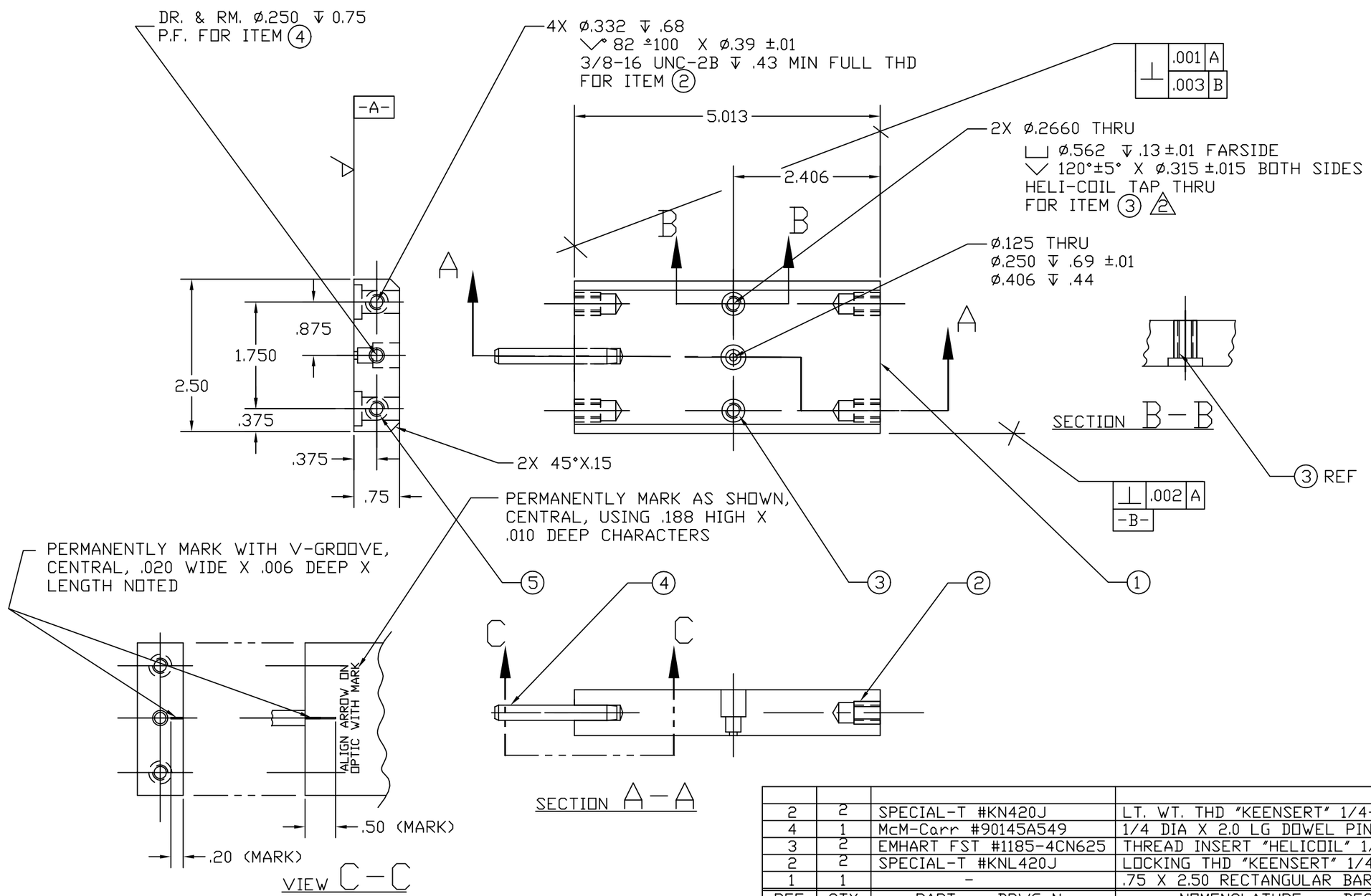

NOTES: (UNLESS OTHERWISE SPECIFIED)

1. INTERPRET DRAWINGS PER ANSI Y14.5M-1982
2. INSTALL ITEM 3 (THREAD INSERT) FROM FARSIDE, TO WITHIN 1/4 THREAD PITCH FLUSH WITH NEAR END OF TAPPED HOLE, NO PROTRUSION. ALTER LENGTH FLUSH WITH FARSIDE WITHIN 1/2 THREAD PITCH, NO PROTRUSION.
3. FOR VENDOR INFORMATION, SEE TOP ASSEMBLY MATERIALS LIST D970006 OR D970007.

REF	QTY	PART or DRWG No.	NOMENCLATURE or DESCRIPTION	MATERIAL
2	2	SPECIAL-T #KN420J	LT. WT. THD "KEENSERT" 1/4-20 X 5/8	STAINLESS STEEL
4	1	McM-Carr #90145A549	1/4 DIA X 2.0 LG DOWEL PIN	STAINLESS STEEL
3	2	EMHART FST #1185-4CN625	THREAD INSERT "HELICOIL" 1/4-20 X 5/8	STAINLESS STEEL
2	2	SPECIAL-T #KNL420J	LOCKING THD "KEENSERT" 1/4-20 X 5/8	STAINLESS STEEL
1	1	-	.75 X 2.50 RECTANGULAR BAR	(SEE MAT'L/H.T. BLKS)

PARTS and MATERIAL LIST 3

DWG. NO.	DESCRIPTION

REFERENCE DRAWINGS

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES

TOLERANCES:
FRACTIONAL ±
ANGULAR ± 0.5°
ANGULARMACH ± BEND ±
TWO PLACE DECIMAL ± .03
THREE PLACE DECIMAL ± .005
FINISHED SURFACE 32 MICROINCH AVERAGE
BREAK CORNERS IN: OUT: .005-.010
REMOVE ALL BURRS

MATERIAL: 6061 ALU BAR PER QQ-A-225/8
HEAT TREAT: T6 PER AMS 2770
FINISH:

USED ON:
NEXT ASS'Y: D961454

REV	DESCRIPTION	DCC	SYS	DET	CDS	VE	CC	BT	CHECK	DRWN	DATE
A	DCN No. E960157										
01	RELEASE FOR FAB										
pA	PRELIMINARY RELEASE										
00	PRE-RELEASE									KABOT	12-29-96

ISSUE DESCRIPTION

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

LARGE CORE OPTIC COMPONENT
CARRIER INDEXED STANDOFF

CAD FILE: D961452-A.dwg
SIZE: B
DWG. NO.: D961452-A-D
SCALE: NTS
SHEET: 1 OF 1