

**Stanford University**  
W.W. Hansen Experimental Physics Laboratory  
Gravity Probe B Relativity Mission  
Stanford, California 94305-4085

**GP-B Telescope**  
**“Position Clamp Supports on Telescope”**  
**P0341 Rev -**

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Prepared: \_\_\_\_\_ Date \_\_\_\_\_  
Ken Bower, Telescope Assembly

Approved: \_\_\_\_\_ Date \_\_\_\_\_  
Lynn Huff, Responsible Engineer

Approved: \_\_\_\_\_ Date \_\_\_\_\_  
John Lipa, Telescope Manager

Approved: \_\_\_\_\_ Date \_\_\_\_\_  
John Turneure, Hardware Manager

Approved: \_\_\_\_\_ Date \_\_\_\_\_  
Ben Taller, Quality Assurance

## POSITION CLAMP SUPPORTS ON TELESCOPE

- for SUGP-B dwg#25091
  - follows *Position Temperature Sensor Blocks on Telescope* (SUGP-B P0340)
  - also use *GP-B Telescope Image Divider Assembly (IDA) General Alignment and Bonding Procedures* (SUGP-B P0282).
- 1) Verify cleanliness of all fixturing.
  - 2) If not already done so, remove the telescope from all fixturing. Use **great** care to prevent any damage or contamination to the telescope and any hardware mounted on it. If electronics are installed, use ESD protection. Orient the telescope vertically with the base plate on the bottom and level.
  - 3) Bond one support (SUGP-B dwg#25603) to Telescope as shown in SUGP-B dwg#25091 using *Bonding Procedures for Fused-Quartz Components* (SUGP-B P0218). Use calipers, measuring tapes, and rulers as required to verify correct positioning of the support. Use care to prevent damage or contamination to any part of the telescope.
  - 4) Repeat step 3 for each support as required.
  - 5) Allow bonds to cure for 48 hours before disturbing telescope.

Attachments: SUGP-B dwg#'s 25603, 25091.