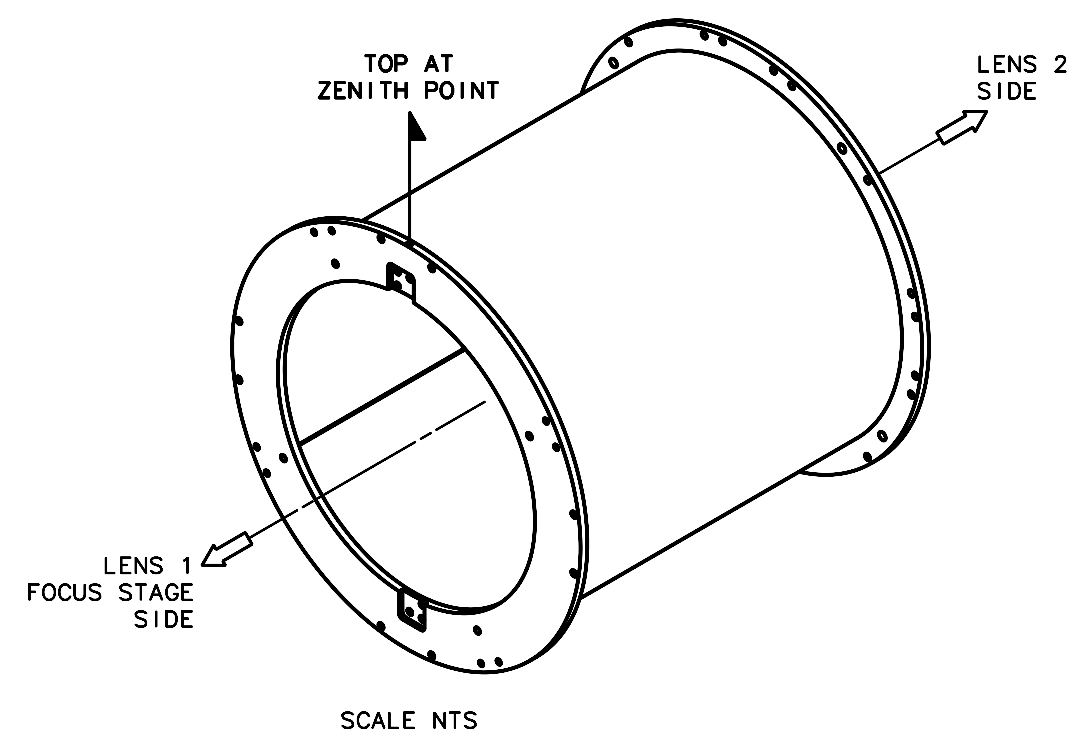
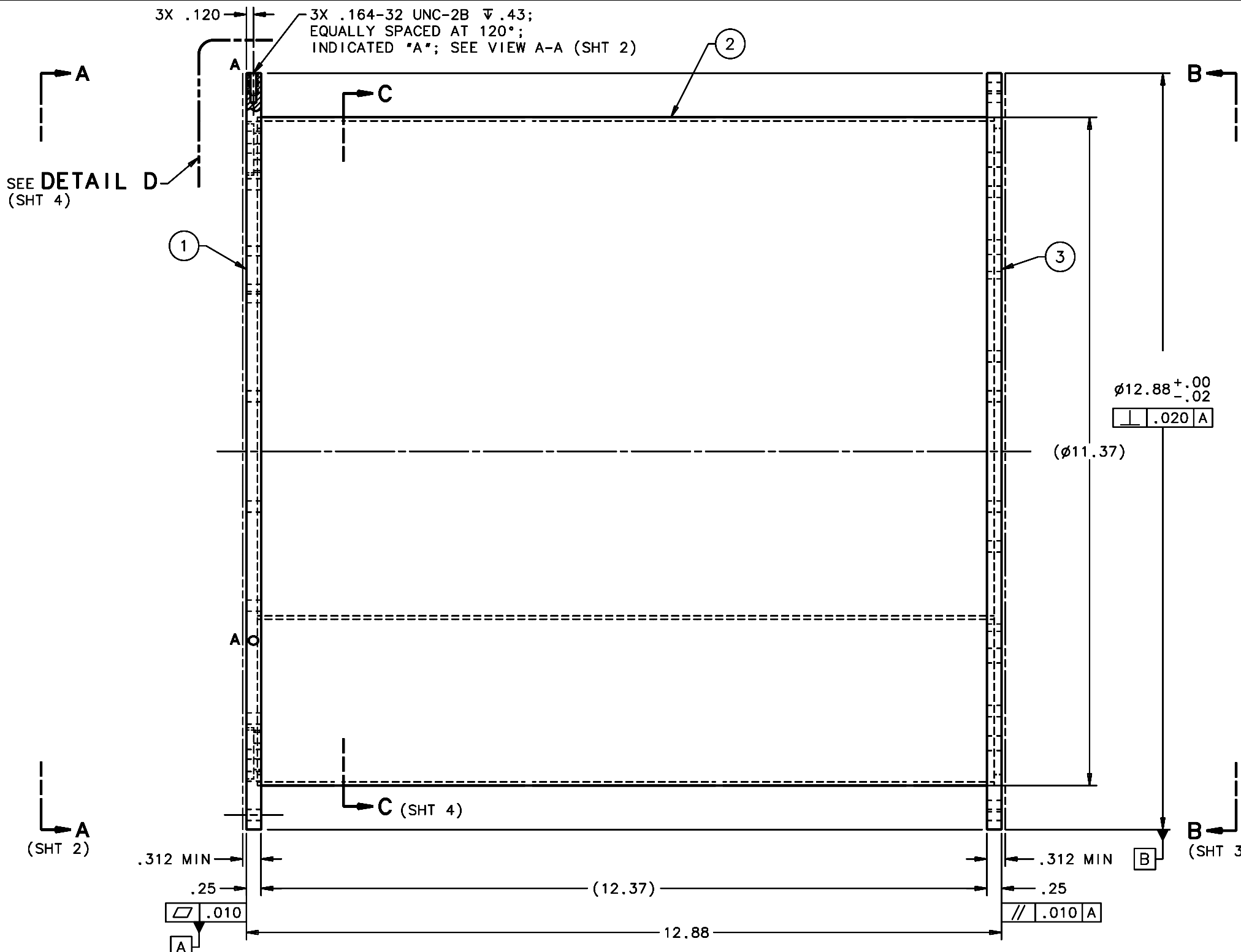


REVISIONS				
LTR	DESCRIPTION	DATE	REVISED BY	APPROVED
A	INITIAL RELEASE	8/17/04	R. NAGY	G. LANDIS
B	SHT 1 ONLY (SHTs 2-4 REMAIN AT REV A): .25, (12.37) WAS (.25), 12.37+.01/-00 [VENDOR REQUEST; NOT A DESIGN CHANGE]	12/15/04	R. NAGY	G. LANDIS



- NOTES:
- BREAK SHARP EDGES & DEBURR.
 - MACHINED SURFACE FINISH TO BE 125 RMS OR BETTER.
 - MACHINED FILLETS TO BE R.015 MAX UNLESS OTHERWISE SPECIFIED.
 - WELDING REQUIREMENTS: A. SEE SECTION C-C (SHT 4) & DETAIL D (SHT 4) FOR WELD CALLOUTS.
B. ALL WELDS TO BE GAS TUNGSTEN ARC WELDING (GTAW) WITH INVAR FILLER ROD.
 - 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.
 - ZINC CHROMATE PER ASTM-B-633-98, TYPE II, BLACK. PLUG ALL THREADED HOLES.
 - DIMENSIONS ARE PRIOR TO ZINC CHROMATE.

QTY PER ASSY	PART NUMBER	PART DESCRIPTION	MANUFACTURER of MAT'L SPEC	ITEM NO.
1	13197-3	REAR FLANGE	-	3
1	13197-2	SHELL	.06-.0625 STK	2
1	13197-1	FRONT FLANGE	-	1

DO NOT SCALE DRAWING		THIS DRAWING CREATED IN:		Steward Observatory, University of Arizona	
INTERPRET DIMENSIONS AND TOLERANCES IN ACCORDANCE WITH ASME Y14.5M-94		ACAD	MECH	IDEAS	933 N. Cherry Avenue, Tucson, AZ 85721 (520)621-7659
TOLERANCES UNLESS OTHERWISE SPECIFIED		<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	DESIGNED BY: D. DEAN DATE: 11/19/03 CATEGORY: MMT
LINEAR				DRAWN BY: R. NAGY 12/15/03 PROJECT: MAESTRO	
ANGULAR ± 1°				CHECKED BY: G. LANDIS 8/17/04 TITLE: LENS CAN-LENS 1 STAGE LENS 1 TO 2 SPOOL WELDMENT	
.X = ±.01				APPROVED: S. MATHEWS 8/17/04	
.XX = ±.005				APPROVED: M. REED 8/17/04	
DIAMETRICAL SEE SPEC S-002				APPROVED: J. BECHTOLD 8/17/04	
MATERIAL INVAR 36 ALLOY		13560	MMT	PLOT SIZE SCALE: D -	DRAWING NUMBER: 13197
FINISH 6		NEXT ASSY	USED ON	REVISION: B	
ASSEMBLY APPLICATION		CURRENT TIME/DATE/FILE LOCATION:			SHEET 1 OF 4
DRAWING ARCHIVE LOCATION: http://dovinci.as.arizona.edu/ocod/default.html					