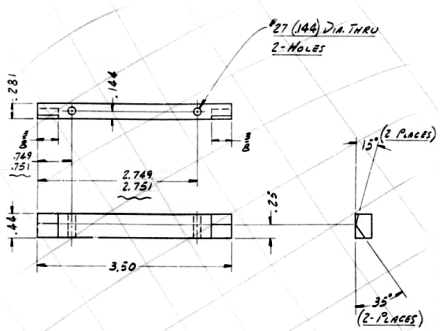
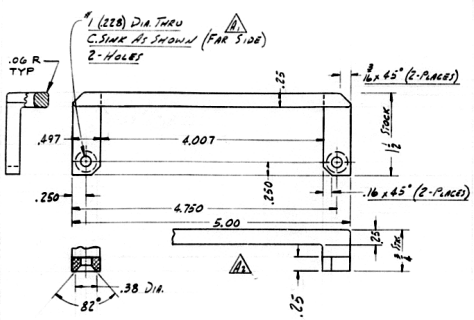
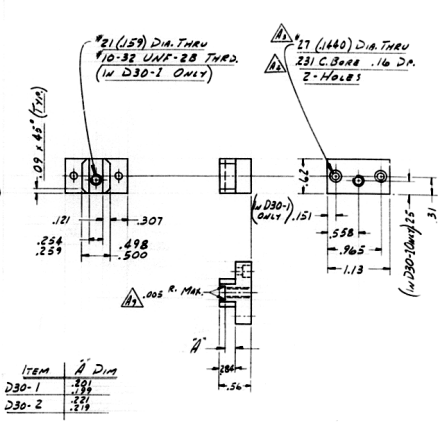


D30-4 CELL RETAINER
No. Req'd: 1
Mat'l: #C1018 COLD ROLLED STEEL
How: CARBORIZE
OPTICAL BLACK CHEMICALLY



D30-3 CELL HANDLE
No. Req'd: 1
Mat'l: ALUM. ALLOY #2024-T351
BLACK SULFURIC ANODIZE

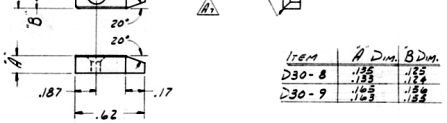


ITEM	"A" DIM
D30-1	.201 .199
D30-2	.221 .219

D30-1 KEYWAY
No. Req'd: 1
Mat'l: KETOS (OR EQUAL)
How: 9/16 48-50
OPTICAL BLACK CHEMICALLY

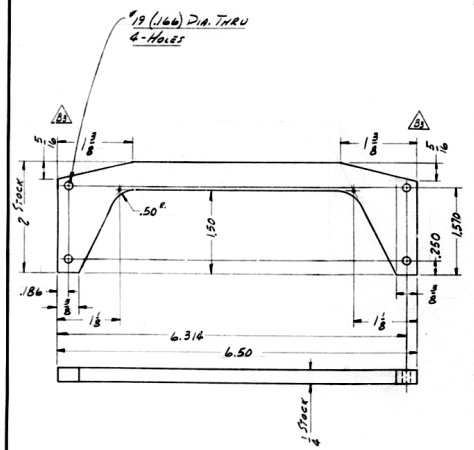
D30-2 KEYWAY (SAME AS D30-1 EXCEPT AS INDICATED)

ITEM	"A" DIM.	"B" DIM.
D30-8	.135 .133	.125 .124
D30-9	.163 .163	.154 .154

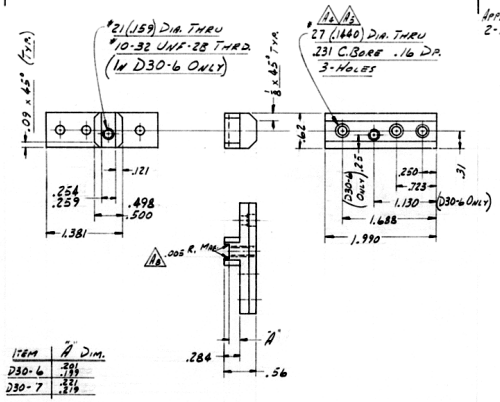


D30-8 KEY
No. Req'd: 2
Mat'l: KETOS (OR EQUAL)
How: 9/16 48-50
OPTICAL BLACK CHEMICALLY

D30-9 KEY 2-Req'd
Mat'l: KETOS OR EQUAL
How: 9/16 48-50
OPTICAL BLACK CHEMICALLY



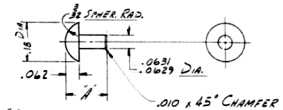
D30-5 BRACE
No. Req'd: 1
Mat'l: ALUM. ALLOY #2024-T4
BLACK SULFURIC ANODIZE



ITEM	"A" DIM.
D30-6	.196 .194
D30-7	.221 .219

D30-6 KEYWAY
No. Req'd: 1
Mat'l: KETOS (OR EQUAL)
How: 9/16 48-50
OPTICAL BLACK CHEMICALLY

D30-7 KEYWAY (SAME AS D30-6 EXCEPT AS INDICATED)

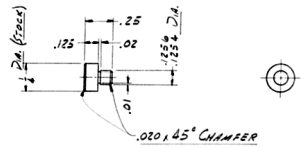


ITEM	"A" DIM.
D30-11	.19
D30-12	.12

NOTE: SIZES OF MATERIAL LISTED DO NOT INCLUDE STOCK ALLOWANCE FOR MACHINING AND CUTTING OFF EXCEPT AS NOTED. THE SIZE SPECIFIES THE MATERIAL REQUIRED FOR ONE PIECE ONLY. QUANTITIES NOTED ARE THE TOTAL NUMBER REQUIRED.

D30-11 DEFINING BUTTON
No. Req'd: 3
Mat'l: NAVAL BRASS ALLOY #450 OR EQUAL
OPTICAL BLACK CHEMICALLY
SCALE: 4 x SIZE

D30-12 DEFINING BUTTON
No. Req'd: 3
Mat'l: NAVAL BRASS ALLOY #450 OR EQUAL
OPTICAL BLACK CHEMICALLY



D30-10 DEFINING BUTTON
No. Req'd: 1-Req'd For D8-1, 1-Req'd For D8-16
Mat'l: #C1018 COLD ROLLED STEEL
How: HEAT TREAT TO R/C 36-40

BILL OF MATERIAL

ITEM	DWG. NO.	QTY.	MATERIAL	DESCRIPTION	WEIGHT
D30-1		1	KETOS (OR EQUAL)	.56 x .62 x 1.13	
-2		1	KETOS (OR EQUAL)	.56 x .62 x 1.13	
-3		1	ALUM. ALLOY #2024-T4	3/4 x 1 1/2 x 5.00	
-4		1	COLD ROLLED STEEL #C-1018	.281 x .44 x 3.50	
-5		1	ALUM. ALLOY #2024-T4	3/4 x 2.00 x 6.50	
-6		1	KETOS (OR EQUAL)	.56 x .62 x 1.990	
-7		1	KETOS (OR EQUAL)	.56 x .62 x 1.990	
-8		2	KETOS (OR EQUAL)	.134 x .250 x .62	
-9		2	KETOS (OR EQUAL)	.164 x .250 x .62	
-10		2	COLD ROLLED STEEL #C-1018	1/8 DIA. x .25 LG.	
-11		3	NAVAL BRASS ALLOY #450	.18 DIA. x .19 LG.	
-12		3	NAVAL BRASS ALLOY #450	.18 DIA. x .12 LG.	

REV.	REVISION	DATE	BY
C	REVISED AS BUILT - ECR 1512	10-27-78	BILL JACK
B4	ADDED 3/16 & 1 1/8 DIMS 2- PLACES	6 OCT 65	PETRI A.K.
B3	REM'D IT. #D30-6		
B2	ADDED APPROX. 3/16 R.		
B1	ADDED .005 R. MAX.		
A9	ADDED .005 R. MAX.		
A8	ADDED .02 x 45° CHAM.		
A7	#27 (.1440) DIA WAS 3/32 (.1562) DIA.		
A6	.231 C'BORE WAS .217 C'BORE		
A5	#27 (.1440) DIA WAS 3/32 (.1562) DIA.		
A4	PICTURE CORRECTED		
A3	ADDED (FAR SIDE)		

REF. FILE 2090

FOR NEXT ASS'Y SEE: 2028.01-D8

REMOVE ALL BURRS & SHARP EDGES UNLESS OTHERWISE SPECIFIED

TOLERANCES UNLESS OTHERWISE NOTED.
DECIMAL 00.00 ±.010 ANGLES ±1/4° 00.000 ±.005
FRACTIONAL — FABRICATION: UP TO 10" ± 1/16; 10" TO 20" ± 1/8; 20" & OVER ± .25; ⊥ .005"/INCH. MACHINING: UP TO 10" ± .016; 10" TO 20" ± .020; 20" & OVER ± .025; ⊥ .003"/INCH.
MACHINED SURFACES ARE FINISHED TO 125 UNLESS OTHERWISE SPECIFIED.

QUANT.	POINT RECORD	DATE

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

84" TELESCOPE -- CASSEGRAIN SPECTROGRAPH

DESIGNED BY: BILL MACHALL — DATE: 10-25-63
DRAWN BY: PETRI — DATE: 10-30-63
APPROVED BY: [illegible] — DATE: 4-13-64
NAME: DETAILS GRATING CELL & CELL HOLDER
SCALE: FULL
DWG. NUMBER: 2028.01-D30
REV: C