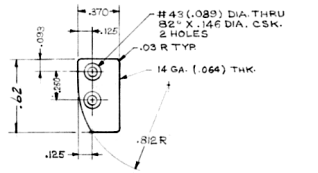


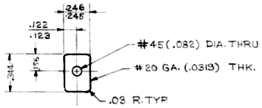
D52-1 FRONT SLIT VIEWING PRISM

MAT'L.- ALTER EDMUNDS RIGHT ANGLE PRISM, NO. 32254 (24 MM X 28 MM X 24 MM, AS SHOWN)
1 REQ'D. FOR ASSEMBLY D3-1
SCALE: FULL SIZE



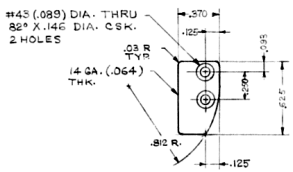
D52-3 PRISM CLIP, R/H

MAT'L., SPRING PHOSPHOR BRONZE ALLOY 351
1 REQ'D. FOR ASSEMBLY D3-1
SCALE: DOUBLE SIZE
FINISH: OPTICAL BLACK CHEMICALLY
125/ FINISH ALL OVER



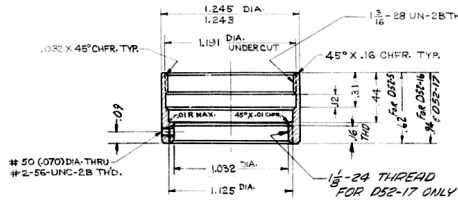
D52-2 PRISM CLIP

MAT'L.- SPRING PHOSPHOR BRONZE ALLOY 351
2 REQ'D. FOR ASSEMBLY D3-1
SCALE: DOUBLE SIZE
FINISH: OPTICAL BLACK CHEMICALLY
125/ FINISH ALL OVER



D52-4 PRISM CLIP L/H

MAT'L., SPRING PHOSPHOR BRONZE ALLOY 351
1 REQ'D. FOR ASSEMBLY D3-1
SCALE: DOUBLE SIZE
FINISH: OPTICAL BLACK CHEMICALLY
125/ FINISH ALL OVER



D52-5 LENS CELL

MAT'L. BRASS ALLOY # 271 - HALF-HARD DRAWN
2 REQ'D. FOR ASSEMBLY D3-2
SCALE: DOUBLE SIZE
FINISH: OPTICAL BLACK CHEMICALLY
125/ FINISH ALL OVER

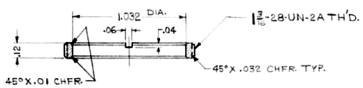
ITEM	NO. REQ'D. ASSEMBLY D3-1	NO. REQ'D. ASSEMBLY D3-2	BILL OF MATERIAL MATERIAL	DESCRIPTION	WEIGHT
*D52-1	1		GLASS	EDMUNDS RIGHT ANGLE PRISM 32.54	
D52-2	2		SPRING PHOSPHOR BRZE ALLOY 351	.246 X 29 GA (.0318) X .344	
D52-3	1		SPRING PHOSPHOR BRZE ALLOY 351	.370 X 43A (.064) X .625	
D52-4	1		SPRING PHOSPHOR BRZE ALLOY 351	.370 X 14 GA (.064) X .625	
D52-5		2	BRASS ALLOY 271 - HALF HARD DRWN	1.24 E DIA. X .62	
D52-6	2	2	BRASS ALLOY 271 - HALF-HARD DRAWN	1 3/16 DIA. X .12	
*D52-7	2	2	GLASS	EDMUNDS ACHROMATIC LENS NO. 6232	
D52-8		1		REAR SLIT VIEWER HOUSING	
D52-9		1	6061-T6 ALUMINUM	2.25 DIA. X 6.25	
D52-10		1	6061-T6 ALUMINUM	2.75 X .38 X 3.50	
D52-11		1		REAR SLIT VIEWER TUBE	
D52-12		1	BRASS ALLOY 218	½ OD X ½ WALL X 10.520 RD SMLS. TUBING	
D52-13		1	BRASS ALLOY 271	1.90 DIA. X .406	
D52-14		1	BRASS ALLOY 271	1.62 DIA. X .125	
D52-15		3	STAINLESS STEEL	0-80-UNF-2A X ¼ FLAT HD. MACH. SCR.	
-16	1		BRASS ALLOY 271 HALF HD. DRWN	1.245 DIA. x .96	
-17	1		BRASS ALLOY 271 HALF HD DRWN	1.245 DIA. x .94	

* : TO BE PROVIDED BY AURA INC.

NOTE: SIZES OF MATERIAL LISTED DO NOT INCLUDE STOCK ALLOWANCE FOR MACHINING AND FINISHING EXCEPT AS NOTED. THE SIZE SPECIFIED IS THE MATERIAL REQUIRED AND IS NOT TO BE REDUCED. NOTES ARE THE FINAL NUMBER

D52-16 LENS CELL
(SAME AS D52-5 EXCEPT AS SHOWN)
1-REQ'D FOR ASS'Y D3-1

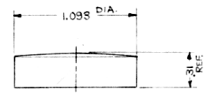
D52-17 LENS CELL (SAME AS D52-16 EXCEPT AS SHOWN)
1-REQ'D FOR ASS'Y D3-1



D52-6 LENS NUT

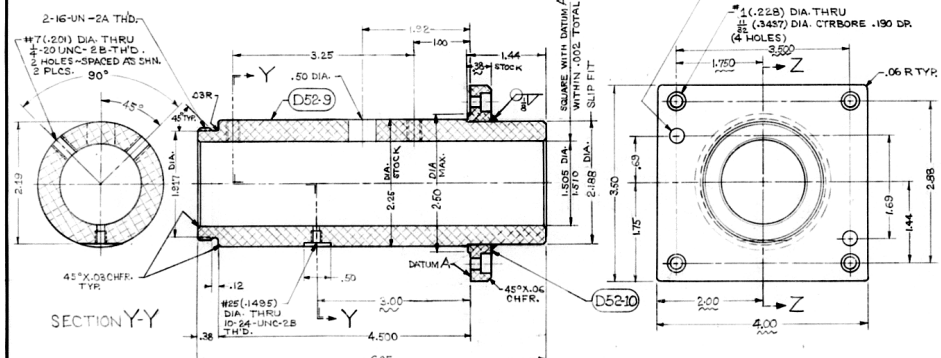
MAT'L. BRASS ALLOY # 271 - HALF-HARD DRAWN
2 REQ'D. FOR ASSEMBLY D3-2
SCALE: DOUBLE SIZE
FINISH: OPTICAL BLACK CHEMICALLY
125/ FINISH ALL OVER

BREAK EDGES .015 MAX.



D52-7 LENS - 4 REQ'D.

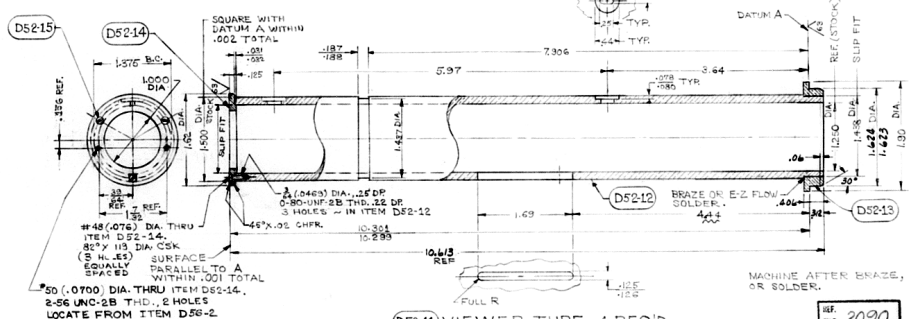
MAT'L.- ALTER EDMUNDS ACHROMATIC LENS STOCK NO. 6232, COATED OBJECTIVE, 32 MM (1.26") X 171 MM FOCAL LENGTH, AS SHOWN
2 REQ'D. FOR ASSEMBLY D3-2



D52-8 REAR SLIT VIEWER HOUSING - 1 REQ'D.
D52-9 TUBE - 1 REQ'D. FOR ASSEMBLY D3-2
D52-10 FLANGE - 1 REQ'D. FOR ASSEMBLY D3-2

MAT'L.- 6061-T6 ALUMINUM
SCALE: FULL SIZE.
FINISH: OPTICAL BLACK CHEMICALLY
125/ FINISH ALL OVER
SCALE: FULL SIZE
MACHINE AFTER WELD AND STRESS RELIEVE.
~~~ = NOT TO SCALE

FINISH: OPTICAL BLACK CHEMICALLY
125/ FINISH ALL OVER EXCEPT AS NOTED



D52-11 VIEWER TUBE - 1 REQ'D.
D52-12 TUBE - BRASS ALLOY NO. 218 - 1 REQ'D. FOR ASSEMBLY D3-2
D52-13 FLANGE - BRASS ALLOY NO. 271 - 1 REQ'D. FOR ASSEMBLY D3-2
D52-14 CAP - BRASS ALLOY NO. 271 - 1 REQ'D. FOR ASSEMBLY D3-2

FOR ASSEMBLY SEE 2028-01-D3

REF. FILE 2090

SCALE: FULL SIZE

QUANT.	PRINT RECEIVED	DATE				
5	Rio	7 March				
			C2	DELETED D3-1 REQ. CALLOUT	2514	RAH
			C1	DELETED D3-1 REQ. CALLOUT		
			B	D52-16 WAS 2 REQD	2-25-75	RAH
				D52-17 ADDED ECR 1362	2-27-75	RAH
			A2	ADDED Ir.° D52-16	APR 4 1975	RAH
			A1	REM'D 2-REQ'D FOR D3-1		
			NO.	REVISION	DATE	BY

TOLERANCES UNLESS OTHERWISE NOTED:
DECIMAL 00.00 ±.010 ANGLES ± 1/4° 00.000 ±.003
FRACTIONAL — FABRICATING: UP TO 12" ± 1/16; 12" TO 30" ± 1/8; 30" & OVER ± .25; 1" .000"/INCH — MACHINING: UP TO 18" ± .015; 18" TO 30" ± .020; 30" & OVER ± .030; .001"/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

TOLERANCES UNLESS NOTED: DECIMAL 00.00 ±.010, 00.000 ±.003; FRACTIONAL ± 1/16, ± 1/64	DESIGNED BY L.C. MACKRILL	DATE 2/27/1968	
	DRAWN BY KH MIRK	DATE 3-6-74	
	APPROVED BY R.L. WALLACE	DATE 3-6-74	
NAME VIEWER TUBE ASSEMBLY DETAILS	SCALE FULL & DOUBLE	DWG. NUMBER 2028.01-D52	REV C
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