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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED

D

D

C

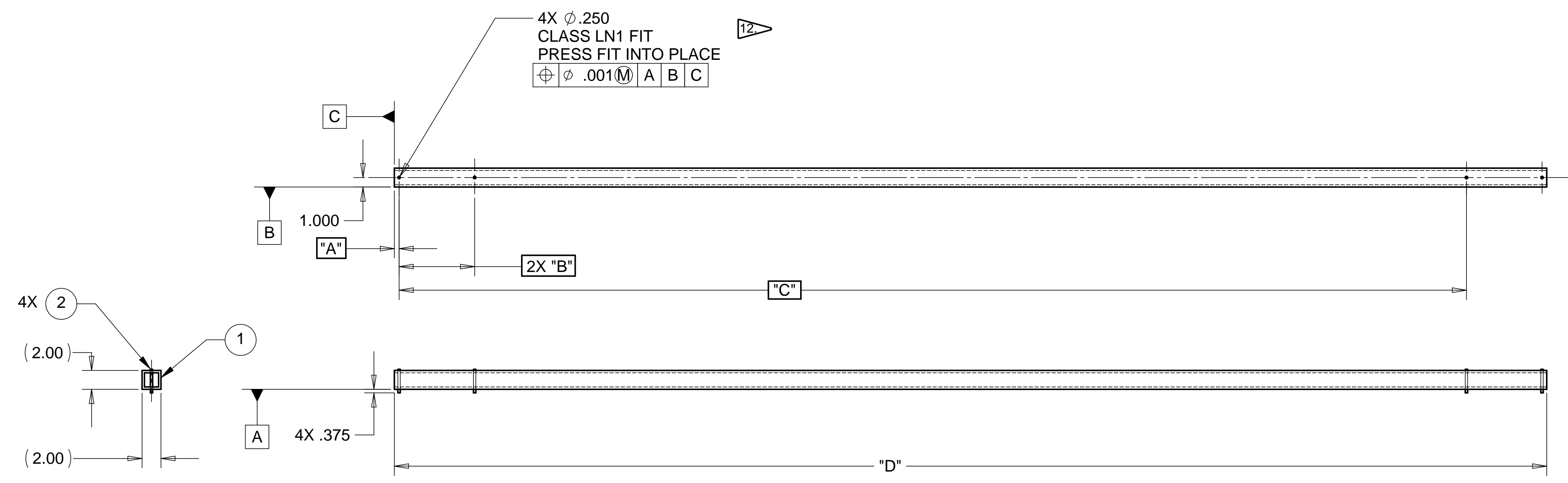
C

B

B

A

A



PART NO	DESCRIPTION	USE	DIM "A"	DIM "B"	DIM "C"	DIM "D"
D972400-1	TOOLING BAR #1	BSC	0.375	8.000	114.000	122.75
D972400-2	TOOLING BAR #4	HAM	0.375	11.000	119.625	120.38
D972400-3	TOOLING BAR #5	HAM	0.375	14.000	74.690	75.44

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
- 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 SPECIFICATION LIGO-TS-03 CATEGORY 1.
- ALL ALUM. WELDING DONE BY A GTAW PROCESS USING 2% THORIATED TUNGSTEN WELDING ELECTRODES AND ER4043 WELDING ROD (SPEC. PER AWS A5.10-80).
- NO SULFUR BASED CUTTING FLUIDS ALLOWED. APPROVED MACHINE LUBRICANT: ALUMICUT, MISTIC METAL MOVER, PRINCETON, IL.

12 USING SHIMS, CLAMP TUBING IN RELAXED STATE BEFORE DRILLING.

ITEM NO.	QTY.	DESCRIPTION	MATERIAL/PART NO.
1	1	TUBING, 2.0 X 2.0 X .25 WALL	6061-T6 ALUM
2	4	DOWEL PIN, 1/4 O.D. X 2.5 LONG	McMASTER #98381A552

PARTS LIST				HYTEC, INC	
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES -TOLERANCES-		CAD GENERATED DRAWING, DO NOT MANUALLY UPDATE DO NOT SCALE DRAWING		TITLE <b>OPTICS PLATE TOOLING BARS</b>	
DECIMALS .XX = +/- .03 .XXX = +/- .010	ANGULAR = +/- 30' SURFACE FINISH = 250	SIGNATURE	DATE	DWG. NO. <b>D972400</b> SIZE <b>D</b> SHEET NO. <b>1 of 1</b>	
FINISH	DESIGNED	W. K. MILLER	4/14/98	SCALE 1/8 REVISION	
PART NO. <b>D972400-1</b>	DRAWN	W. K. MILLER	4/14/98		
	CHECKED	HARRY SALAZAR	-		
	ENGR.	T. THOMPSON	-		
	APPROVED	T. THOMPSON	-		

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