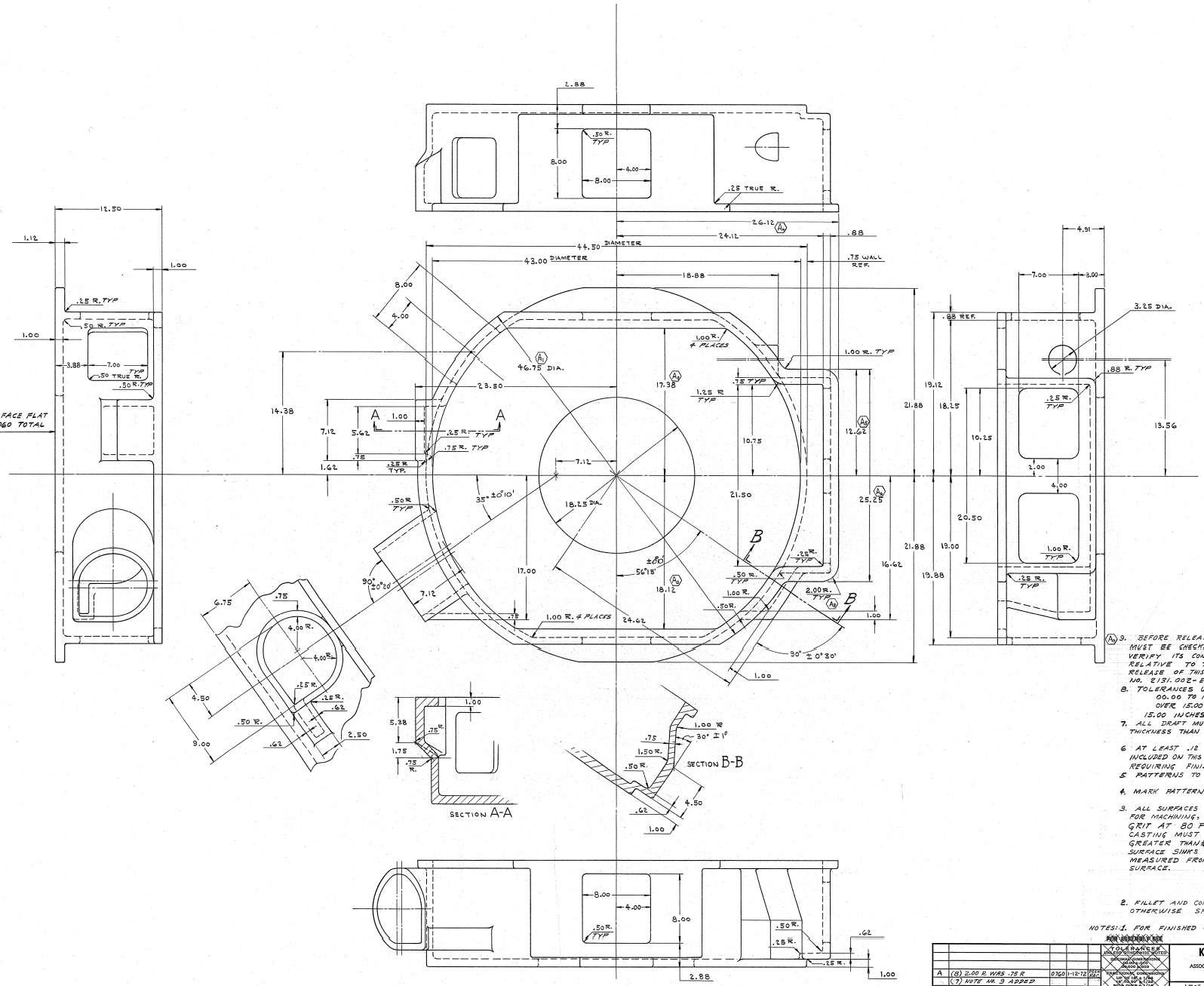
BILL OF MATERIAL

ITEM	QTY.	MATERIAL	DESCRIPTION	WEIGHT



(E3-1) CASSEGRAIN INST ROTATOR FRAME CASTING
1 REQD
MATL: 356-T6 ALUMINUM ALLOY

(A7) 9. BEFORE RELEASING TO FOUNDRY, THE PATTERN MUST BE CHECKED BY A.U.R.A. ENGINEERING TO VERIFY ITS CONFIGURATION AND CONDITION RELATIVE TO THE LATEST ENGINEERING CHANGE RELEASE OF THIS DRAWING AND DRAWING NO. 2131.002-E28.

8. TOLERANCES UNLESS OTHERWISE NOTED:
00.00 TO 15.00 — ±.030
OVER 15.00 — ±(.030 + .002 IN. PER IN. OVER 15.00 INCHES)

7. ALL DRAFT MUST RESULT IN GREATER MATERIAL THICKNESS THAN DIMENSIONS INDICATE. (1° MAX)

6. AT LEAST .12 FINISH ALLOWANCE HAS BEEN INCLUDED ON THIS DRAWING FOR ALL SURFACES REQUIRING FINISHING.

5. PATTERNS TO BECOME THE PROPERTY OF AURA.

4. MARK PATTERN WITH PART NO. 2131.002-E3

3. ALL SURFACES OF THE CASTING, AS CAST AND READY FOR MACHINING, SHALL BE SANDBLASTED WITH NO. 80 GRIT AT 80 PSI. AFTER SANDBLASTING THE CASTING MUST BE FREE OF HOLES OR VOIDS GREATER THAN 1/8 DIAMETER, CRACKS LONGER THAN 1/32 & SURFACE SINKS OR DEPRESSIONS DEEPER THAN 1/8 MEASURED FROM THE UN-DEPRESSED SURROUNDING SURFACE.

2. FILLET AND CORNER RADII TO BE .12 UNLESS OTHERWISE SPECIFIED.

NOTES: 1. FOR FINISHED CASTING SEE 2131.002-E28

FOR ASSEMBLY SEE

LET.	REVISION	ECR	DATE	BY
A	(8) 2.00 R. WAS .75 R	0760	1-12-72	RAC
	(7) NOTE NO. 9 ADDED			
	(6) 25.25 WAS 25.00			
	(5) 12.62 WAS 12.50			
	(4) 26.12 WAS 26.00			
	(3) 18.12 WAS 18.00			
	(2) 17.38 WAS 17.25			
	(1) 46.75 WAS 46.50			

TOLERANCES UNLESS OTHERWISE NOTED: DECIMAL DIMENSIONS ±0.010 ANGULAR ±0°30' FRACTIONAL DIMENSIONS UP TO 18" ± 1/16 OVER 18" ± 1/8 NEW EDGES 1/16
BREAK SHARP EDGES
ALL SURFACES TO HAVE 250 FINISH UNLESS OTHERWISE NOTED.

KITT PEAK NATIONAL OBSERVATORY
OPERATED BY THE ASSOCIATION OF UNIVERSITIES FOR RESEARCH IN ASTRONOMY, INC.
UNDER CONTRACT WITH NATIONAL SCIENCE FOUNDATION

150" TELESCOPE
REF. FILE 1290
SCALE 1/4
PRINT ISSUED
NAME: CASSEGRAIN INST. ROTATOR FRAME CASTING
DESIGNED BY R.C.V.C. DATE 1-25-71
DRAWN BY R.C.V.C. DATE 1-25-71
CHECKED BY R.A.C. DATE 2-12-71
APPROVED BY DATE 1-15-71
APPROVED BY DATE 1-25-71
DRAWING NUMBER 2131.002-E3
REV. A

6/69 DIETZGEN-POST CLEARPRINT 1000