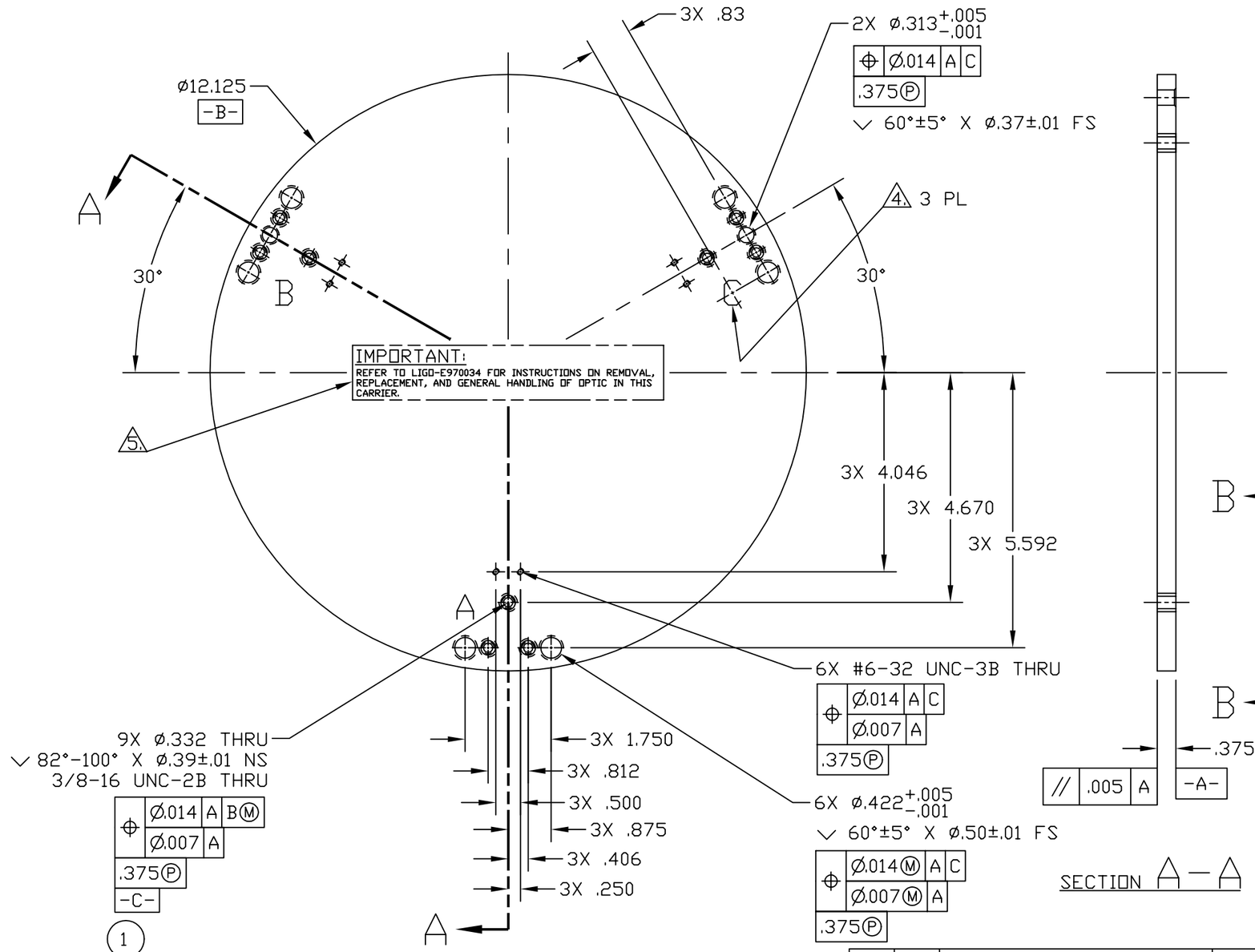

NOTES: (UNLESS OTHERWISE SPECIFIED)

1. INTERPRET DRAWING PER ANSI Y14.5M-1982.
2. ALL LOCATING DIMENSIONS ON DRAWING ARE BASIC.
3. MACHINE PROTRUDING END OF ITEM 1 (THREADED INSERT) FLUSH WITH FACE WITHIN .005-.010 INSIDE OF PART TO NOTED DIAMETER.
   OPT: MACHINE ITEM 1 TO .325-.335 LENGTH BEFORE INSTALLATION TO AVOID PROTRUSION.
4. PERMANENTLY MARK AS SHOWN USING 3/8 HIGH X .010 DEEP CHARACTERS.
5. PERMANENTLY MARK APPROX.. WHERE SHOWN USING 1/8 & 1/4 HIGH X .010 DEEP CHARACTERS.
6. FOR VENDOR INFORMATION, SEE TOP ASSEMBLY MATERIALS LIST D970006 OR D970007.

PARTS and MATERIAL LIST 6

REF.	QTY.	PART or DRWG No.	NOMENCLATURE or DESCRIPTION	MATERIAL
1	9	KEENSERT #KN420J	1/4-20 THREADED INSERT, NON-LOCKING	SS

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES

TOLERANCES:
FRACTIONAL ±
ANGULAR ±0.5°
ANGULARMACH ± 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 TOOLING PLATE 3/8 THICK
HEAT TREAT: T6 PER AMS 2770
FINISH:

REV	DESCRIPTION	DRWN	CHECK	DATE	DCC	DATE
C	DCN E970075	CONLEY				
B	DCN E970062	CONLEY	CDYNE	5-9-97		
A	DCN E960157	CONLEY	CDYNE	2-14-97		
01	RELEASE FOR FAB					
pA	PRELIMINARY RELEASE					
00	PRE-RELEASE	CONLEY		1-3-97		

ISSUE DESCRIPTION

DWG. NO.	DESCRIPTION
REFERENCE DRAWINGS	

USED ON: NEXT ASS'Y: D961450

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY

CORE OPTIC COMPONENT CARRIER TOP PLATE

CAD FILE: D961449-C.dwg
SIZE: B
DWG. NO.: D961449-C-D
SCALE: NTS
SHEET: 1 OF 1