

NOTES CONTINUED:

⑤ SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED. EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX

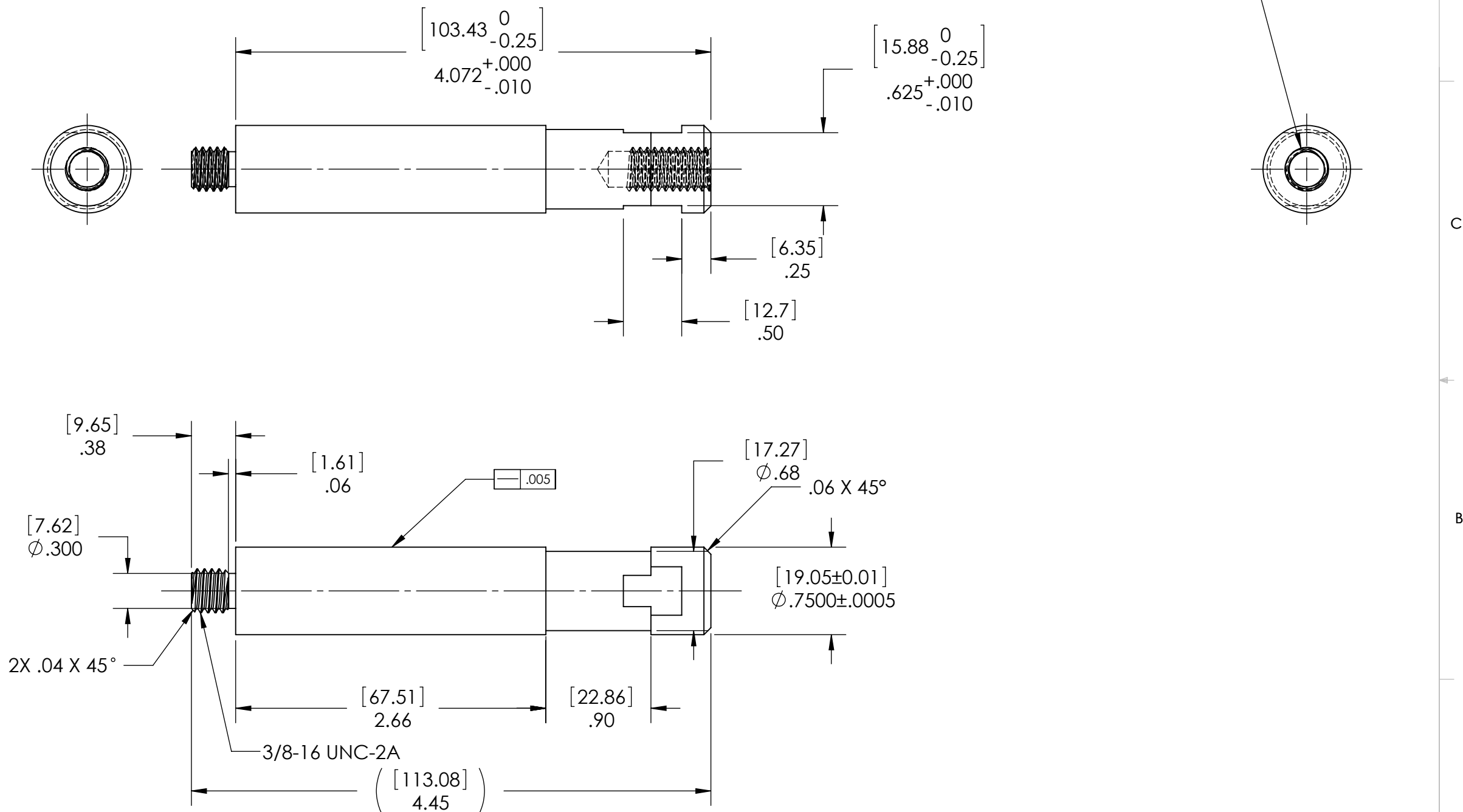
⑥ CAN BE MADE FROM MCMMASTER #8934K17 PRECISION GROUND SHAFTING

⑦ HELICOIL INSTALLATION:

- A) DRILL PILOT HOLE FOR INSERT SPECIFIED ON THE DRAWING, REFERENCE HELI-COIL PRODUCT CATALOGUE, HC 2000
- B) COUNTERSINK HOLE FOR INSERT SPECIFIED ON THE DRAWING, REFERENCE HELI-COIL PRODUCT CATALOGUE, HC 2000
- C) TAP HOLE FOR INSERT SPECIFIED ON THE DRAWING, REFERENCE HELI-COIL PRODUCT CATALOGUE, HC 2000
- D) REMOVE ALL CHIPS
- E) GAGE THREADS WITH GAGE TOOL FOR INSERT SPECIFIED IN DRAWING, REFERENCE HELI-COIL PRODUCT CATALOGUE, HC 2000
- F) CLEAN THE HOLE, INSERTING TOOL AND HELI-COIL WITH SOAP AND WATER
- G) CLEAN THE HELI-COIL AND INSERT TOOL IN ACETONE (IF THE INSERT TOOL HAS ANY PLASTIC USE ISOPROPYL ALCOHOL INSTEAD OF ACETONE TO CLEAN THE INSERT TOOL)
- H) CLEAN THE HOLE WITH ACETONE AND A STAINLESS STEEL WIRE BRUSH
- I) RINSE THE HELI-COIL, INSERTING TOOL AND THE HOLE WITH DE-IONIZED WATER
- J) POWDER FREE LATEX GLOVES MUST BE WORN WHEN INSERTING THE HELI-COILS. (LATEX GLOVES FROM ANSELL EDMONT, ACCUTECH-ULTRA CLEAN 91-300)
- K) INSERT THE HELI-COIL WITH TOOL TO 3/4 TO 1 1/2 PITCH BELOW SURFACE
- L) BREAK OFF AND REMOVE TANG
- M) ONCE HELI-COILS HAVE BEEN INSERTED AND FINAL ASSEMBLY IS BEING CARRIED OUT, FOR EXAMPLE, INSERTING THE O-RINGS PLEASE KEEP THE ASSEMBLIES AS CLEAN AS POSSIBLE I.E. FREE FROM OIL, GREASE, DIRT, AND CHIPS CLEAN.

REV.	DATE	DCN #	DRAWING TREE #
V1	17 JUN 2010		

⑦
 DRILL AND TAP FOR 3/8-16
 N60 HELICOIL INSERT #1185-6EN750



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES [MM]
 TOLERANCES:
 .XX ± .01
 .XXX ± .005
 ANGULAR ± 0.5°

1. INTERPRET DRAWING PER ASME Y14.5-1994.
 2. REMOVE ALL SHARP EDGES, R.02 MIN.
 3. DO NOT SCALE FROM DRAWING.
 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.

MATERIAL 304 SSSL ⑥ FINISH 63 μinch

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
SYSTEM ADVANCED LIGO SUB-SYSTEM COC NEXT ASSY		LOCATING SHAFT, R OPTIC, INSPECTION FIXTURE	
DESIGNER	K. BUCKLAND	22 FEB 2010	SIZE DWG. NO.
DRAFTER	K. BUCKLAND	22 FEB 2010	B
CHECKER			D1000349
APPROVAL			REV. V1
SCALE: 1:1		PROJECTION:	
		SHEET 1 OF 1	

D1000349 LOCATING SHAFT, R OPTIC INSPECTION FIXTURE, COC CONTAINER, ADVANCED LIGO, PART PDM REV: X-000, DRAWING PDM REV: X-001