


| ITEM | DWG. NO. | QTY. | MATERIAL | DESCRIPTION | WEIGHT |
|---|---|---|---|---|---|
| D48-1 | | 1 | BRASS ALLOY #271 | .34 DIA. x .281 LG. | |
| 2 | | 1 | STN. STL. ALLOY #303 SE COND'A' | 1.1128 DIA. x .500 LG. | |
| 3 | | 1 | BRASS ALLOY #271 | 3/4 DIA. x .38 LG. | |
| 4 | | 1 | BRASS ALLOY #271 | 1/8 DIA. x .38 LG. | |
| 5 | | 1 | ALUM. ALLOY #2024-T4 | .60 DIA. x .375 LG. | |
| 6 | | 1 | ALUM. ALLOY #2024-T4 | .60 DIA. x 1.562 LG. | |
| 7 | | 1 | ALUM. ALLOY #2024-T4 | 1.56 x 3.125 x 3.38 | |

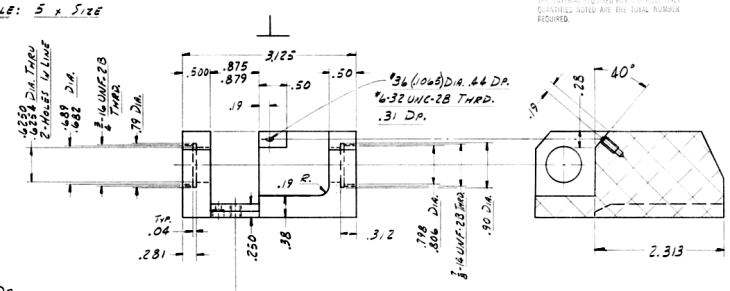
BILL OF MATERIAL

NOTE: SIZES OF MATERIAL GIVEN ARE FUTURE STOCK ALLOWANCE FOR MACHINING THIS DETAIL. FOR STOCK AS NOTED IN BILL OF MATERIAL REQUIRED FOR ONE PIECE ONLY. QUANTITIES NOTED ARE THE TOTAL NUMBER REQUIRED.

**D48-1 SPACER**
No. Req'd: 1
Mat'l: Brass Alloy #271
Optical Black Chemically
Scale: 5 x Size

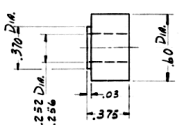
American Standard Fine Pitch Worm Data

| | | |
|---|---|---|
| Lead (Single Thrd.) | : | .03 |
| Lead Angle | : | .5° |
| Pitch Dia. | : | 1.0937 |
| Mating Worm Gear | : | 1-Item #D31-3 (8.000 P.D.) |
| Pressure Angle | : | 20° |
| Hand | : | Right |
| Tolerance Class | : | AGMA Prec. 3 |

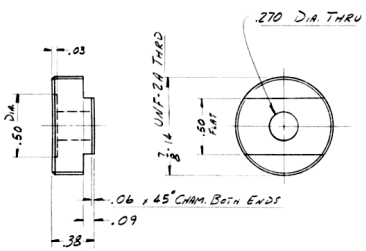


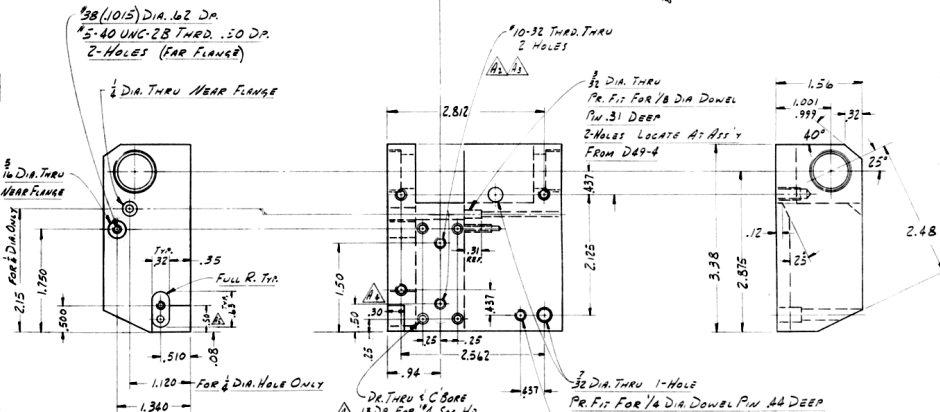

**D48-3 BEARING RETAINER**
No. Req'd: 1
Mat'l: Brass Alloy #271
Optical Black Chemically
Scale: 2 x Size

**D48-2 WORM**
No. Req'd: 1
Mat'l: Stainless Steel Alloy #303 SE Cond. 'A'
Optical Black Chemically
Scale: 2 x Size

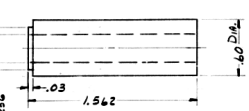



**D48-5 SPACER**
No. Req'd: 1
Mat'l: Alum. Alloy #2024-T4
Optical Black Chemically




**D48-7 INNER GRATING DRIVE HOUSING**
No. Req'd: 1
Mat'l: Alum. Alloy #2024-T4
Black Sulfuric Anodize




**D48-4 BEARING RETAINER**
No. Req'd: 1
Mat'l: Brass Alloy #271
Optical Black Chemically
Scale: 2 x Size

**D48-6 SPACER**
No. Req'd: 1
Mat'l: Alum. Alloy #2024-T4
Optical Black Chemically

Remove All Burrs & Sharp Edges Unless Otherwise Specified

| QUANT. | PRINT RECORD | DATE | REVISION | DATE | BY |
|---|---|---|---|---|---|
| | | | A3 Added .30 Dim. A6 Added .50 Dim. | | |
| | | | A3 Added 2 #10-32 Holes | | |
| | | | A3 Rem'd 2 - 5/16 Dia. Holes | | |
| | | | A1 Added Dr. & C'Bore For 4 - 6 Soc Hd Cap Scr. | 8/4/65 | 8/24/65 |

TOLERANCES UNLESS OTHERWISE NOTED:
DECIMAL .XX ±.010 .XXX ±.005 ANGULAR ± 1/2°
FRACTIONAL ± 1/64
MACHINED SURFACES 125 RMS UNLESS OTHERWISE SPECIFIED

For Next Ass'y See 2028.01-D47

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

84 Telescope Cassegrain Spectrograph

| | | |
|---|---|---|
| DESIGNED BY | A.E. MARSHALL | DATE 10 OCT 63 |
| DRAWN BY | PETRI | DATE 2-13-64 |
| APPROVED BY | | DATE |
| NAME | Inner Grating Drive Details | |
| SCALE | FULL | |
| DWG. NUMBER | 2028.01-D48 | REV. A |

REF. FILE 2090

DIETZGEN-POST CLEARPRINT 110000

