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

BILL OF MATERIAL

ITEM	QTY.	MATERIAL	DESCRIPTION	WEIGHT
D58-1	1	2024-T4 ALUM ALLOY	HOUSING ASSEMBLY	
D58-2	1	"	.25 x 3.94 x 11.38	
D58-3	1	"	.25 x 3.94 x 6.00	
D58-4	1	"	.25 x 3.19 x 3.84	
D58-5	1	"	.25 x 3.19 x 3.84	
D58-6	1	"	.25 x 3.84 x 5.38	
D58-7	1	2024-T4 ALUM. ALLOY	.25 x 3.84 x 5.38	
D58-8	32	STEEL	4-40 UNC-2A x .25 SOC HD. CAPSCREW	

D58-8
#31 (.120) DIA. HOLE THRU
#9 (.196) DIA. .13 DEEP IN D58-2, D58-3, D58-4 & D58-5 AS SHOWN
32 HOLES
#43 (.089) DIA. x .25 DEEP
#4-40 UNC-2B THRD. .19 DEEP IN D58-4, D58-5, D58-6 & D58-7 AS SHOWN
32 HOLES

.144 DIA. THRU
.218 DIA. .12 DEEP
2 HOLES

No. 29 (.136) DIA. THRU & 32 UNC-2B THD. 4 HOLES - LOCATE FROM ITEM DG1-5

DRILL & REAM SLIP FIT FOR 3/32 (.094) DIA. DOWEL PIN @ ASSEM. W. ITEM DG1-5 (2 HOLES)

No. 8 (.199) DIA. THRU 6 HOLES

#8 (.199) DIA. THRU 6 HOLES

PR. FIT FOR 1/8 DIA. DOWEL PIN 2 HOLES

D58-5

D58-3

D58-4

D58-2

#2-56 THRD. THRU 4 HOLES LOCATED FROM IT.# D42-6

Press Fit FOR .094 DIA. DOWEL PIN 2 HOLES - LOCATE FROM ITEM D59-3

No. 43 (.089) DIA. THRU - 4-40 UNC-2B THD. 2 HOLES LOCATE FROM ITEM D59-3

1/8 (.125) DIA. THRU; .190 DIA. C'BORE, .125 DP. (4 HOLES)

Press Fit FOR .094 DIA. DOWEL PIN. 2 HOLES

#50 (.070) DIA. THRU. #2-56 UNC-2B THRD. 2 HOLES Locate From It.# D16-6

Bore Thru & Mill .093 Deep To Receive Item # D16-6

.50 DIA. THRU

.100 DIA. THRU

.50 DIA. HOLE

.515 DIA. THRU & .88 DIA. .16 DEEP

#38 (.1015) DIA. THRU #5-40 UNC-2B THRD. THRU 2 HOLES Locate From It.# D16-7,8 (See Dwg. D16)

D58-7

D58-6

.25 TYP. (STOCK)

SECTION 'ZZ'
FULL SIZE

FOR ASSEMBLY SEE 2028.01-D40

D58-1 OUTER SKYLIGHT SUPPRESSOR DETAILS - HOUSING ASSEMBLY -
MATERIAL: 2024-T4 ALUMINUM - 1 REQ'D.
FINISH: BLACK SULFURIC ANODIZE
SCALE: FULL SIZE

QUANT.	PRINT RECORD	DATE

NO.	REVISION	DATE	BY
B	ADDED #2-56 THRD. 4 HOLES	2 MAY 64	RLR
A1	ADDED .50 DIA. THRU & .100 DIA. THRU;		
A	.515 DIA. THRU & .88 DIA. .16 DP. & #2-56 THRD. 2 HOLES & #5-40 THRD. 4 HOLES &	15 MAY 64	RLR
A	BORE & MILL TO RECEIVE IT.# D16-6	15 MAY 64	RLR

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 ±.030, 00.000 ±.003; FRACTIONAL ± 1/64, ± 1/16; ANGLES ± 1/4°

DESIGNED BY L.C. HACKRILL DATE 20 MAY 63
DRAWN BY K.H.K. DATE 20 MAY 64
APPROVED BY K.K. PARE DATE 21 MAY 64

NAME OUTER SKYLIGHT SUPPRESSOR DETAILS (HOUSING ASSEMBLY)
SCALE FULL SIZE
DWG NUMBER 2028.01-D58 B

DIETZGEN-POST CLEARPRINT 11X36