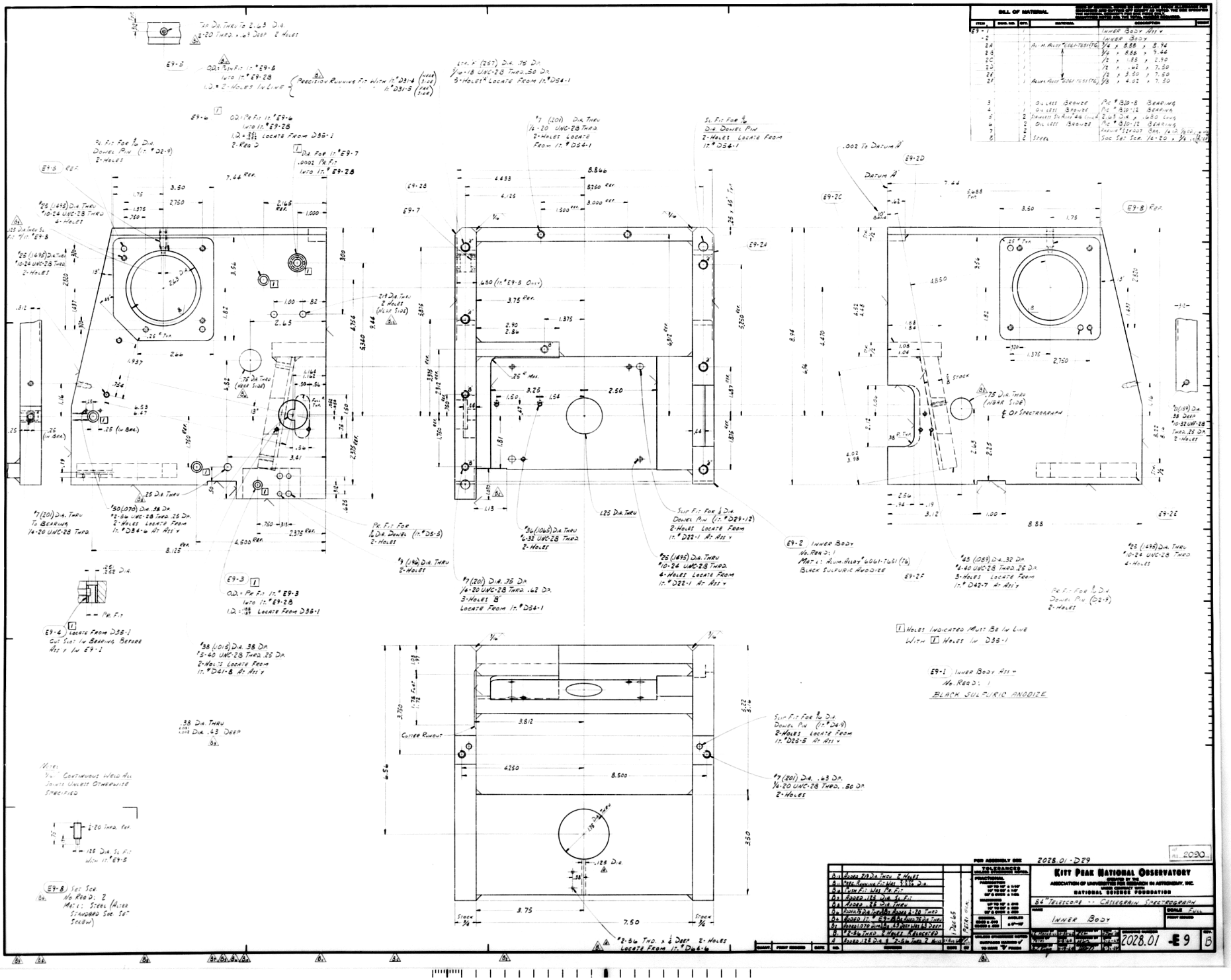

BILL OF MATERIAL
E9-1 Inner Body Assy
-2 1 Inner Body
2A 1 Al. H Alloy (Ref. Tests) (T6) 1/4 x 8.88 x 8.94
2B 1 3/4 x 8.88 x 9.44
2C 1 1/2 x 1.88 x 2.90
2D 1 1/2 x 1.40 x 7.50
2E 1 1/2 x 3.50 x 7.50
2F 1 Alum. Alloy Tool Test (T6) 1/8 x 4.02 x 7.50
3 1 Oil Less Bronze Pic # 810-8 Bearing
4 1 Oil Less Bronze Pic # 810-12 Bearing
5 2 Stainless Steel 416 Cond. A 1/2 x 1.50 Long
6 2 Oil Less Bronze Pic # 810-12 Bearing
7 6 Steel Fabrik # 514-307 Brg. 1/4 I.D. x 1/2 O.D. x 1/2 Long
8 2 Steel Soc. Set Screw, 1/4-20 x 1/4
E9-5
Tap Dia. Thru To 2.63 Dia. 3/8-20 Thrd. x .63 Deep 2 Holes
E9-6
OD = Run Fit In. #E9-5 Into In. #E9-28
I.D. = 2 Holes 1/4 Line
Precision Running Fit With In. #D31-4 (.002 / .004)
In. #D31-5 (.004 / .006)
Loc. 4 (.257) Dia. .75 Dp. 1/4-28 UNC-28 Thrd. .50 Dp. 3 Holes Locate From In. #D54-1
E9-4
OD = Pr. Fit In. #E9-4 Into In. #E9-28
I.D. = Locate From D35-1 2 Req'd
Dia. For In. #E9-7 .0002 Pr. Fit Into In. #E9-28
Pr. Fit For 1/4 Dia. Dowel Pin (In. #D2-9) 2 Holes
E9-8 Ref.
#25 (.1495) Dia. Thru #10-24 UNC-28 Thrd. 4 Holes
#25 (.1495) Dia. Thru #10-24 UNC-28 Thrd. 2 Holes
.25 Dia. Thru To Fit In. #E9-8
.25 (In Brg.)
.75 Dia. Thru (Inner Side)
#7 (.201) Dia. Thru To Bearing 1/4-20 UNC-28 Thrd.
#50 (.070) Dia. .38 Dp. #2-56 UNC-28 Thrd. .25 Dp. 2 Holes Locate From In. #D34-4 At Ass'y
E9-3
OD = Pr. Fit In. #E9-3 Into In. #E9-28
I.D. = Locate From D35-1
E9-6 Locate From D35-1 Cut Slot In Bearing, Before Ass'y In. E9-1
Pr. Fit
#38 (1015) Dia. .38 Dp. #5-40 UNC-28 Thrd. .25 Dia. 2 Holes Locate From In. #D41-8 At Ass'y
.38 Dia. Thru (.001 / .005 Dia. .43 Deep
Notes:
1/16 Continuous Weld All Joints Unless Otherwise Specified
.220 Thrd. Ref.
.125 Dia. Pr. Fit With In. #E9-8
E9-8 Set Scr. No. Req'd: 2 Mat'l: Steel (Allen Standard Soc. Set Screw)
#7 (.201) Dia. Thru 1/4-20 UNC-28 Thrd. 2 Holes Locate From In. #D54-1
Pr. Fit For 1/4 Dia. Dowel (In. #D5-8) 2 Holes
#9 (.196) Dia. Thru 2 Holes
#36 (.1063) Dia. Thru #6-32 UNC-28 Thrd. 2 Holes
Slip Fit For 1/4 Dia. Dowel Pin (In. #D29-12) 2 Holes Locate From In. #D22-1 At Ass'y
#25 (.1495) Dia. Thru #10-24 UNC-28 Thrd. 4 Holes Locate From In. #D22-1 At Ass'y
E9-7
E9-2 Inner Body No. Req'd: 1 Mat'l: Alum. Alloy 6061-T651 (T6) Black Sulfuric Anodize
E9-27
#43 (.1089) Dia. .32 Dp. #8-40 UNC-28 Thrd. .25 Dp. 3 Holes Locate From In. #D42-7 At Ass'y
Pr. Fit For 1/4 Dia. Dowel Pin (D2-9) 2 Holes
#25 (.1495) Dia. Thru #10-24 UNC-28 Thrd. 4 Holes
Holes Indicated Must Be In Line With Holes In D35-1
E9-1 Inner Body Ass'y No. Req'd: 1 Black Sulfuric Anodize
.002 To Datum A
Datum A
E9-20
E9-22
E9-24
E9-26
.75 Dia. Thru (Inner Side) & Of Spectrograph
#7 (.201) Dia. .75 Dp. 1/4-20 UNC-28 Thrd. .62 Dp. 3 Holes Locate From In. #D54-1
Slip Fit For 1/4 Dia. Dowel Pin (In. #D4-9) 2 Holes Locate From In. #D25-5 At Ass'y
#7 (.201) Dia. .63 Dp. 1/4-20 UNC-28 Thrd. .50 Dp. 2 Holes
Cutter Runout
#2-56 Thd. x 1/4 Deep 2 Holes Locate From In. #D44-6
Stock 3/4
Stock 1/4
Dec 65
2028.01-D29
Kitt Peak National Observatory
Operated by the Association of Universities for Research in Astronomy, Inc. National Science Foundation
84" Telescope -- Cassegrain Spectrograph
Inner Body
2028.01 E9
B