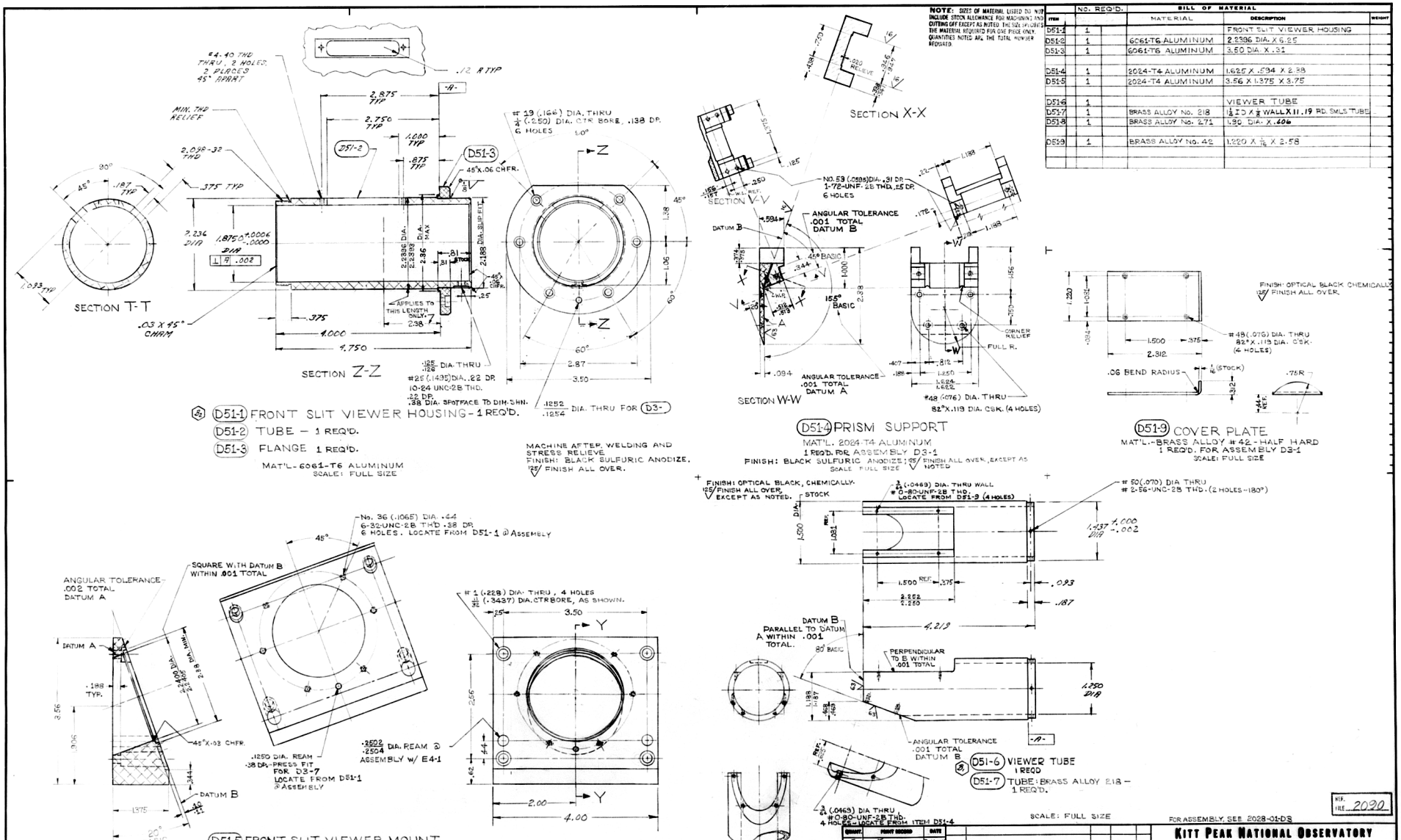


ITEM	NO. REQ'D.		BILL OF MATERIAL MATERIAL	DESCRIPTION	WEIGHT
D51-1	1			FRONT SLIT VIEWER HOUSING	
D51-2	1		6061-T6 ALUMINUM	2.2396 DIA. X 6.25	
D51-3	1		6061-T6 ALUMINUM	3.50 DIA. X .31	
D51-4	1		2024-T4 ALUMINUM	1.625 X .594 X 2.38	
D51-5	1		2024-T4 ALUMINUM	3.56 X 1.375 X 3.75	
D51-6	1			VIEWER TUBE	
D51-7	1		BRASS ALLOY No. 218	1 1/2 I.D. X 3/4 WALL X 11.19 RD. SMLS TUBE	
D51-8	1		BRASS ALLOY No. 271	1.90 DIA. X .606	
D51-9	1		BRASS ALLOY No. 42	1.220 X 1/16 X 2.58	

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

(D51-1) FRONT SLIT VIEWER HOUSING – 1 REQ'D.
(D51-2) TUBE – 1 REQ'D.
(D51-3) FLANGE 1 REQ'D.
MAT'L - 6061-T6 ALUMINUM
SCALE: FULL SIZE

MACHINE AFTER WELDING AND STRESS RELIEVE
FINISH: BLACK SULFURIC ANODIZE, 125/ FINISH ALL OVER.

(D51-4) PRISM SUPPORT
MAT'L. 2024-T4 ALUMINUM
1 REQ'D. PER ASSEMBLY D3-1
FINISH: BLACK SULFURIC ANODIZE; 125/ FINISH ALL OVER, EXCEPT AS NOTED
SCALE: FULL SIZE

(D51-9) COVER PLATE
MAT'L. - BRASS ALLOY #42 - HALF HARD
1 REQ'D. FOR ASSEMBLY D3-1
SCALE: FULL SIZE

(D51-5) FRONT SLIT VIEWER MOUNT
MAT'L. 2024-T4 ALUMINUM – 1 REQ'D.
FINISH: - BLACK SULFURIC ANODIZE
125/ FINISH ALL OVER
SCALE: FULL SIZE

(D51-6) VIEWER TUBE
1 REQD
(D51-7) TUBE: BRASS ALLOY 218 – 1 REQ'D.

SCALE: FULL SIZE

FOR ASSEMBLY, SEE 2028-01-D3

REF. FILE 2090

QUANT.	PRINT RECORD	DATE
5	510	7 May 68

NO.	REVISION	ECR	DATE	BY
B2	REDESIGN	2544	5-12-81	RJS
B1	REDESIGN			
A6	6.656 WAS 7.125	1177	6-15-78	RJS
A5	Changed Thickness SECTION F-F			
A4	4.000 WAS 5.148 A3 ADDED 2.25			
A3	1.687 WAS 1.875 A2 5.175 WAS 6.25			

TOLERANCES UNLESS OTHERWISE NOTED.
DECIMAL 00.00 ±.010 .000 ±.002 ANGLES ± 1/4°
FRACTIONAL — FABRICATION: UP TO 10" ± 1/16; 10" TO 20" ± 1/8; 20" & OVER ± .25 ± .005"/INCH
MACHINING: UP TO 10" ± .015; 10" TO 20" ± .020; 20" & OVER ± .050 ± .005"/INCH
MACHINED SURFACES ARE FINISHED TO 125/ UNLESS OTHERWISE SPECIFIED.

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

84-INCH TELESCOPE CASSEGRAIN SPECTROGRAPH

DESIGNED BY	D.C. MACKRILL	DATE	24 Apr 68
DRAWN BY	R.H. KIRK	DATE	3 May 68
APPROVED BY	D.C. MACKRILL	DATE	8/10/68
SCALE	FULL SIZE		
DWG. NUMBER	2028-01-D51	REV	3

NAME: SLIT VIEWER ASSEMBLY DETAILS