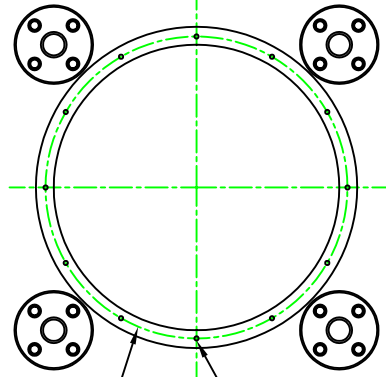
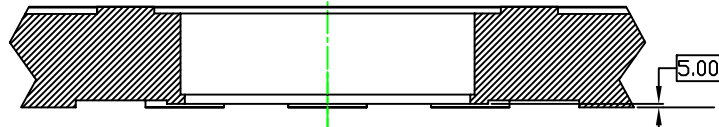
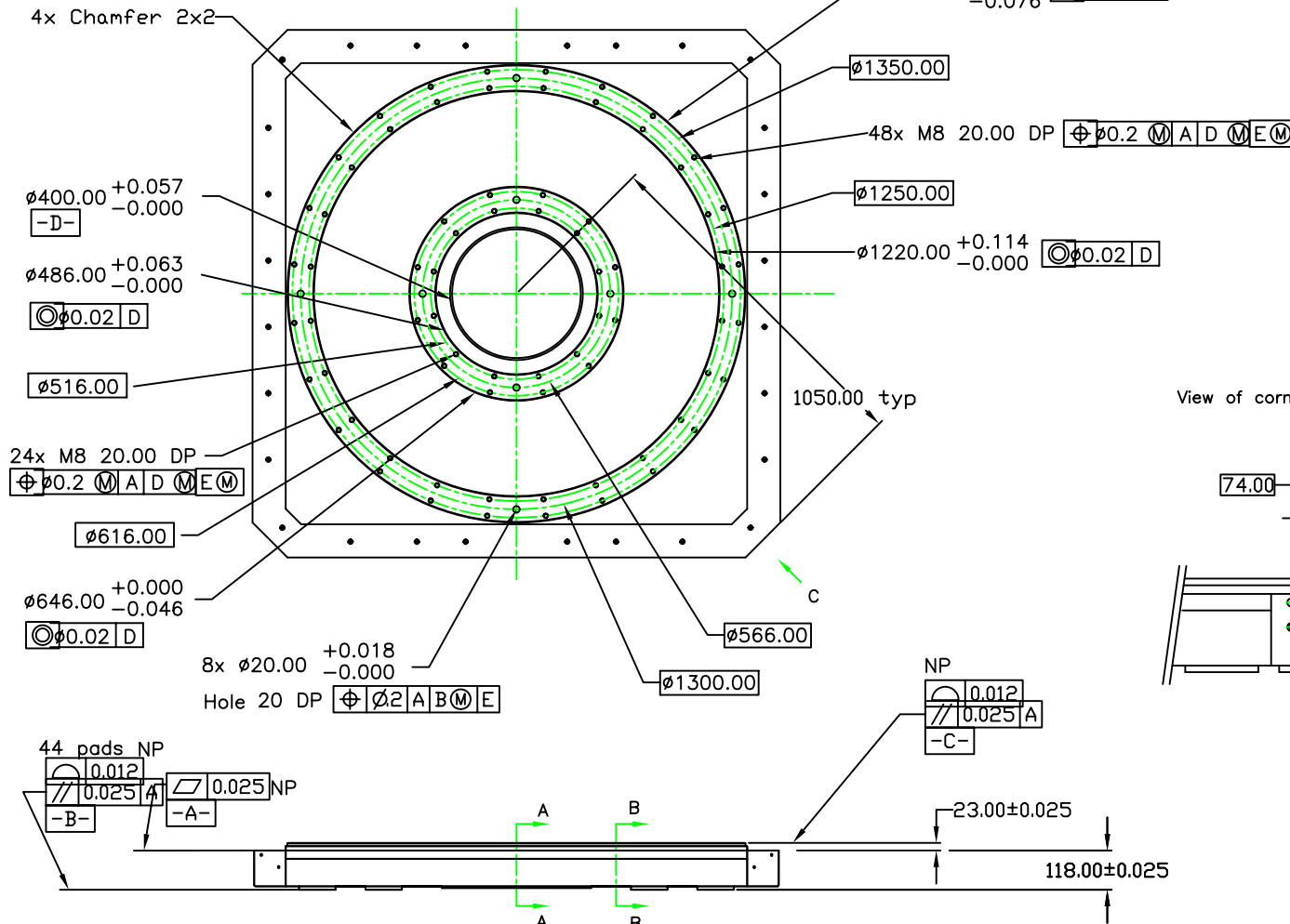
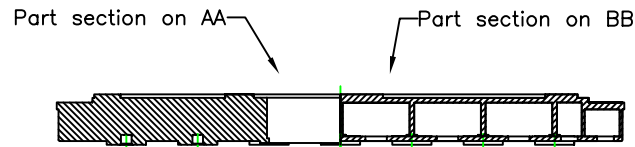


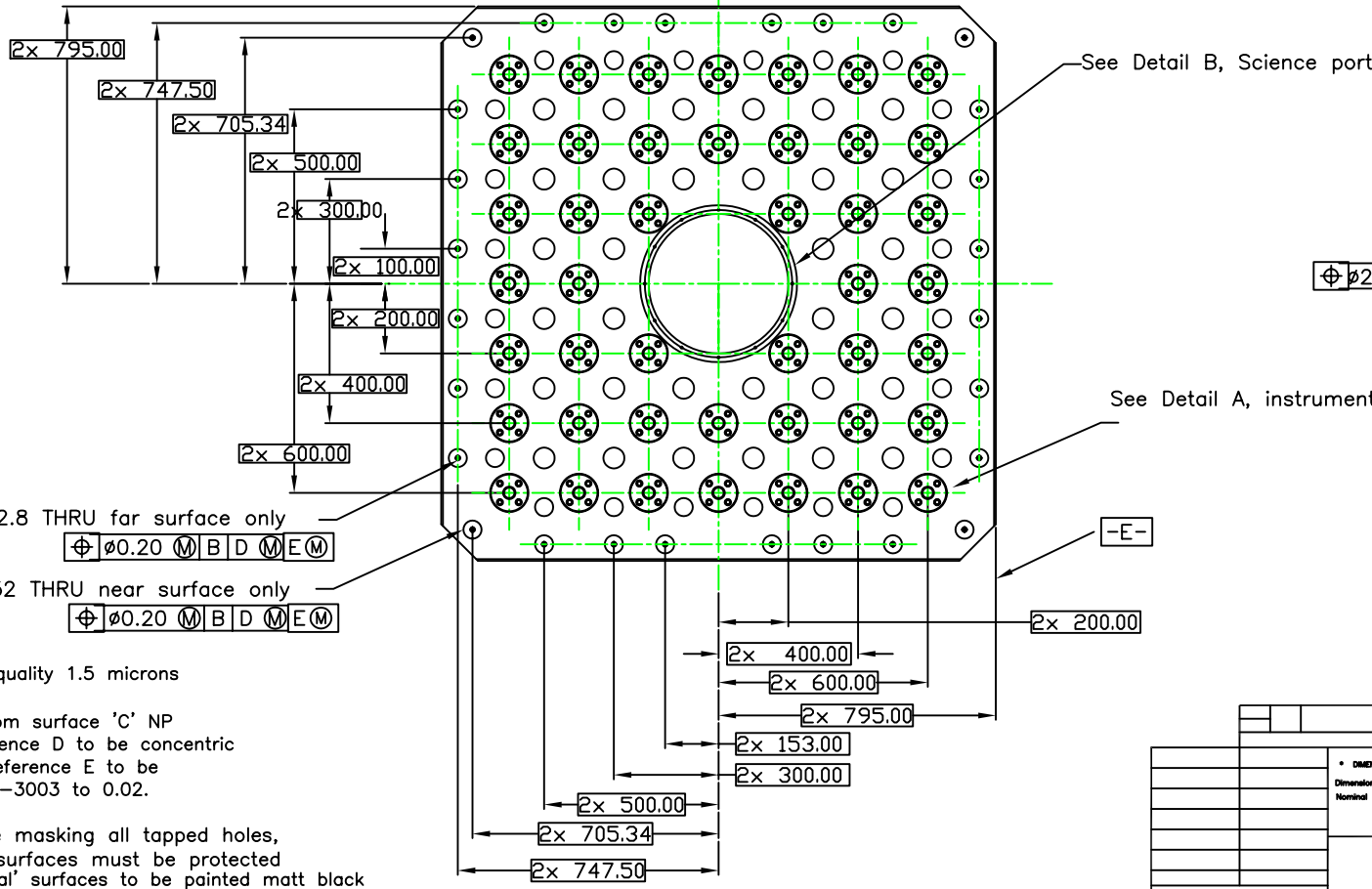
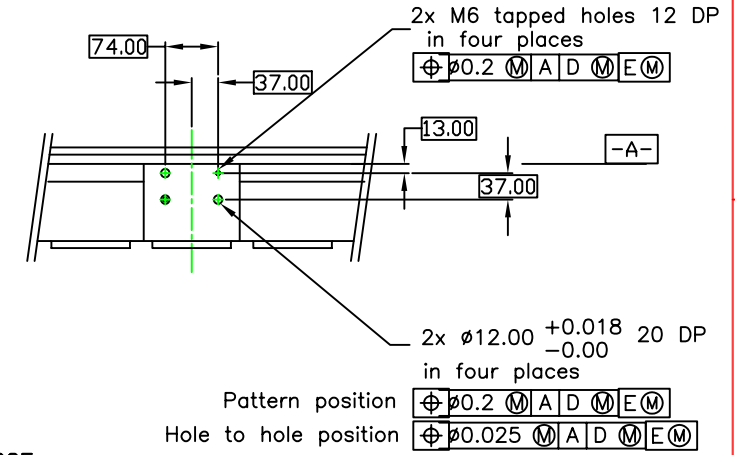
Science port detail. Scale 2:1



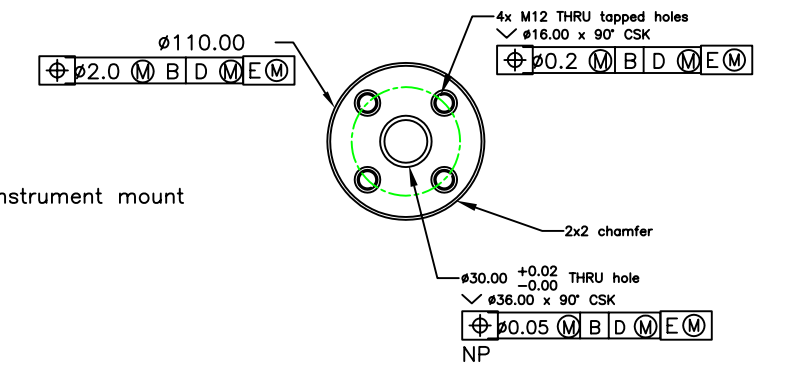
12x M6 12 DP
 $\Phi 0.2$ M A D M E M



View of corner detail looking on 'C' 4x
 Scale: 2:1



Detail A Instrument Mount Detail 4X



Detail is in 44 places

- Note 1: Reference surface A flatness 0.025, surface quality 1.5 microns
- Note 2: Break all machined edges
- Note 3: Locating clearance diameters extend 8mm from surface 'C' NP
- Note 4: On assembly to support structure body, reference D to be concentric to ref B on Drg. 89-1000-3003 to 0.02. Reference E to be parallel with ref. surface D on Drg. 89-1000-3003 to 0.02.

Finish paint all surfaces as described in workscope masking all tapped holes, machined holes and surfaces marked 'NP'. These surfaces must be protected by a thin film lubricant. Port walls and upper 'internal' surfaces to be painted matt black

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS Dimensional tolerances are ± 0.2 U.S. Nominal dimensions are 25		D. MONTGOMERY 4/11/85	GEMINI 8-M Telescopes Project
HOLE TOLERANCES			INSTRUMENT SUPPORT STRUCTURE BASE
		E	89-GP-1000-3003

89-GP-1000-3003 1 2

8

7

6

5

4

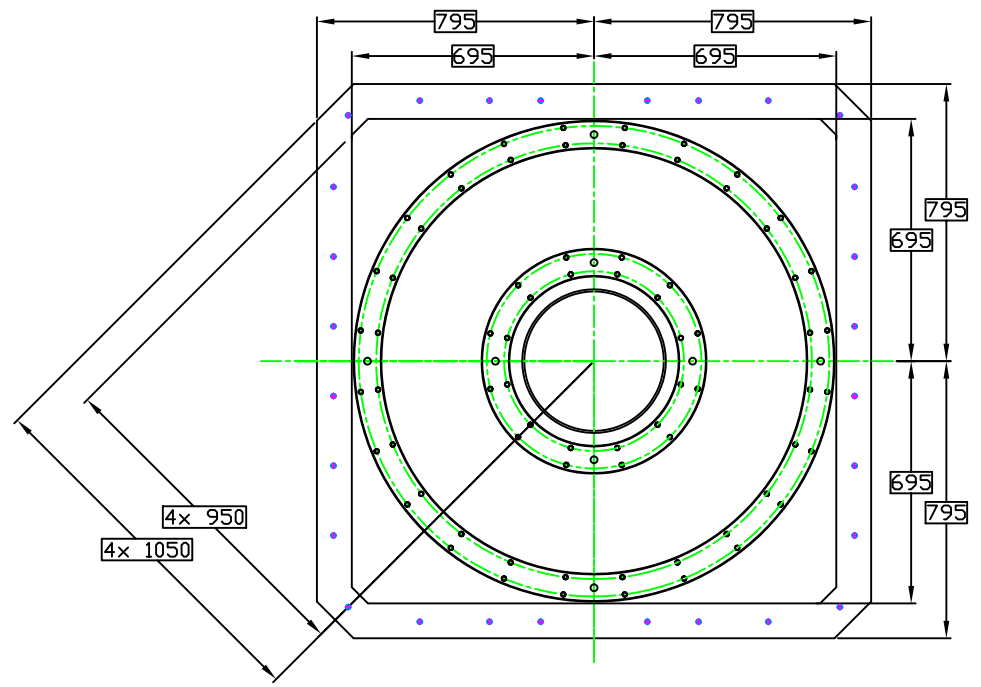
3

2

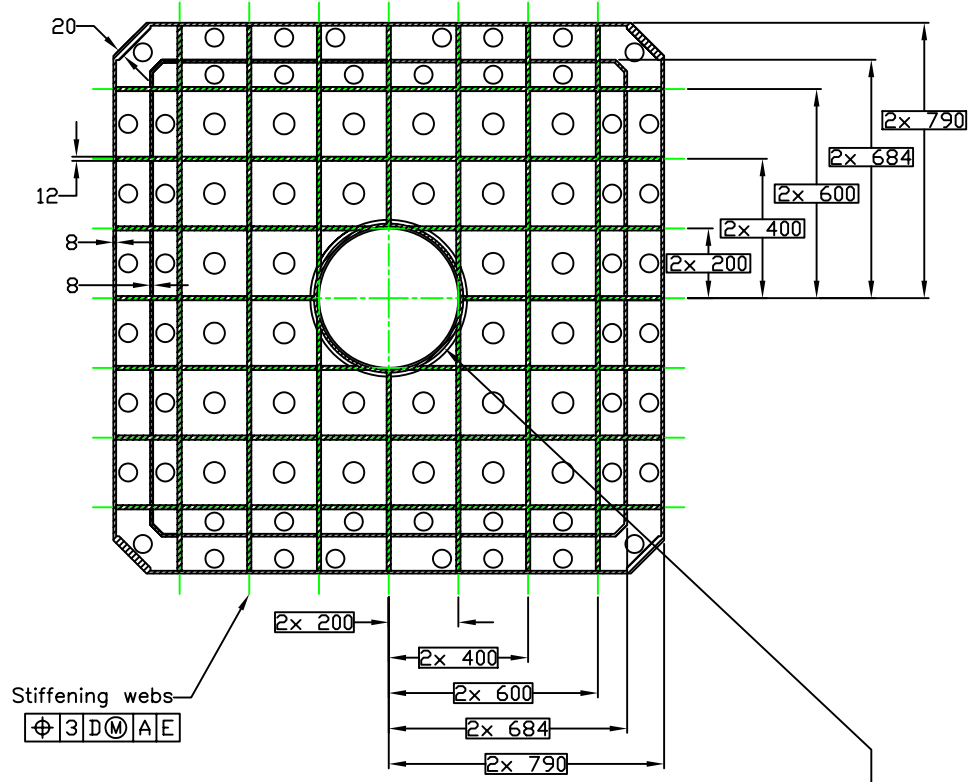
1

H
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D
C
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H
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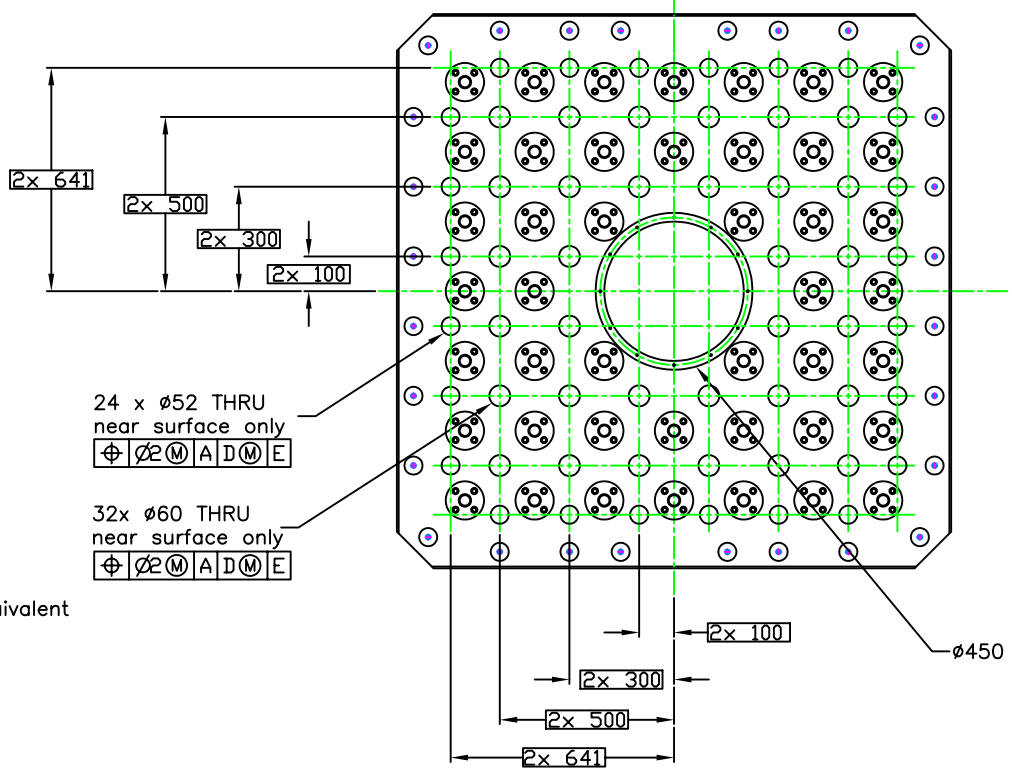
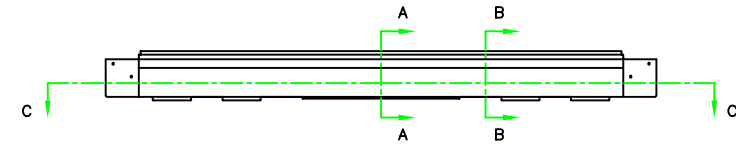
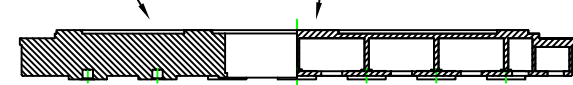


Section through CC

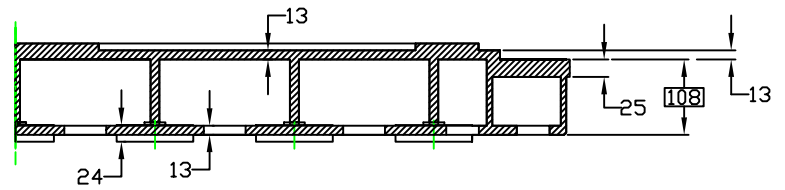


Cylinder 412 internal diameter
8 thick

Part section on AA
Part section on BB



Part section on BB scaled x2



Dimensional tolerances are ± 0.2 U.S.
Fabrication positional tolerances are ± 0.3 U.S.

Note 1. Material is mild steel, ASTM A36 or equivalent
Note 2. General fabrication tolerances are ± 3.0

GEMINI		INSTRUMENT SUPPORT STRUCTURE BASE	
8-M Telescopes Project	D. MONTGOMERY	DATE 7.10.96	SCALE 1/1
RELEASE		SIZE E	SHEET 2 OF 2
		DWG NO. 89-GP-1000-3003	REV C

8

7

6

5

4

3

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