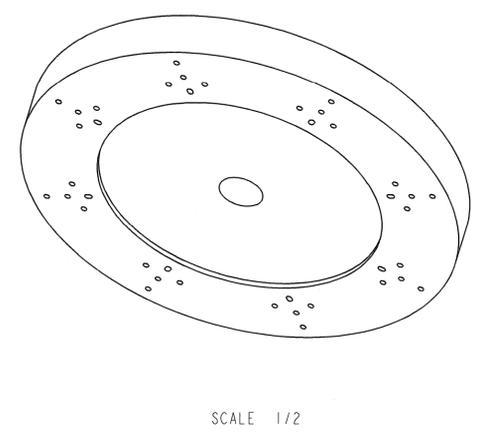
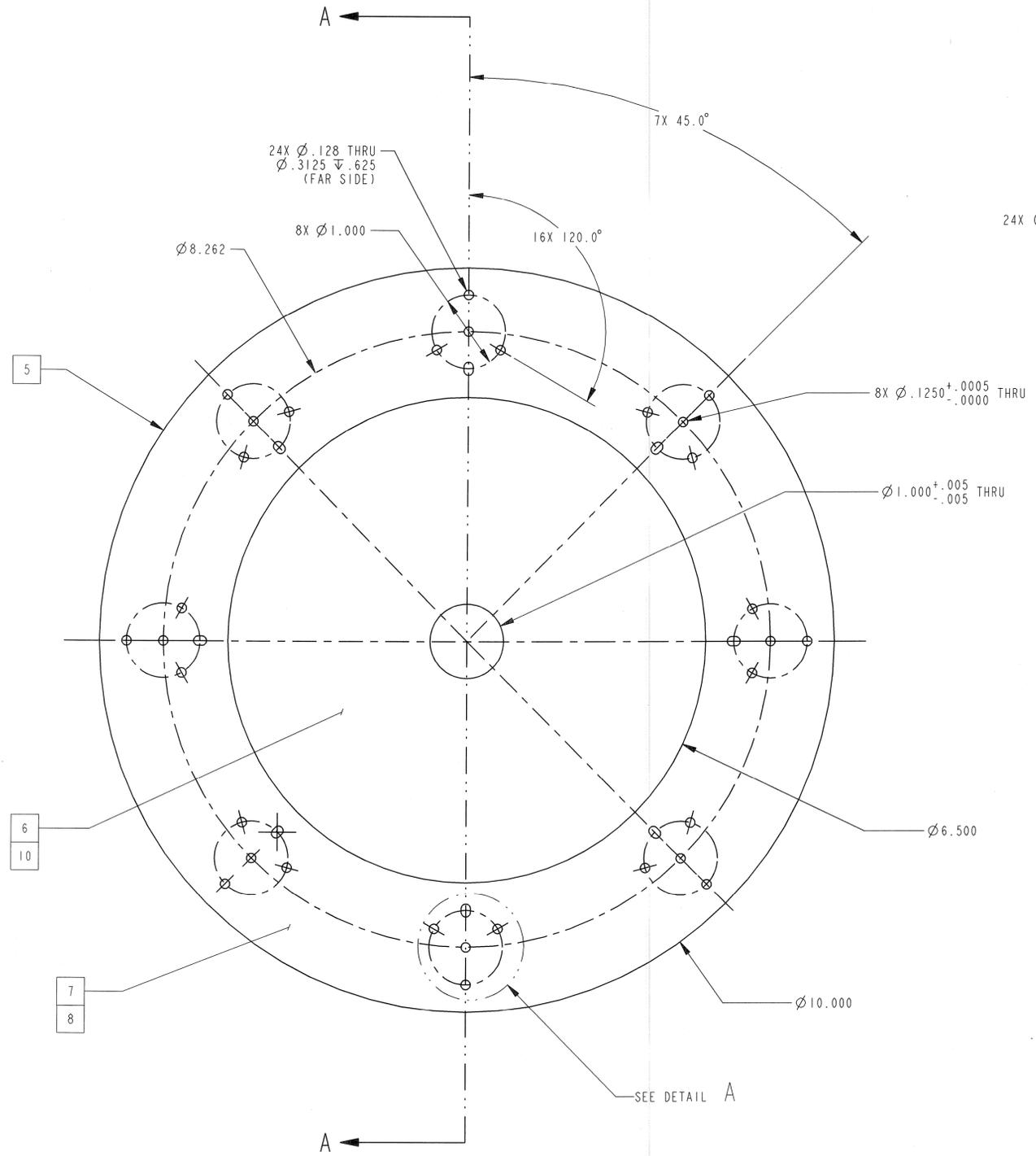


- NOTES:
- APPLICABLE STANDARDS/SPECIFICATIONS:
MIL-STD-100, DOD STANDARD PRACTICE FOR ENGINEERING DRAWINGS,
ASME Y14.100M, ENGINEERING DRAWING PRACTICES,
MIL-T-31000, TECHNICAL DATA PACKAGES.
 - BREAK ALL SHARP EDGES AND REMOVE ALL BURRS 0.25 MAX CHAMFER OR RADIUS.
 - SURFACE ROUGHNESS SHALL BE 125 RMS OR BETTER.
 - DIMENSIONS APPLY AFTER SURFACE TREATMENT(S)
 - PERFORM HEAT TREAT AND THERMAL STABILIZATION PROCESSES IN THE FOLLOWING ORDER, PRIOR TO PERFORMING DIAMOND TURNING OPERATIONS:
 - ROUGH MACHINE MIRROR TO WITHIN A MAXIMUM OF 0.050 OVERSIZED OF FINAL DIMENSIONS TO ALLOW FOR DIMENSIONAL CHANGES DUE TO STRESS RELAXATION
 - SOLUTION HEAT TREAT PART IN ACCORDANCE WITH AMS 2770. HEAT PART TO 985 DEG F (529 DEG C) +/- 10 DEG F FOR TWO HOURS MINIMUM. QUENCH IN A 20-22% POLYALKYLENE GLYCOL SOLUTION IN ACCORDANCE WITH AMS 3025. QUENCH TEMPERATURE SHALL BE 85 TO 90 DEG F AT THE START OF THE QUENCH
 - PRECIPITATION AGE MIRROR IN ACCORDANCE WITH AMS 2770 AT 350 DEG F (177 DEG C) +/- 10 DEG F FOR 8 TO 10 HOURS
 - FINISH MACHINE TO FINAL DIMENSIONS EXCLUDING DIAMOND TURNED SURFACES
 - THERMAL CYCLE PART FIVE TIMES FROM ROOM TEMPERATURE TO -95 DEG F (-70 DEG C) +/- 10 DEG F TO 200 DEG F (93 DEG C) +/- 10 DEG F WITH THE TEMPERATURE CHANGE RATE NOT TO EXCEED 10 DEG F PER MINUTE. DWELL TIME AT HIGH AND LOW TEMPERATURES SHALL BE 30 MINUTES MINIMUM
 - CHROMATE CONVERSION COAT IN ACCORDANCE WITH MIL-C-5541, CL 1A PRIOR TO FINISH OF DIAMOND TURNED MOUNTING SURFACES
 - DIAMOND TURNED SURFACES SHALL BE ELECTROLESS NICKEL PLATED PER AMS2404F. NICKEL PLATING THICKNESS SHALL BE .001 MIN/.003 MAX AFTER DIAMOND TURNING
 - INDICATED DIAMOND TURNED SURFACE (S) SHALL BE FLAT WITHIN 3 WAVES
 - PACKAGE IN ACCORDANCE WITH MIL-F-48616. INTERMEDIATE PACKAGES AND SHIPPING CONTAINERS SHALL BE MARKED WITH "CAUTION: PRECISION OPTICAL PART. DO NOT OPEN INDIVIDUAL UNIT CONTAINERS IN RECEIVING." ATTACH ALL PACKING SLIPS, INVOICES, ETC., ON OUTSIDE OF PACKAGING
 - IDENTIFY IN ACCORDANCE WITH MIL-STD-130, METHOD AND TYPE OPTIONAL. LOCATE APPROXIMATELY WHERE SHOWN, RADIAL POSITION OPTIONAL. INCLUDE PART NUMBER, DASH NUMBER, AND SERIAL NUMBER BEGINNING WITH SERIAL NUMBER 001



-1		OAP FIXTURE PLATE		ALUMINUM ALLOY		1	
QTY REQD		CAGE CODE		PART OR IDENTIFYING NO.		NOMENCLATURE OR DESCRIPTION	
						PARTS LIST	
						NATIONAL AERONAUTICS & SPACE ADMINISTRATION LANGLEY RESEARCH CENTER HAMPTON, VA 23681-2199	
						OAP FIXTURE PLATE IR INSTRUMENT ASSY CLARREO	
						SIZE CAGE CODE DWG. NO. 1251589	
						SCALE 1/1 SHEET 1 OF 1	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES.		TOLERANCES	
DECIMALS		ANGULAR	
.XX ± .03		.X ± .5°	
.XXX ± .010			
DO NOT SCALE DRAWING			
TREATMENT		APPROVALS	
5		DATE	
FINISH		DESIGNER	
6 7		LA 1087	
PART DASH NO.		LEAD ENGR	
-1		10	
NEXT FINAL		APPLICATION	
NEXT ASSY		USED ON	
SIMILAR TO		SPECIAL MARKING SYM	
		10	