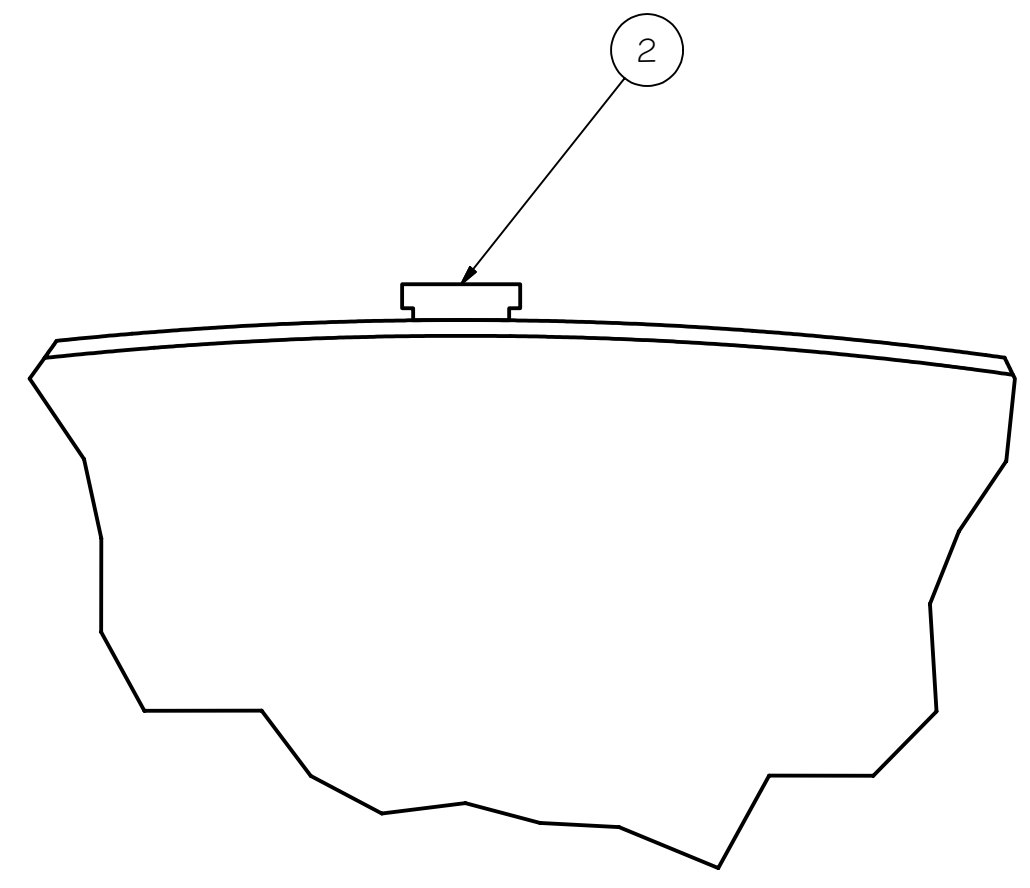
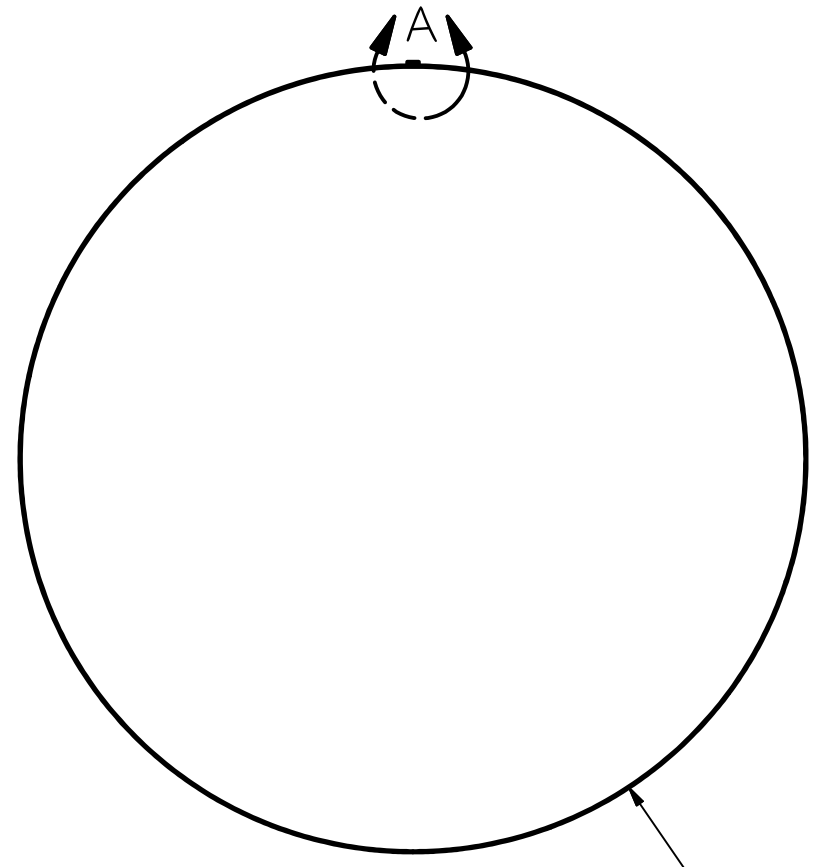


REV	DRWN	CHK'D	DATE	DESCRIPTION
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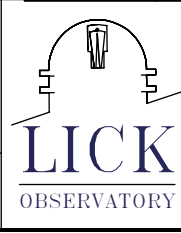


DETAIL A
SCALE 1 : 1

NOTES:
 POSITION INDEX ON THICK EDGE OF PRISM
 +/- .25" ON CIRCUMFERENCE
 PERPENDICULAR TO FLAT SURFACE +/-0.005"
 BOND PER PROCEDURE ON SHEET 2.

Parts List			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	A2010	OPTIC, ADC
2	1	A2014	INDEX, OPTIC

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



DRAWN: vernon 9/4/2003
 CHECKED: _____
 DESIGNED: vernon
 ENGINEER: vernon

Cassegrain ADC
 TITLE: OPTIC ASSEMBLY
 PROJECT CODE: A2001
 DWG NO: A2012
 REV: A
 1/2

QTY: 1

4

3

2

1

REV	DRWN	CHK'D	DATE	DESCRIPTION
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CLEANING PROCEDURE - INVAR:
 ACETONE WASH, BEADBLAST, DRY NITROGEN CLEAN AND ALCOHOL RINSE.

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

GLUEING PROCEDURE:

A: HYSOL EA93 I 3 MIXED 4: 1 BY VOLUME IN A CLEAN PLASTIC CONTAINER

B: CURE TIME IS 5 DAYS AND 75°F.

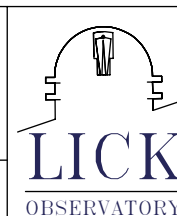
1. GLUE GAP IS TO BE 0.010" THICK
2. USE TEFLON SPACERS AND GUIDES TO POSITION AND MAINTAIN GAP DURING CURING.
3. REFERENCE: KECK OBSERVATORY PMSS BY ANDY DUBOIS, DATED 11-26-90, "EPOXY BONDS AFOR SEGMENT INSERTS."
4. SOLVENT FOR CURED EPOXY IS METHYLENE CHLORIDE.
5. INSPECT GLUE JOINT FOR BUBBLES BY OBSERVING THROUGH SURFACE OF PRISM.
6. DEXTER HYSOL AE93 I 3 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.

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



DRAWN	vernon	9/4/2003
CHECKED		
DESIGNED	vernon	
ENGINEER	vernon	

Cassegrain ADC

TITLE	OPTIC ASSEMBLY
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MATERIAL	FINISH	PROJECT CODE	DWG NO	REV
		A2001	A2012	A
				2/2

4

3

2

1

B

B

A

A