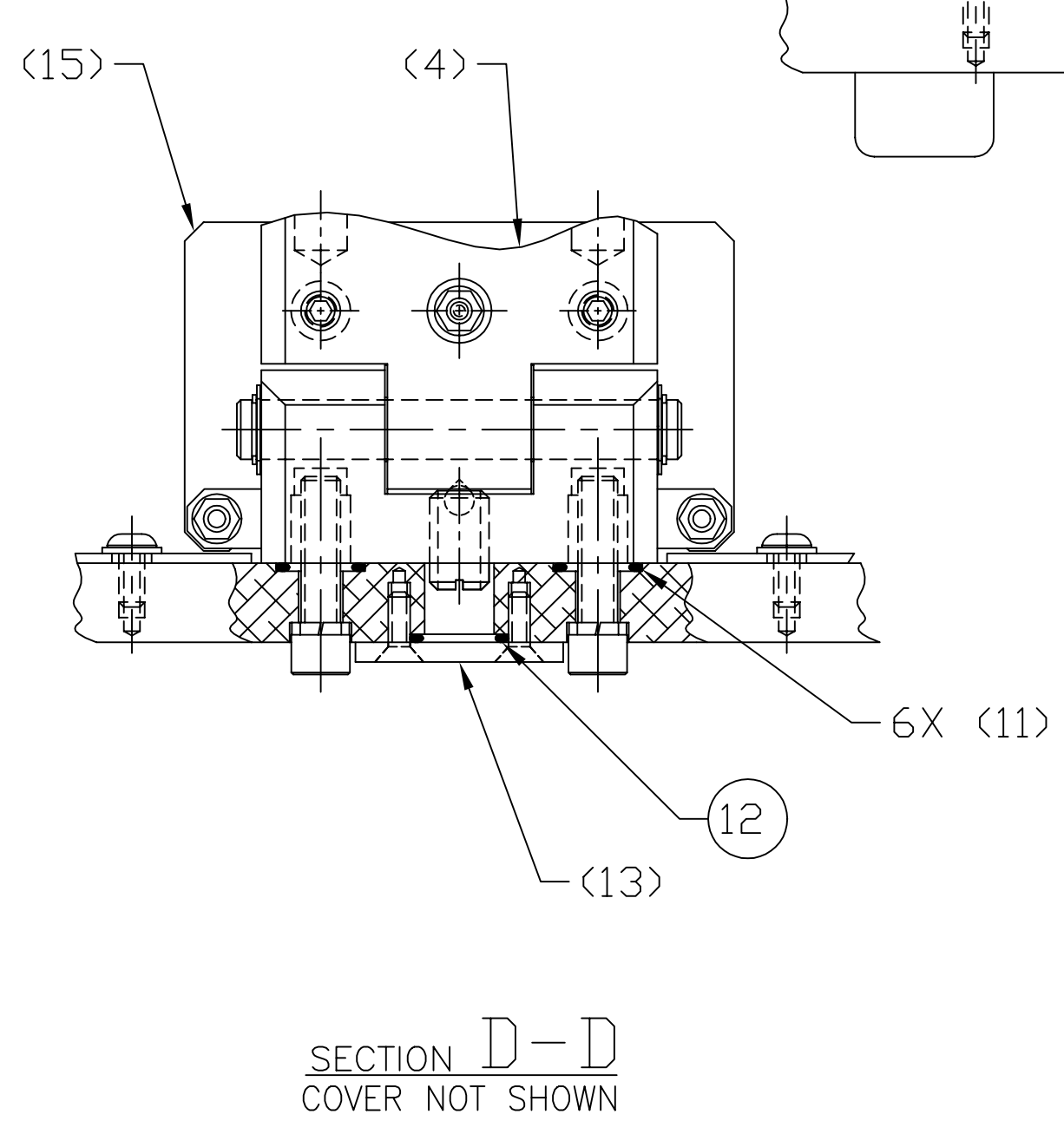
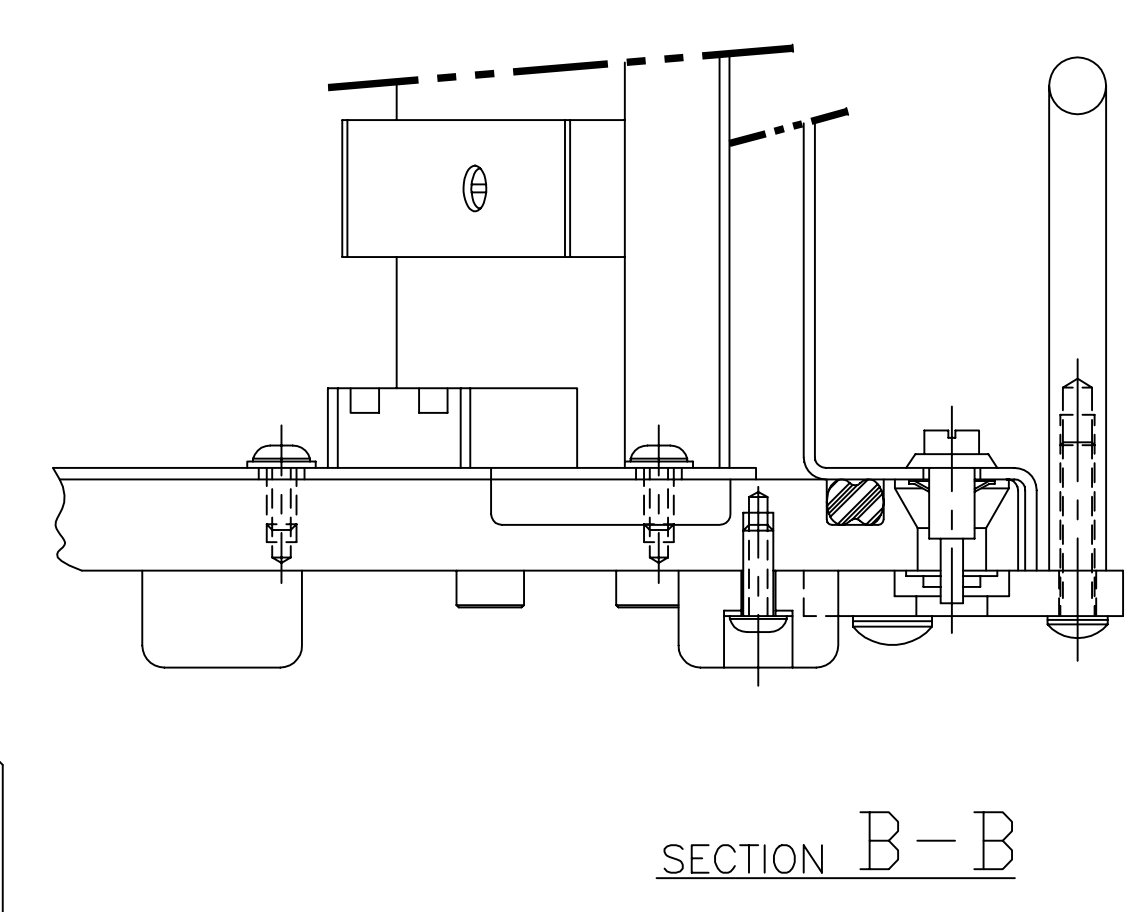
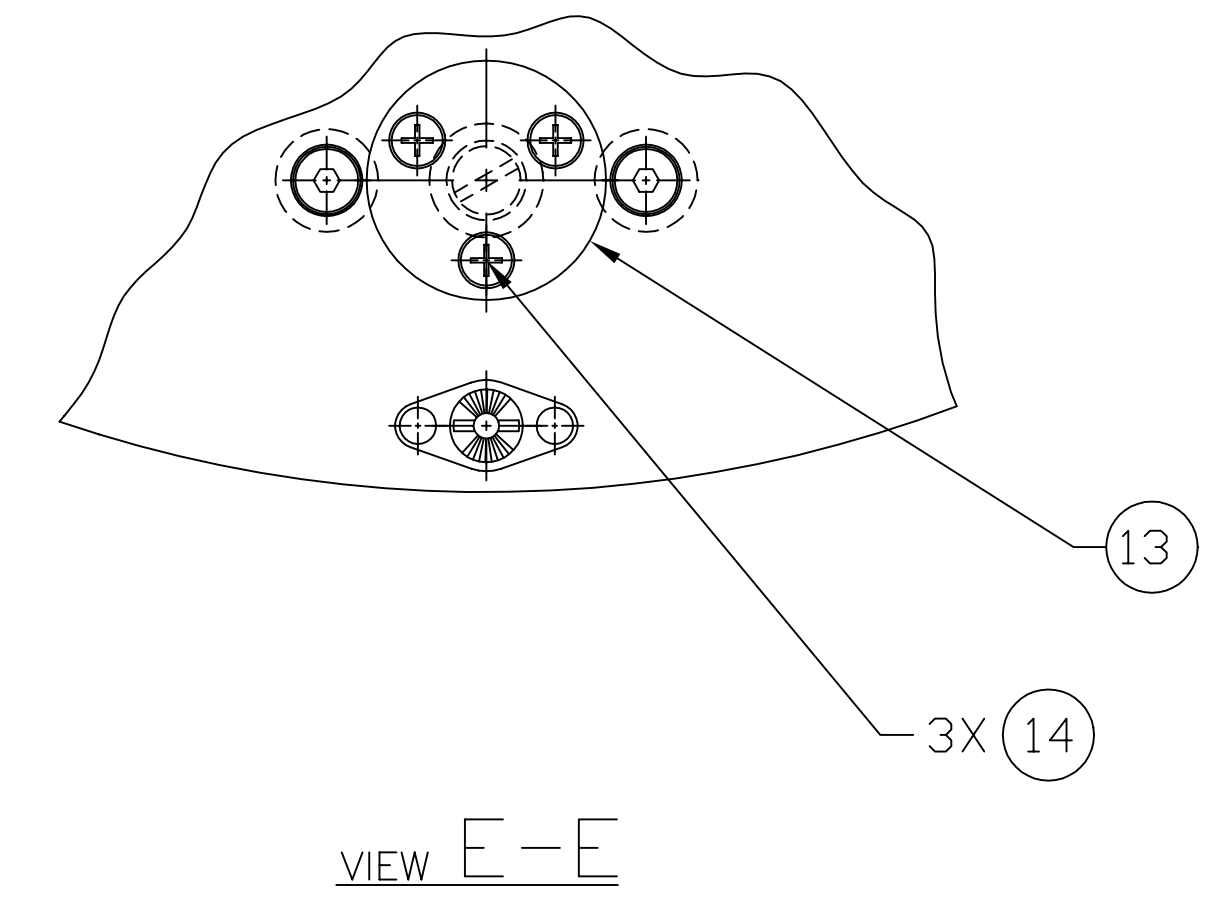
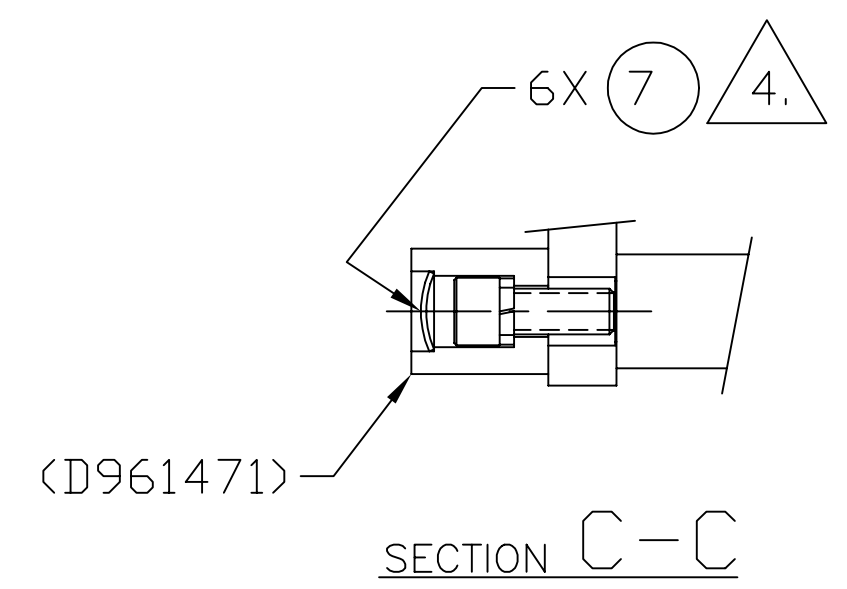


NOTES: (UNLESS OTHERWISE SPECIFIED)
 1. SEE SEPARATE MATERIALS LIST D970007 FOR PARTS, MATERIALS, & VENDOR INFORMATION.
 2. TORQUE ITEM 9 (SCREW) TO 70-75 in-lb.
 3. TO INSTALL ITEM 5 (TOP PLATE ASSEMBLY), BACK OFF THE 2 MOUNTING SCREWS (SEE SECTION C-C) FOR EACH OF THE 3 CAPTIVE SCREW BRACKET SUB ASSEMBLIES (D961471 & D961472), UNTIL THE LOCK WASHERS ARE FREE OF COMPRESSION. SET ITEM 5 IN PLACE AND TORQUE THE CAPTIVE SCREWS (6 TDT) TO 65-70 in-lb. THEN, RE-TORQUE THE CAPTIVE SCREW BRACKET MOUNTING SCREWS TO 65-70 in-lb WHILE ITEM 5 REMAINS MOUNTED. REMOVE ITEM 5 FOR NEXT OPERATION. SEE NOTE 4.
 4. AFTER REMOVING ITEM 5, REMOVE CAPTIVE SCREWS (6 TDT, BY REMOVING WIRE RETAINING RING FROM SHANK USING PLIERS) FROM ITEM 5 AND INSTALL ITEM 7 (EXPANSION PLUG) USING D970004 EXPANSION PLUG INSTALLATION TOOL. DO NOT MAR BOTTOM SURFACE OF ITEM 5 WITH ANVIL. INSTALLATION TOOL MAY BE MODIFIED AS NECESSARY FOR PROPER COMPRESSION OF EXPANSION PLUG BY CUTTING BACK SHOULDER. FINALLY, REPLACE CAPTIVE SCREWS.



UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN FEET (in)		TOLERANCES: FRACTIONAL # ANGULAR/ARCH # BEND # TWO PLACE DECIMAL # THREE PLACE DECIMAL # FINISHED SURFACE RING BREAK CORNERS IN REMOVE ALL BURRS		DO NOT SCALE THIS DRAWING		USED ON: NEXT ASSY: N/A		REV		DESCRIPTION		ISSUE DESCRIPTION		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY BEAM SPLITTER OPTIC CARRIER ASSEMBLY CAD FILE: D961461-C.dwg SIZE: E DWG NO: D961461-C-D SCALE: NTS SHEET: 1 OF 1	
DWG. NO.	DESCRIPTION	DWG. NO.	DESCRIPTION	REV	DESCRIPTION	REV	DESCRIPTION	DRWN	DATE	CHECK	DATE	DCC	DATE		
				B	DCN E970059			CDNLEY	10-1-97						
				A	DCN E960157			CDNLEY	5-20-97	CDYNE	5-27-97	TURNER	5-30-97		
								CDNLEY	2-14-97	CDYNE	2-14-97	TURNER	2-20-97		
								CDNLEY	1-2-97						