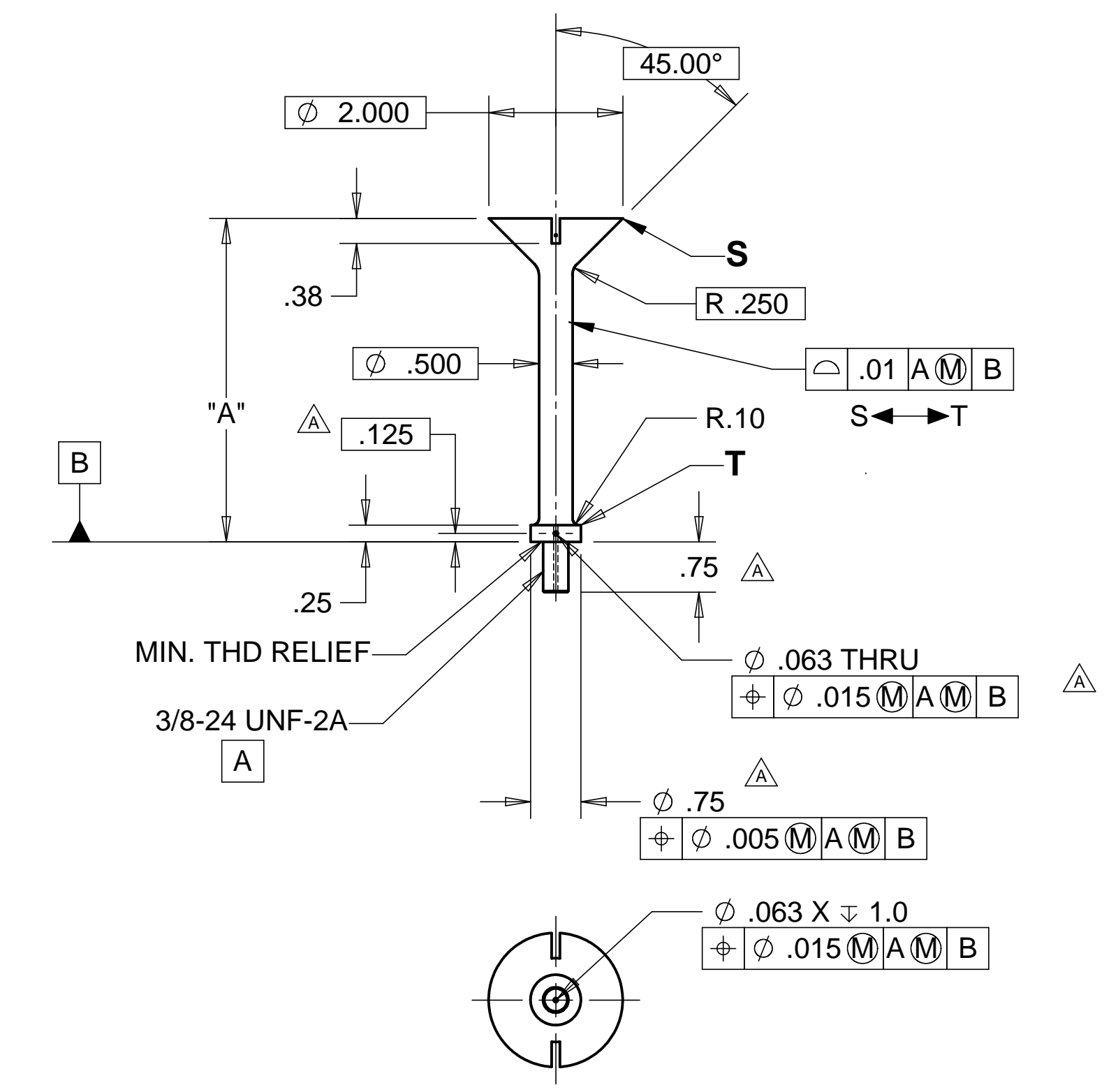
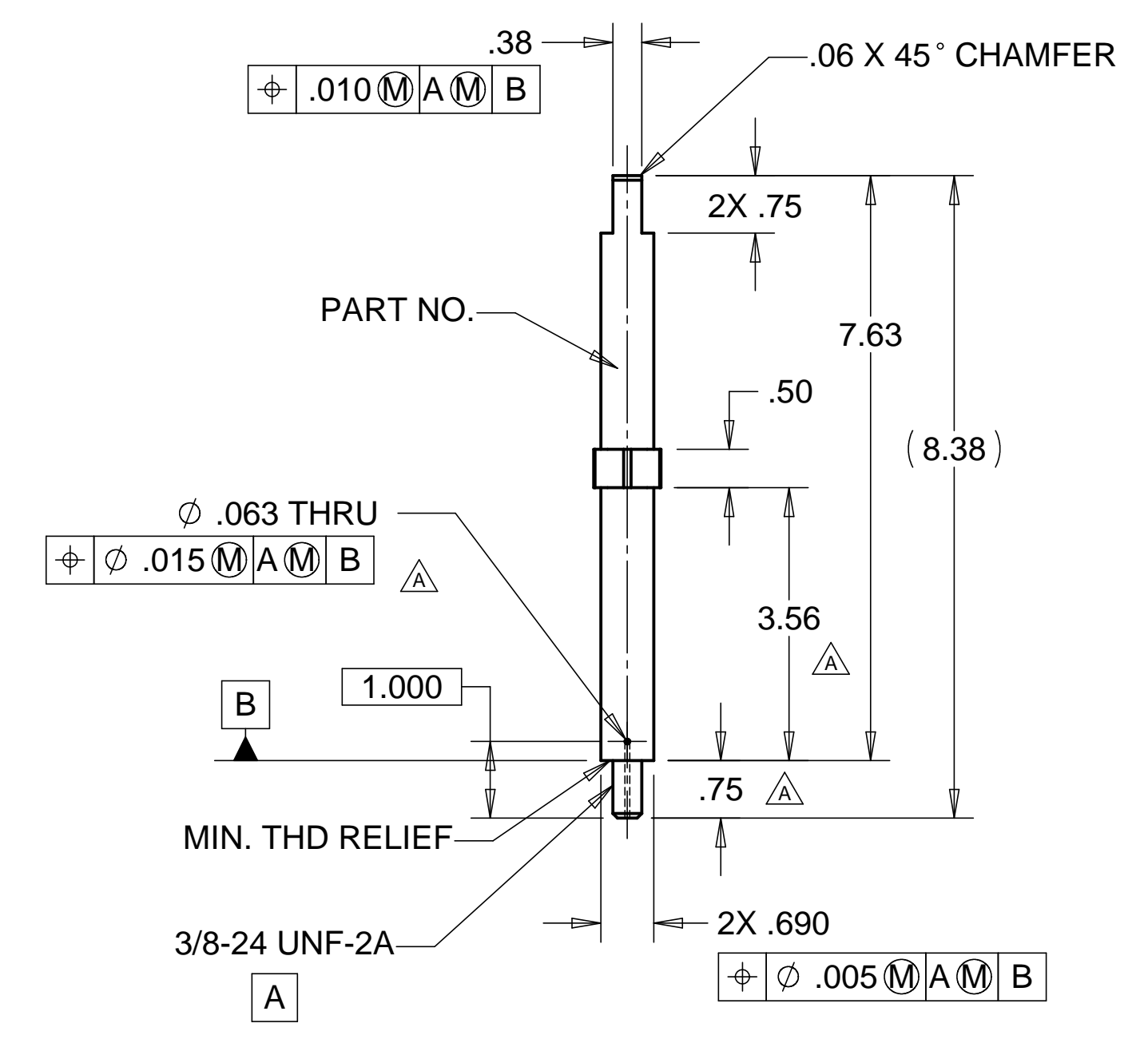
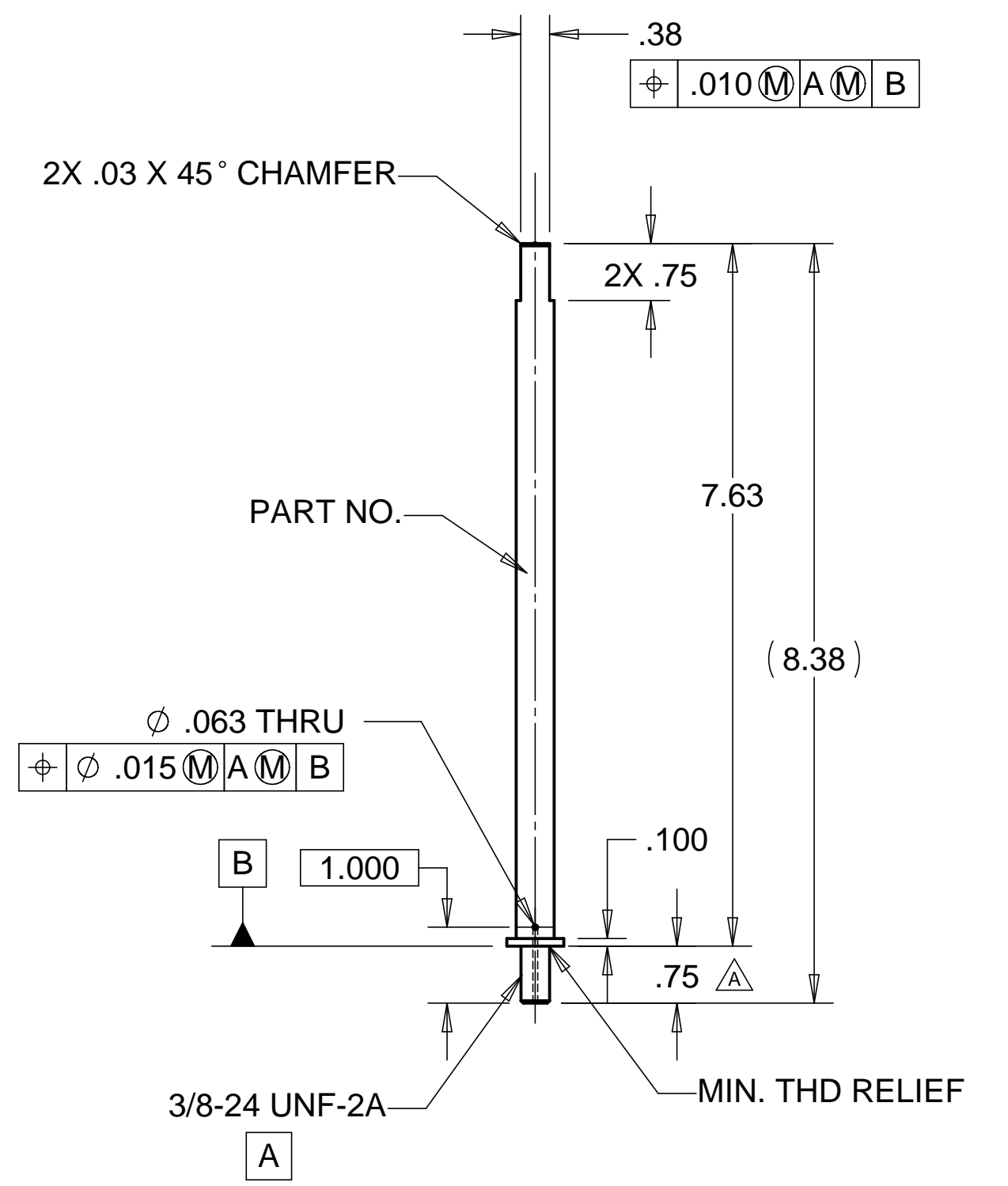
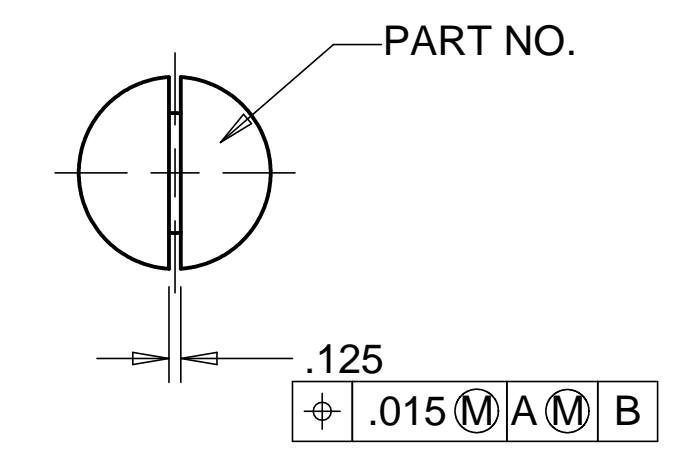
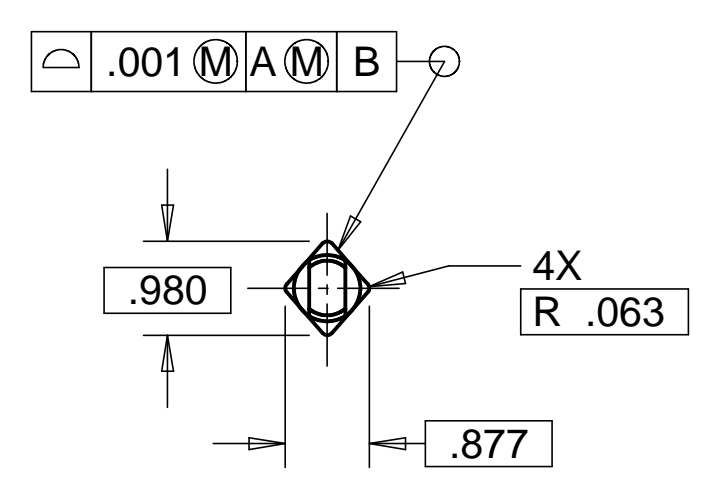
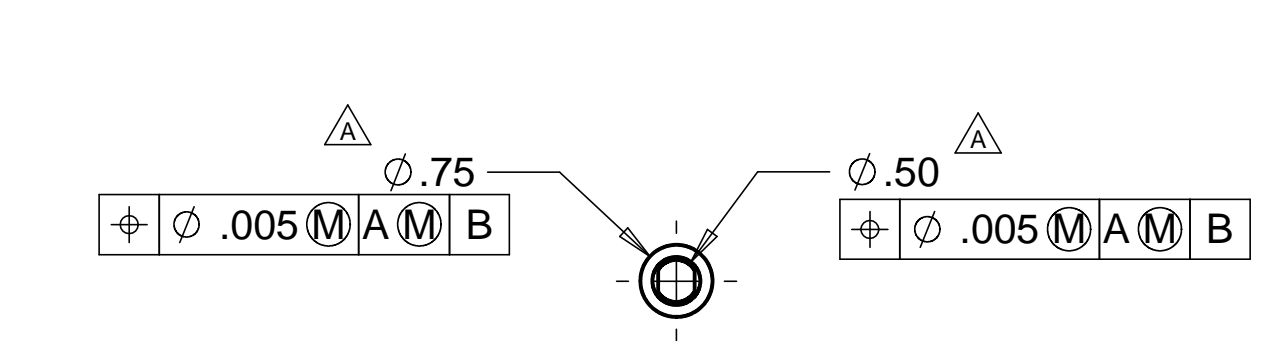


8 7 6 5 4 3 2 1

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
A	SEE ECN# D972715-A FOR CHANGE LIST	11-03-97	T. THOMPSON



-5 SAFETY PIN  
P.N.: D972715-5  
MATL: 304 SST  
MAGNAPLATE CORP.  
PVD TITANIUM NITRIDE (TiN) COATING  
MAGNAGOLD  
△ WEIGHT: 0.53 lbs.

-7 LOCATING PIN  
P.N.: D972715-7  
MATL: 304 SST  
MAGNAPLATE CORP.  
PVD TITANIUM NITRIDE (TiN) COATING  
MAGNAGOLD  
△ WEIGHT: 0.85 lbs.

MATL: 304 SST  
MAGNAPLATE CORP.  
PVD TITANIUM NITRIDE (TiN) COATING  
MAGNAGOLD

PART NO.	DESCRIPTION	"A"	WEIGHT
D972715-1	HAM LEG SCREW 1	3.919	0.51 lbs.
D972715-3	HAM LEG SCREW 2	5.766	0.61 lbs.

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 STAINLESS STEEL MACHINE LUBRICANT: RELTON A-9, RELTON

PARTS LIST			
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES -TOLERANCES-	CAD GENERATED DRAWING. DO NOT MANUALLY UPDATE DO NOT SCALE DRAWING		<b>HYTEC, INC</b> TITLE LIGO HAM ISOLATION STACK LEG LOCATION & ASSEMBLY PINS
	DECIMALS .X = +/- .1 .XX = +/- .03 .XXX = +/- .010	ANGULAR = +/- .30° SURFACE FINISH = 250	
FINISH ALL MACHINED SURFACES 64 RMS	SIGNATURE DESIGNED ROGER L. SMITH DRAWN ROGER L. SMITH CHECKED HARRY SALAZAR ENGR. T. THOMPSON APPROVED T. THOMPSON	DATE 5-28-97 5-28-97 6-6-97 7-10-97 7-10-97	SHEET NO. D 1 of 1 REVISION A
PART NO. D972715			

8 7 6 5 4 3 2 1