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REVISIONS			
REV	DESCRIPTION	DATE	APPROVED
A	SEE ECN# D972216-A FOR CHANGE LIST	11/03/97	T. THOMPSON
B	SEE ECN# D972216-B FOR CHANGE LIST	04/23/99	T. THOMPSON

D

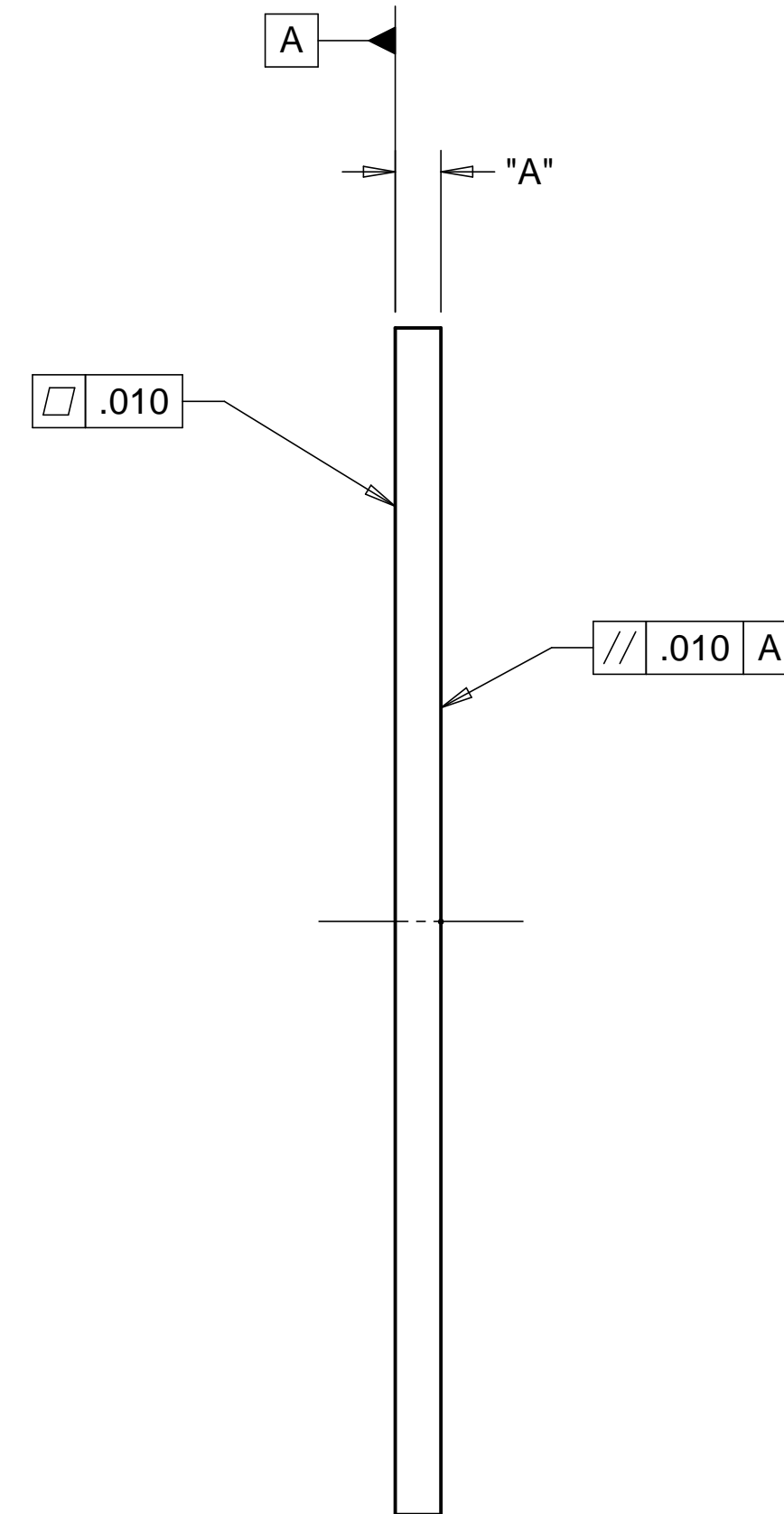
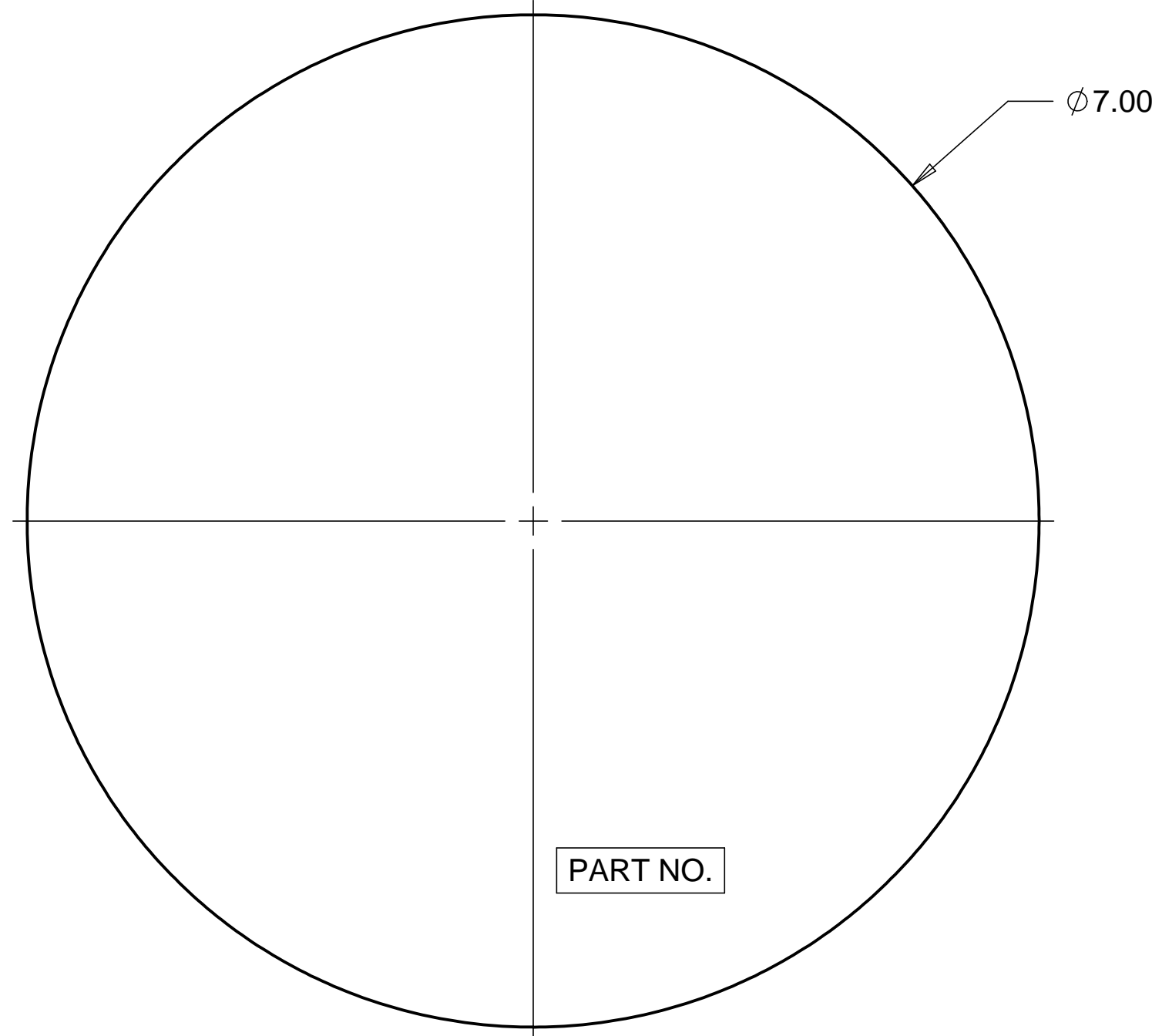
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B



PART NO.	DESCRIPTION	"A"	WEIGHT
D972216-1	SHIM, NOMINAL	0.400	1.5 lbs.
D972216-3	SHIM, 1/8 UNDER NOMINAL	0.275	1.0 lbs.
D972216-5	SHIM, .275 UNDER NOMINAL	0.125	.47 lbs.

MATL: ALUM. 6061-T651

NOTES: UNLESS OTHERWISE SPECIFIED

- ALL DIMENSIONS IN INCHES
- DIMENSIONS AND TOLERANCING PER ASME Y14.5M-1994
- SURFACE TEXTURE PER ANSI/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.) TO BE CLEARLY MARKED EITHER ON THE PART ITSELF, OR ON A TAG ATTACHED TO THE PART OR PACKAGE
- ALL FABRICATION, CLEANING, AND HANDLING MAINTAINED TO HYTEC SPECIFICATION: LIGO-TS-03 CATEGORY 1.
- NO SULFUR BASED CUTTING FLUIDS ALLOWED. APPROVED MACHINE LUBRICANT: ALUMICUT, MISTIC METAL MOVER, PRINCETON, IL.

PARTS LIST			
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES -TOLERANCES- DECIMALS .XX = +/- .03 .XXX = +/- .010 ANGULAR = +/- .30° SURFACE FINISH = 250	CAD GENERATED DRAWING, DO NOT MANUALLY UPDATE DO NOT SCALE DRAWING		HYTEC, INC TITLE LIGO ISOLATION STACK SHIM
			FINISH ALL MACHINED SURFACES 32 RMS
PART NO. D972216-1	DWG. NO. D972216	SIZE D	SHEET NO. 1 of 1
SCALE 1/1		REVISION B	

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