NOTES:
POSITION INDEX ON THICK EDGE OF PRISM
+ . .25" ON CIRCUMFERENCE
PERPENDICULAR TO FLAT SURFACE + .005"
BOND PER PROCEDURE ON SHEET 2.

TOLERANCES UNLESS OTHERWISE NOTED:
FRACTIONAL:       0"-6": ±1/64"       6"-24": ±1/32"
24"+: ±1/16"
DECIMAL:        X.X:  ±0.1000"            X.XX:  ±0.0100"
X.XXX:  ±0.0050"       X.XXXX:  ±0.0001"
ANGLES:  ±0.5°     FINISH: 125 MICRO INCHES
BREAK ALL SHARP EDGES & CORNERS 1/64" MAX

Parts List

<table>
<thead>
<tr>
<th>ITEM</th>
<th>QTY</th>
<th>PART NUMBER</th>
<th>DESCRIPTION</th>
</tr>
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<tr>
<td>1</td>
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<td>A2010</td>
<td>OPTIC, ADC</td>
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<tr>
<td>2</td>
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<td>A2014</td>
<td>INDEX, OPTIC</td>
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NOTES:
POSITION INDEX ON THICK EDGE OF PRISM
+ . .25" ON CIRCUMFERENCE
PERPENDICULAR TO FLAT SURFACE + .005"
BOND PER PROCEDURE ON SHEET 2.
CLEANING PROCEDURE - INVAR:
ACETONE WASH, BEADBLAST, DRY NITROGEN CLEAN AND ALCOHOL RINSE.

CLEANING PROCEDURE - FUSED SILICA:
3-DAY AMMONIUM BIFLOURIDE ETCH, WATER RINSE AND ALCOHOL RINSE.

GLUEING PROCEDURE:
A: HYDOL EA9313 MIXED 4:1 BY VOLUME IN A CLEAN PLASTIC CONTAINER
B: CURE TIME IS 5 DAYS AND 75°F.
1. GLUE GAP IS TO BE 0.010" THICK.
2. USE TEFAG SPACERS AND GUIDES TO POSITION AND MAINTAIN GAP DURING CURING.
3. REFERENCE: KECK OBSERVATORY PM55 BY ANDY DUBOIS, DATED 11-26-90, "EPOXY BONDS AFOR SEGMENT INSERTS."
4. SOLVENT FOR CURED EPOXY IS METHYLENE CHLORIDE
5. INSPECT GLUE JOINT FOR BUBBLES BY OBSERVING THROUGH SURFACE OF PRISM.
6. DEXTER HYDOL EA9313 EPOXY RESIN

VENDOR: EV ROBERTS & ASSOCIATES
8500 STELLER
CULVER CITY, CA 90232
(213) 870-9561

PROPERTIES:
1. POT LIFE 60 MIN.
2. TENSILE STRENGTH 6300 PSI
3. SHEAR STRENGTH 4000 PSI
4. USEABLE TEMPERATURE RANGE: ROOM TEMP TO -40°F.
5. HUMIDITY AND CONDENSATION TOLERANT
6. 5 DAY CURE AT 75°F.