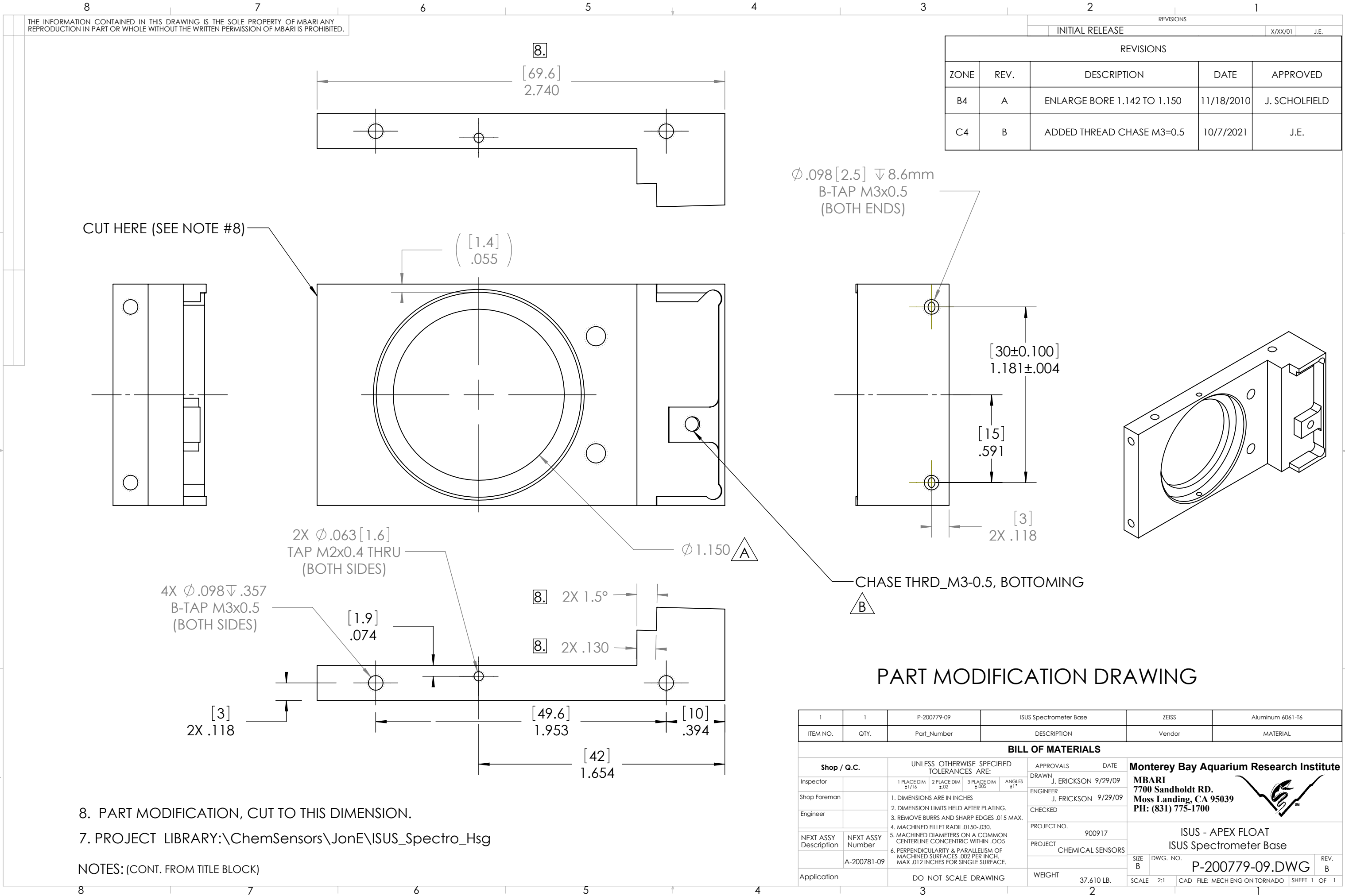




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REVISIONS			INITIAL RELEASE		X/XX/01	J.E.
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REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
B4	A	ENLARGE BORE 1.142 TO 1.150	11/18/2010	J. SCHOLFIELD
C4	B	ADDED THREAD CHASE M3=0.5	10/7/2021	J.E.

Ø.098 [2.5] ∇ 8.6mm
B-TAP M3x0.5
(BOTH ENDS)

[30±0.100]
1.181±.004

[15]
.591

[3]
2X .118

Ø 1.150 A

CHASE THRD_M3-0.5, BOTTOMING
B

PART MODIFICATION DRAWING

1	1	P-200779-09	ISUS Spectrometer Base	ZEISS	Aluminum 6061-T6
ITEM NO.	QTY.	Part_Number	DESCRIPTION	Vendor	MATERIAL
BILL OF MATERIALS					
Shop / Q.C.		UNLESS OTHERWISE SPECIFIED TOLERANCES ARE:		APPROVALS DATE	
Inspector		1 PLACE DIM ±1/16	2 PLACE DIM ±.02	3 PLACE DIM ±.005	ANGLES ±1°
Shop Foreman		1. DIMENSIONS ARE IN INCHES		DRAWN J. ERICKSON 9/29/09	
Engineer		2. DIMENSION LIMITS HELD AFTER PLATING.		ENGINEER J. ERICKSON 9/29/09	
		3. REMOVE BURRS AND SHARP EDGES .015 MAX.		CHECKED	
		4. MACHINED FILLET RADII .0150-.030.		PROJECT NO. 900917	
NEXT ASSY Description	NEXT ASSY Number	5. MACHINED DIAMETERS ON A COMMON CENTERLINE CONCENTRIC WITHIN .005		PROJECT CHEMICAL SENSORS	
	A-200781-09	6. PERPENDICULARITY & PARALLELISM OF MACHINED SURFACES .002 PER INCH. MAX .012 INCHES FOR SINGLE SURFACE.		WEIGHT 37.610 LB.	
Application		DO NOT SCALE DRAWING		SIZE B DWG. NO. P-200779-09.DWG	
				SCALE 2:1 CAD FILE: MECH ENG ON TORNADO SHEET 1 OF 1	

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ISUS - APEX FLOAT
ISUS Spectrometer Base
P-200779-09.DWG

8. PART MODIFICATION, CUT TO THIS DIMENSION.
7. PROJECT LIBRARY:\ChemSensors\JonE\ISUS_Spectro_Hsg
NOTES: (CONT. FROM TITLE BLOCK)