

NOTES: UNLESS OTHERWISE SPECIFIED:

1. **CAUTION:** THIS ASSEMBLY IS USED TO SUPPORT OPTICAL COMPONENTS. PRIOR TO INSTALLING OPTICS, CLEAN ALL GREASE, OIL, AND DEBRIS FROM NON-OPTICAL COMPONENTS INCLUDING THREADED HOLES. WASHING WITH SOAP AND WATER FOLLOWED BY SOLVENT SUCH AS ACETONE OR ETHANOL IS RECOMMENDED. WEAR CLEAN GLOVES WHEN HANDLING COMPONENTS AFTER CLEANING AND WHEN ASSEMBLING.
2. LIGHTLY COAT FASTENER THREADS WITH DOW CORNING 321 MOLY/GRAPHITE DRY LUBRICANT. REMOVE EXCESS LUBRICANT AND LET DRY. FAILURE TO LUBRICATE FASTENERS MAY CAUSE THREAD GALLING/SEIZING.
3. STORE ASSEMBLY IN CLEAN, DRY ENVIRONMENT UNTIL USE.

THIS HANDLE TO BE REMOVED  
WHEN ASSEMBLY TO AS-ISS  
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DETAIL A  
SCALE 1 : 5

**NOTE:** O-RING TO BE CUT TO LENGTH AND EPOXY GLUED USING  
SUPER-GLUE SUGGETED BY VENDOR (McMASTER 7569A22  
OR O-RING CORD SPLICING KIT - 9695K11).

**NOTE:** INSTALL KEY-INSERTS USING  
APPROPRIATE TOOL.

**NOTE:** ITEM 11 TO BE SEALED AND GLUED IN PLACE  
AFTER INSTALLATION OF ITEM 5 IS COMPLETED.  
EPOXY SUGGESTED: DOW CORNING SILICONE SEALANT.

DETAIL C  
SCALE 1 : 5

**NOTE:** O-RING TO BE CUT TO LENGTH AND EPOXY GLUED USING  
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ISOMETRIC VIEW

ITEM	QTY.	DESCRIPTION	NORM/DIMENSION/DRAWIN
1	1	FSU MOUNTING FLANGE	JPC-500-DWG-0101-rev2.0
2	1	FSU MOUNTING FLANGE LOCATOR BUSHING	JPC-500-DWG-0102-rev1.0
3	1	MOUNTING FLANGE LOCATOR GROOVE	JPC-500-DWG-0103-rev1.0
4	2	MODIFIED MCMASTERCARR - 93600A185 - DIA8x16 DOWEL PIN	JPC-500-DWG-0104-rev1.0
5	1	FSU AUXILIARY FLANGE SUPPORT INTERFACE	JPC-500-DWG-0105-rev1.0
6	1	FSU AUXILIARY FLANGE SUPPORT SHORT PIN	JPC-500-DWG-0106-rev1.0
7	1	FSU AUXILIARY FLANGE SUPPORT LONG PIN	JPC-500-DWG-0107-rev1.0
8	8	FSU LOCATOR WASHER	JPC-500-DWG-0109-rev1.0
9	30	SEALED ALUMINUM CAP	JPC-500-DWG-0110-rev1.0
10	1	MCMASTER-CARR - N2 O-RING SEAL .139in - ISS TO FSU	9407K12
11	2	MCMASTERCARR - DIA8x16 DOWEL PIN	93600A185
12	1	MCMASTERCARR - BONN SHUTTER SOFT VITON O-RING	7643K75
13	14	CARRLANE - KEY INSERT	CLM-58-SKS
14	4	MCMASTER-CARR - PLASTIC PULL HANDLE	1078A1
15	8	SOCKET HEAD CAP SCREW	M3 x 0.5 x 10mm - DIN912
16	8	SOCKET HEAD CAP SCREW	M6 x 1.0 x 16mm - DIN912
17	16	SOCKET HEAD CAP SCREW	M8 x 1.25 x 30mm - DIN912

<b>ASTRO</b>			SYSTEM/SUB-SYSTEM:	OAJ T250	SIZE:	A2
TOLERANCES UNLESS OTHERWISE NOTED: DIN 7168-4-R			JPCam			
<b>NOTES: UNLESS OTHERWISE NOTED</b> 1. DIMENSION LIMITS AFTER PLATING 2. DIMENSIONS ARE IN MILLIMETERS (mm) 3. REMOVE AL BURRS AND SHARP EDGES			MATERIAL/SIZE:	SEE PART LIST	TITLE:	FSU MOUNTING FLANGE ASSY
CHECKED	F.SANTORO	SIGN	DATE	SURFACE RUGHNESS:	3.2/	DRAWING NO.
DESIGNED	F.SANTORO		OCT/2014	PLATING:	N/A	JPC-500-DWG-0100-rev1.0
DRAWIN	F.LOURENÇO		OCT/2014	HEAT TREATMENT:	N/A	NEXT ASSY:
REVIEWS	00					JPC-500-DWG-0010-rev1.0
QTY.:	01	DENSITY:	N/A	kg/m <sup>3</sup>	MASS:	MEDIA FILE:
					34.25kg	JPC-500-DWG-0100
						SHEET: 01/01