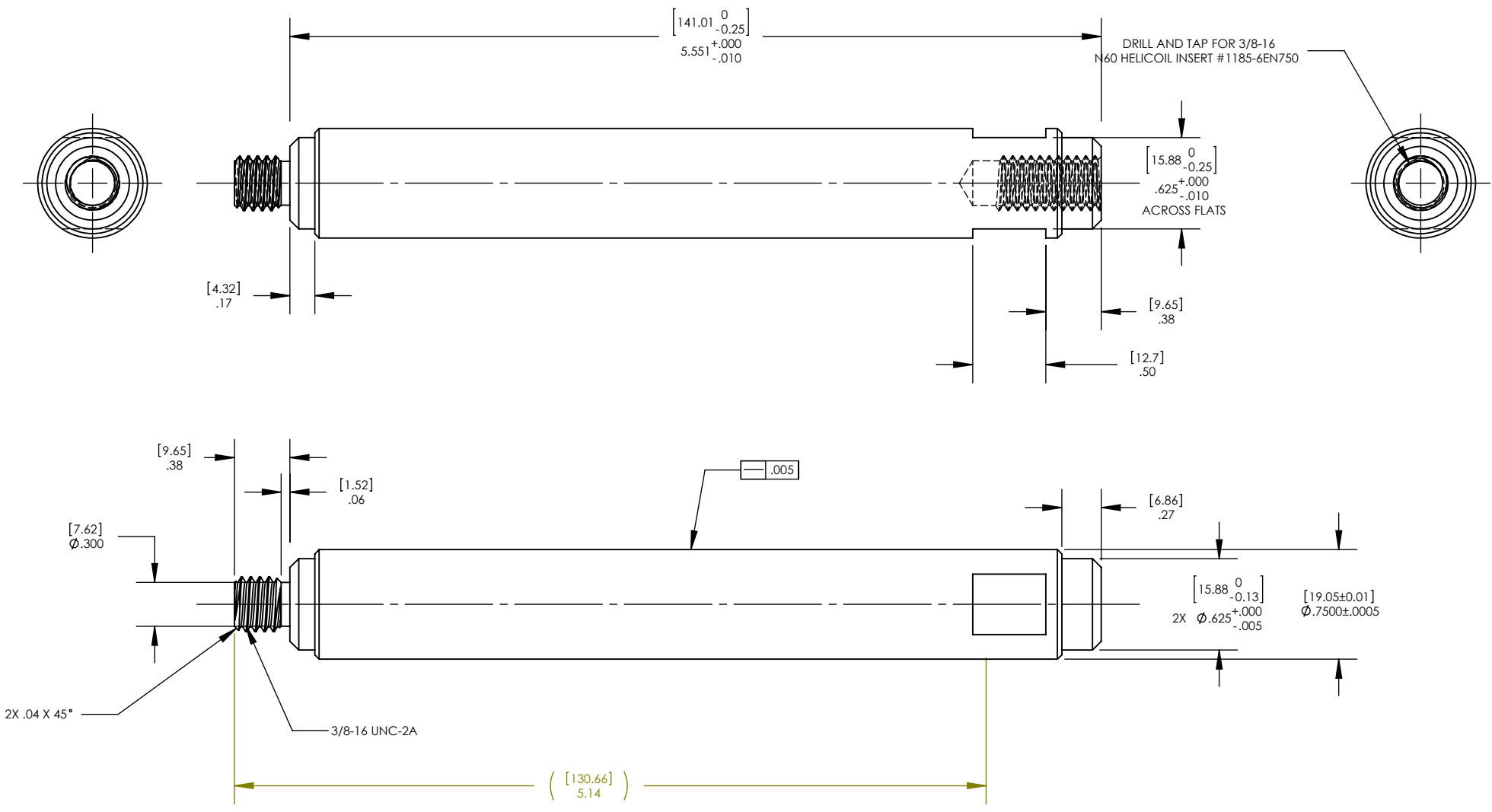


- NOTES CONTINUED:**
- Ⓢ SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED IN INCREASING ORDER.
 - Ⓢ HARDSHIP SHALL BE A MINIMUM 0.12" HIGH AND SHALL BE REFERENCED TO THE Heli-Coil Product Catalogue, HC 2000.
 - Ⓢ VITACOR (V) SHALL BE REFERENCED TO THE Heli-Coil Product Catalogue, HC 2000.
 - B) COUNTERSINK HOLE FOR INSERT SPECIFIED ON THE DRAWING, REFERENCE HELI-COIL PRECISION PRODUCTS 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 ¾ TO 1½ 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 OR

REV.	DATE	DCN #	DRAWING TREE #
v1	11 JUN 2013		



D1300533 KAGRA, LOCATING SHAFT, 370mm OPTIC CONTAINER, PART PDM REV: X-001, DRAWING PDM REV: X-001

DIMENSIONS ARE IN INCHES [MM]		TOLERANCES:		ANGULAR ± 0.5°		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
.XX	± .01	.XXX	± .005			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.	LOCATING SHAFT, 370mm OPTIC CONTAINER	
MATERIAL		FINISH		NEXT ASSY		SYSTEM		SUB-SYSTEM		DESIGNER	REV.
304 SSSL 6		63 μinch		D1300532		KAGRA		N/A		K. BUCKLAND	v1
										DRAFTER	SIZE DWG. NO.
										K. BUCKLAND	B D1300533
										CHECKER	SCALE: 1:1
										APPROVAL	PROJECTION:
											SHEET 1 OF 1