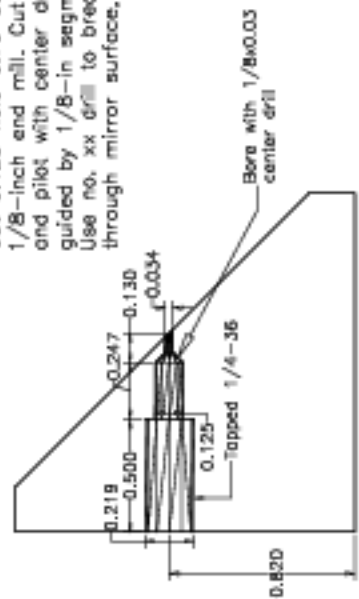


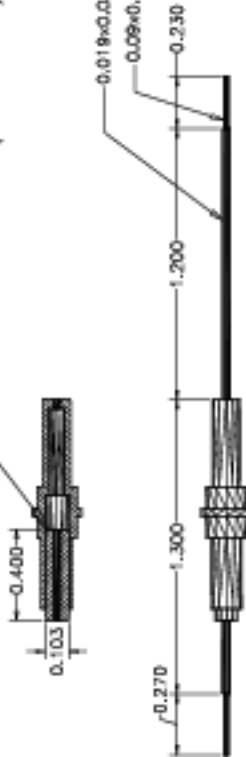
Boring Holes in Guide-Mirror

Start hole with counterbore .73 deep. Drill end tap top of hole. Cut 0.125 hole 0.73 deep with 1/8-inch end mill. Cut taper and pilot with center drill, guided by 1/8-in segment. Use no. xx drill to break through mirror surface.

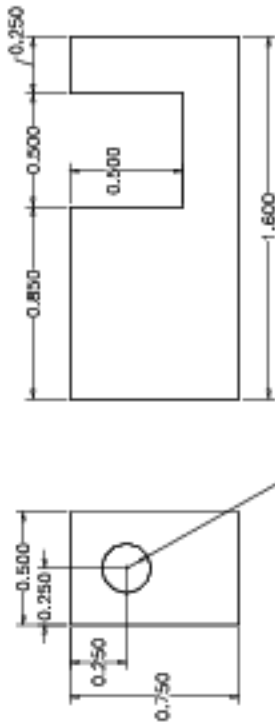


Part 5-067, Details of holes for Fiber Optic Guides. Make all three holes the same size (contrary to the appearance of the other drawings). This is a cut through the hole, essentially the same view as in ast-05-r23.

Make guide of 0.101 drill rod, center-drilled 0.052 (no. 55 drill)



Parts 5-130--134, Holder for fiber projecting through pickoff mirror. (6 reqd)



Part 5-140, Alignment jig. Make of aluminum sheet. (1 reqd)

Tenn. State Univ.	
CASS 2-m AST Project	
07/04/00	AST-05-R24
J.A.E.	