TYP EXTRUDED OR CAST SURFACES

125

(1.5 X 8 PL)

14.30

4 X M5 X .8 ↧ 14 MIN DRILL FROM FS OK

72.00

2

R17.5

12.5

SECTION A-A

52.00

(ADD MATERIAL TO PATTERN AT BOSS LOCATION 6PL)

NOTES, UNLESS OTHERWISE SPECIFIED

1. REMOVE BURRS AND BREAK SHARP EDGES
2. ONE DECIMAL TOLERANCE ± 0.8 MM
3. THIS IS A LIMITED DIMENSION DRAWING SHOWING CRITCAL DIMS AND TOLERANCES. USE MODEL TO DETERMINE DIMS NOT SHOWN
4. MATERIAL: CAST ALUM 356A HAVING 10% ELONGATION MIN
5. PATTERN SHOULD COMPENSATE FOR EXPECTED SHRINKAGE, INCLUDING ANGLE CHANGES (WITHIN TOLERANCE SHOWN)
6. 3 HOLES TO BE BORED IN THE SAME SET-UP TO INSURE PARALLELISM. WATER
7. SAW SLITS AFTER HOLE IS BORED TO SIZE TO MAINTAIN RIGIDITY
8. INSIDE CORNER FILLETS 1 MM MIN, TO 3 MM MAX
9. UNDIMENSIONED MACHINED SURFACES PROFILED WITHIN .3 MM OF SURFACES A, B AND C

C

125

[.61]
15.50
4.50

3 x ∅6.00 RELF

∅8.40 THRU
⌴ ∅ 15.0↧ 6.0

72.05

114.30

3 X ∅ 25.47 / 25.43
SEE NOTE 6
⊥ .07 A

WORKPOINT

2 X ∅ 6.9 / 6.4 THRU BOTH SIDES

2 X M3x0.5 ↧ 6 MIN

80.00

A

3 X 2.0 / 1.0 SAW SEE NOTE 8

154.40

120.00

36.00

B

11.00

10.00

232.00

(217.5)

2 X ∅5.0

3 x 4.0 / 1.0
SEE NOTE 7

40.00

6 X ∅ 5.3 MM THRU FIRST WALL
M5 X .8 ↧ 14 MIN IN NEXT WALL FOR CLAMP SCREWS

-101

NOM CASTING CL WORKPOINT

2 X M6x1.0 ↧ 14 MIN

7.5

A

72.00

(50.30)

125

152.5

271.0

94.19

61.39

2 X M6x1.0 INSERT

(1.5)

∅8.15 / 8.05

(ADD MATL FOR FINISH MACHG)

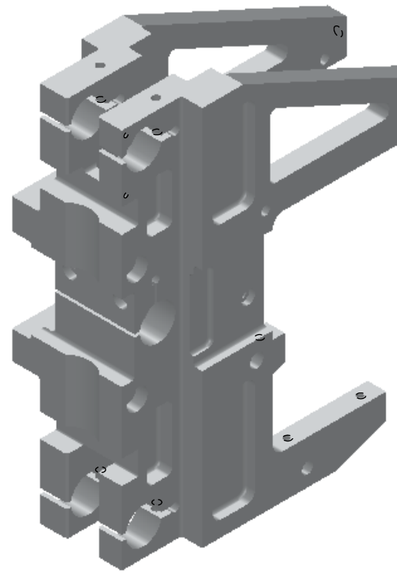
172.00

19.0

∅8.10 THRU ALL

102.0

90 ∅14.1



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METRIC

THIRD ANGLE PROJECTION

NEXT ASSY | USED ON

APPLICATION

UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN MILLIMETERS
TOLERANCES:
ANGULAR: MACH ±0.5°
TWO PLACE DECIMAL ±0.20
THREE PLACE DECIMAL ±0.05
INTERPRET GEOMETRIC TOLERANCING PER: ASME Y14.5M-1994

MATERIAL

FINISH

DO NOT SCALE DRAWING

	NAME	DATE
DRAWN	JM	3-16-10
CHECKED		
ENG APPR.		
MFG APPR.		
Q.A.		

TMT Observatory Corporation
2632 E. Washington Blvd.
Pasadena, CA 91107

TITLE:

SAT HOUSING RH (MACHINING)

SIZE	DWG. NO.	REV
B		

SCALE: 1:3 | WEIGHT: | SHEET 1 OF 1