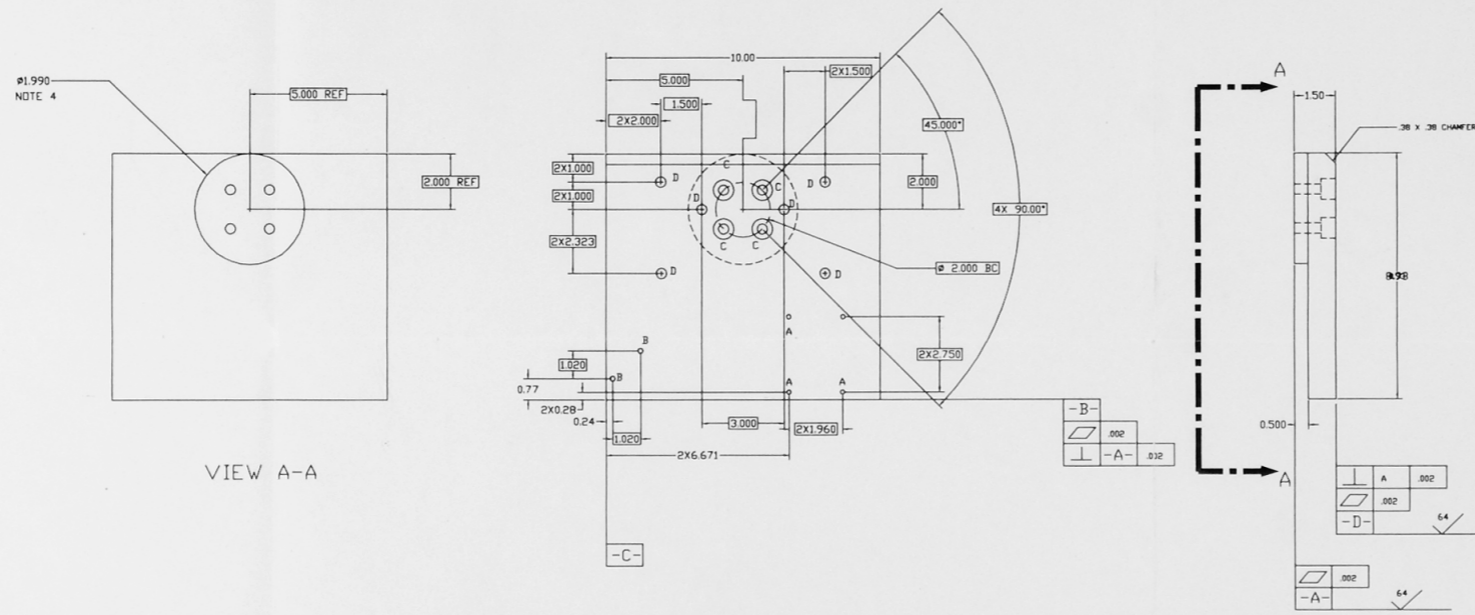


NOTES

1. Conversion Coat per MIL-C-5541 Class 3.
2. Deburr and break sharp edges.
3. AFTER FINISH, INSTALL INSERTS .75-1.50 PITCH BELOW THE SURFACE. REMOVE AND DISCARD THE TANG IF APPLICABLE.
4. FILLETS TO BE R.03

| HOLE | QTY | TOLERANCE | DESCRIPTION |
|------|-----|--|--|
| A | 4 | $\varnothing .010$ A B C | DRILL $\varnothing .144 - .150$, .532 MIN DEEP, CSINK 120 +/- 5 DEG X $\varnothing .18 - .21$ HELI-COIL TAP .31 MIN DP, #6-32 UNC-3B. CSINK AND INSTALL EMHART LOCKING HELI-COIL P/N 3585-06CN276 OR EQUIVALENT. |
| B | 2 | $\varnothing .010$ A B C | DRILL $\varnothing .198 - .204$, .568 MIN DEEP, CSINK 120 +/- 5 DEG X $\varnothing .23 - .26$ HELI-COIL TAP .32 MIN DP, #10-32 UNF-3B. CSINK AND INSTALL EMHART NON-LOCKING HELI-COIL P/N 1191-3CN285 OR EQUIVALENT. |
| C | 4 | $\varnothing .007$ A B C $\varnothing .005$ A B C | DRILL $\varnothing .391$ THRU, CBORE $\varnothing .75$, .55 DEEP. |
| D | 6 | $\varnothing .007$ A B C $\varnothing .005$ A B C | DRILL $\varnothing .387 - .393$, .917 MIN DEEP, CSINK 120 +/- 5 DEG X $\varnothing .42 - .45$ HELI-COIL TAP .79 MIN DP, #3/8-24 UNF-3B. CSINK AND INSTALL EMHART NON-LOCKING HELI-COIL P/N 1191-6CN750 OR EQUIVALENT. |



| | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|--|--|--|--|---|--|-------------------|--|----------------|--|---|--|-------------|--|---------------------------------|--|----|--|----|--|----|--|-------|--|------|--|------|--|--------------|--|
| UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES | | FINISHED SURFACE RMS BREAK CORNERS IN: OUT: REMOVE ALL BURRS | | LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY | | | | | | | | | | | | | | | | | | | | | | | | | |
| TOLERANCES: FRACTIONAL ± ANGULAR ±.10 TWO PLACE DECIMAL ±.01 THREE PLACE DECIMAL ±.005 | | | | MATERIAL: 6061-T6 AL | | HEAT TREAT: | | FINISH: | | A PRE-RELEASE FOR QUOTE, DCN E970012-00-H | | mjs 1-24-98 | | PEM, INTERFACE PLATE HAM | | | | | | | | | | | | | | | |
| | | | | USED ON: | | NEXT ASS'Y: | | REV | | 01 RELEASE | | mjs 11-8-97 | | | | | | | | | | | | | | | | | |
| | | | | | | | | 00 PRE-RELEASE | | mjs 5-7-97 | | CAD FILE | | SIZE DWG. NO. C D 970270-A-H | | | | | | | | | | | | | | | |
| DWG. NO. | | DESCRIPTION | | SCALE | | ISSUE DESCRIPTION | | DCC | | SYS | | DET | | CDS | | VE | | CC | | BT | | CHECK | | DRWN | | DATE | | SHEET 1 OF 1 | |