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.

HOLE	QTY	TOLERANCE	DESCRIPTION
A	4	⊕ Ø .010 Ⓜ A B C	DRILL Ø .170- .176, .516 MIN DEEP, CSINK 120 +/- 5 DEG X Ø .20- .23 HELI-COIL TAP .371 MIN DP, #8-32 UNC-3B. CSINK AND INSTALL EMHART HELI-COIL P/N 1185-2CN246 OR EQUIVELENT.
B	2	⊕ Ø .010 Ⓜ A B Ø .005 Ⓜ	DRILL Ø .611-.617 THRU CBORE Ø 1.50, .63 DEEP
C	5	⊕ Ø .010 Ⓜ A B C	DRILL Ø .263 - .269, .925 MIN DEEP, CSINK 120 +/- 5 DEG X Ø .31- .34 HELI-COIL TAP .55 MIN DP, #1/4-20 UNC-3B. CSINK AND INSTALL EMHART LOCKING HELI-COIL P/N 3585-4CN500 OR EQUIVELENT.

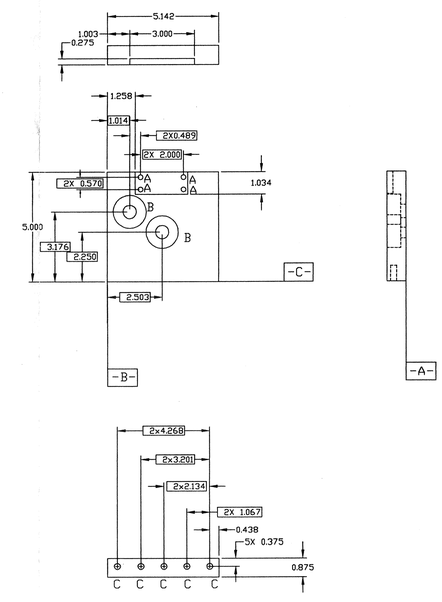

TABLE	
-1	-2
AS SHOWN	MIRROR IMAGE

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

MATERIAL: 6061-T6 AL
HEAT TREAT:
FINISH:

USED ON:
NEXT ASS'Y:

DWG. NO.	DESCRIPTION
REFERENCE DRAWINGS	

REV	DESCRIPTION	DCC	SYS	DET	CDS	VE	CC	BT	CHECK	DRWN	DATE
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, ELECTRO-MAGNETIC
SHAKER PLATE, SIDE

CAD FILE: r13/win/penplotes/releaseddrawings
SIZE: C
DWG. NO.: D970272-A-H
SCALE
SHEET 1 OF 1