

**NOTES:**

**1. CLEANLINESS, CONTAMINATION:**

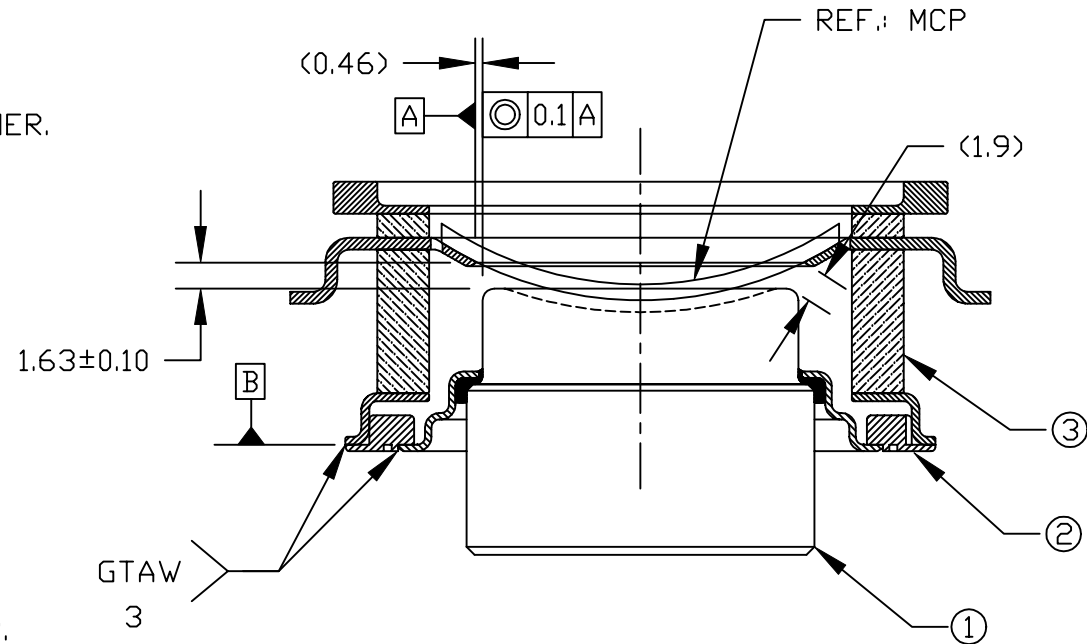
- A. PARTS MUST BE CLEANED PRIOR TO ASSEMBLY. ONLY LIGHT SPOT CLEANING ON OUTSIDE OF COMPLETED ASSEMBLY IS ALLOWED DUE TO DELICATENESS OF PHOSPHOR COATING.
- B. HANDLE WITH GLOVES AT ALL TIMES.
- C. ASSEMBLY IN CLEAN ROOM ENVIRONMENT. WHEN NECESSARY TO REMOVE FROM CLEAN ROOM, BAG PARTS OR STORE IN CLEAN, SEALED CONTAINER.

**2. ASSEMBLY INSTRUCTIONS:**

- A. STACK PARTS AS SHOWN; PROTECT FIBER OPTIC FACE; PREVENT CONTACT WITH OR CONTAMINATION OF PHOSPHOR COATING.
- B. MEASURE CLEARANCE OF FIBER OPTIC CORNER WITH I.D. OF CURVE FLANGE ON BRAZED ASSY. DETERMINE FINAL CUT ON SURF. **[B]** OF I/F RING TO MEET INDICATED DIMENSION SPEC'S.
- C. WELD FIBER OPTIC ASSY TO I/F RING.
- D. REASSEMBLE PARTS AND VERIFY STEP B.
- E. PROTECT F/O FACE AND SECURE A PROTECTIVE CUP OVER PHOSPHOR COATING AS PREP. FOR REMOVAL FROM CLEAN ROOM AND MACHINING STEP.
- F. MAKE FINAL CUT ON SURF **[B]** OF I/F RING.
- G. REASSEMBLE PARTS AND VERIFY DIMENSIONS.

**3. WELD HERMETIC TO 1X10-8 ATM-CC/SEC.**

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
A	BASELINE RELEASE	9/26/97	D.S.



25 mm

3	1	8078-A3	BRAZED ASSEMBLY	
2	1	8063-A3	DET. BODY TO F.O. I/F RING	
1	1	8064-A3	FIBER OPTIC ASSEMBLY	
ITEM#	QTY	PART NUMBER	NOMENCLATURE	MATERIAL SPECIFICATION

THIRD ANGLE PROJECTION			
NEXT	FINAL	NEXT ASSY	USED ON
QTY REQD PER ASSY		APPLICATION	

TOLERANCES (EXCEPT AS SPECIFIED)		
OVER	TO	TOLERANCE
0	49.99	±0.1
50	249.9	±0.5
250	-	±1
ANGLES		±0.1°
SURFACE FINISH		
SURFACE TREATMENT		
		MASS

DO NOT SCALE DRAWING	
METRIC DRAWING (UNITS: mm)	
INTERPRET PER ANSI Y14.5-1982	
WELDING SYMBOLS PER ANSI/AWS A2.4-79	
APPROVALS	DATE
DRAWN J. STOCK	9/23/97
CHECKED D.S.	9/25/97
ISSUED J.S.	9/26/97

<i>Experimental Astrophysics Group</i> UNIVERSITY OF CALIFORNIA, BERKELEY, USA			
DWG TITLE <b>DETECTOR-FIBER OPTIC SUBASSY</b> WIC DETECTOR			
SIZE	PROGRAM	DWG. NO.	REV
A	IMAGE-FUV	8134-A3	A
SCALE	2/1	SHEET	1 OF 1