



Modification of Tube, 1

Step 1. Cut off central cone parallel to base just above welds.

Step 2. Weld (or bolt) part 5-050 in at top of cone with its top edge level with the base plate.

Base Plate of Mirror Cell

Step 3. Machine pocket into top face of central cone as shown in inset at right.

12 holes spaced  
for 0.1875 inches  
apart on 0.1875  
dia. hole  
 $\varnothing 0.003$

17.000

Machining: Bore a pocket into the central cone concentric with the axis of the mirror cell, with bottom parallel to the base plate of the cell and 0.25 inches below the top of the base plate. Drill and tap 12 screw holes to attach central cylinder (part 5-003).

Tenn. State Univ.	
CASS 2-m AST Project	
06/24/97	AST-05-R10
J.A.E.	