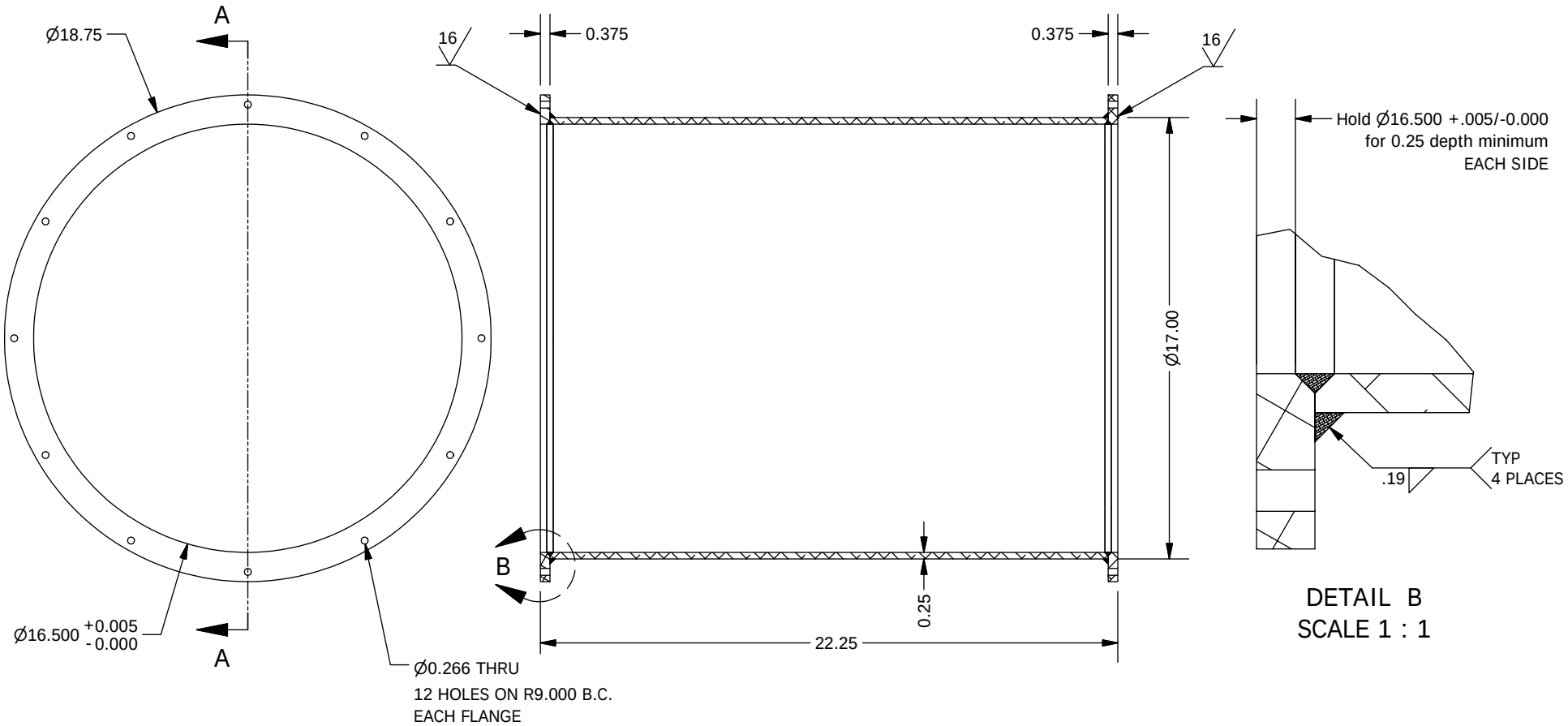

POSSIBLE MANUFACTURING PROCESS

1. Roll oversized (thickness) sheet and weld to form tube. Chamfer ends to prep for weld to flanges.

2. Prepare oversized (thickness) flanges with chamfer preparations for welding to tube. Weld flanges to tube.

3. Machine inside diameter of tube + flanges over full length. The ID tolerance of 16.500 +.005/-0.000 is only applicable to 0.25" from either end. These flanges will be mated to pieces that have a Ø16.498, 0.125 tall boss.

4. Machine complete flange faces. Note surface roughness.

5. All welds MUST be vacuum-grade.

6. Polishing and anodizing to be completed by OCIW.

ITEM	QTY	DESCRIPTION
1	1	PFS11005

Bill of Material

THE OBSERVATORIES
OF THE CARNEGIE INSTITUTION OF WASHINGTON
813 Santa Barbara Street
Pasadena, CA 91101

MATERIAL: Aluminum 6061	UNLESS OTHERWISE SPECIFIED FRACTIONAL +/- 1/32 DECIMAL .XX +/- 0.01 ANGULAR +/- 0.1 DEG .XXX +/- 0.002 GOAL .XXX +/- 0.005 REQD BREAK SHARP EDGES MACHINED SURFACES 125 ALL DIMENSIONS IN INCHES
EST WEIGHT: 32.2 lb	
SCALE: 1:6	**P** lanet **F** inder **S** pectrograph — Prism/Grating Assembly Vacuum Shell

DWN	CRANE	5/11/2007
APVD		
	BY	DATE

SHEET	DRAWING NUMBER		REV
A	PFS11005r1	SHT 1 OF 1	1