



90°

.02 x 45 deg.
chamf

Modify 10-32 x 3/4 Lg. set screw as shown

ref. make 3 per assembly

NOTES: (UNLESS OTHERWISE SPECIFIED)

Liquid contaminants/Machining Lubricants
Liquids containing hydrocarbons or other contaminants, other than the machining fluids specified herein, shall not be allowed to come into contact with suspension material at any time. All machining fluids shall be water soluble and free of sulfur, chlorine and silicone; such as Cincinnati Milacron's Cimtech 410 (stainless steel).

Identification_Serial Number
A serial number shall be etched, or scribed on the part see note drawing note.

Serial Number Format
The Serial number shall be of the format:
D99xxxx-x-001

Example: D990021-A-001
The drawing number, The revision number, The sequential part number

BAG AND TAG PARTS

REF.	QTY.	PART or DRWG No.	NOMENCLATURE or DESCRIPTION	MATERIAL
PARTS and MATERIAL LIST				
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES				
TOLERANCES:		THREE PLACE DECIMAL ± .005		
FRACTIONAL ± 1/16		FINISHED SURFACE RMS 6.3		
ANGULAR ± .25°		BREAK CORNERS IN: .015 OUT: .015		
ANGULAR MACH ± BEND ±		REMOVE ALL BURRS		
TWO PLACE DECIMAL ± .01				
MATERIAL:	McMASTER 92311A431	HEAT TREAT:	/	FINISH:
DWG. NO.	REFERENCE DRAWINGS	USED ON: XXX	NEXT ASS'Y: XXX	
A			FOR FABRICATION	kenn 1/14/00
00			PRE-RELEASE	- -
REV	DESCRIPTION	DCN NUMBER	-	APPR'D CHECK DRWN DATE
ISSUE DESCRIPTION				
SCALE 2X				SHEET
CAD FILE D000010-A				SIZE DWG. NO. B D000010-A
LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY				
PRIMARY MIRROR CENTERING SCREW				