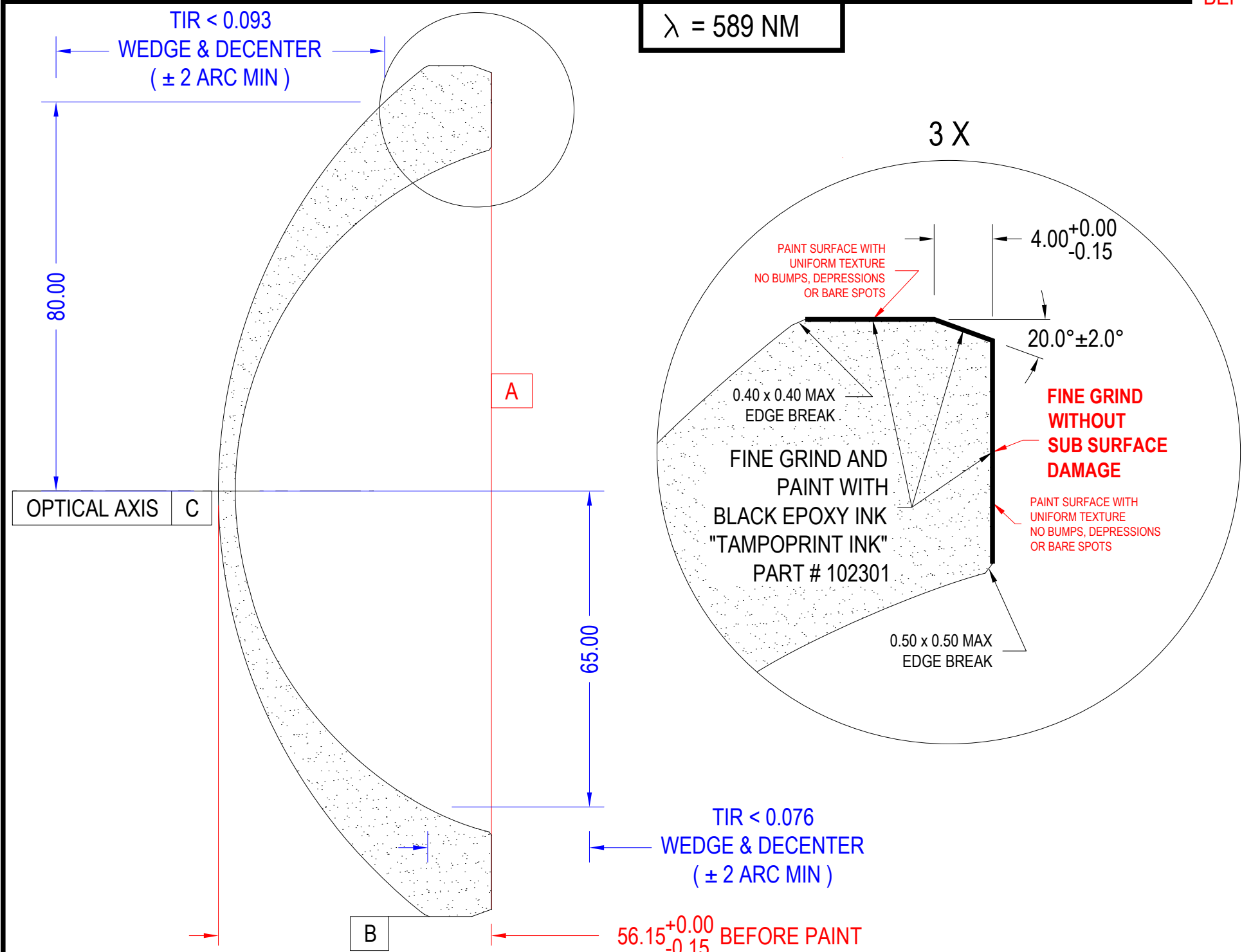


RADIUS	RAD. TOL.	TEST PLATE RAD.	RAD. FIT @ C.A.	IRREG. @ C.A.	C. A. Ø	SCR / DIG					
110.66 (CX)	± 0.15	110.660 ± 0.148	8 RINGS	2 RINGS	171.6	40 / 20	EDGE Ø	EDGE Ø TOL	C. T.	C. T. TOL	GLASS
73.192 (CC)	± 0.070	73.192 ± 0.069	8 RINGS	1 RING	139.8	40 / 20	175.00	+ 0.00 / - 0.10	3.50	+ 0.10 / - 0.20	H-K9L



BEFORE PAINT BEFORE PAINT

GLASS
CDGM H-K9L #517642; FINE ANNEALED; STRIAE GRADE 1;
BUBBLE GRADE "A00", (CHINA SPECIFICATION).

COATING ON CONVEX SURFACE
SINGLE LAYER SiO₂ ANTIREFLECTION COATING @ 520 NM ON CONVEX SURFACE.

COATING ON CONCAVE SURFACE
BBAR COATING ON CONCAVE SURFACE TO MIL-C-675C. CENTER COATING @ 550 NM. OPTIMIZE FROM 440 TO 740 NM. REFLECTION AT NORMAL INCIDENCE < 0.5 % NEAR CENTER AND < 5% AT 0.9 CA FOR ANY WAVELENGTH FROM 440 TO 740 NM.

EDGES & BEVELS
FINE GRIND AND CLEAN PRIOR TO PAINTING. PAINT (3) INDICATED SURFACES WITH BLACK EPOXY INK. 0.40 x 0.40 MM AND 0.50 x 0.50 MM EDGE BREAKS MUST BE UNIFORM TO ACHIEVE PROPER COSMETIC APPEARANCE. NO PAINT REQUIRED ON 0.40 x 0.40 MM AND 0.50 x 0.50 MM EDGE BREAKS. NO WRITING MARKS, DISCOLORATION OR FOREIGN PARTICLES UNDER PAINTED SURFACES WILL BE ACCEPTED. PAINTED SURFACES MUST APPEAR UNIFORMLY BLACK WHEN VIEWED THROUGH CONVEX SURFACE.

PAINTED SURFACES MUST HAVE UNIFORM TEXTURE WITHOUT BARE SPOTS, BUMPS AND LARGE DEPRESSIONS THAT PREVENT VACUUM SEAL WITH O-RING.

NO CHIPS ALLOWED WITHIN CLEAR APERTURE.

GRIND MOUNTING SURFACE A IN MULTIPLE STAGES TO MINIMIZE SUB SURFACE DAMAGE. THIS SURFACE IS SUBJECTED TO 600 P.S.I. COMPRESSION DURING OPERATION. CRACKS AND EDGE FRACTURES ORIGINATE AT SURFACE A IF GRINDING INDUCED STRESS AND SUB SURFACE DAMAGE EXISTS.

GENERAL FABRICATION
PITCH POLISH OPTICAL SURFACES. UNLESS OTHERWISE NOTED, THIS LENS MUST BE FABRICATED IN ACCORDANCE WITH MIL-O-13830A.

- INSPECTION REPORT REQUIRED FOR EACH LENS
- CERTIFY ALL SPECIFICATIONS IN HEADER.
 - CERTIFY EDGE BREAKS.
 - CERTIFY CONCENTRICITY AND TOTAL INDICATOR RUNOUT TOLERANCES.
 - CERTIFY DIMENSION FROM CX VERTEX TO SURFACE A

ALL DIMENSIONS IN MILLIMETERS

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EX-1_HD_SWP	SWP_44C		SWP_44C_1

0.050	C	B	BEFORE PAINT
2 ARC MINUTES	C	A	BEFORE PAINT
2 ARC MINUTES	B	A	BEFORE PAINT

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