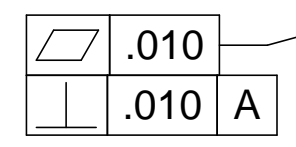
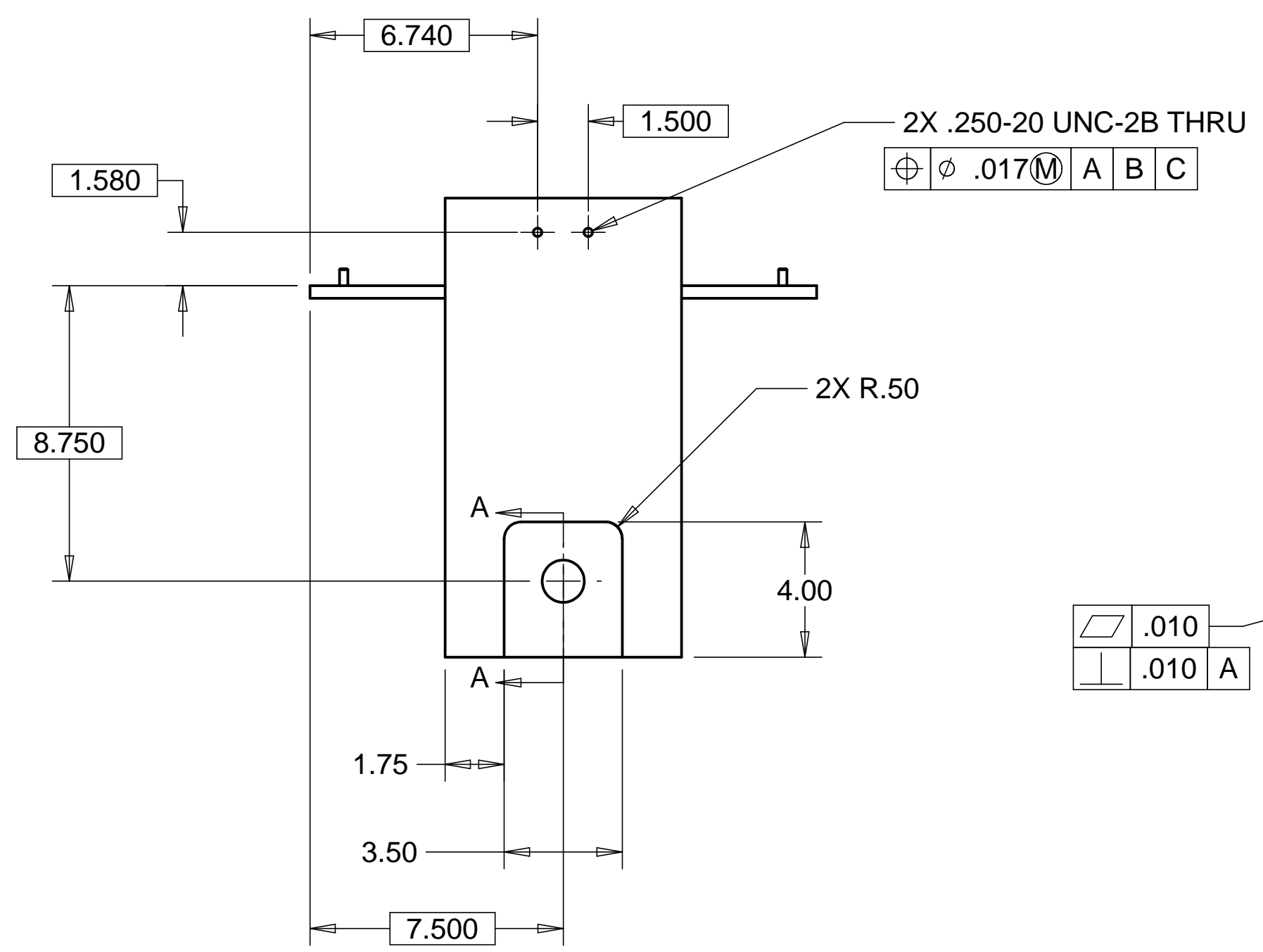
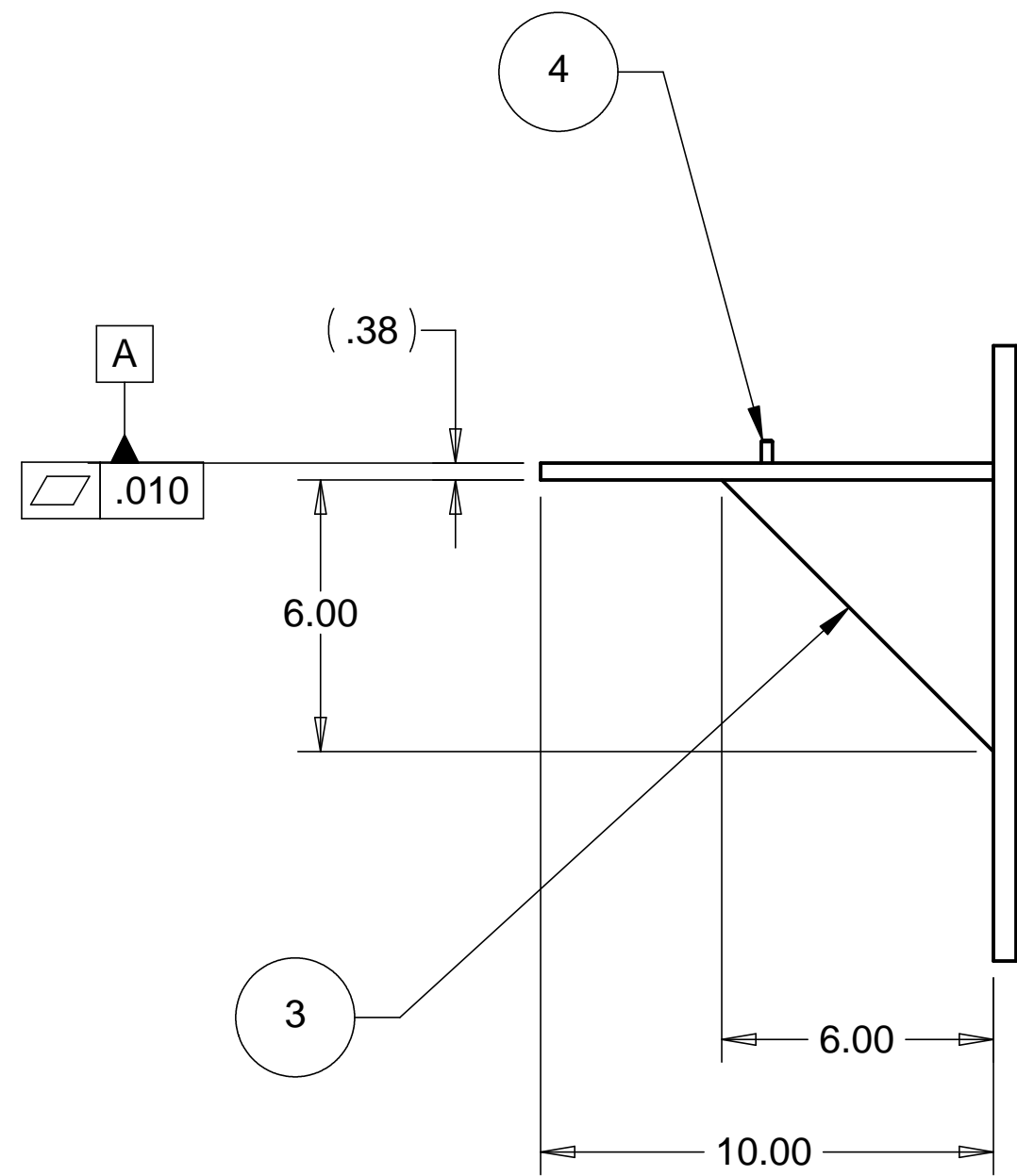
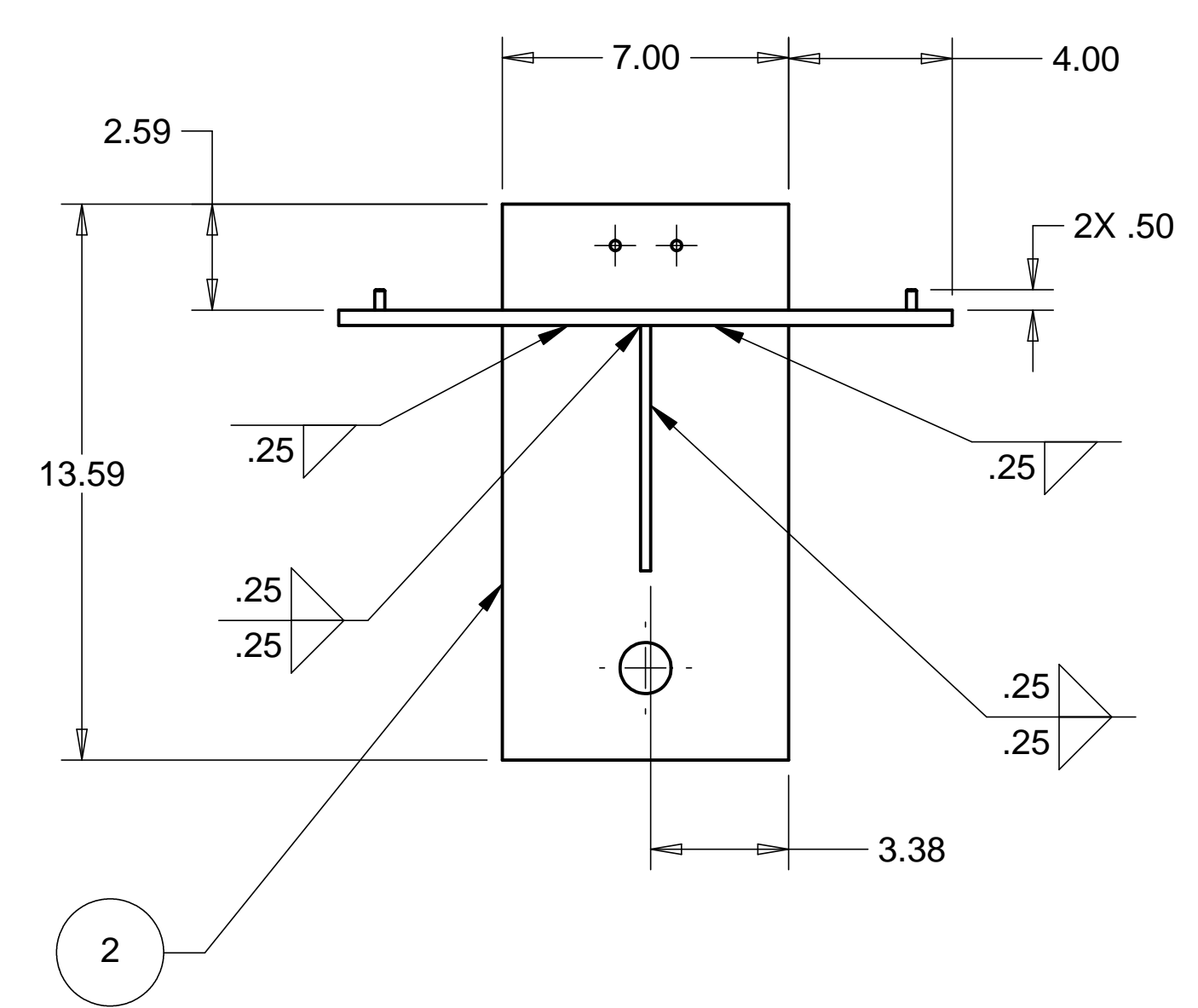
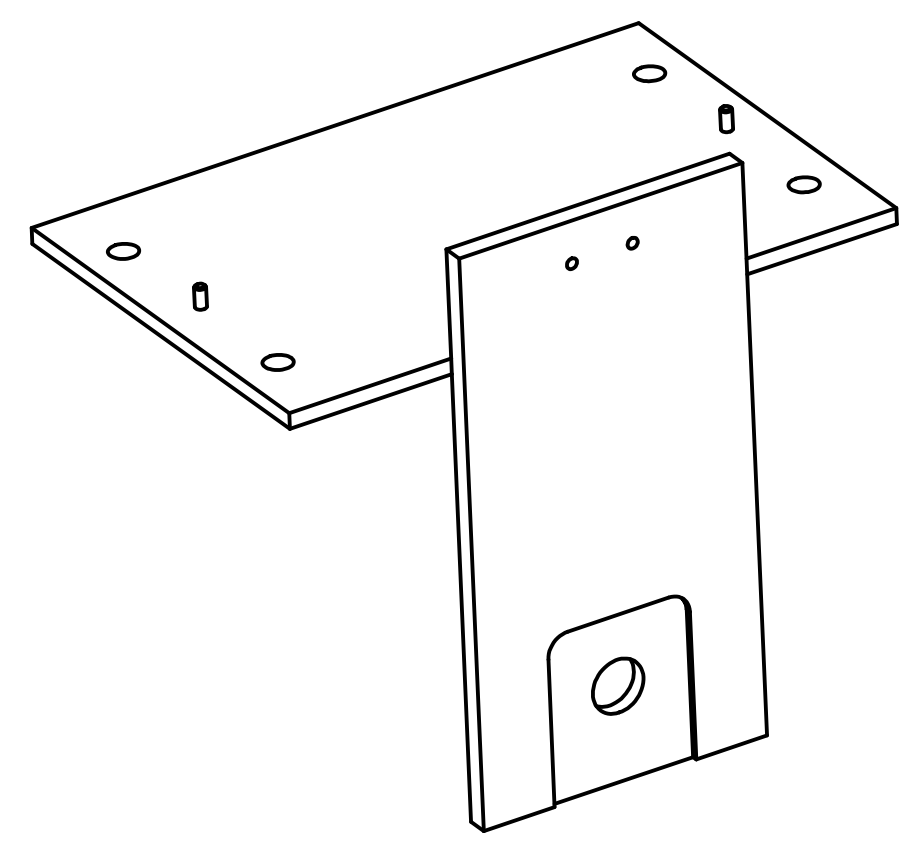
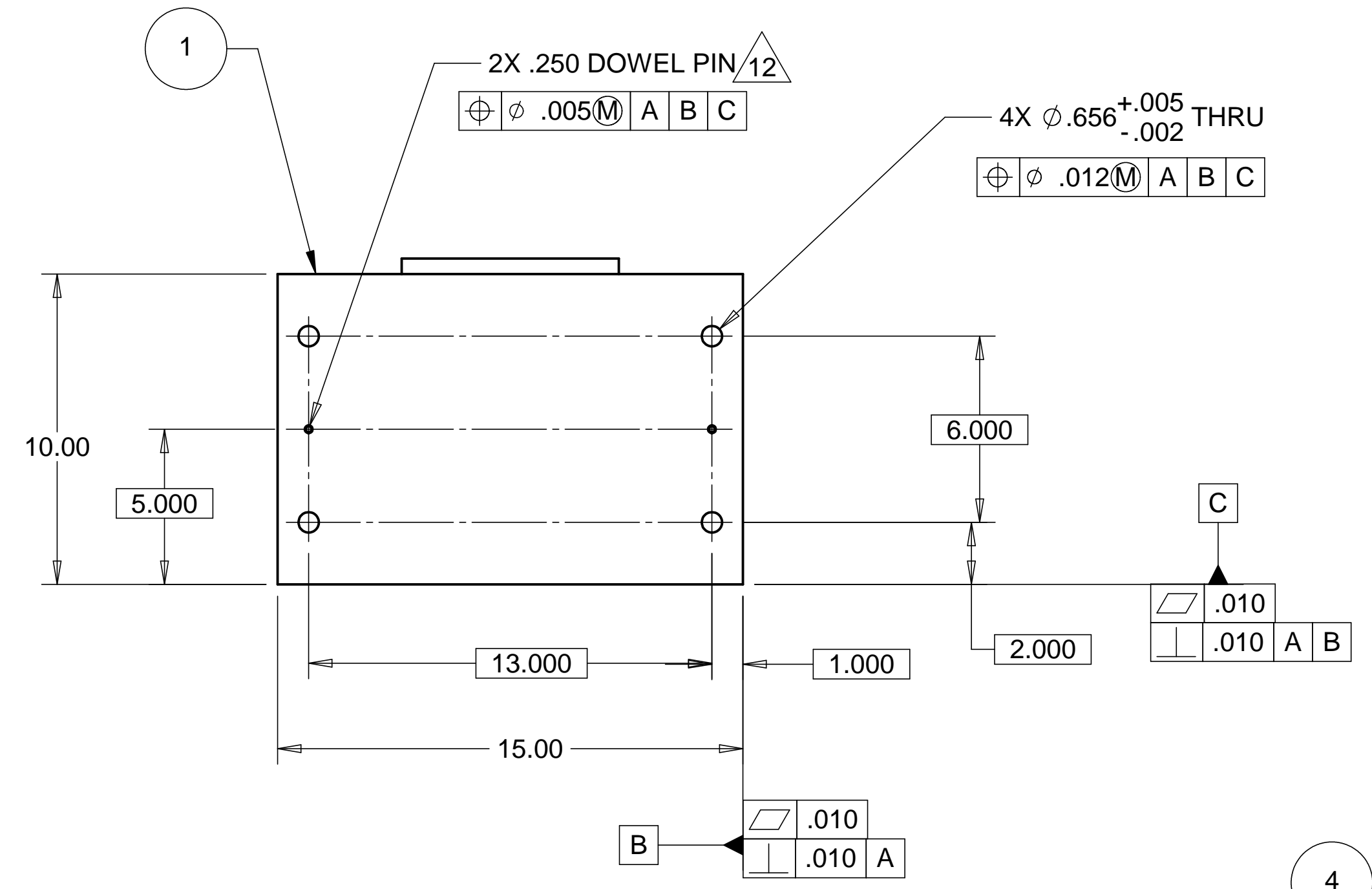


REVISIONS		DATE	APPROVED
REV.	DESCRIPTION		



SECTION A-A  
SCALE: 1:2

WEIGHT: 30.5 lbs

NOTES: UNLESS OTHERWISE SPECIFIED

- ALL DIMENSIONS IN INCHES
- DIMENSIONS AND TOLERANCING PER ANAS1 Y14.5M-1994
- SURFACE TEXTURE PER ANI/ASME B 46.1-1985
- REMOVE ALL BURRS AND BREAK SHARP EDGES TO A MAXIMUM OF .015
- ALL INSIDE CORNERS TO BE .015 RADIUS MAX
- COUNTERSINK 82 DEGREES ALL TAPPED HOLES TO MAJOR DIAMETER
- COUNTERSINK 82 DEGREES APPROXIMATELY .015 DEEP ALL DRILLED HOLES
- PARTS TO BE THOROUGHLY CLEANED TO REMOVE ALL OIL, GREASE, DIRT AND CHIPS
- PART NUMBER (DRAWING NO. PLUS DASH NO. PLUS SERIAL NO.) TO BE CLEARLY MARKED ON THE PART ITSELF
- ALL FABRICATION, CLEANING, AND HANDLING MAINTAINED TO HYTEC SPECIFICATIONS: LIGO-TS-03 CATEGORY
- NO SULFUR BASED CUTTING FLUIDS ALLOWED. APPROVED STAINLESS STEEL MACHINE LUBRICANT: RELTON A-9, RELTON

12. PRESS DOWEL PINS USING A FN 5 FIT.

ITEM NO.	QTY.	DESCRIPTION	MATERIAL
1	1	PLATE, .375 THK	304 EZ CUT STAINLESS STEEL
2	1	PLATE, .500 THK	304 EZ CUT STAINLESS STEEL
3	1	PLATE, .500 THK	304 EZ CUT STAINLESS STEEL
4	2	PIN, DOWEL .25 DIA. X 1.0 LG.	McMASTER-CARR #98381A542

PARTS LIST

UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES -TOLERANCES-		CAD GENERATED DRAWING, DO NOT MANUALLY UPDATE DO NOT SCALE DRAWING		<p><b>HYTEC, INC</b></p> <p>TITLE <b>BSC CENTERING JIG RIGHT SIDE WELDMENT</b></p>	
DECIMALS .X = +/- .1 .XX = +/- .03 .XXX = +/- .010	ANGULAR = +/- 30' SURFACE FINISH = 250	FINISH	SIGNATURE	DATE	
			DESIGNED	W. K. MILLER	1-14-98
			DRAWN	GERALD BUSTOS	1-14-98
			CHECKED	HARRY SALAZAR	----
			ENGR.	T. THOMPSON	----
			APPROVED	T. THOMPSON	----
PART NO. <b>D972423-1</b>		DWG. NO. <b>D972423</b>	SCALE 1/4	SIZE <b>D</b>	SHEET NO. <b>1 of 1</b>
				REVISION	