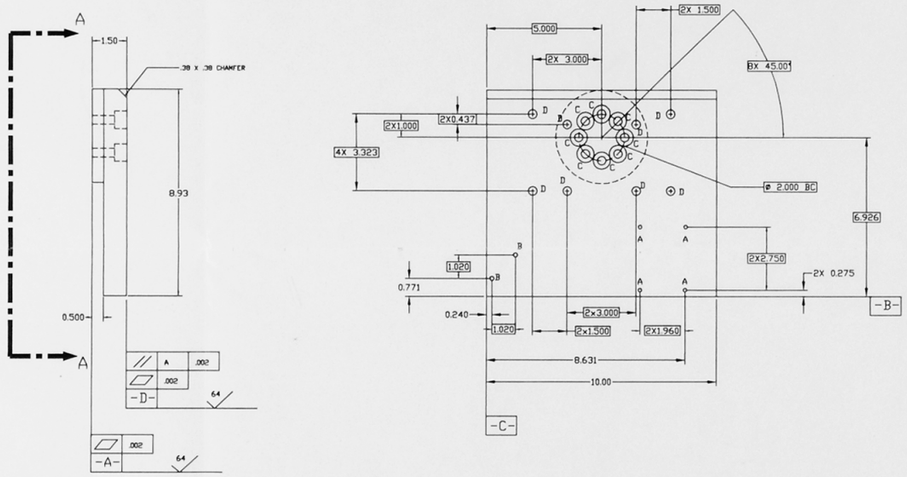
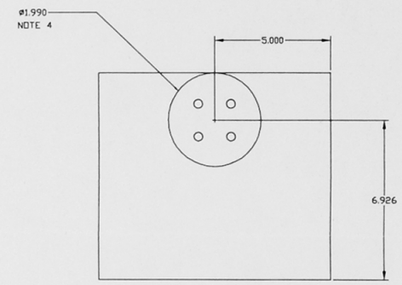
NOTES

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 MAX

HOLE	QTY	TOLERANCE	DESCRIPTION
A	4	⌖ Ø .010 M A B C	DRILL Ø .144 - .150, .532 MIN DEEP, CSINK 120 +/- 5 DEG X Ø .18- .21 HELI-COIL TAP .31 MIN DP, #6-32 UNC-3B. CSINK AND INSTALL EMHART LOCKING HELI-COIL P/N 3585-06CN276 OR EQUIVELENT.
B	2	⌖ Ø .010 M A B C	DRILL Ø .198- .204, .568 MIN DEEP, CSINK 120 +/- 5 DEG X Ø .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 EQUIVELENT.
C	8	⌖ Ø .007 M A B C Ø .005 M	DRILL Ø .406 THRU, CBORE Ø .75, .55 DEEP, NEARSIDE
D	8	⌖ Ø .007 M A B C Ø .005 M	DRILL Ø .387- .393, .917 MIN DEEP, CSINK 120 +/- 5 DEG X Ø .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 EQUIVELENT.





VIEW A-A

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES

TOLERANCES:
FRACTIONAL ±
ANGULAR ± .10
TWO PLACE DECIMAL ±.01
THREE PLACE DECIMAL ±.005

FINISHED SURFACE RMS
BREAK CORNERS IN: OUT:
REMOVE ALL BURRS

DWG. NO.	DESCRIPTION
REFERENCE DRAWINGS	

MATERIAL: 6061-T6 AL | HEAT TREAT: | FINISH: NOTE 1

USED ON: | NEXT ASS'Y:

REV	DESCRIPTION	DCC	SYS	DET	CDS	VE	CC	BT	CHECK	DRWN	DATE
B	RELEASE DCN E980013-00-H									mjs	1-27-98
A	PRE-RELEASE FOR QUOTE DCN E980012-00-H									mjs	1-24-98
01	RELEASE									mjs	11-8-97
00	PRE-RELEASE									mjs	5-7-97

ISSUE DESCRIPTION

LIGO
CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

PEM, INTERFACE PLATE
HAM

CAD FILE: r/12/ryn/pendata/released drawings
SCALE:
SIZE: C
DWG. NO.: D 970270-B-H
SHEET: 1 OF 1