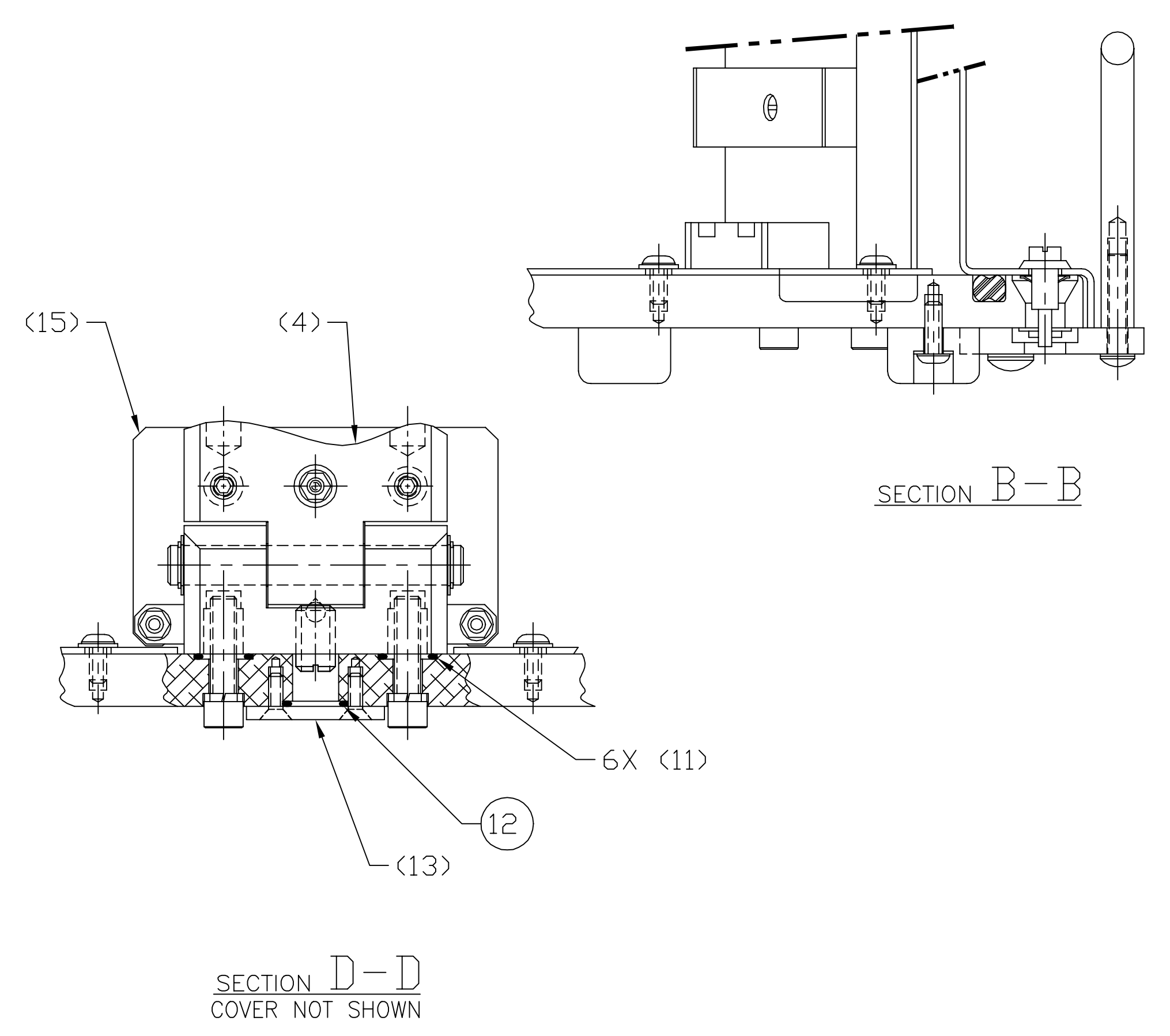
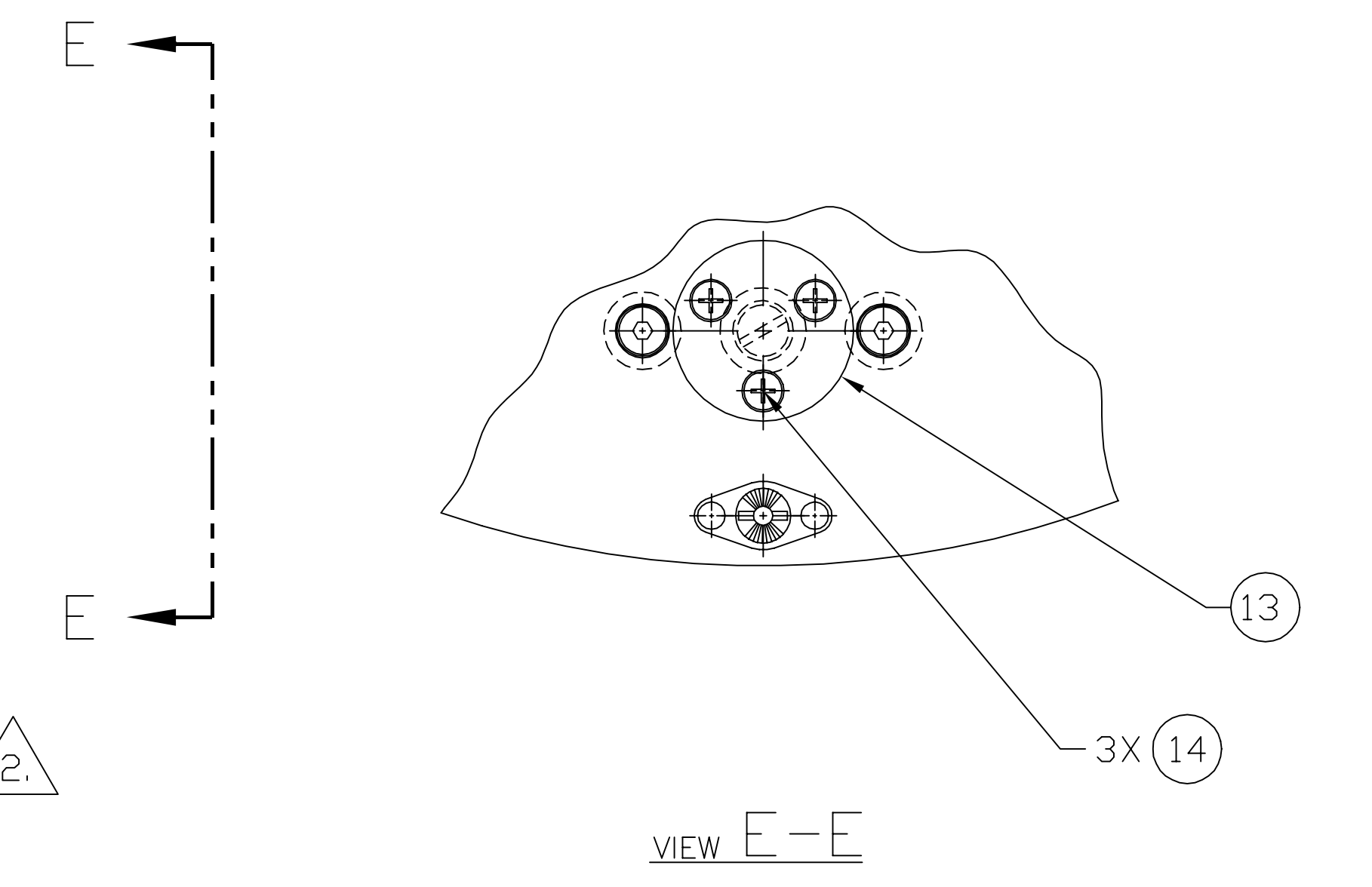
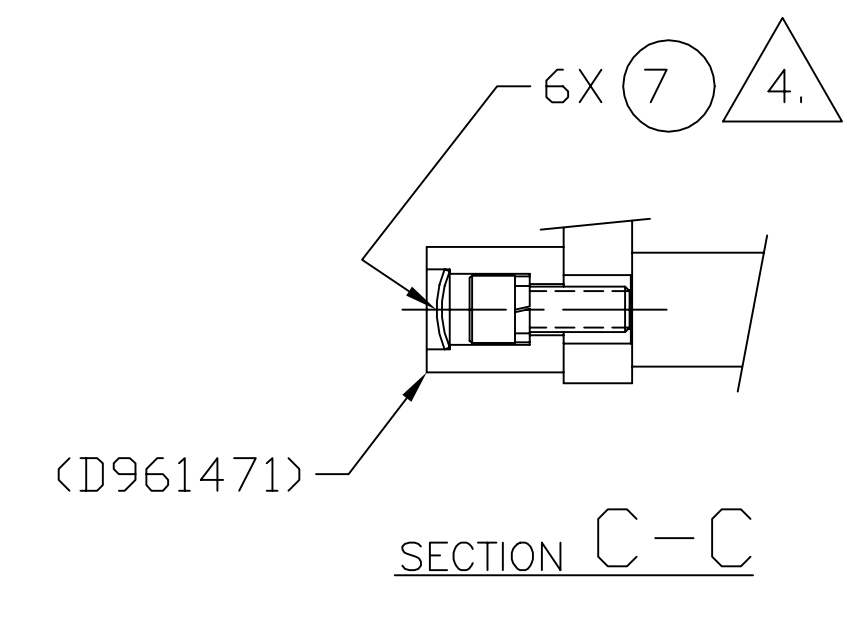


NOTES: (UNLESS OTHERWISE SPECIFIED)
 1. SEE SEPARATE MATERIALS LIST D970007 FOR PARTS, MATERIALS, & VENDOR INFORMATION.
 ⚠ TORQUE ITEM 9 (SCREW) TO 70-75 in-lb.
 ⚠ TO INSTALL ITEM 5 (TOP PLATE ASSEMBLY), BACK OFF THE 2 MOUNTING SCREWS (SEE SECTION C-C) FOR EACH OF THE 3 CAPTIVE SCREW BRACKET SUB ASSEMBLIES (D961471 & D961472), UNTIL THE LOCK WASHERS ARE FREE OF COMPRESSION. SET ITEM 5 IN PLACE AND TORQUE THE CAPTIVE SCREWS (6 TOT) TO 65-70 in-lb. THEN, RE-TORQUE THE CAPTIVE SCREW BRACKET MOUNTING SCREWS TO 65-70 in-lb WHILE ITEM 5 REMAINS MOUNTED. REMOVE ITEM 5 FOR NEXT OPERATION. SEE NOTE 4.
 ⚠ AFTER REMOVING ITEM 5, REMOVE CAPTIVE SCREWS (6 TOT, BY REMOVING WIRE RETAINING RING FROM SHANK USING PLIERS) FROM ITEM 5 AND INSTALL ITEM 7 (EXPANSION PLUG) USING D970004 EXPANSION PLUG INSTALLATION TOOL. DO NOT MAR BOTTOM SURFACE OF ITEM 5 WITH ANVIL. INSTALLATION TOOL MAY BE MODIFIED AS NECESSARY FOR PROPER COMPRESSION OF EXPANSION PLUG BY CUTTING BACK SHOULDER. FINALLY, REPLACE CAPTIVE SCREWS.



UNLESS OTHERWISE SPECIFIED
 DIMENSIONS ARE IN FEET (cm)
 TOLERANCES:
 FRACTIONAL #
 ANGULAR APPROX ± BEND #
 TWO PLACE DECIMAL #
 THREE PLACE DECIMAL #
 FINISHED SURFACE, SHG. DUTY
 BREAK CORNERS ON REMOVE ALL BURNS
 DO NOT SCALE THIS DRAWING
 USED ON: _____
 NEXT ASS'Y: N/A

REV	DESCRIPTION	ISSUE DESCRIPTION	BCC	SYS	BET	CDS	VE	CC	BT	DRWN	CHECK	DATE
B	DCN E970059									CONLEY		
A	DCN E960157									CONLEY	CDYNE	2-14-97
00	PRE-RELEASE									CONLEY		1-2-97

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**BEAM SPLITTER OPTIC
 CARRIER ASSEMBLY**

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 DWG NO: D961461-B-D
 SHEET: 1 OF 1