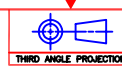
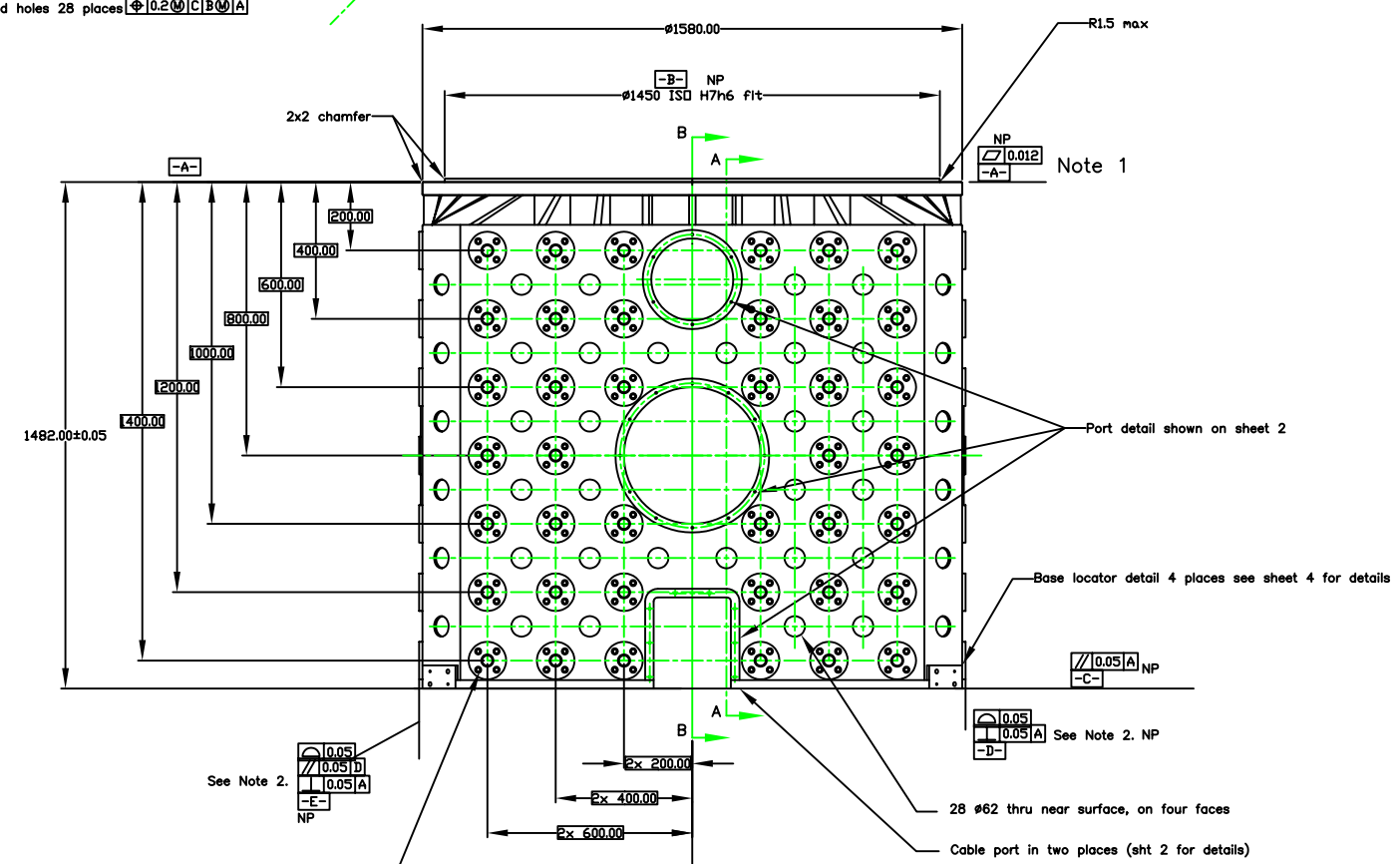
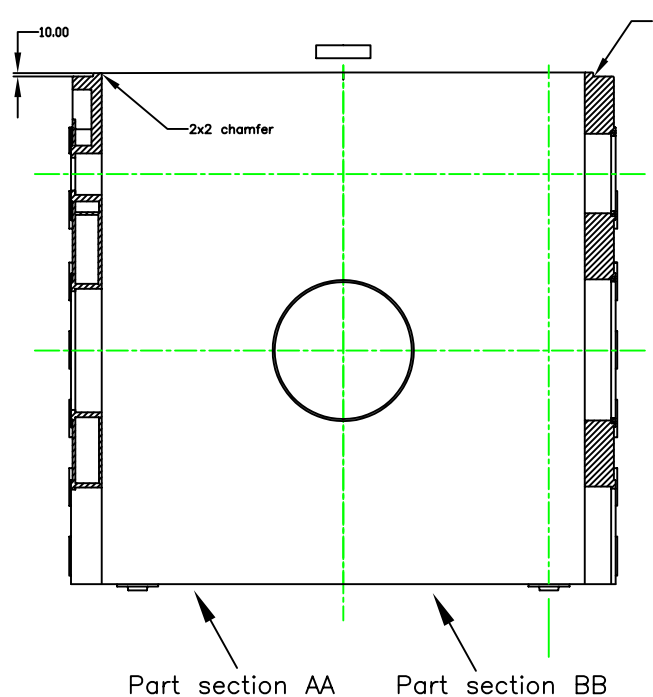
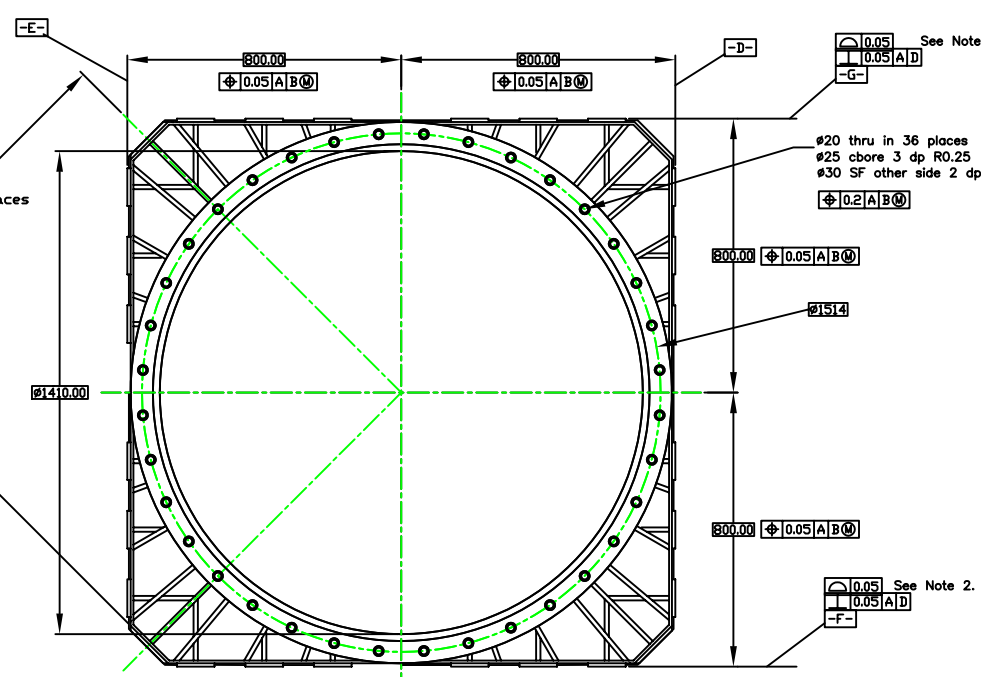
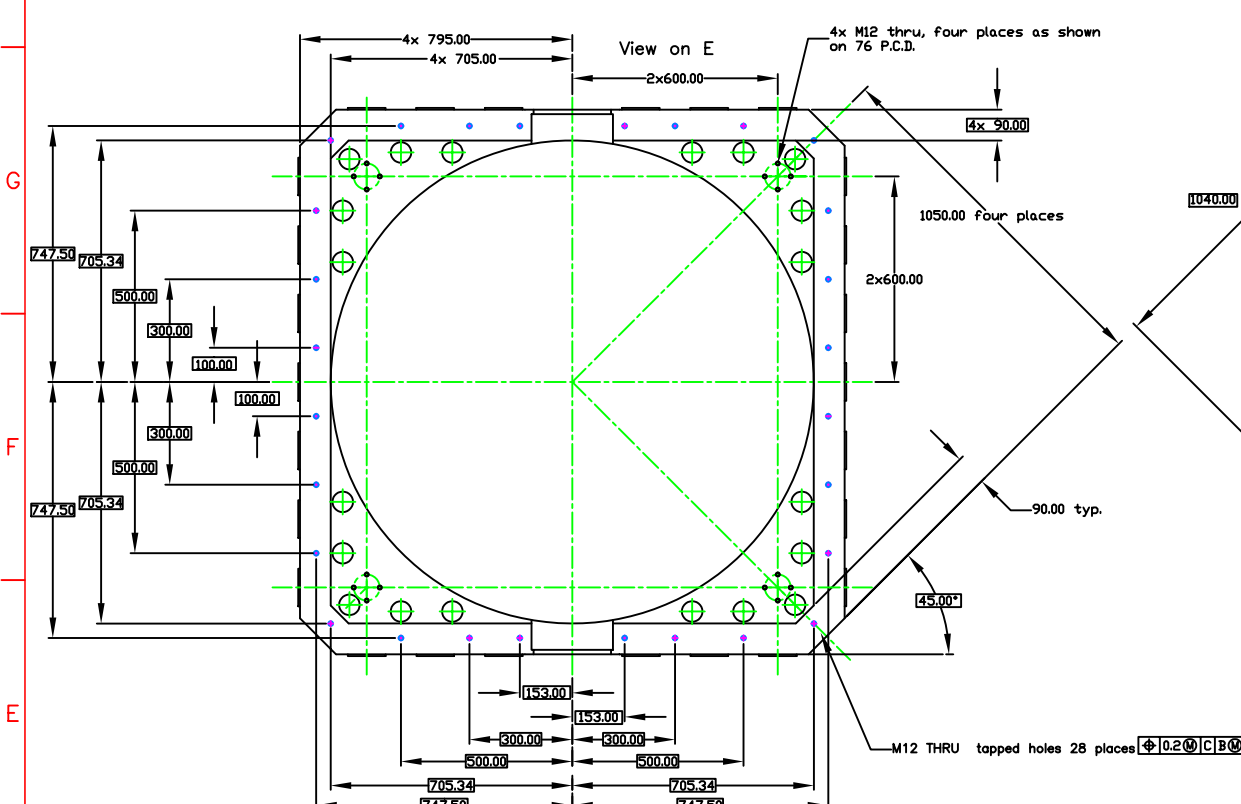


NOTES, UNLESS OTHERWISE SPECIFIED:



REV	DESCRIPTION	DATE	APPROVED
C	AO port size increased		
D	Handling pad detail added	1.22.97	
F	Revised cable port detail	4.25.97	

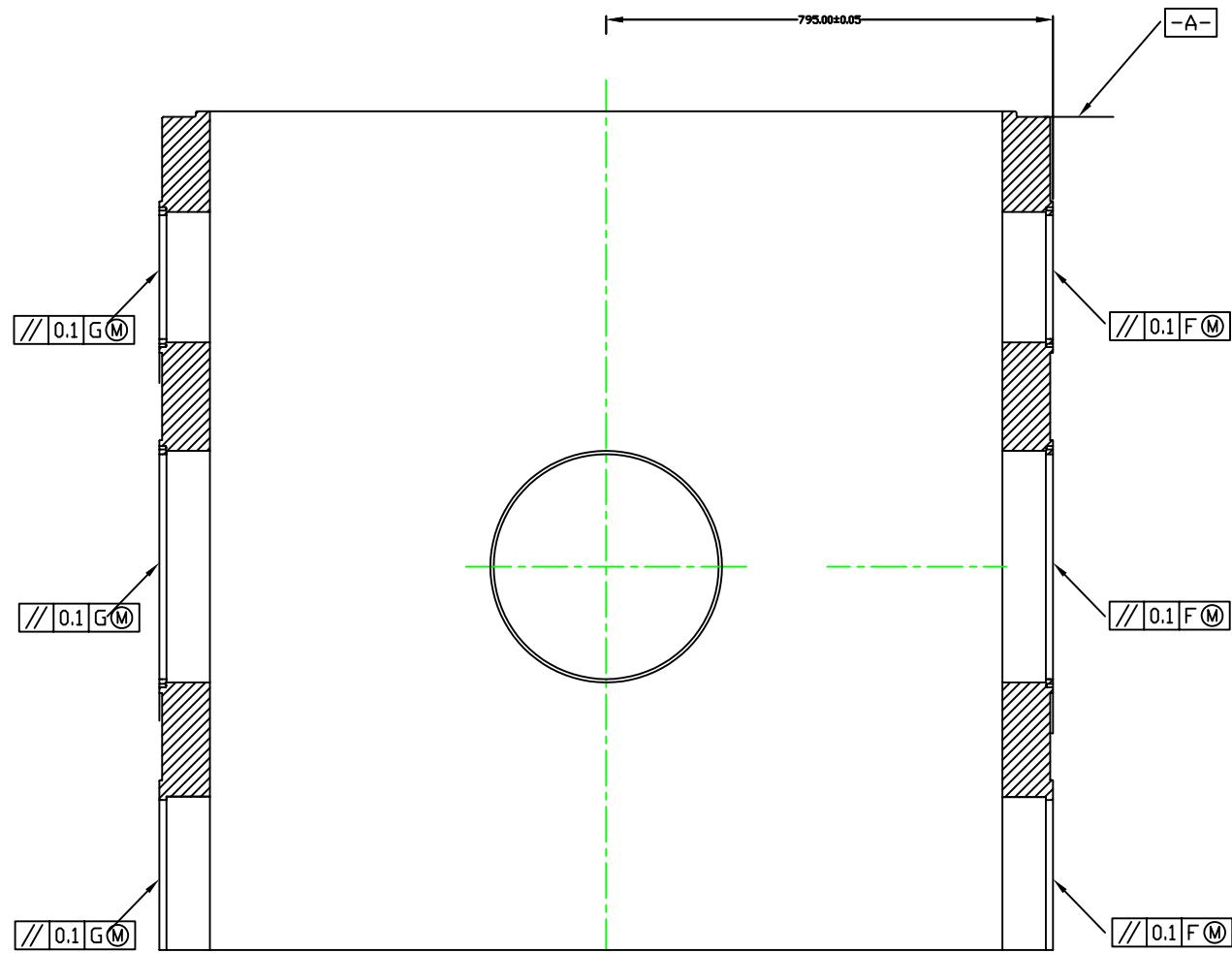


Note1: Surface roughness is 1.5 microns, allowable slope errors are defined on sheet 6
 Note2: Geometric tolerance applies to 40 pads considered as an interrupted surface
 Note3: Break all sharp edges

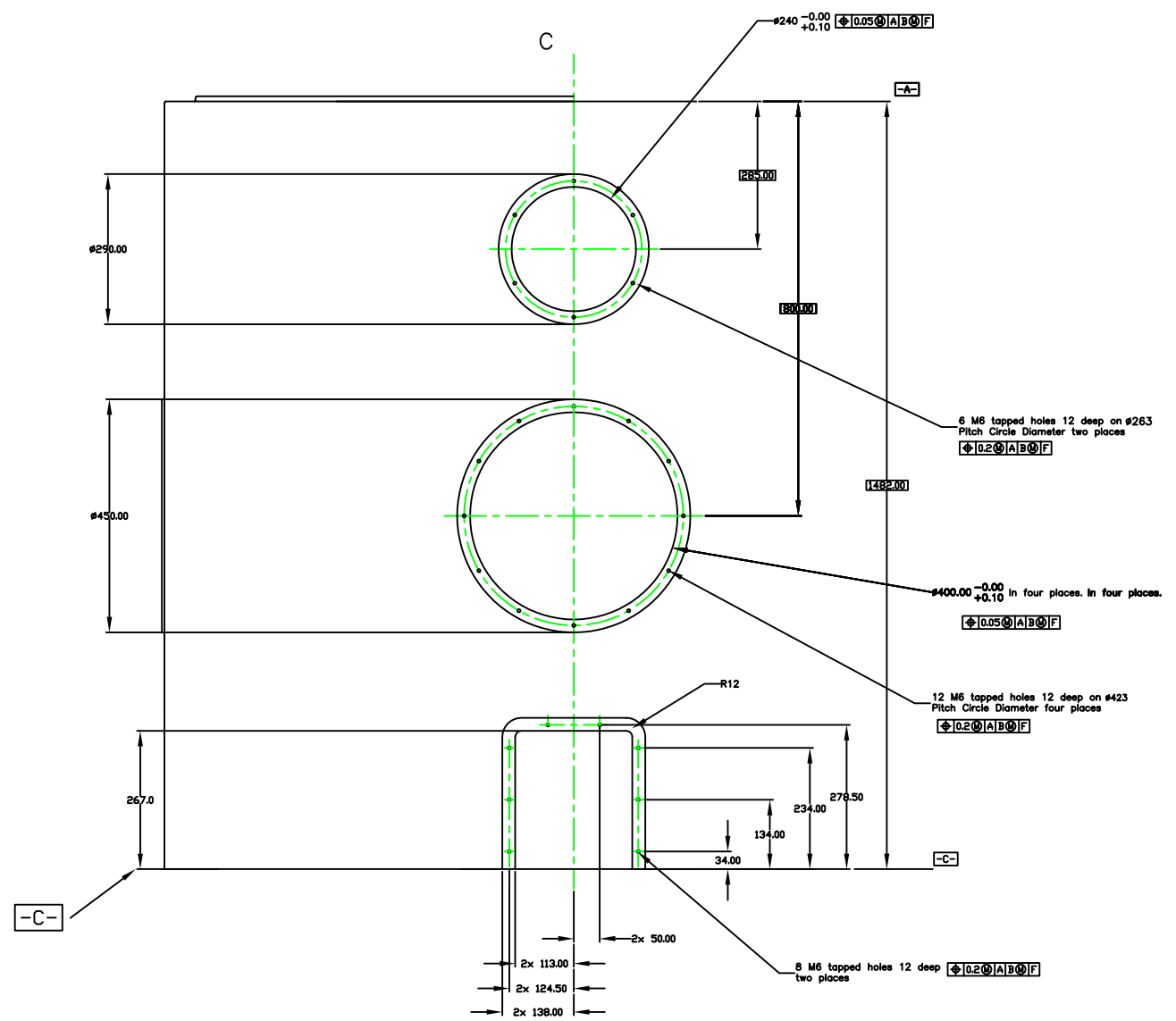
Finish paint all surfaces as described in workscope masking all tapped holes, machined holes and surfaces marked 'NP'. These surfaces must be protected by a thin film lubricant. Internal cylinder and port walls are to be painted matt black.

ITEM NO.	QTY	PART OR IDENTIFYING NUMBER	NOMENCLATURE OR DESCRIPTION	PROCUREMENT SPECIFICATION	NOTES																																				
<p>UNLESS OTHERWISE SPECIFIED</p> <p>• DIMENSIONS ARE IN MILLIMETERS</p> <p>• GENERAL TOLERANCES:</p> <p> FRACTIONS: $F = \pm 0.1$ X = ± 0.5 ANGLES: ± 0.07</p> <p>• DIMENSIONAL INFORMATION IS FOR REFERENCE ONLY</p> <p>• REMOVE ALL BURRS AND BREAK SHARP EDGES 0.5 MAX.</p> <p>• FINISH: POLYURETHANE MACHINED SURFACES 0.25 PM</p> <p>• INSPECTION OF SCREW THREADS IS PER FED-STD-H/20, SYSTEM 21</p>																																									
<p>HOLE TOLERANCES</p> <table border="1"> <tr> <td>33</td> <td>+0.13</td> <td>3.18</td> <td>+0.13</td> <td>0.38</td> <td>+0.15</td> </tr> <tr> <td>THRU</td> <td>-0.23</td> <td>THRU</td> <td>-0.13</td> <td>THRU</td> <td>-0.23</td> </tr> <tr> <td>3.18</td> <td></td> <td>6.35</td> <td></td> <td>12.70</td> <td></td> </tr> <tr> <td>12.71</td> <td>+0.20</td> <td>19.05</td> <td>+0.25</td> <td>25.41</td> <td>+0.30</td> </tr> <tr> <td>THRU</td> <td>-0.23</td> <td>THRU</td> <td>-0.25</td> <td>THRU</td> <td>-0.30</td> </tr> <tr> <td>19.05</td> <td></td> <td>25.40</td> <td></td> <td>50.80</td> <td></td> </tr> </table>						33	+0.13	3.18	+0.13	0.38	+0.15	THRU	-0.23	THRU	-0.13	THRU	-0.23	3.18		6.35		12.70		12.71	+0.20	19.05	+0.25	25.41	+0.30	THRU	-0.23	THRU	-0.25	THRU	-0.30	19.05		25.40		50.80	
33	+0.13	3.18	+0.13	0.38	+0.15																																				
THRU	-0.23	THRU	-0.13	THRU	-0.23																																				
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12.71	+0.20	19.05	+0.25	25.41	+0.30																																				
THRU	-0.23	THRU	-0.25	THRU	-0.30																																				
19.05		25.40		50.80																																					
<p>CONTRACT: 89-GP-1000-3002</p> <p>SCALE: 1/1</p> <p>SHEET: 1 OF 6</p>																																									

Sectional view on CC



View showing port detail on external face



Note 1: non relevant detail omitted for clarity

GEMINI		INSTRUMENT SUPPORT STRUCTURE BODY	
8-M Telescopes Project	D. MONTGOMERY	DATE 10.7.96	SCALE 1/1
REV E	REV E	DWG NO. 89-GP-1000-3002	SHEET 2 OF 6

4

3

2

1

D

D

C

C

B

B

A

A

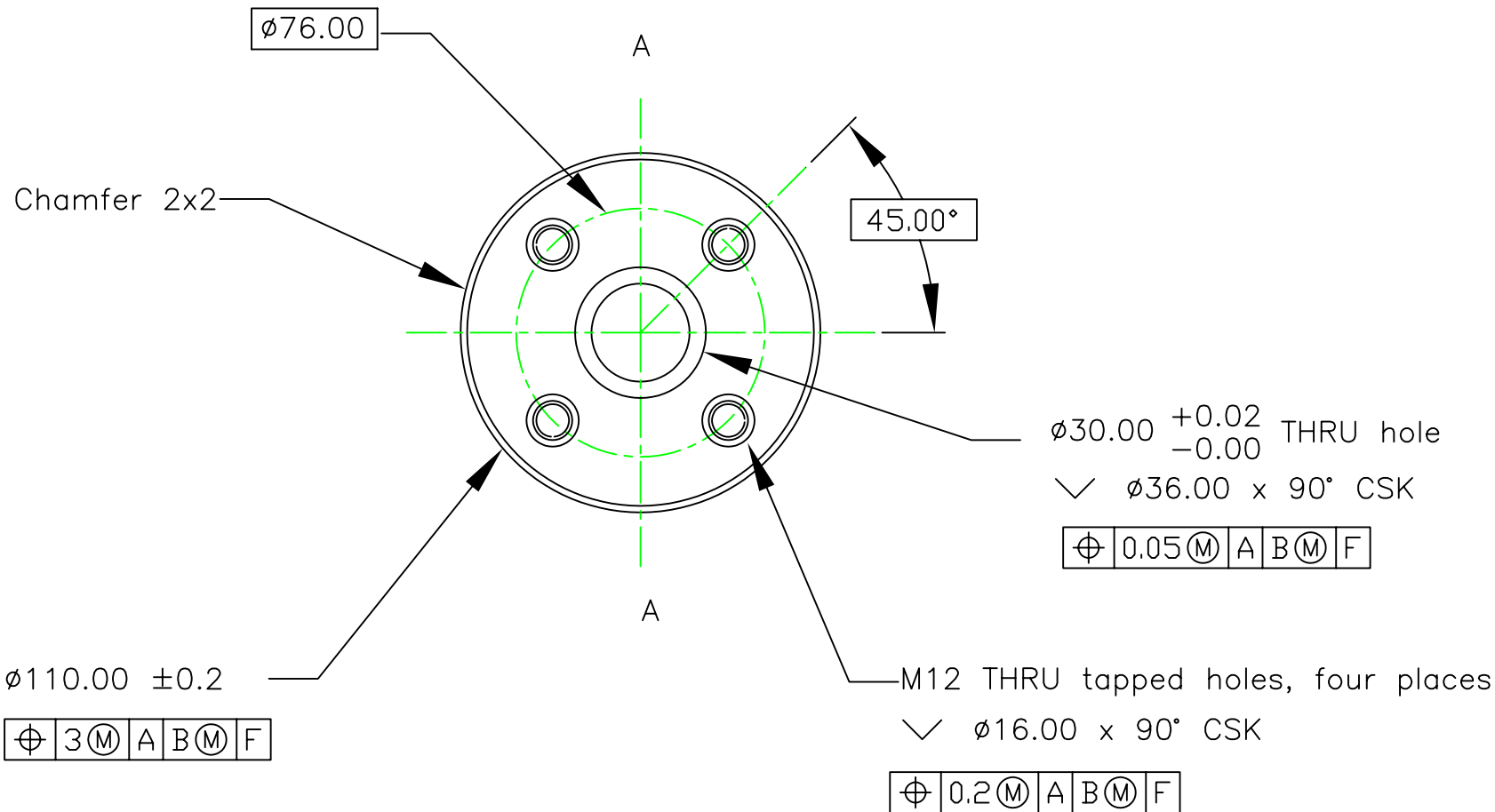
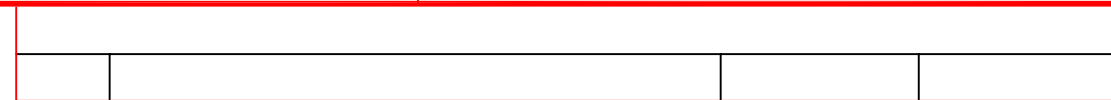
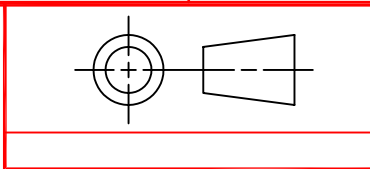
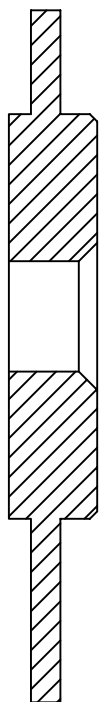
4

3

2

1

Part section through AA



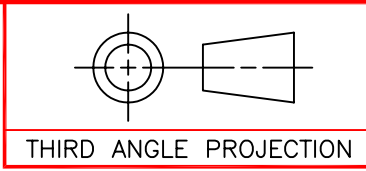
UNLESS OTHERWISE SPECIFIED • DIMENSIONS ARE IN MILLIMETERS Dimensional tolerances are $\pm 0.2\text{mm}$ U.O.S.		David Montgomery	22.Nov.95	GEMINI 8-M Telescopes Project	
HOLE TOLERANCES				ISS instrument mounting pad detail	
				A	89-GP-1000-3002 E
		SCALE 1=1		3	6

4

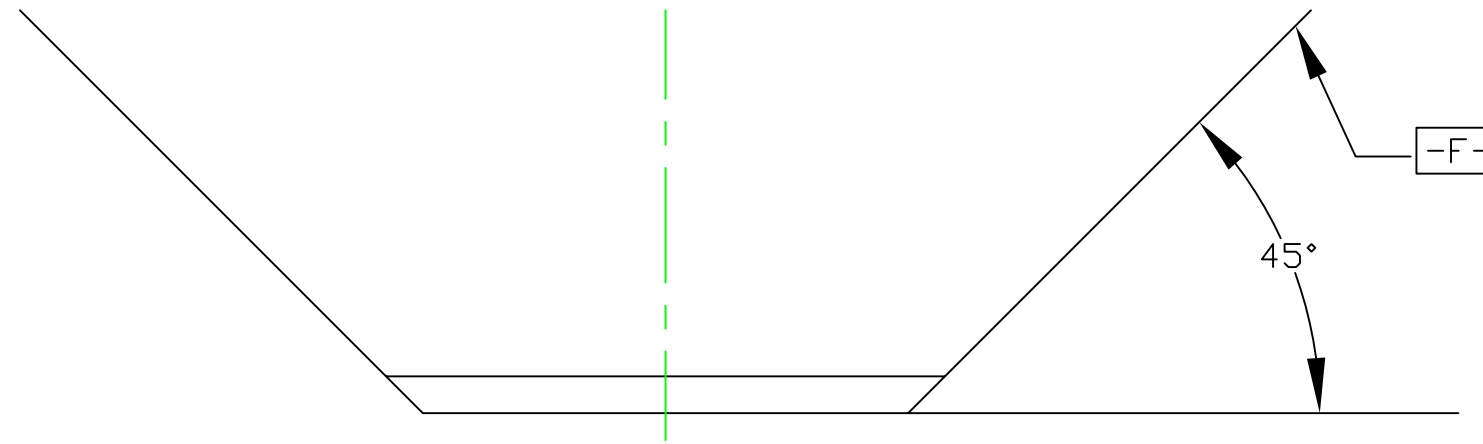
3

2

1



REVISIONS			
REV	DESCRIPTION	DATE	APPROVED

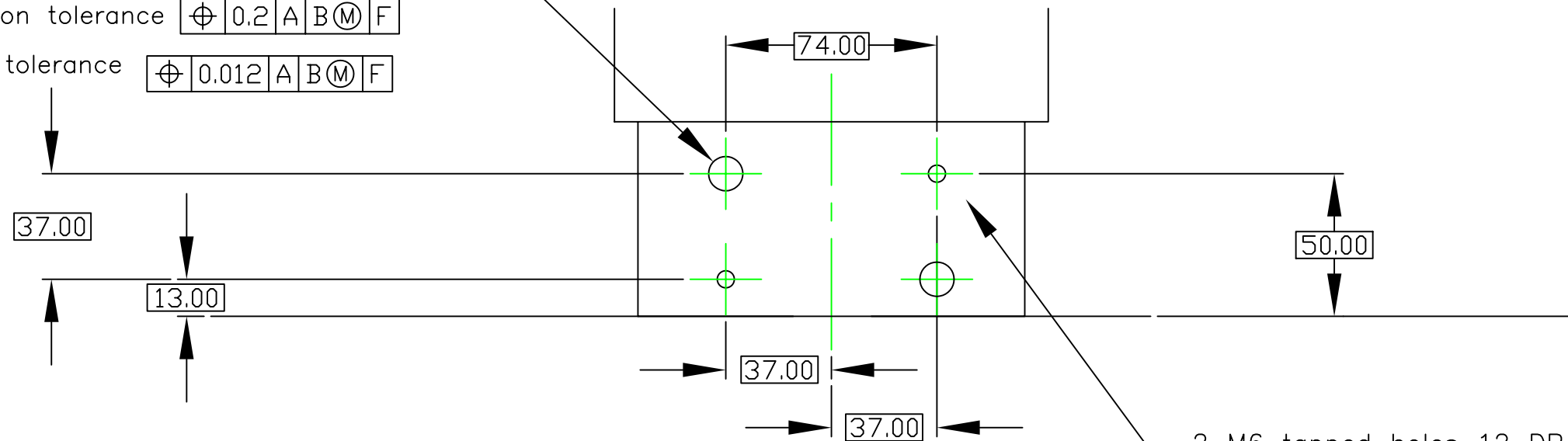


∅12.00 -0.0 +0.018 THRU locating dowel holes in 2 places. Pattern repeated in four places

Pattern position tolerance $\boxed{\oplus 0.2 A B \textcircled{M} F}$

Hole to hole tolerance $\boxed{\oplus 0.012 A B \textcircled{M} F}$

View on A (see sheet 1)



2 M6 tapped holes 12 DP in four places

$\boxed{\oplus 0.2 A B \textcircled{M} F}$

Break all sharp edges

-1 QTY	ITEM NO.	PART OR IDENTIFYING NUMBER	NOMENCLATURE OR DESCRIPTION	PROCUREMENT SPECIFICATION	NOTES

UNLESS OTHERWISE SPECIFIED		DRAWN		DATE	
• DIMENSIONS ARE IN MILLIMETERS		David Montgomery		22 Nov 95	
• INSPECTION OF SCREW THREADS IS IAW FED-STD-H28/20, SYSTEM 21		CHK			
		ENGR			
		APVD			
		QA			
		CONTRACT			
		RELEASE			
NEXT ASSY		USED ON		APPLICATION	

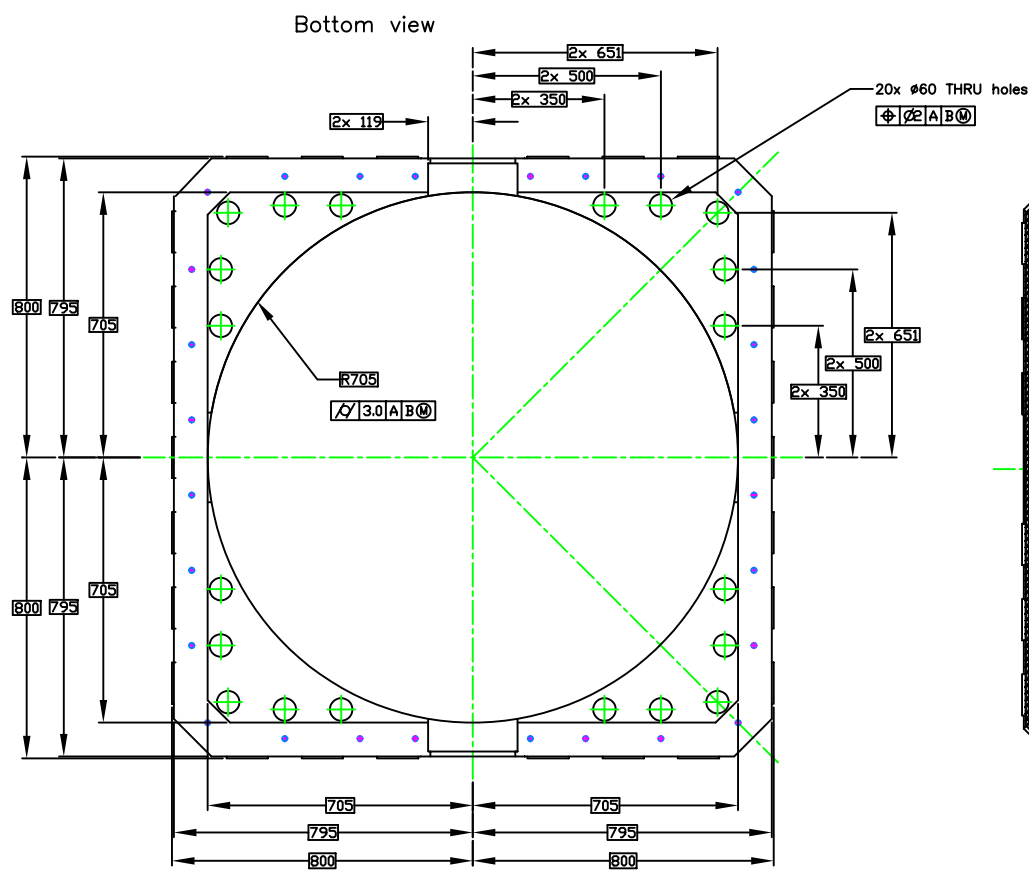
PARTS LIST			
GEMINI 8-M Telescopes Project			
<small>Operated by the Association of Universities for Research in Astronomy, Inc. (AURA) under cooperative agreement with the National Science Foundation</small>			
Base locating block mount detail			
SIZE	DRAWING NO.	REV	
A	89-GP-1000-3002	E	
SCALE:	SCALE	1=1	4 6

4

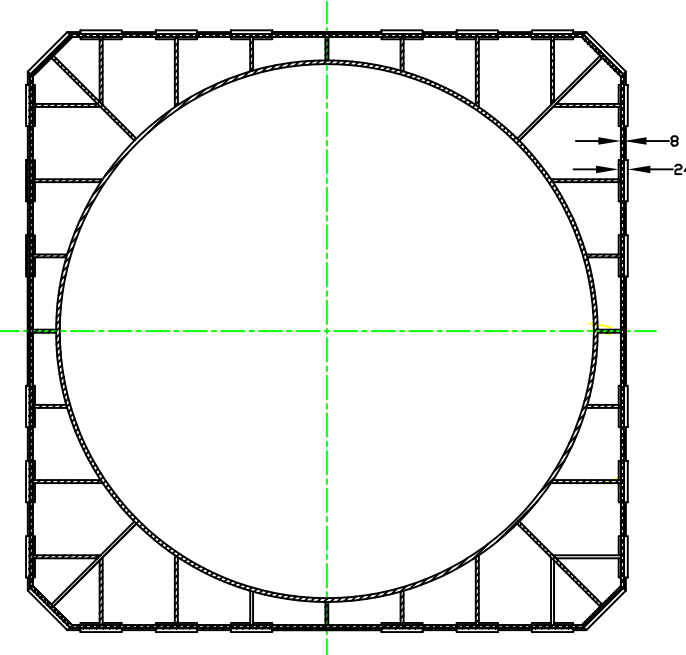
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2

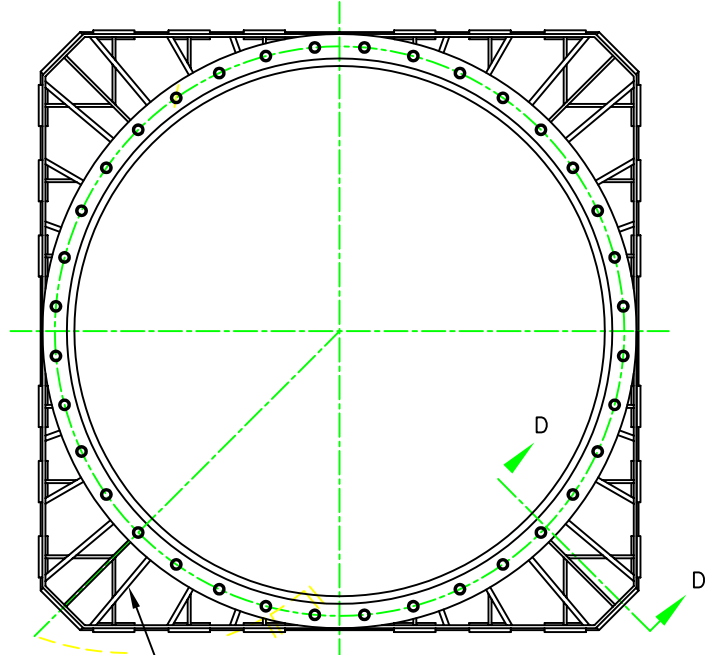
1



Section on C-C

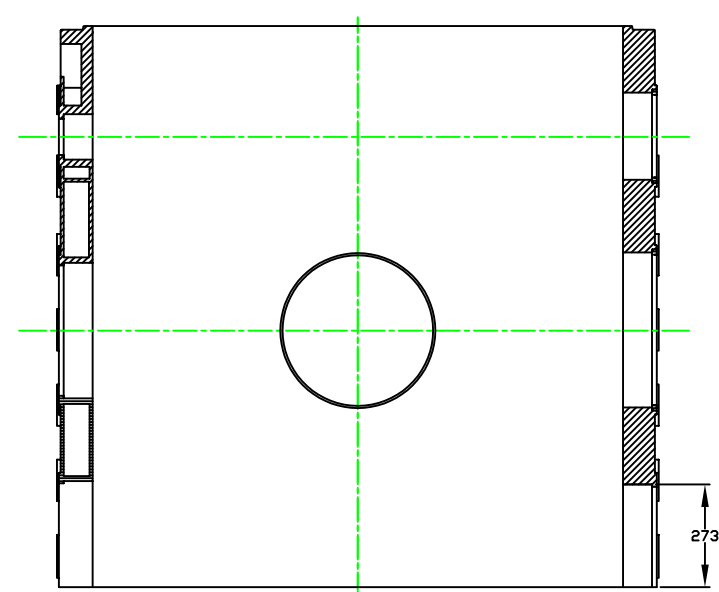


Top view

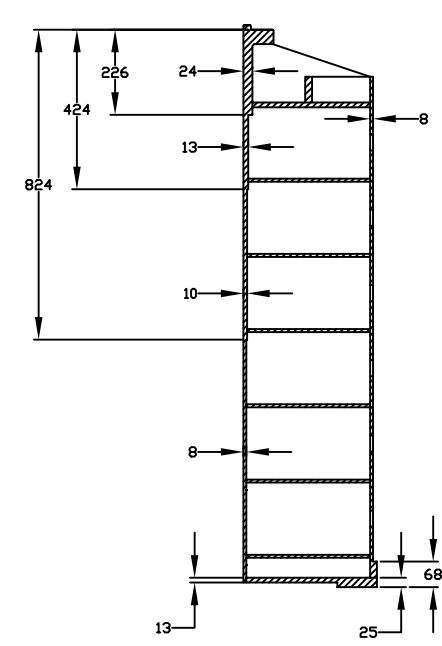


Part section on B-B

Part section on A-A

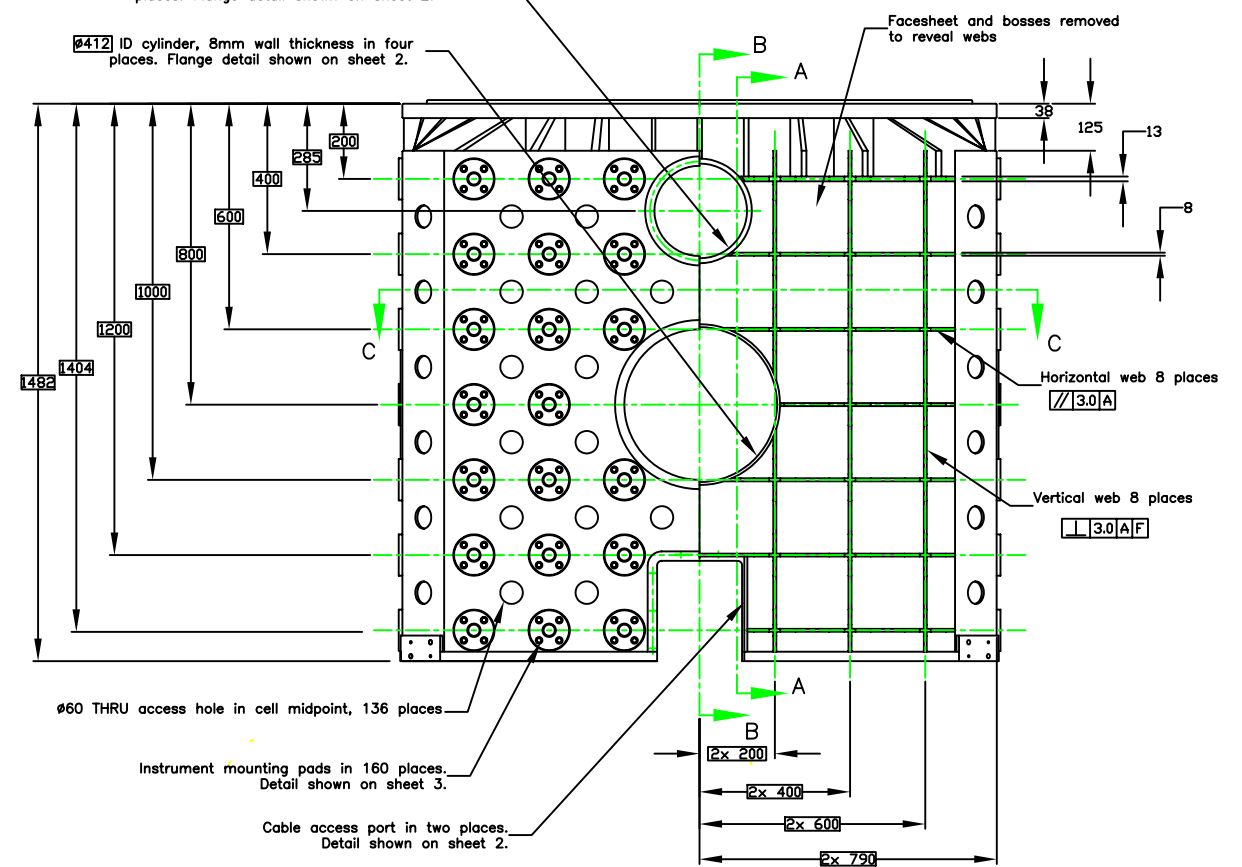


Part section on D-D



Ø252 ID cylinder, 13mm wall thickness in two places. Flange detail shown on sheet 2.

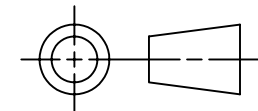
Ø412 ID cylinder, 8mm wall thickness in four places. Flange detail shown on sheet 2.



Note 1: General fabrication position tolerances are ±3mm U.O.S.
 Note 2: Material is mild steel ASTM A36 or equivalent

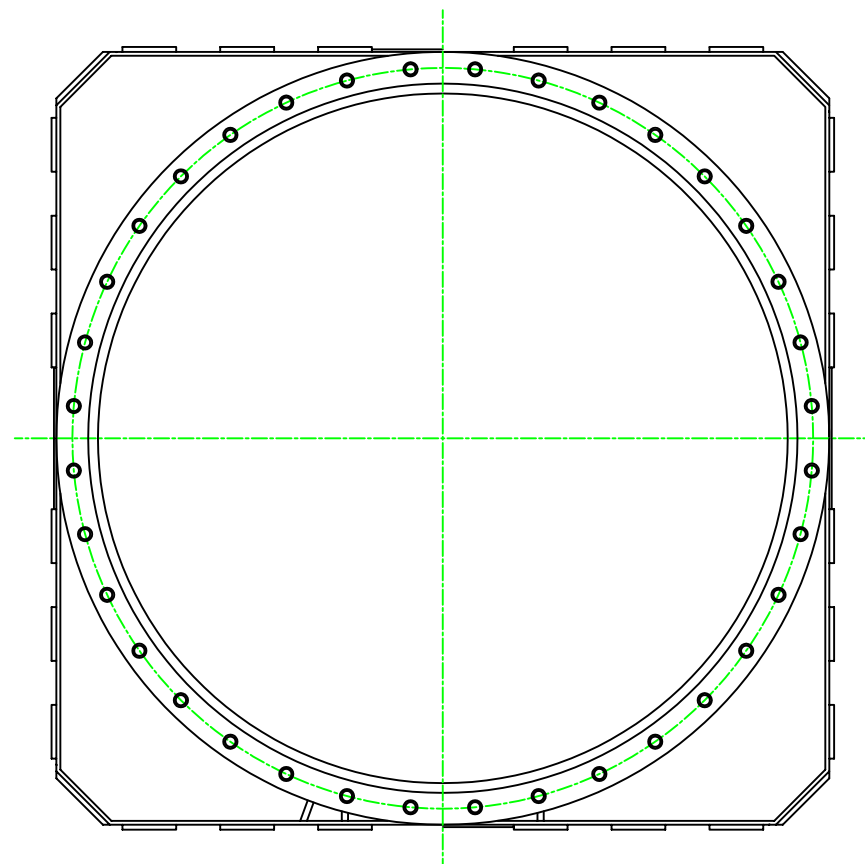
General tolerance ±0.2

INSTRUMENT SUPPORT STRUCTURE BODY (MACHINING)					
GEMINI	D. MONTGOMERY	10.7.96	E	89-GP-1000-3002	E
			1/1	5	6

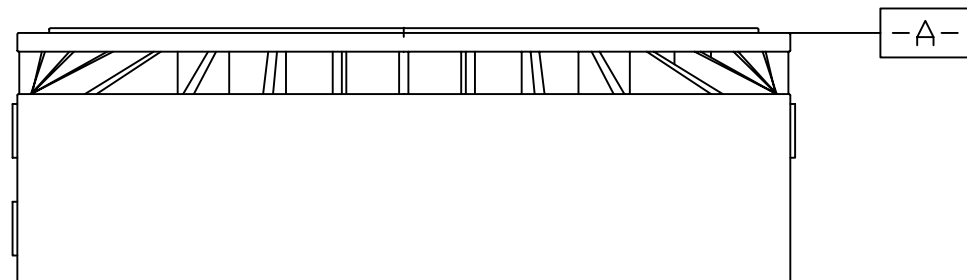
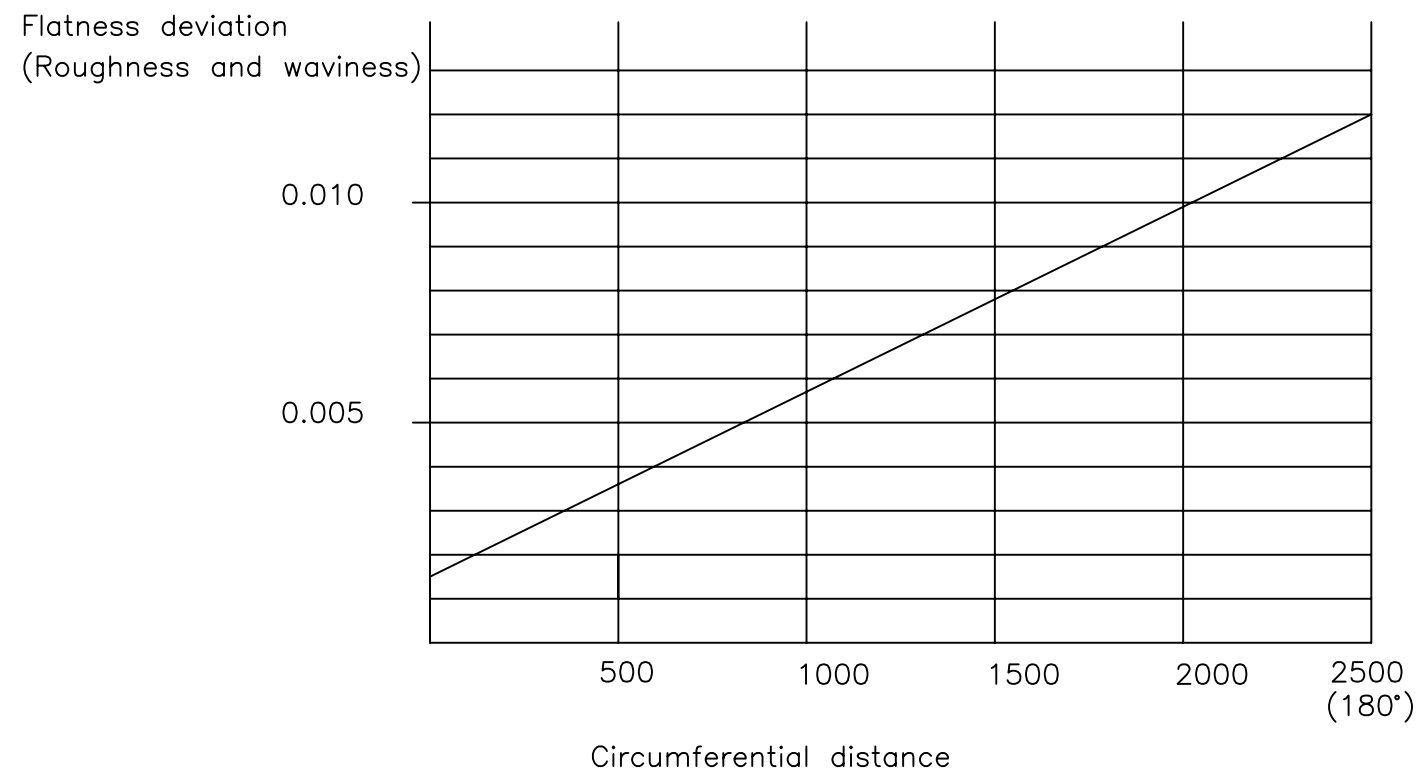


THIRD ANGLE PROJECTION

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED



Circumferentially around the flange from any point, the required flatness tolerance relative to that point and the mean plane is described in the following graph



-1 QTY	ITEM NO.	PART OR IDENTIFYING NUMBER	NOMENCLATURE OR DESCRIPTION	PROCUREMENT SPECIFICATION	NOTES
PARTS LIST					
NEXT ASSY	USED ON				
APPLICATION					

UNLESS OTHERWISE SPECIFIED * DIMENSIONS ARE IN MILLIMETERS	DRAWN David Montgomery	DATE 27 Jan 96	GEMINI 8-M Telescopes Project <small>Operated by the Association of Universities for Research in Astronomy, Inc. (AURA) under cooperative agreement with the National Science Foundation</small>	
	CHK			
	ENGR			
	APVD			
	QA		Mounting flange form tolerance	
	CONTRACT		SIZE A	
	RELEASE		DRAWING NO. 89-GP-1000-3002	REV E
			SCALE: 1=1	6 6