

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. INSIDE RADIUS TO BE .03 MAX

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

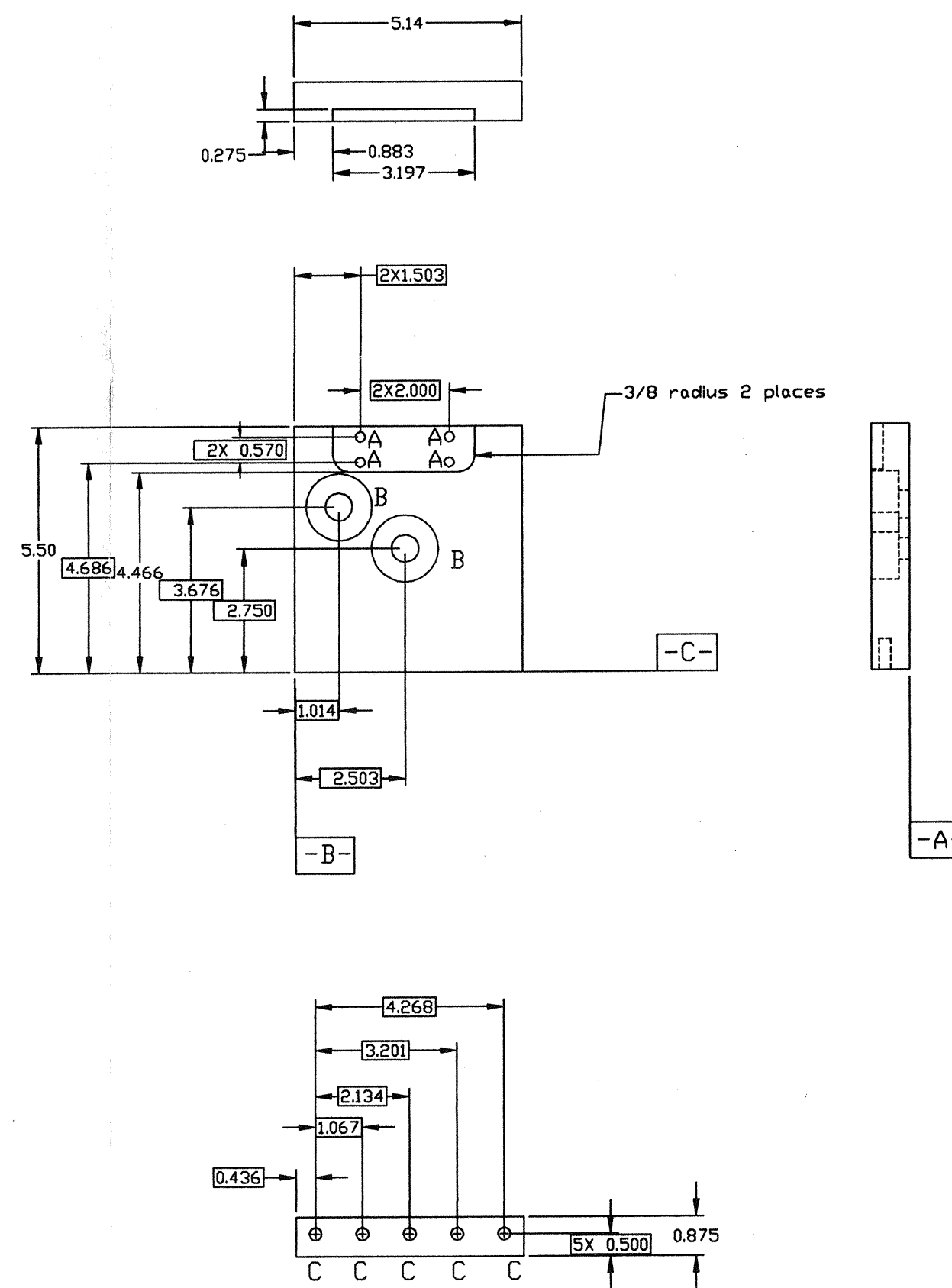


TABLE	
-1	-2
AS SHOWN	MIRROR IMAGE

		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
		TOLERANCES: FRACTIONAL ± ANGULAR ±.10 TWO PLACE DECIMAL ±.01 THREE PLACE DECIMAL ±.005		FINISHED SURFACE RMS BREAK CORNERS IN: OUT: REMOVE ALL BURRS		REV	
MATERIAL: 6061-T6 AL		HEAT TREAT:		FINISH: N0TE 1		DATE	
DESCRIPTION		USED ON:		NEXT ASS'Y:		SCALE	
REFERENCE DRAWINGS						C	
						D970272-B-H	
						SHEET 1 OF 1	