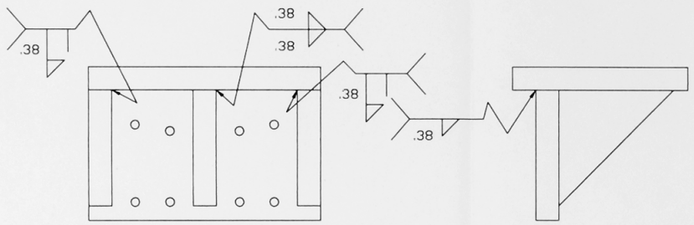
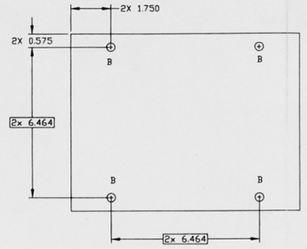
NOTES

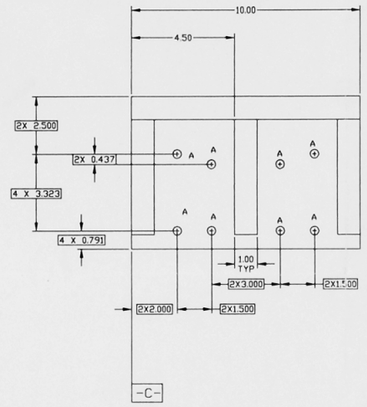
1. Conversion Coat per MIL-C-5541 Class 3.
2. Deburr and break sharp edges.
3. AFTER FINISH, INSTALL INSERTS .75-1.50 PITCH BELOW THE SURFACE. REMOVE AND DISCARD THE TANG IF APPLICABLE.

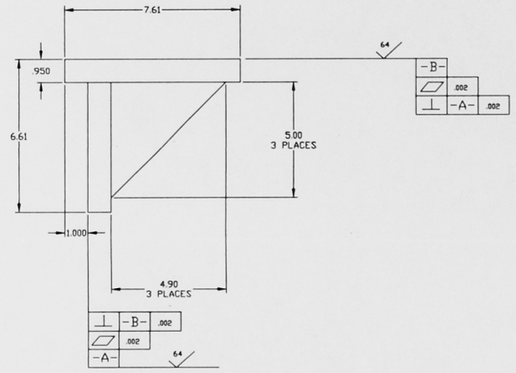
HOLE	QTY	TOLERANCE	DESCRIPTION
A	8	⊙ Ø .007 Ⓜ A B C Ø .005 Ⓜ	DRILL Ø .391 THRU
B	4	⊙ Ø .007 Ⓜ A B C Ø .005 Ⓜ	DRILL Ø .387- .393, .917 MIN DEEP, CSINK 120 +/- 5 DEG X Ø .42 - .45. HELI-COIL TAP .79 MIN DP, #3/8-24 UNF-3B. CSINK AND INSTALL EMHART NON-LOCKING HELI-COIL P/N 1191-6CN750 OR EQUIVELENT.



WELD VIEW







MACHINE VIEW

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: NOTE 1

USED ON: | NEXT ASS'Y:

REV	DESCRIPTION	DCC	SYS	DET	CDS	VE	CC	BT	CHECK	DRWN	DATE
B	RELEASE,CHANGE A HOLES 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

DWG. NO.	DESCRIPTION
	REFERENCE DRAWINGS

LIGO
CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

PEM, SUPPORT PLATE

CAD FILE: r13/win/penplates/releaseddrawings
SIZE: C
DWG. NO.: D 970288-B-H
SCALE:
SHEET 1 OF 1