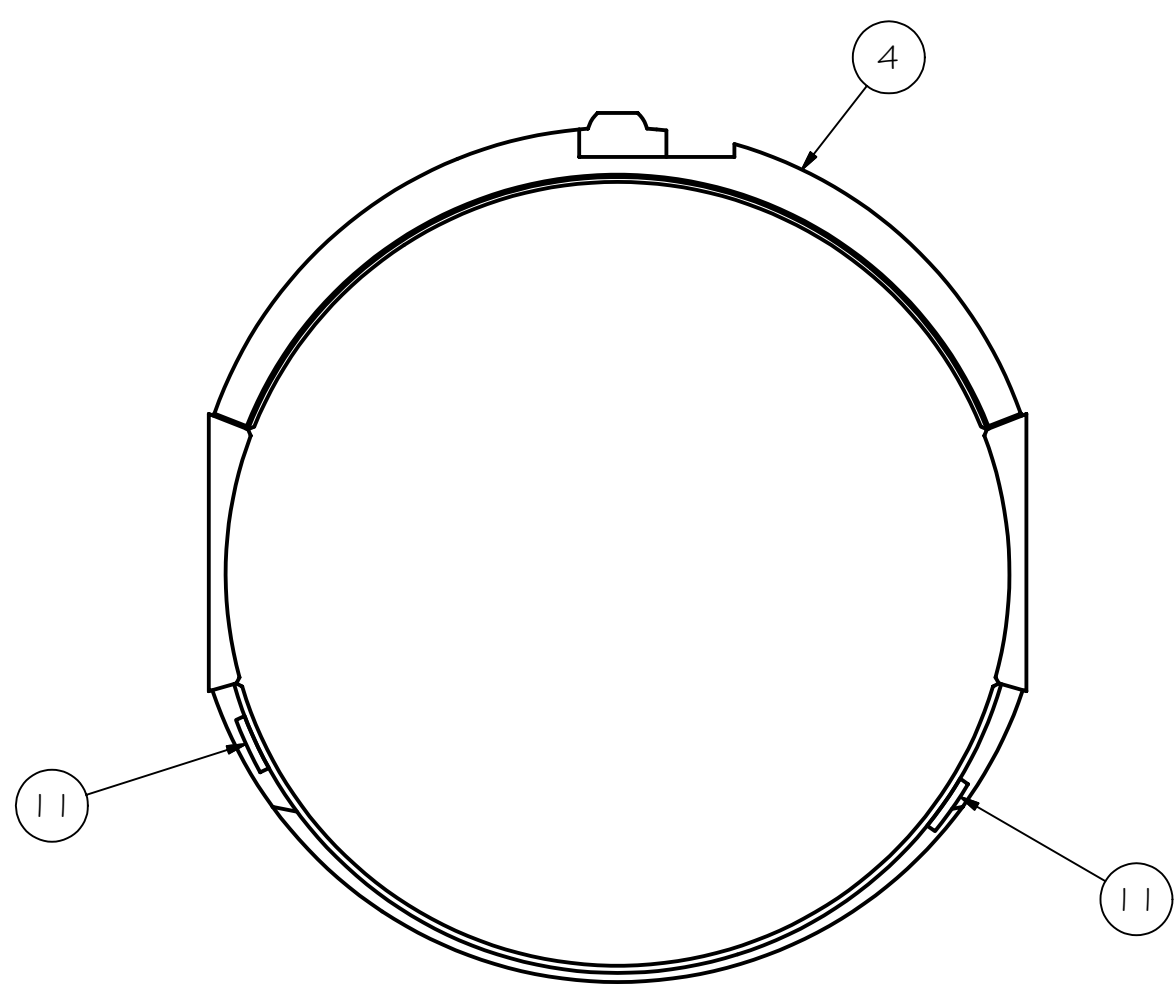
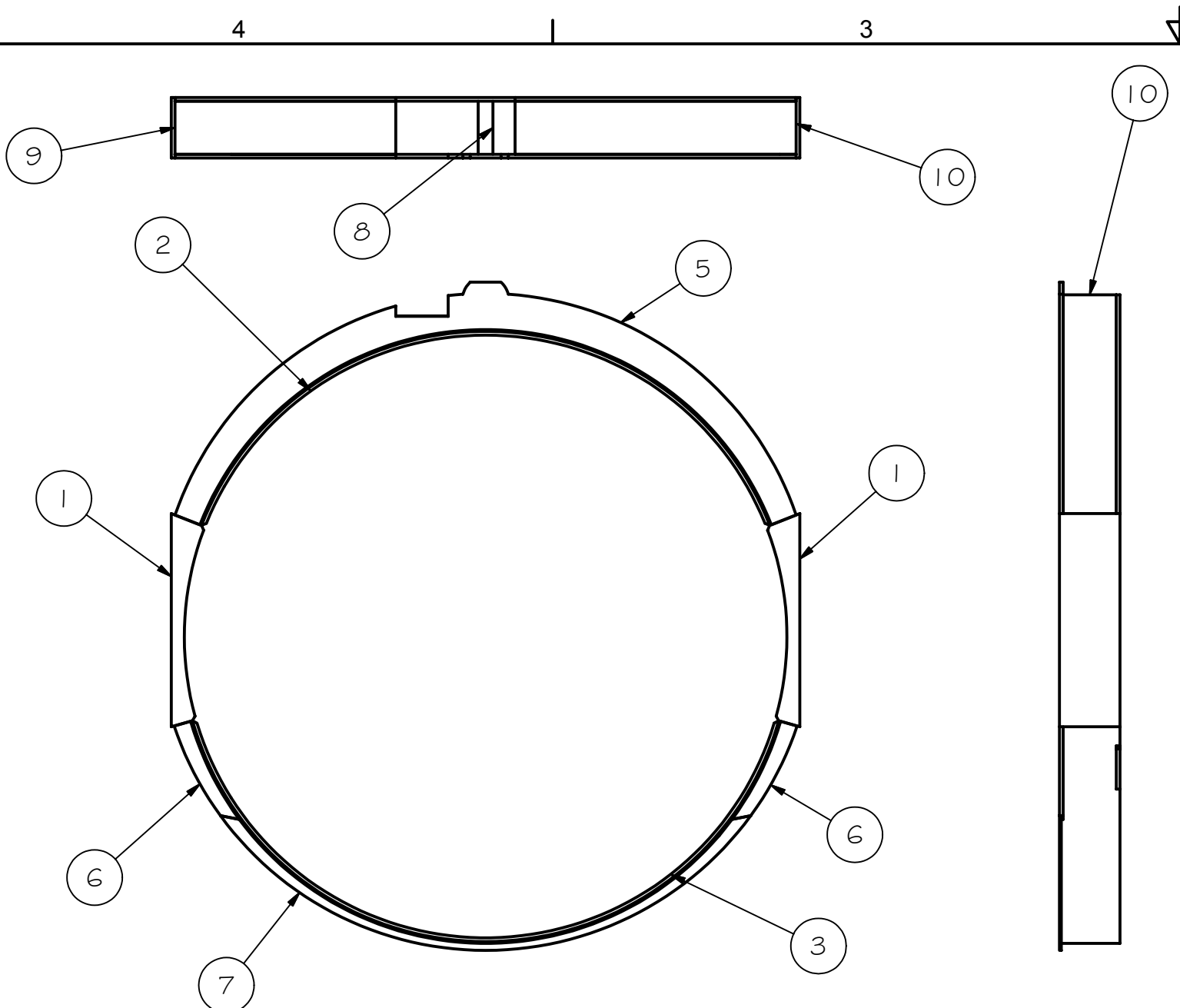


REV	DRWN	CHK'D	DATE	DESCRIPTION
B	VRW	VRW	12/17/04	CHANGE BALL SCREW MOUNT, ADD HOLES, REDRAW
C	VRW	VRW	1/21/05	CHANGE HOLE DIMENSIONS (SH 5)
D	VRW	VRW	2/1/05	CHANGE CLEARANCE HOLES (SH5)
E	VRW	VRW	5/25/05	INCREASE BORE DIAMETER BY .040"



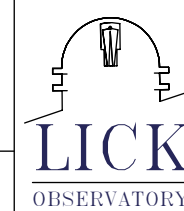
Parts List			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	A2032	SIDE BLOCK, AFT
2	1	A2033	LOWER CYLINDER, AFT
3	1	A2034	UPPER CYLINDER, AFT
4	1	A2035	FLANGE, LOWER, AFT
5	1	A2036	FLANGE, DRIVE, AFT
6	2	A2037	FLANGE, SHORT, AFT
7	1	A2038	FLANGE, THIN, AFT
8	1	A2039	STIFFENER, AFT
9	1	A2029	CYLINDER, OUTER, AFT
10	1	A2031	CYLINDER, OUTER, AFT
11	2	A2043	AXIAL CLAMP BRACKET, AFT

WELDMENT VIEW: STRESS RELIEVE BEFORE FINAL MACHINING



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

MATERIAL FINISH

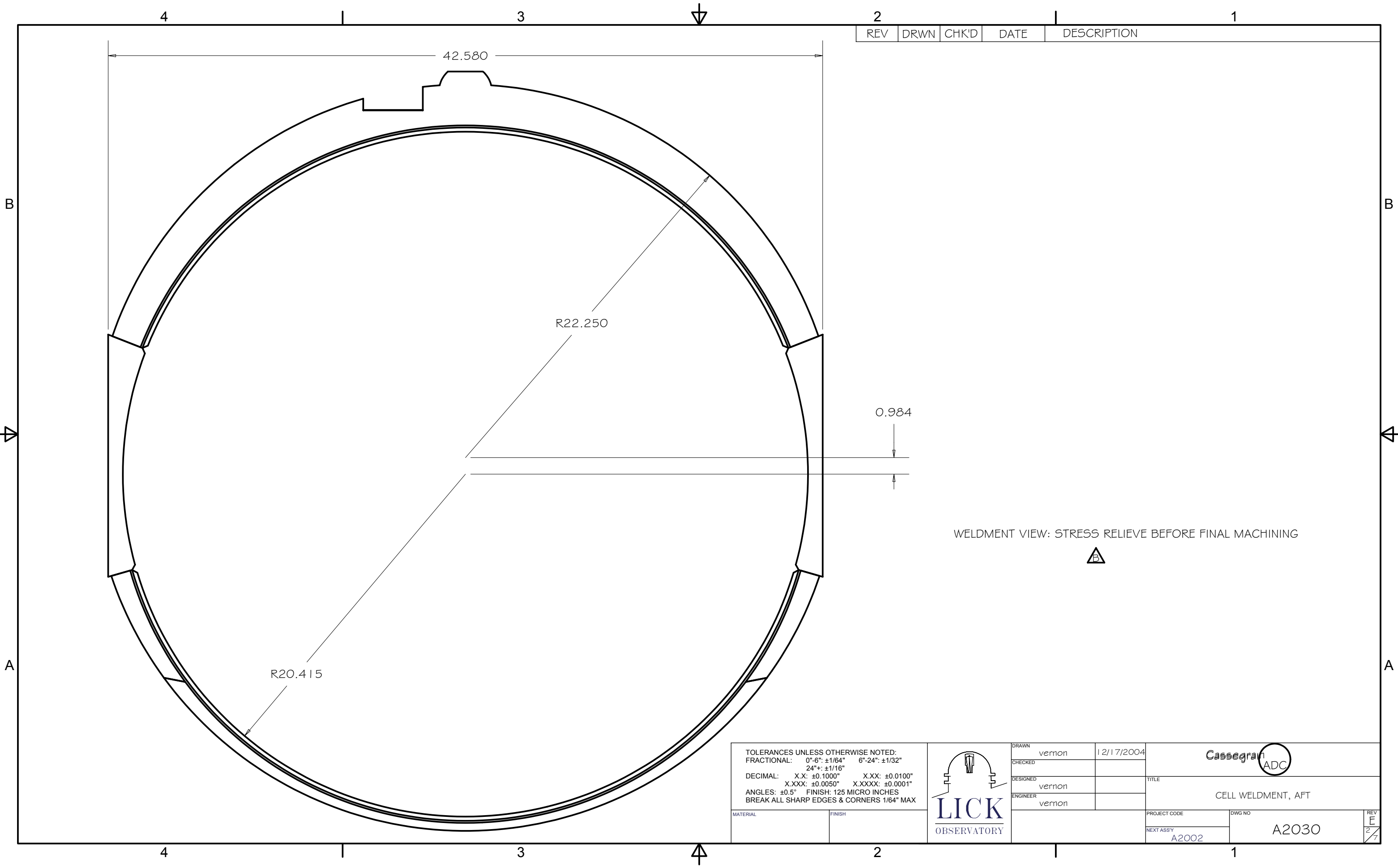


DRAWN: vernon 12/17/2004
 CHECKED: _____
 DESIGNED: vernon
 ENGINEER: vernon

QTY: 1

Cassegrain ADC
 TITLE: CELL WELDMENT, AFT
 PROJECT CODE: A2002
 DWG NO: A2030
 REV: E
 DATE: 1/7

REV	DRWN	CHK'D	DATE	DESCRIPTION
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WELDMENT VIEW: STRESS RELIEVE BEFORE FINAL MACHINING



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	
MATERIAL	FINISH



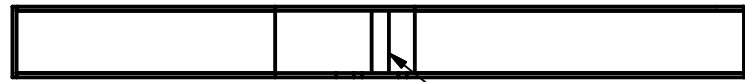
DRAWN	vernon	12/17/2004
CHECKED		
DESIGNED	vernon	
ENGINEER	vernon	

PROJECT CODE		DWG NO	REV
NEXT ASSY		A2030	E
A2002			2/7

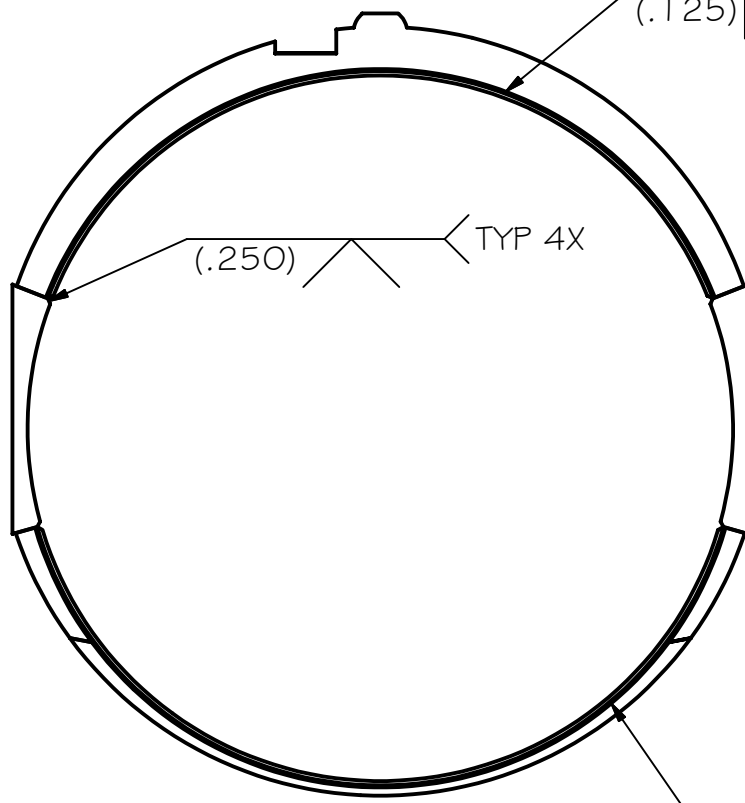
Cassegrain ADC

CELL WELDMENT, AFT

REV	DRWN	CHK'D	DATE	DESCRIPTION



.125
|.125|



(.250) TYP 4X

SCALE 0.09 : 1

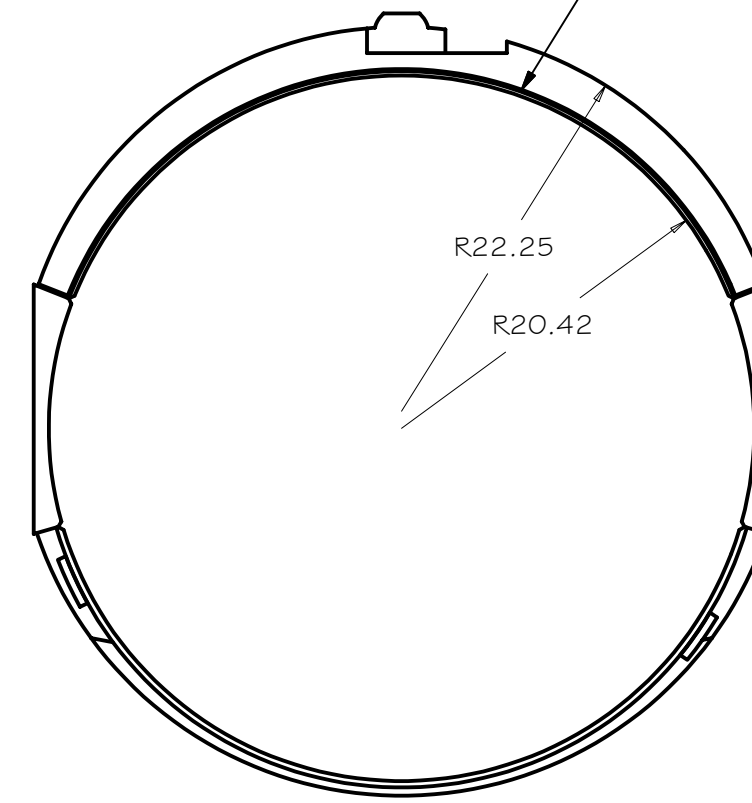


(.125)

(.125)

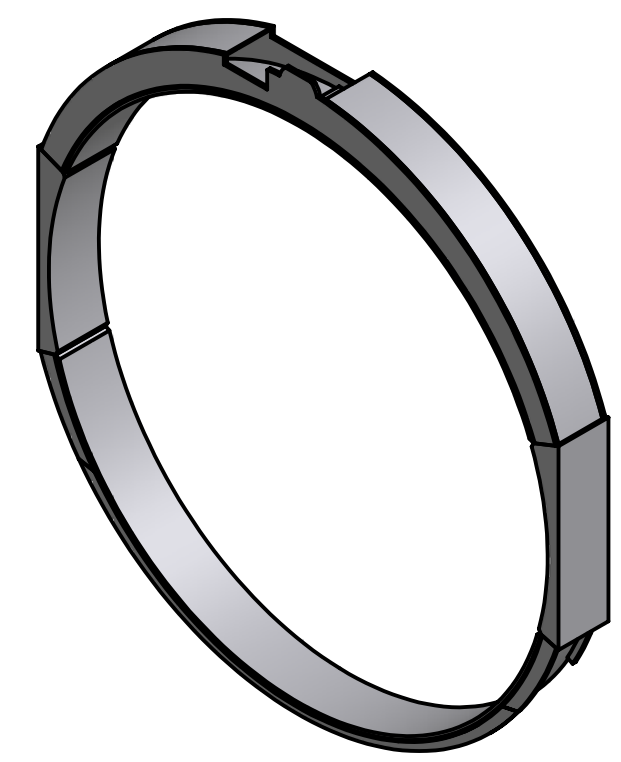
4.10

(.125)
|.125| 1-2



R22.25
R20.42

.125
|.125| 1-2



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



DRAWN	vernon	12/17/2004
CHECKED		
DESIGNED	vernon	
ENGINEER	vernon	

PROJECT CODE		DWG NO	REV
NEXT ASSY		A2030	E
A2002			3/7

Cassegrain ADC

CELL WELDMENT, AFT

B

B

A

A

4

3

2

1

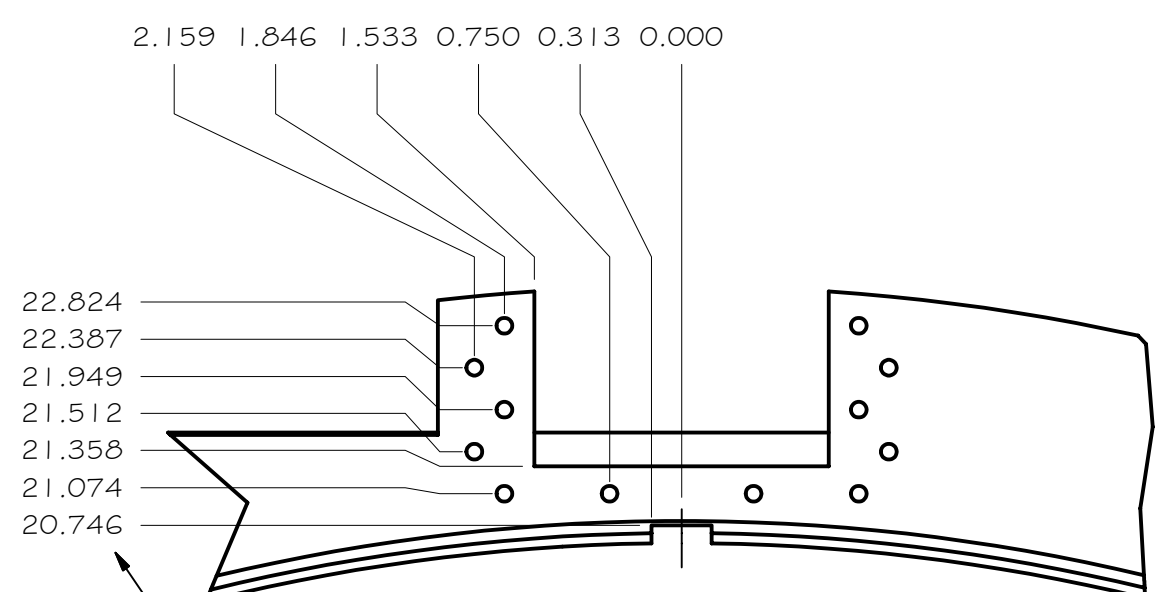
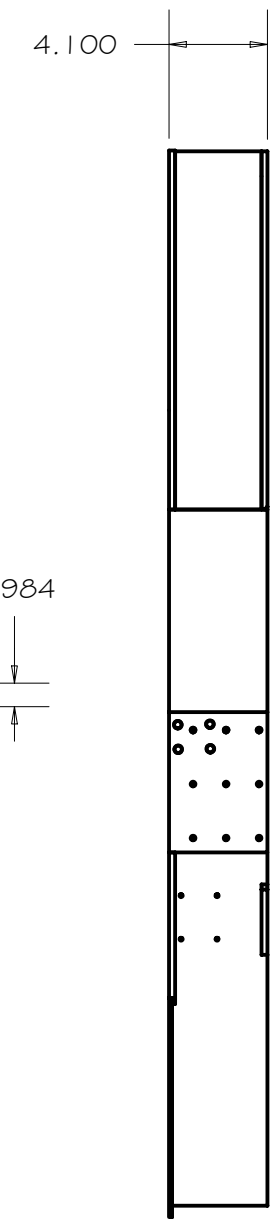
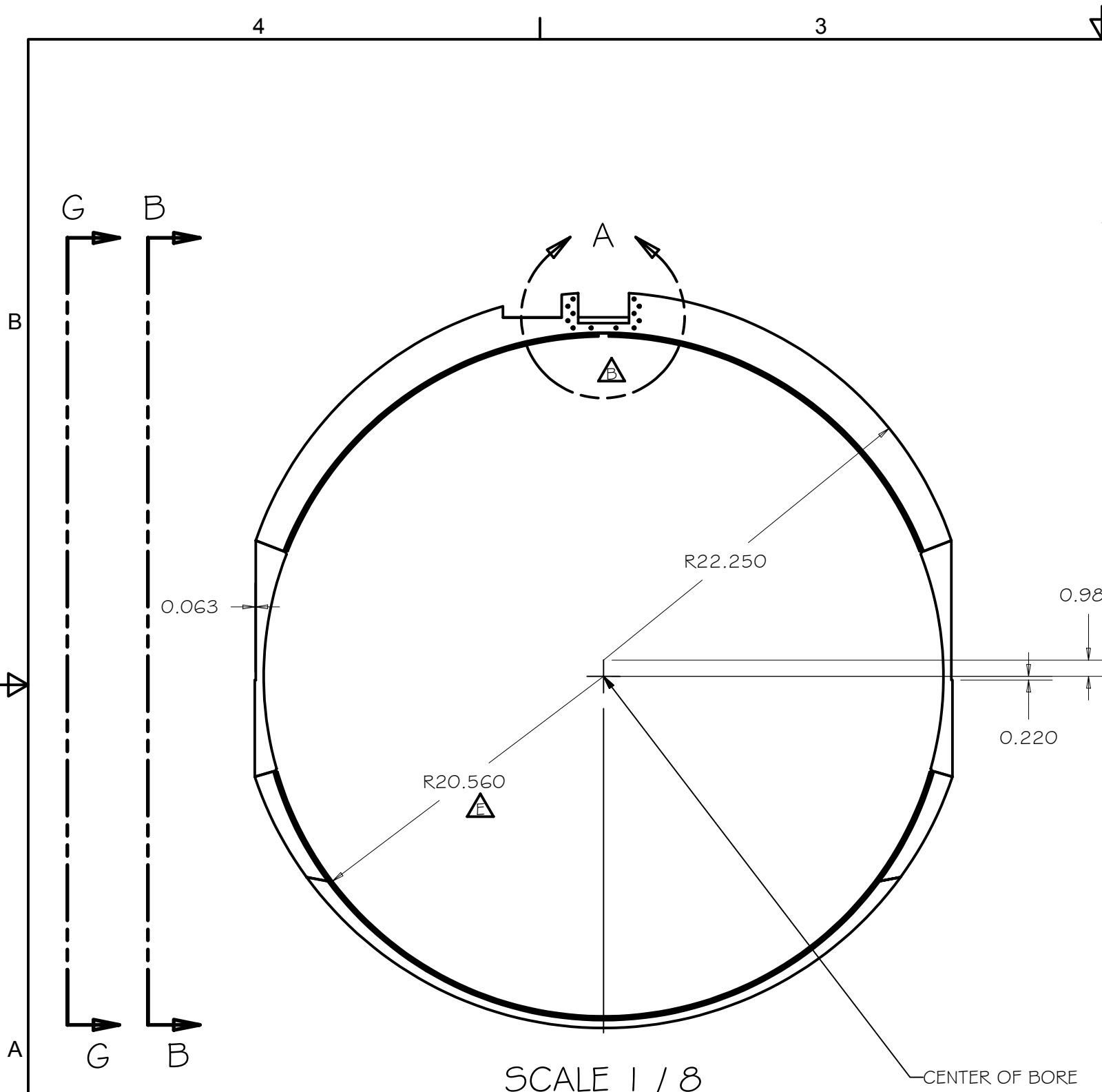
4

3

2

1

REV	DRWN	CHK'D	DATE	DESCRIPTION



DETAIL A
SCALE 1 / 2

FINAL MACHINING AFTER STRESS RELIEVE

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



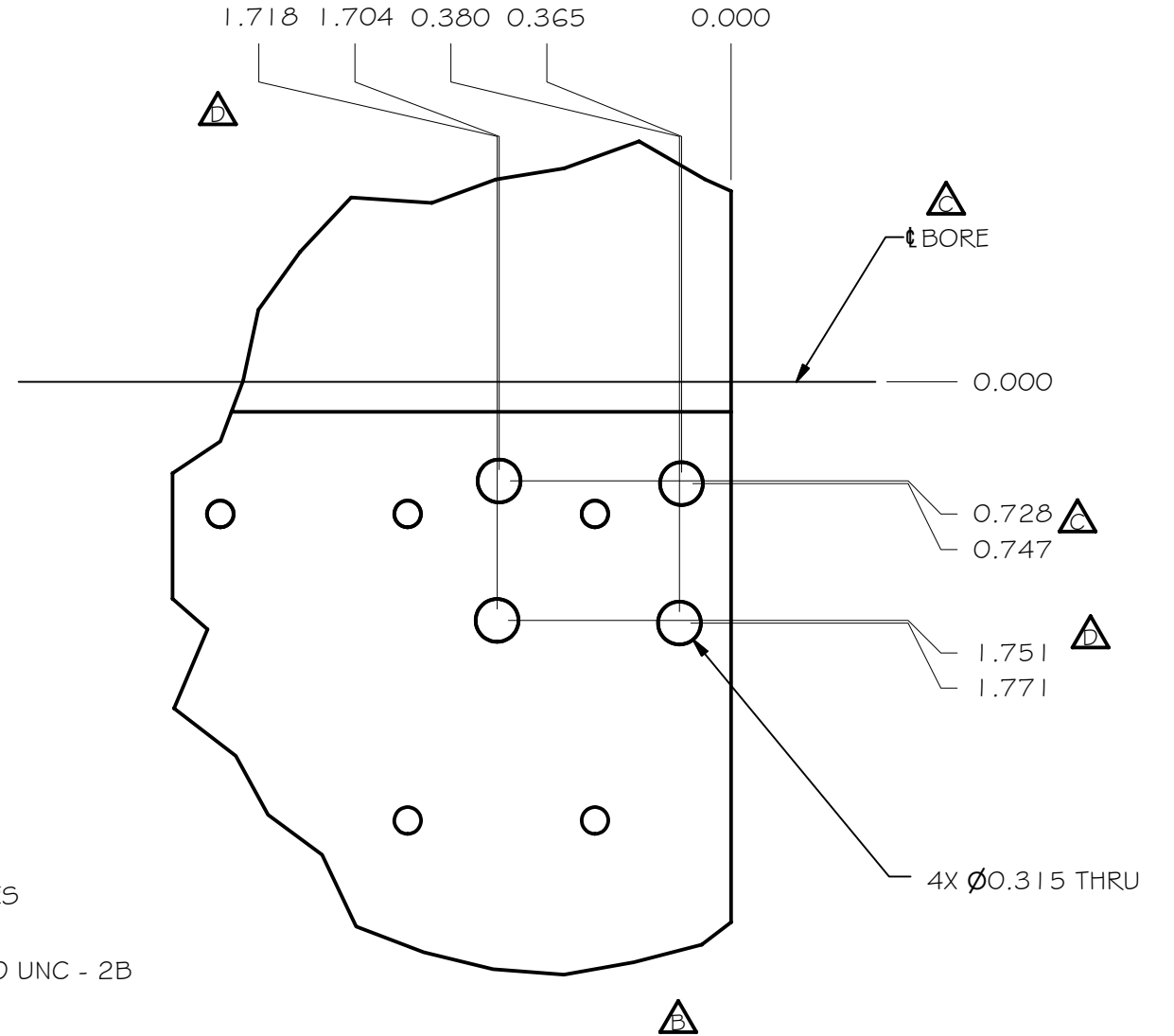
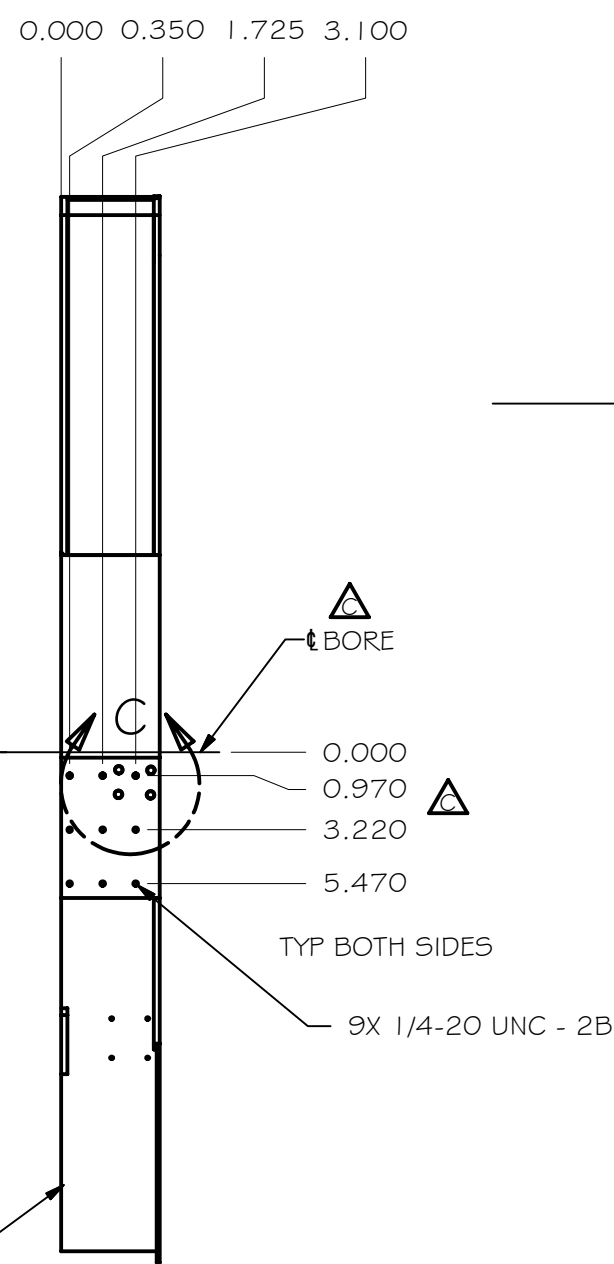
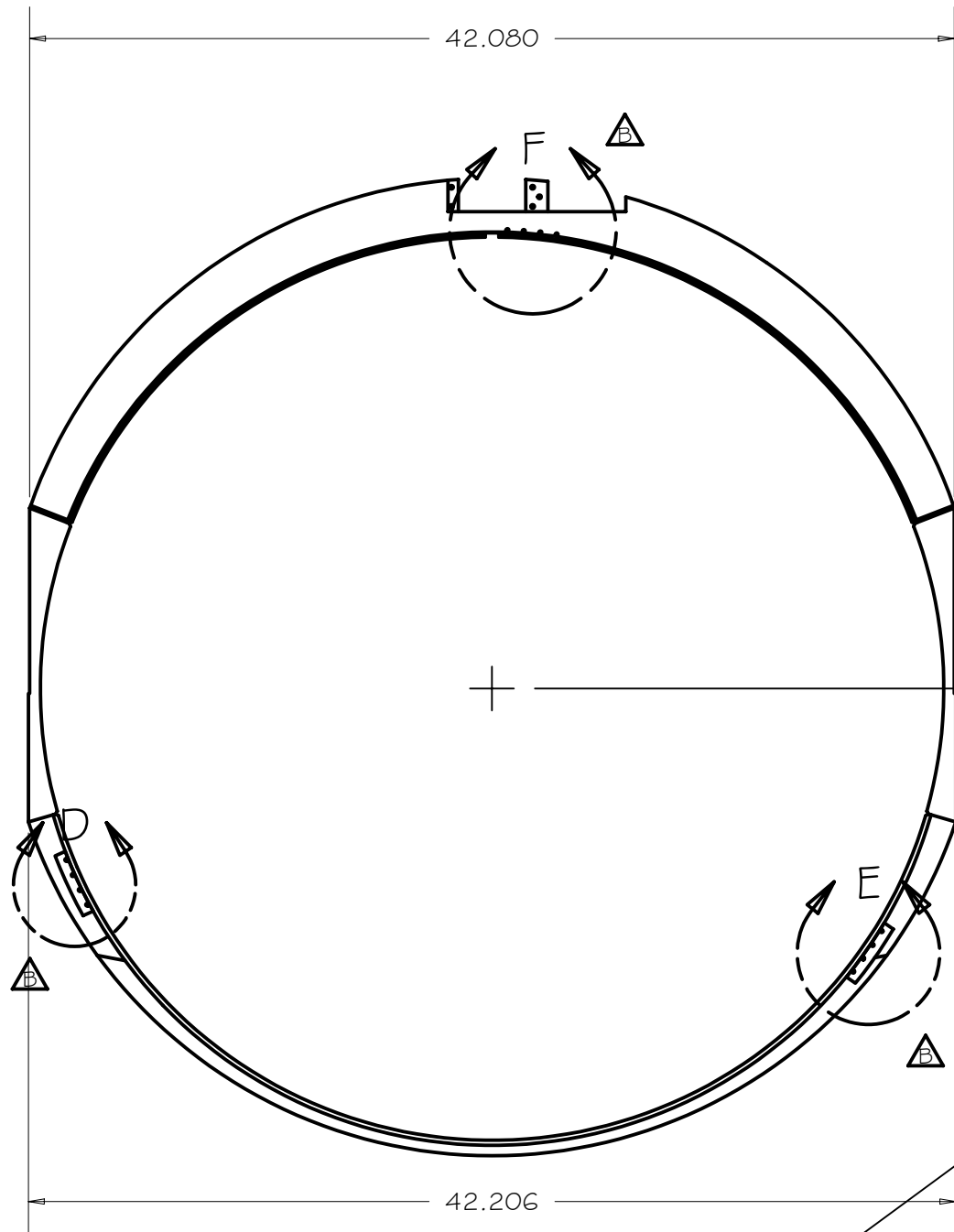
DRAWN	vernon	12/17/2004
CHECKED		
DESIGNED	vernon	
ENGINEER	vernon	

PROJECT CODE		DWG NO	REV
NEXT ASSY		A2030	E
A2002			4/7

Cassegrain ADC

CELL WELDMENT, AFT

REV	DRWN	CHK'D	DATE	DESCRIPTION



DETAIL C
SCALE 3 / 4

FINAL MACHINING AFTER STRESS RELIEVE

VIEW B-B
SCALE 1 / 8

FACE THIS SURFACE CLEAN, SPOT FACE OPPOSITE SURFACE BEHIND PRISM MOUNT HOLES (3X) AND ADJUST LENGTHS OF A2050, A2051, A2052 BY DIFFERNECE BETWEEN 4.100" AND FINISHED DISTANCE BETWEEN SURFACE AND SPOT FACES.

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

MATERIAL	FINISH



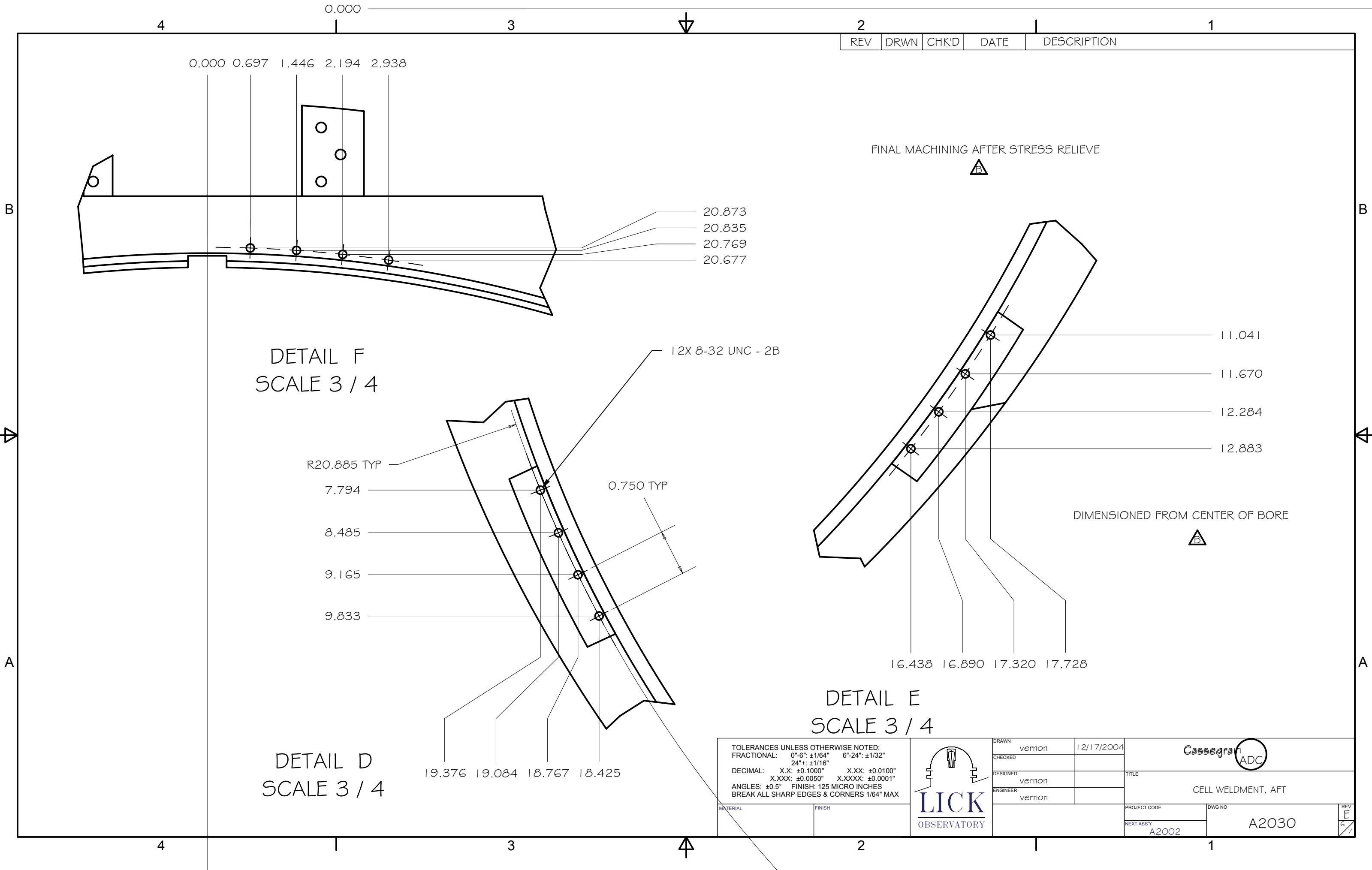
DRAWN	vernon	12/17/2004
CHECKED		
DESIGNED	vernon	
ENGINEER	vernon	

PROJECT CODE		DWG NO	REV
NEXT ASSY		A2030	E
A2002			5/7

Cassegrain ADC

CELL WELDMENT, AFT

REV	DRWN	CHK'D	DATE	DESCRIPTION



DETAIL F
SCALE 3 / 4

DETAIL E
SCALE 3 / 4

DETAIL D
SCALE 3 / 4

FINAL MACHINING AFTER STRESS RELIEVE

DIMENSIONED FROM CENTER OF BORE

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	12/17/2004
CHECKED		
DESIGNED	vernon	
ENGINEER	vernon	

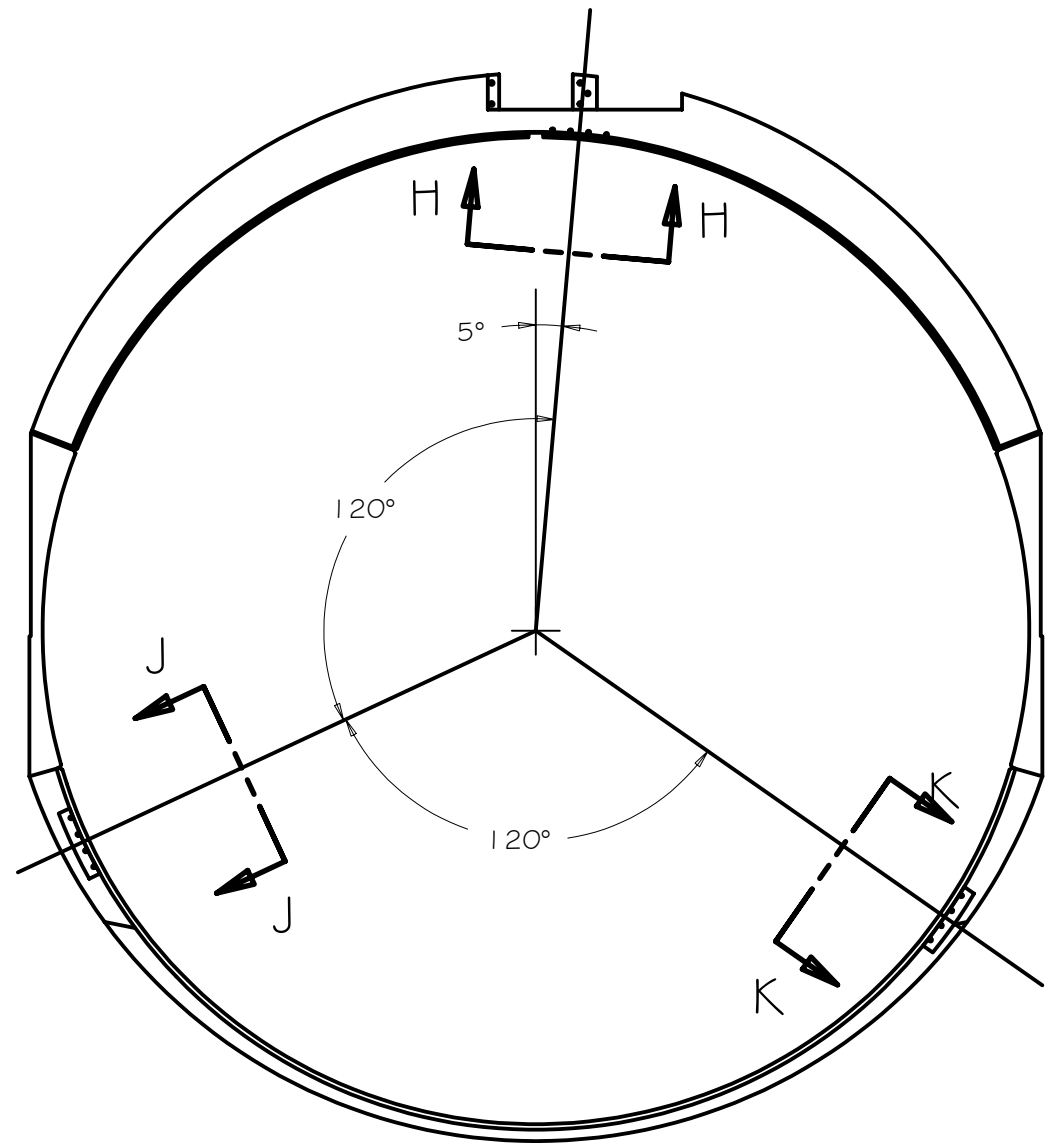
PROJECT CODE		DWG NO
NEXT ASSY		
A2002		A2030

Cassegrain ADC

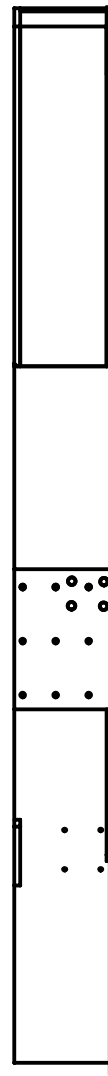
CELL WELDMENT, AFT

REV	E
	6/7

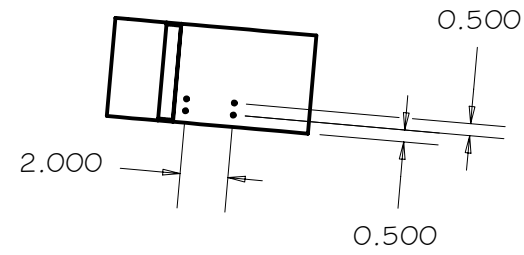
REV	DRWN	CHK'D	DATE	DESCRIPTION



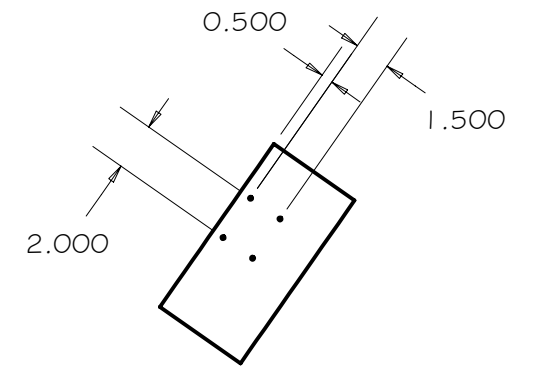
FINAL MACHINING AFTER STRESS RELIEVE



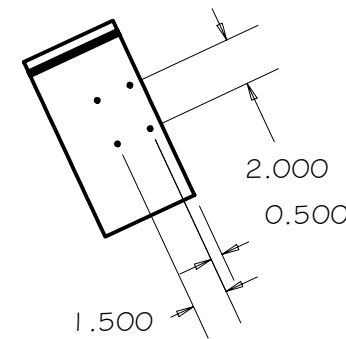
VIEW G-G
SCALE 1 / 8



SECTION H-H
SCALE 1 / 8



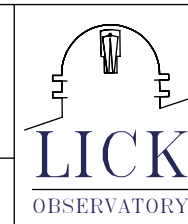
SECTION K-K
SCALE 1 / 8



SECTION J-J
SCALE 1 / 8

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

MATERIAL	FINISH



DRAWN	vernon	12/17/2004
CHECKED		
DESIGNED	vernon	
ENGINEER	vernon	

PROJECT CODE		DWG NO	REV
NEXT ASSY		A2030	E
A2002			7/7

Cassegrain ADC

CELL WELDMENT, AFT

A2030