

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

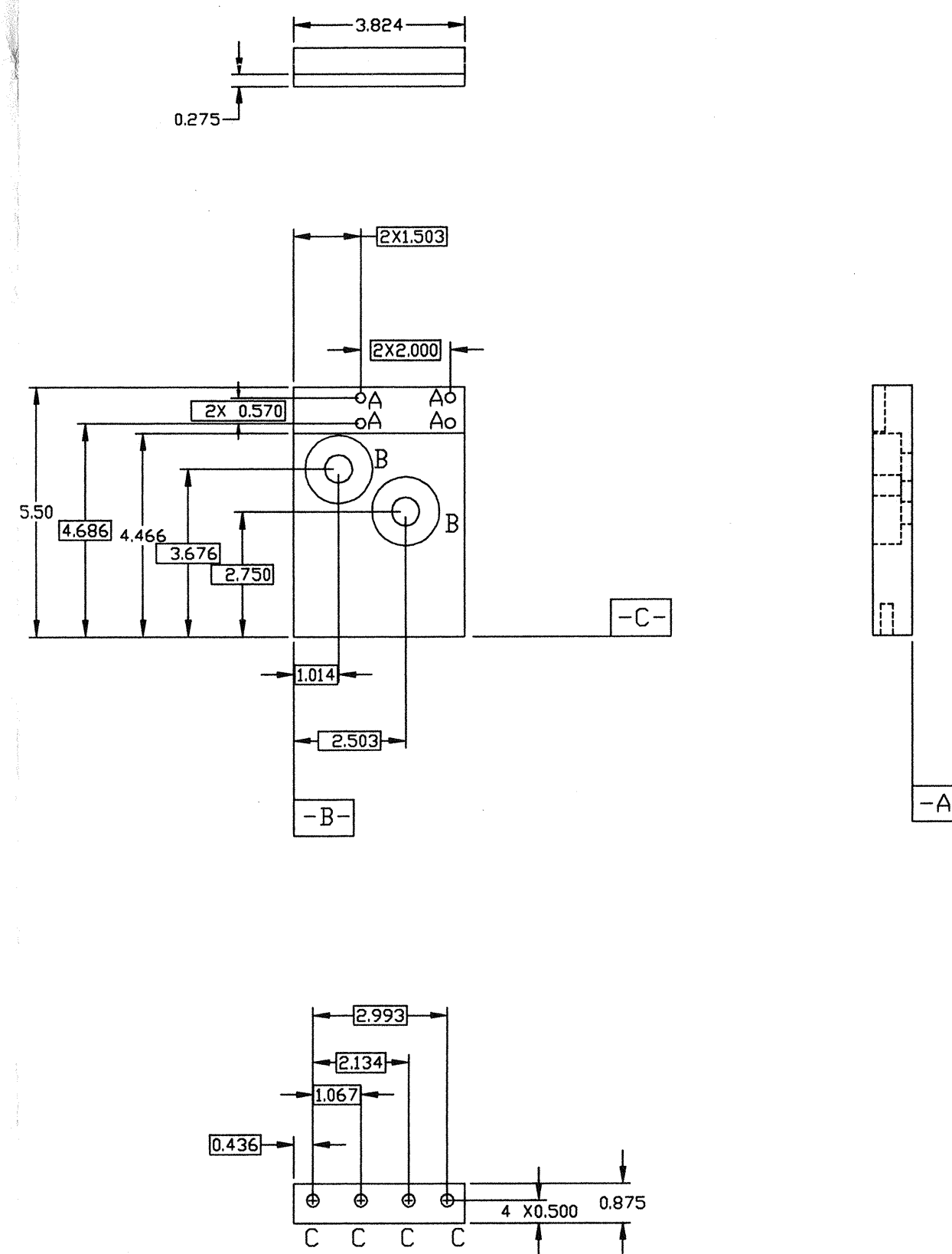


TABLE	
-1	-2
AS SHOWN	MIRROR IMAGE

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		TOLERANCES:		FINISHED SURFACE RMS BREAK CORNERS IN: OUT:		MATERIAL:		HEAT TREAT:		FINISH: NOTE 1		LIGO						
		FRACTIONAL \pm		REMOVE ALL BURRS		6061-T6 AL						CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY						
		ANGULAR $\pm .10$										PEM, ELECTRO-MAGNETIC SHAKER PLATE, SIDE						
		TWO PLACE DECIMAL $\pm .01$										CAB FILE d:\cnc\980015\9970272c.dwg						
		THREE PLACE DECIMAL $\pm .005$										SIZE DWG. NO. C D970272-C-H						
DWG. NO.	DESCRIPTION	USED ON:	REFERENCE DRAWINGS	NEXT ASS'Y:	REV	DESCRIPTION	DCC	SYS	DET	CDS	VE	CC	BT	CHECK	DRWN	DATE	SCALE	SHEET 1 OF 1
					00	PRE-RELEASE										5-7-97		
					01	RELEASE										11-8-97		
					A	PRE-RELEASE FOR QUOTE	DCN E980012-00-H									mjs		
					B	MINOR DIMENSION CHANGES	DCN E980013-00-H									mjs		
					C	modify hole pattern	DCN E980015-00-H									mjs		