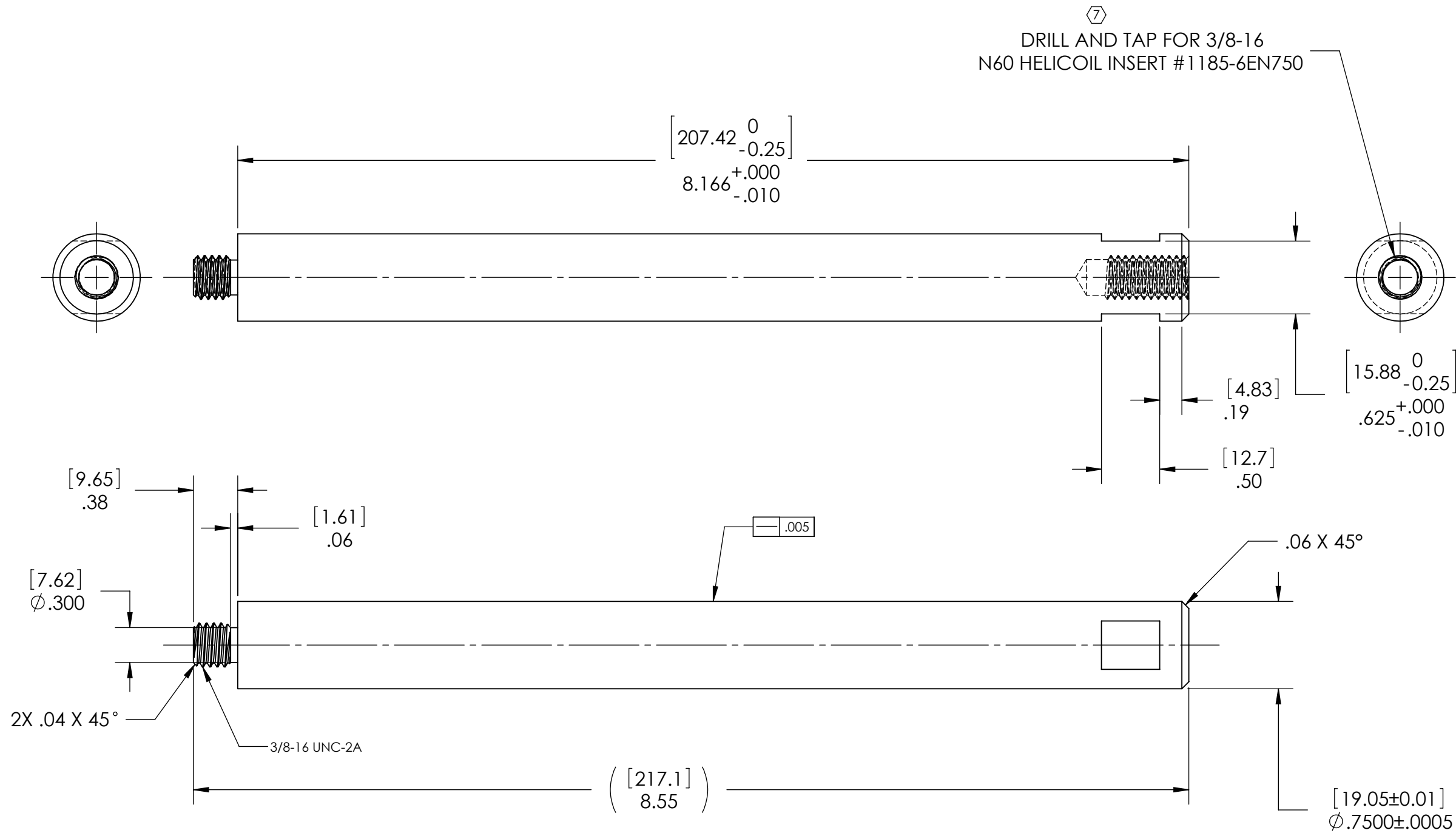


NOTES CONTINUED:
 ⑤ SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR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

⑥ CAN BE MADE FROM MCMASTER #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	12 JUN 2013		



D1300540 KAGRA, LOCATING SHAFT, 220mm OPTIC CONTAINER, PART PDM REV: X-001, DRAWING PDM REV: X-001

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
DIMENSIONS ARE IN INCHES [MM]				SYSTEM		LOCATING SHAFT, 220mm OPTIC CONTAINER	
TOLERANCES: .XX ± .01 .XXX ± .005				KAGRA		DESIGNER K. BUCKLAND 12 JUN 2013	
ANGULAR ± 0.5°				SUB-SYSTEM N/A		DRAFTER K. BUCKLAND 12 JUN 2013	
MATERIAL 304 SSSL ⑥				NEXT ASSY D1300539		SIZE DWG. NO. B D1300540	
FINISH 63 μinch						CHECKER	
						APPROVAL	
						SCALE: 1:1 PROJECTION: SHEET 1 OF 1	
						REV. v1	