1. SURFACE FINISH INSIDE DOME TO BE 32 MICRO-INCHES OR BETTER PRIOR TO WELDING.
2. DEBURR AND BREAK SHARP EDGES.
3. STRESS RELIEVE PRIOR TO MACHINING.
4. PART TO BE VISIBLY CLEANED PER VENDOR STANDARD CLEANING PROCEDURE. ALL SURFACES TO BE FREE OF OILS, FINGERPRINTS AND PARTICULATES.
5. VENDOR TO FABRICATE FIND NO'S 2, 3 AND 4.

HOLES MARKED "A"
- .456 X 90°, FAR SIDE
- .456 X 90°, NEAR SIDE

THRU ALL

HOLES MARKED "B"
- .597 X 90°, FAR SIDE
- .600 X 90°, NEAR SIDE

12X

DOMES MARKED "X"
- .015

- .010

DIMENSIONS ARE IN INCHES
TOLERANCES:
FRACTIONAL
ANGULAR: MACH .5
BEND TWO PLACE DECIMAL .005
THREE PLACE DECIMAL

MATERIAL
FINISH
INTERPRET GEOMETRIC TOLERANCING PER:

APPLICATION USED ON NEXT ASSY B

M.I.T Kavli Institute for Astrophysics & Space Research

REV

DATE

NAME

COMMENTS

Q.A.
MFG APPR.
ENG APPR.
CHECKED
DRAWN

DIMENSIONS
FINISH
MATERIAL
INTERPRET GEOMETRIC TOLERANCING PER:

DIMENSIONS ARE IN INCHES
TOLERANCES:
FRACTIONAL
ANGULAR: MACH .5
BEND TWO PLACE DECIMAL .005
THREE PLACE DECIMAL

APPLICATION USED ON NEXT ASSY B
NOTES: FINISH AND MASKING

- MASK FROM FINISH AS SHOWN.
- MASK HOLES AS SHOWN.
- CHAMFER CAN BE EITHER MASKED OR PAINTED.

4. PRIME WITH P123 PRIMER AND PAINT WITH AEROGLAZE Z306 BLACK PER ECSS-Q-70-13 OR EQUIVALENT. THE ACCEPTANCE CRITERIA SECTION 6 (EXCEPT FOR ADHESION TESTING) MAY BE USED FOR ADEQUACY TESTING.

5. ADHESION TESTING SHALL BE USED FOR ADEQUACY TESTING PER ECSS-Q-70-13 OR EQUIVALENT AND SUPPLIED TO MIT.