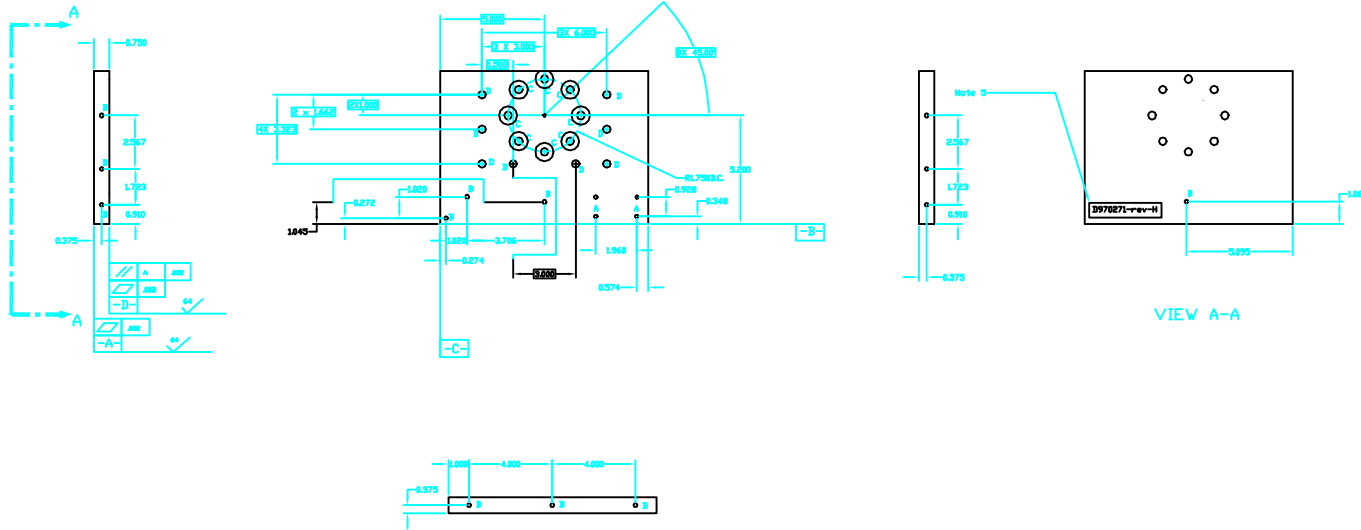


NOTES:

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. FILLETS TO BE R.03 MAX
5. VIBROETCH PART NUMBER AND REVISION, APPROX, WHERE SHOWN

HOLE	QTY	TOLERANCE	DESCRIPTION
A	4	$\varnothing .010 \text{ (M)}$ A B C	DRILL $\varnothing .144 - .150$, .532 MIN DEEP, CSINK 120 +/- 5 DEG X $\varnothing .18 - .21$ HELI-COIL TAP .31 MIN DP, #6-32 UNC-3B. CSINK AND INSTALL EMHART LOCKING HELI-COIL P/N 3585-06CN276 OR EQUIVALENT.
B	13	$\varnothing .010 \text{ (M)}$ A B C	DRILL $\varnothing .198 - .204$, .568 MIN DEEP, CSINK 120 +/- 5 DEG X $\varnothing .23 - .26$ HELI-COIL TAP .32 MIN DP, #10-32 UNF-3B. CSINK AND INSTALL EMHART NON-LOCKING HELI-COIL P/N 3591-3CN285 OR EQUIVALENT.
C	8	$\varnothing .007 \text{ (M)}$ A B C $\varnothing .005 \text{ (M)}$	DRILL $\varnothing .406$ THRU, CBORE $\varnothing .88$, .12 DEEP, NEAR SIDE
D	8	$\varnothing .007 \text{ (M)}$ A B C $\varnothing .005 \text{ (M)}$	DRILL $\varnothing .387 - .393$, THRU, CSINK 120 +/- 5 DEG X $\varnothing .42 - .45$ HELI-COIL TAP THRU #3/8-24 UNF-3B. CSINK AND INSTALL EMHART NON-LOCKING HELI-COIL P/N 1191-6CN562 OR EQUIVALENT.



REF	QTY	PART or DRWG No.	CDS	MATERIAL
			PARTS and MATERIAL LIST	
			LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
			PEM, INTERFACE PLATE BSC	
A		RELEASE DCN E980108-00-H	SMITH	6-98
00		PRE-RELEASE	SMITH	6-98
REV		DESCRIPTION	DCC	SYS
			DET	CBS
			VE	CC
			BT	CHECK
			DRWN	DATE
ISSUE DESCRIPTION			SCALE	SHEET
			FULL	1 of 1

UNLESS OTHERWISE SPECIFIED			
DIMENSIONS ARE IN FEET (cm)			
FRACTIONAL $\pm 1/16(1.6)$	FINISHED SURFACE RMS 63		
ANGULAR $\pm 1^\circ$	BREAK CORNERS .02		
TWO PLACE DECIMAL $\pm .01(0.25)$	REMOVE ALL BURRS		
THREE PLACE DECIMAL $\pm .005(0.13)$			
MATERIAL:	HEAT TREAT:	FINISH:	
6061-T6 ALUM.	-	note 1	
USED ON:-	NEXT ASS'Y:-		