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**GP-B Telescope Image Divider Assembly (IDA)**  
**“Position IDA Pad on IDA”**  
**P0303 Rev -**

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## **POSITION IDA PAD ON IDA**

- for SUGP-B dwg#25091
  - follows *Position Left and Right Relay Lenses on IDA Channel A* (SUGP-B P0295)
  - also use *GP-B Telescope Image Divider Assembly (IDA) General Alignment and Bonding Procedures* (SUGP-B P0282).
- 1) Verify cleanliness of all fixturing.
  - 2) Place IDA (SUGP-B 25089) on a protective surface with the bottom of the channel A plate facing up.
  - 3) Without allowing the Pad (SUGP-B dwg#25398) to touch the IDA, hold the pad over the bonding area by hand to approximate the correct bonding position as shown in SUGP-B dwg#25091.
  - 4) Bond Pad to IDA using *Bonding Procedures for Fused-Quartz Components* (SUGP-B P0218).
  - 5) Locate and adjust the position of the Pad on the IDA by hand. Use care to avoid downward force that could cause an early contact. Use care to avoid contamination around and underneath the edges of the Pad.
  - 6) After curing, store completed IDA safely.

Attachments: SUGP-B dwg#'s 25089, 25398, 25091.