

DR. & RM. $\phi.250 \nabla .75$
P.F. FOR ITEM ④

4X $\phi.332 \nabla .68$
 $\sphericalangle 82 \pm 100 \times \phi.39 \pm .01$
3/8-16 UNC-2B $\nabla .43$ MIN FULL THD
FOR ITEM ⑤ NEAR SIDE
FOR ITEM ② FAR SIDE

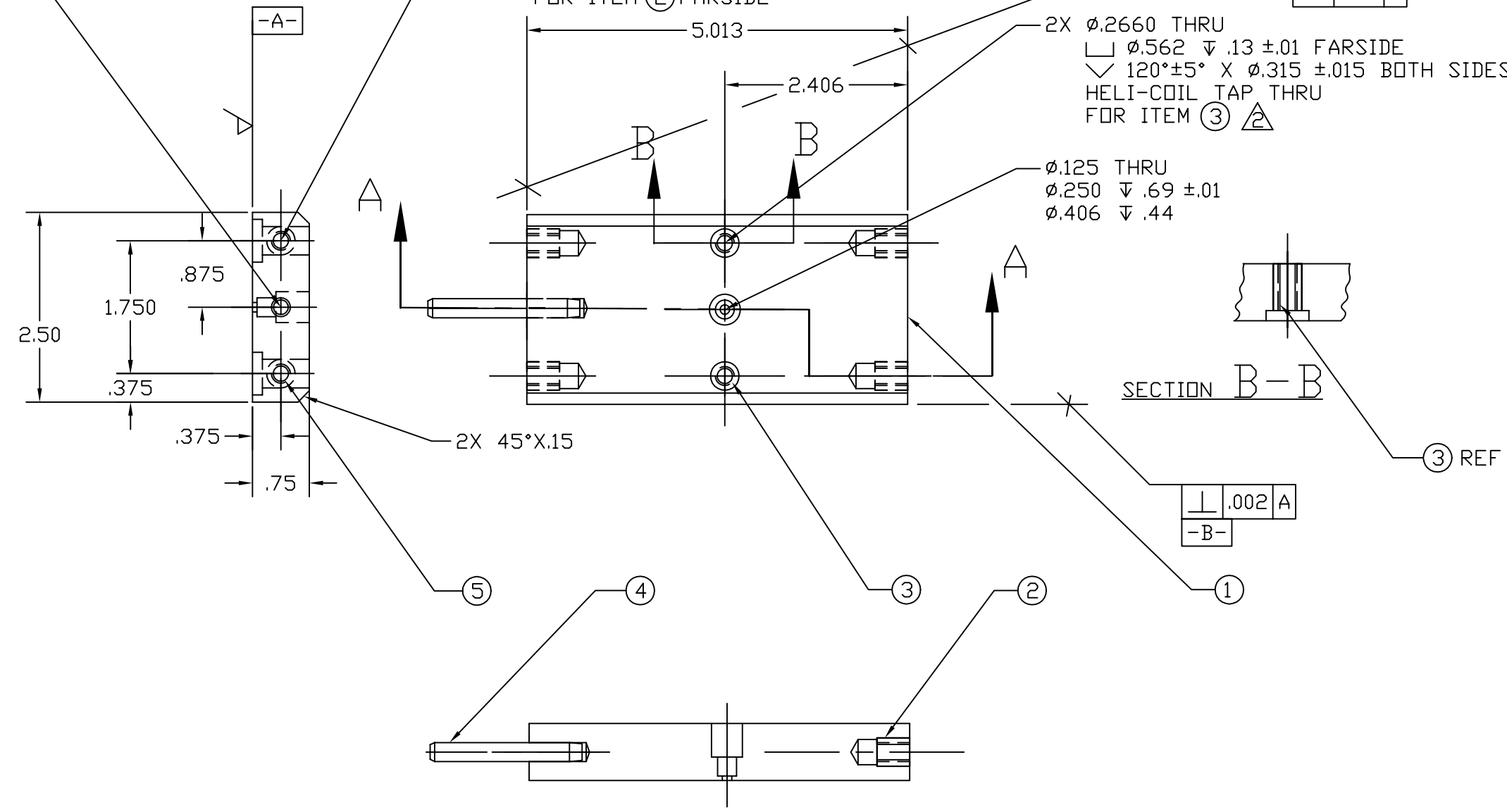
2X $\phi.2660$ THRU
 $\square \phi.562 \nabla .13 \pm .01$ FAR SIDE
 $\sphericalangle 120 \pm 5 \times \phi.315 \pm .015$ BOTH SIDES
HELI-COIL TAP THRU
FOR ITEM ③

$\phi.125$ THRU
 $\phi.250 \nabla .69 \pm .01$
 $\phi.406 \nabla .44$

⊥	.001	A
	.003	B

⊥	.002	A
	-	B-

- NOTES: (UNLESS OTHERWISE SPECIFIED)
1. INTERPRET DRAWING PER ANSI Y14.5M-1982
 - INSTALL ITEM 3 (THREAD INSERT) FROM NEAR SIDE, TO WITHIN 1/4 THREAD PITCH FLUSH WITH FAR END OF TAPPED HOLE, NO PROTRUSION. ALTER LENGTH FLUSH WITH NEAR SIDE WITHIN 1/2 THREAD PITCH, NO PROTRUSION.
 - FOR VENDOR INFORMATION, SEE TOP ASSEMBLY MATERIALS LIST D970006 OR D970007.



SECTION A-A

REF	QTY	PART or DRWG No.	NOMENCLATURE or DESCRIPTION	MATERIAL
5	2	SPECIAL-T #KN420J	LT. WT. THD "KEENSERT" 1/4-20 X 5/8	STAINLESS STEEL
4	1	McM-Carr #90145A549	1/4 DIA X 2.0 LG DOWEL PIN	STAINLESS STEEL
3	2	EMHART FST #1185-4CN625	THREAD INSERT "HELICOIL" 1/4-20 X 5/8	STAINLESS STEEL
2	2	SPECIAL-T #KNL420J	LOCKING THD "KEENSERT" 1/4-20 X 5/8	STAINLESS STEEL
1	1	-	.75 X 2.50 RECTANGULAR BAR	(SEE MAT'L/H.T. BLKS)
REF				

PARTS and MATERIAL LIST

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		TOLERANCES: FRACTIONAL ± ANGULAR ± 0.5° ANGULAR MACH ± BEND ± TWO PLACE DECIMAL ± .03		THREE PLACE DECIMAL ± .005 FINISHED SURFACE 32 MICROINCH AVERAGE BREAK CORNERS IN "OUT" .005-.010 REMOVE ALL BURRS		MATERIAL: 6061 ALU BAR PER QQ-A-225/8		HEAT TREAT: T6 PER AMS 2770		FINISH:		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY LARGE CORE OPTIC COMPONENT CARRIER STANDOFF									
DWG. NO.	DESCRIPTION	USED ON:	NEXT ASS'Y:	DCN No. E960157	01 RELEASE FOR FAB	00 PRE-RELEASE	REV	DESCRIPTION	DCS	SYS	DET	CDS	VE	CC	BT	CHECK	DRWN	DATE	CAD FILE	SIZE	DWG. NO.
6	REFERENCE DRAWINGS	5	D961434																D961432-Adwg	B	D961432-A-D
SCALE: NTS																	SHEET: 1 OF 1				