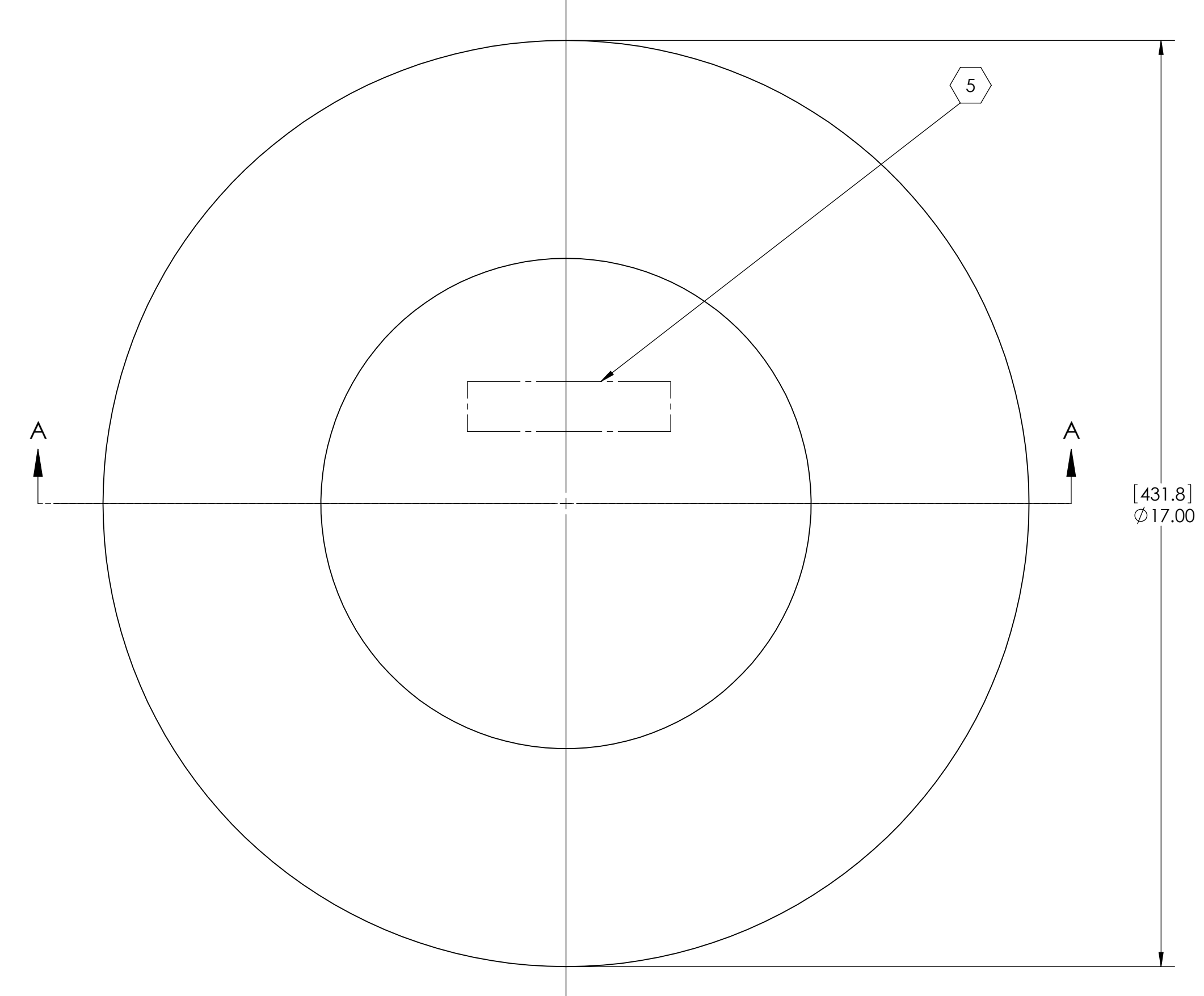
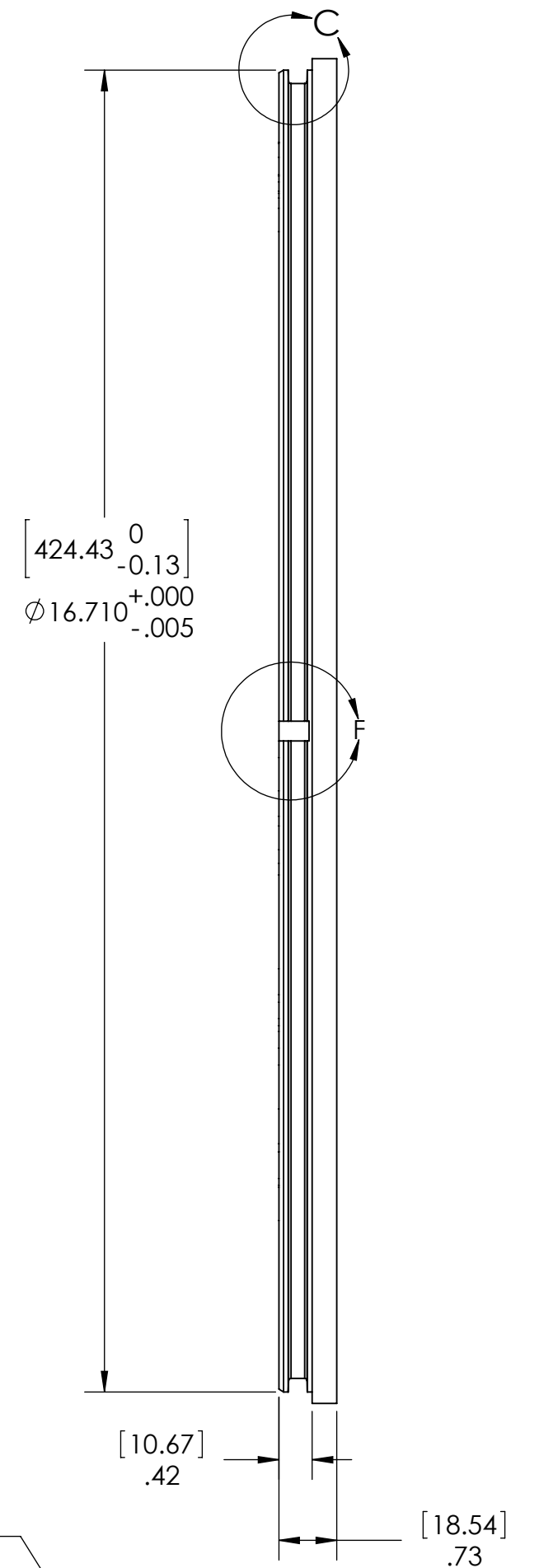
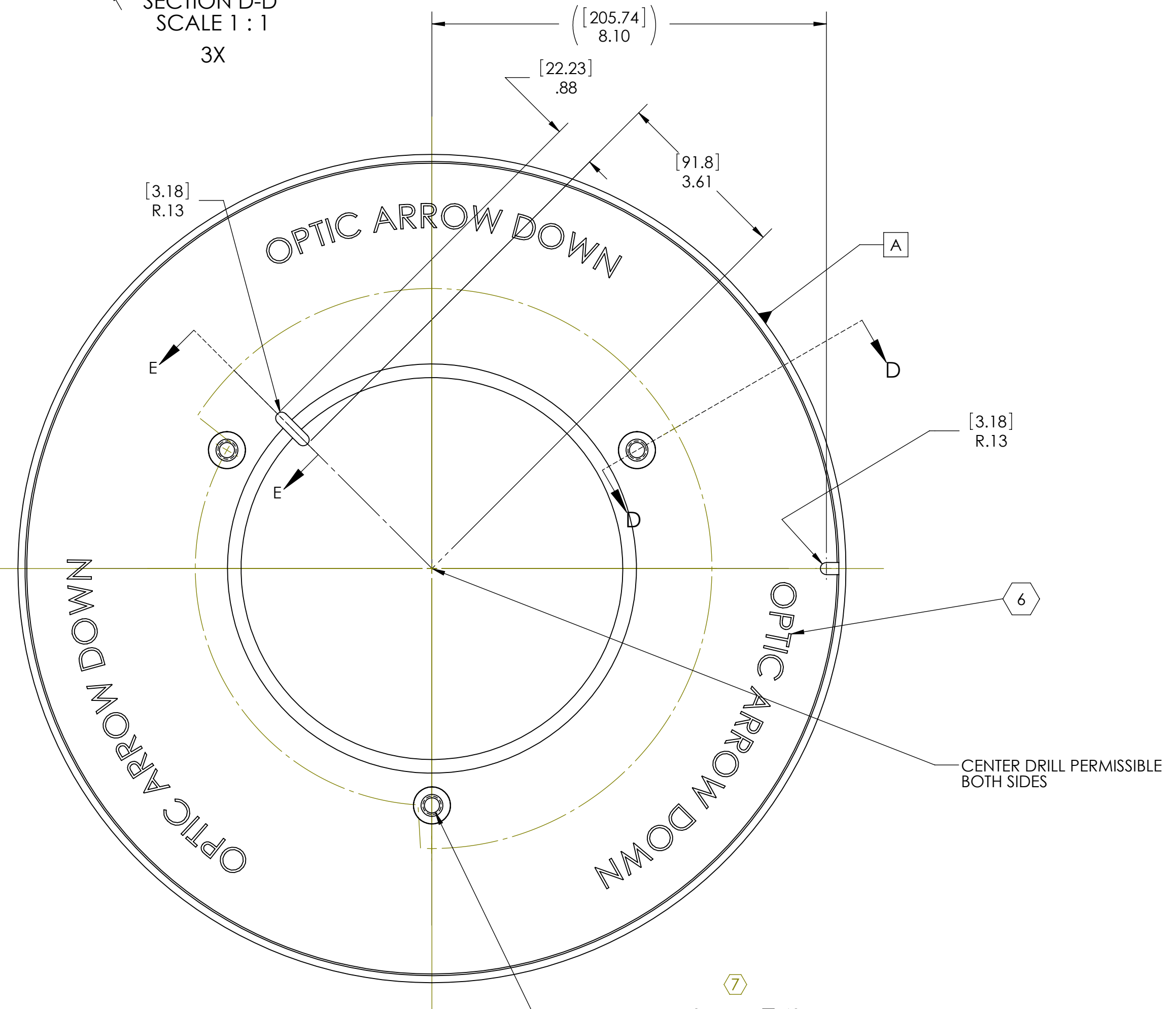
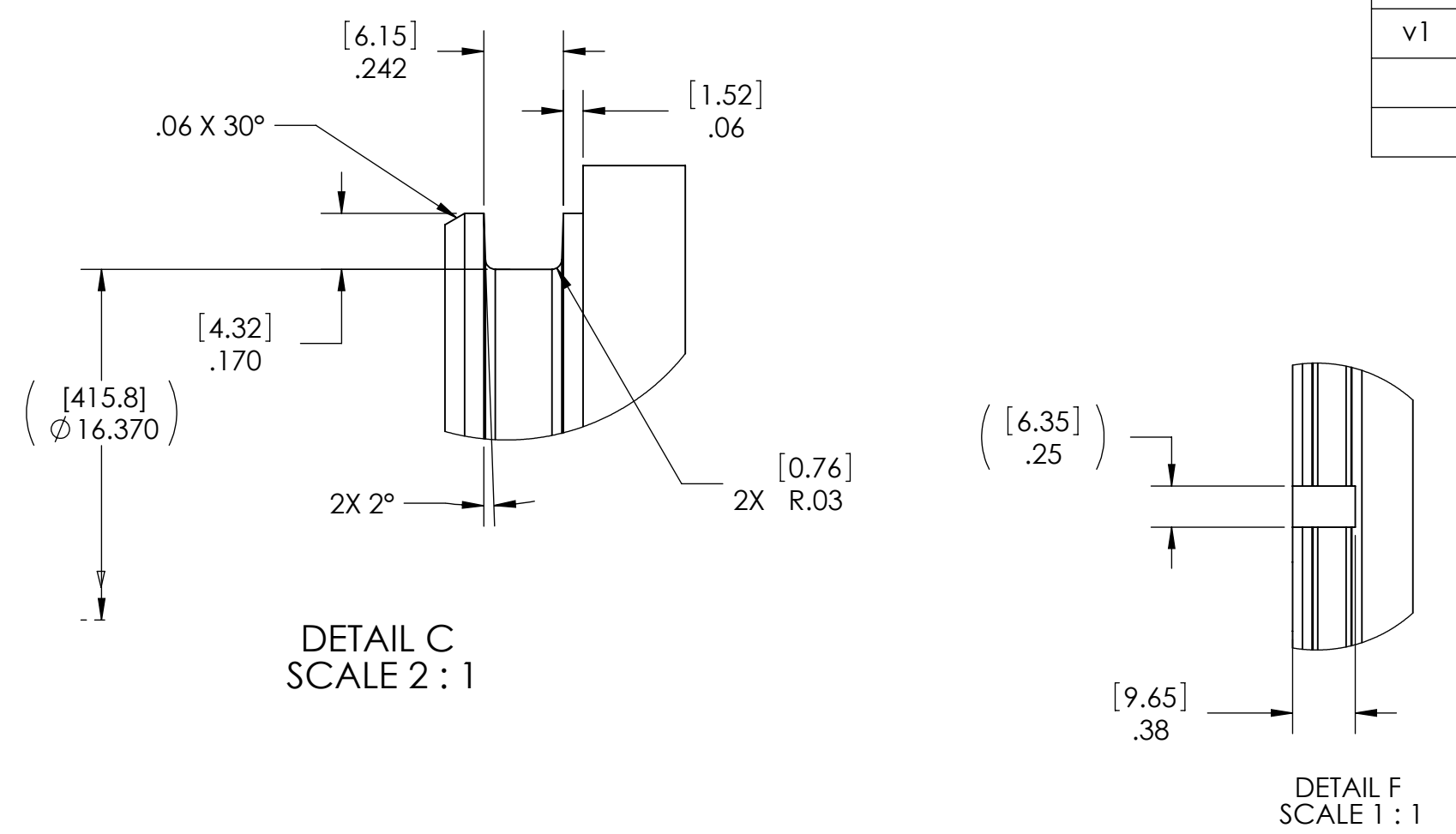
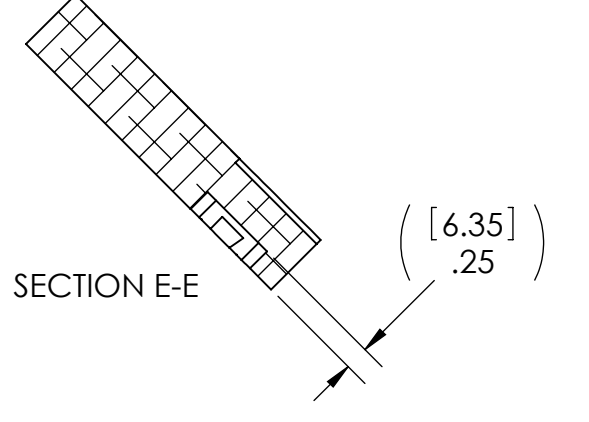
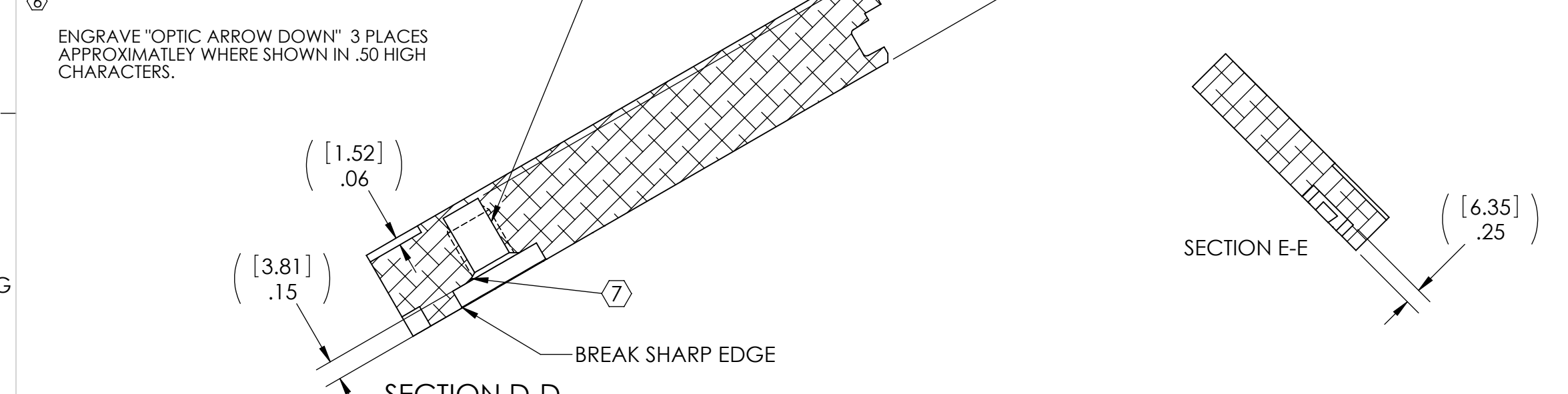
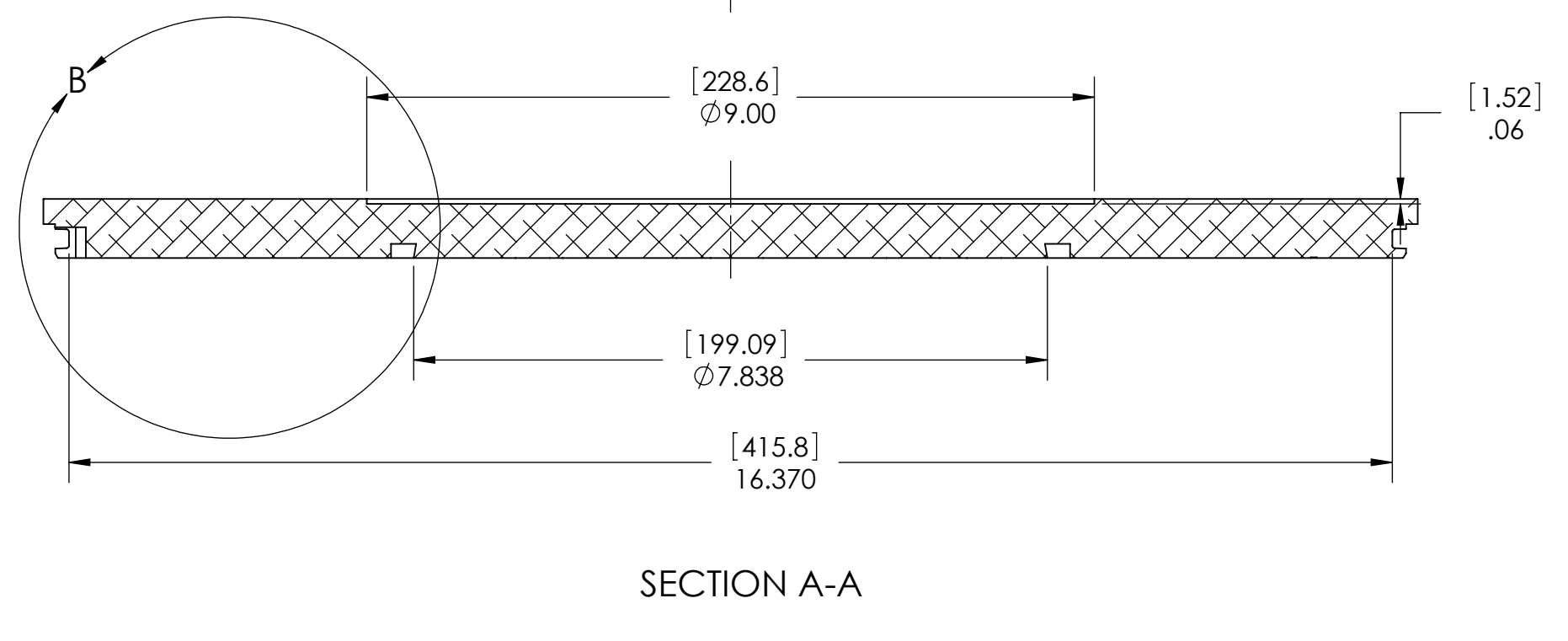
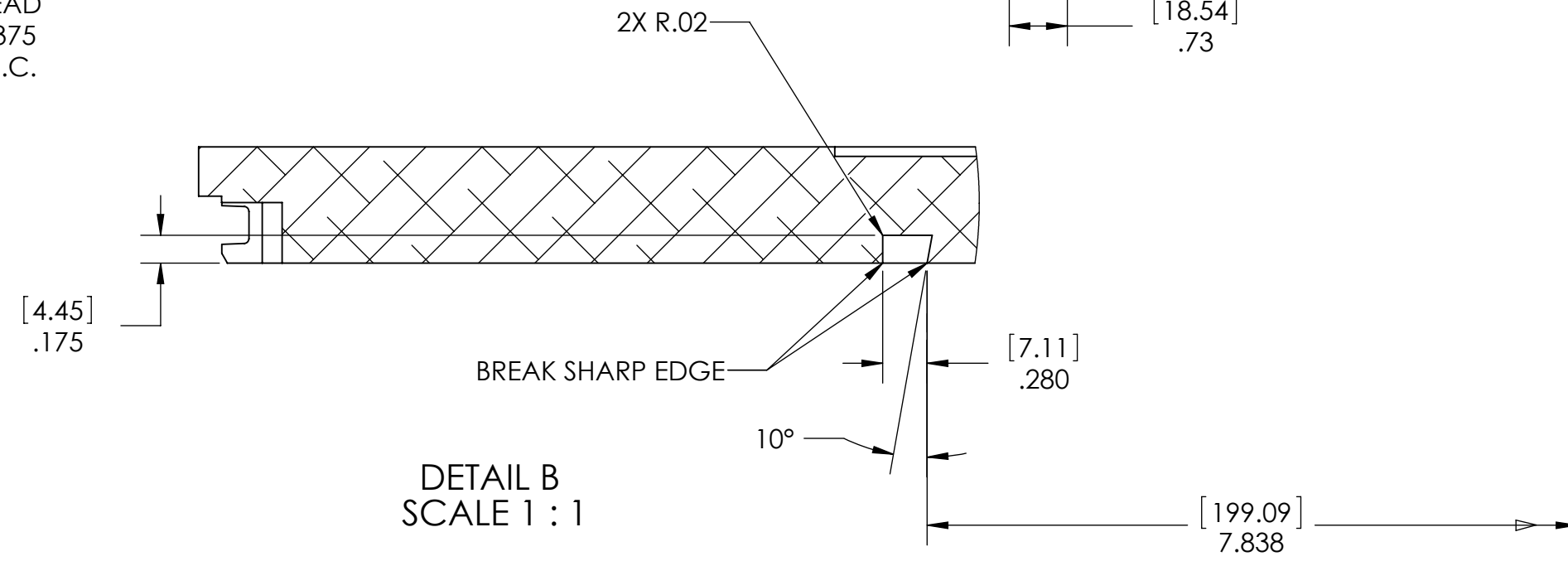


| REV. | DATE | DCN # | DRAWING TREE # |
|------|-------------|-------|----------------|
| v1 | 13 JUN 2013 | | |

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) ENGRAVE "OPTIC ARROW DOWN" 3 PLACES APPROXIMATELY WHERE SHOWN IN .50 HIGH CHARACTERS.



3X DRILL ∇ .68
 ∇ Ø .755 ± .003 ∇ .150
 TAP FOR 3/8-16 X .440 DEEP FULL THREAD FOR N60 HELICOIL INSERT #1185-6EN375 EQUALLY SPACED ON A 9.721 ± .005 B.C.
 (6) Ø .010 A



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 OR CONTACTING

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)
 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.

DIMENSIONS ARE IN INCHES [MM]
 TOLERANCES:
 .XX ± .01
 .XXX ± .005
 ANGULAR ± 0.5°

| | | | |
|----------|------------|--------|----------|
| MATERIAL | 6061-T6 Al | FINISH | 63 µinch |
|----------|------------|--------|----------|

| | | | | | | | | | |
|---|----------|------------|-----|-----------------------------------|-------------|-------------|------------|-------------|--------------|
| CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY | | PART NAME | | BASE PLATE, 220mm OPTIC CONTAINER | | | | | |
| SYSTEM | KAGRA | SUB-SYSTEM | N/A | DESIGNER | K. BUCKLAND | 13 JUN 2013 | SIZE | DWG. NO. | REV. |
| NEXT ASSY | D1300539 | CHECKER | | DRAFTER | K. BUCKLAND | 13 JUN 2013 | D | D1300546 | v1 |
| | | | | APPROVAL | | | SCALE: 1:2 | PROJECTION: | SHEET 1 OF 1 |

D1300546 KAGRA - BASE PLATE, 220mm OPTIC CONTAINER - PART PDM REV: X-001 - DRAWING PDM REV: X-001