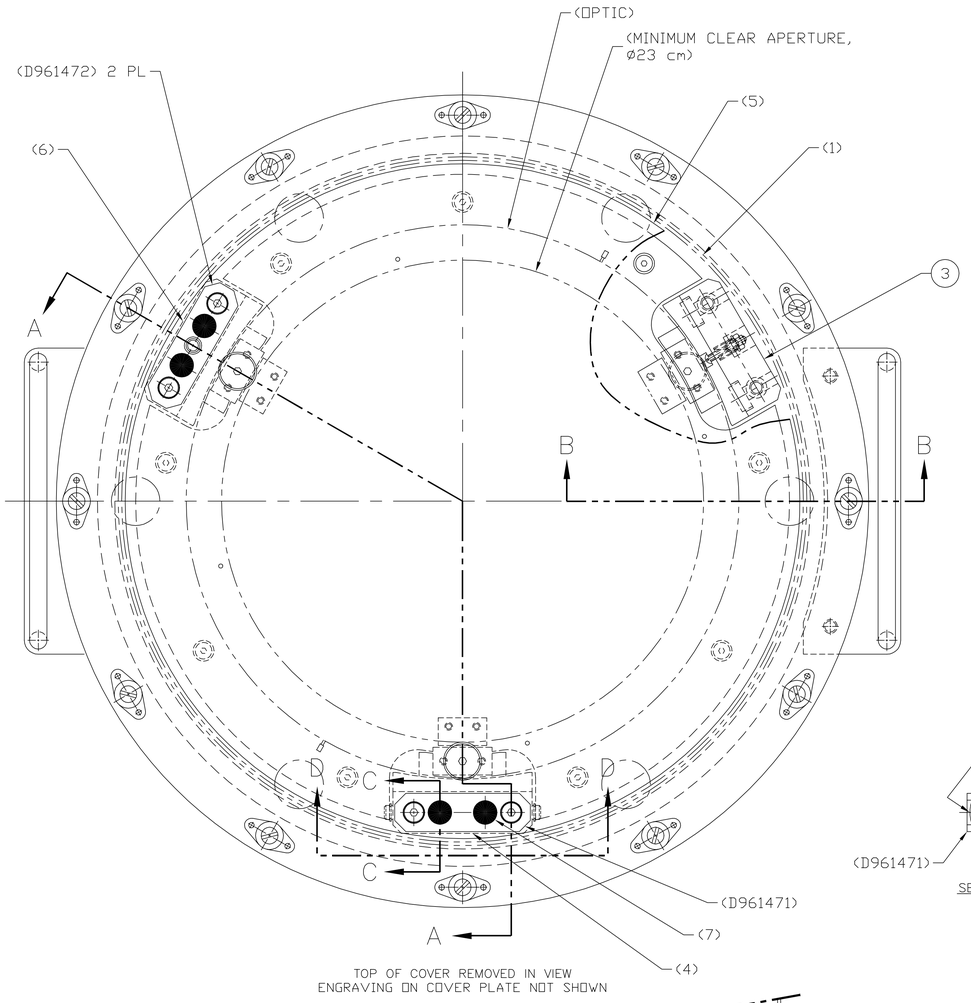
NOTES: (UNLESS OTHERWISE SPECIFIED)
1. SEE SEPARATE MATERIALS LIST D970006 FOR PARTS, MATERIALS, & VENDOR INFORMATION.

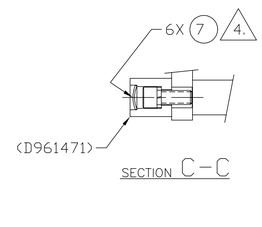
2. TORQUE ITEM 9 (SCREW) TO 70-75 in-lb.

3. TO INSTALL ITEM 5 (TOP PLATE ASSEMBLY), BACK OFF THE 2 MOUNTING SCREWS (SEE SECTION C-C) FOR EACH OF THE 3 CAPTIVE SCREW BRACKET SUB ASSEMBLIES (D961471 & D961472), UNTIL THE LOCK WASHERS ARE FREE OF COMPRESSION. SET ITEM 5 IN PLACE AND TORQUE THE CAPTIVE SCREWS (6 TOT) TO 65-70 in-lb. THEN, RE-TORQUE THE CAPTIVE SCREW BRACKET MOUNTING SCREWS TO 65-70 in-lb WHILE ITEM 5 REMAINS MOUNTED. REMOVE ITEM 5 FOR NEXT OPERATION, SEE NOTE 4.

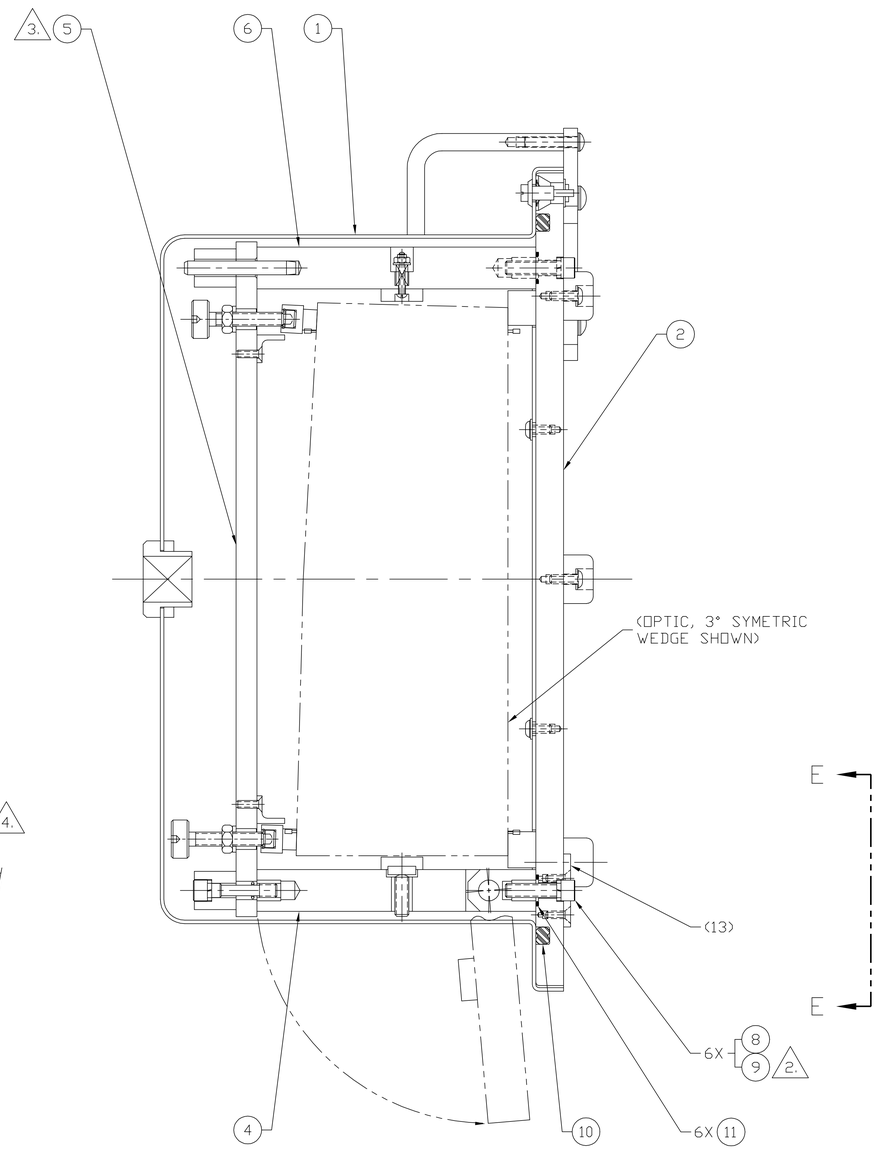
4. AFTER REMOVING ITEM 5, REMOVE CAPTIVE SCREWS (6 TOT, BY REMOVING WIRE RETAINING RING FROM SHANK USING PLIERS) FROM ITEM 5 AND INSTALL ITEM 7 (EXPANSION PLUG) USING D970004 EXPANSION PLUG INSTALLATION TOOL. DO NOT MAR BOTTOM SURFACE OF ITEM 5 WITH ANVIL. INSTALLATION TOOL MAY BE MODIFIED AS NECESSARY FOR PROPER COMPRESSION OF EXPANSION PLUG BY CUTTING BACK SHOULDER. FINALLY, REPLACE CAPTIVE SCREWS.



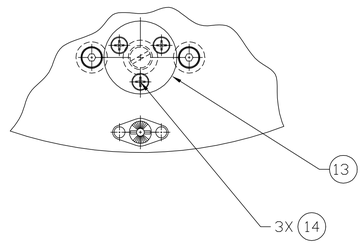
TOP OF COVER REMOVED IN VIEW
ENGRAVING ON COVER PLATE NOT SHOWN



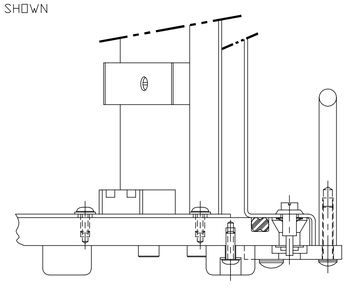
SECTION C-C



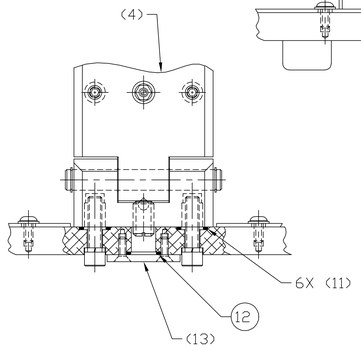
SECTION A-A



VIEW E-E



SECTION B-B



SECTION D-D
COVER NOT SHOWN

DWG. NO.	DESCRIPTION	DWG. NO.	DESCRIPTION
REFERENCE DRAWINGS			

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN FEET (cm)
TOLERANCES:
FRACTIONAL ±
ANGULAR MACH ± BEND ±
TWO PLACE DECIMAL ±
THREE PLACE DECIMAL ±
FINISHED SURFACE RMS
BREAK CORNERS (IN OUT)
REMOVE ALL BURRS

DO NOT SCALE THIS DRAWING
USED ON:
NEXT ASS'Y: N/A

REV	DESCRIPTION	DCC	SYS	DET	CDS	VE	CC	BT	CHECK	DRWN	DATE
A	DCN E960157										
00	PRE-RELEASE									CONLEY	10-29-96

ISSUE DESCRIPTION

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

LARGE CORE OPTIC COMPONENT CARRIER ASSEMBLY

CAD FILE	SIZE	DWG NO.
D961460-A.dwg	E	D961460-A-D
SCALE NTS		SHEET 1 OF 1