



NOTES: (UNLESS OTHERWISE SPECIFIED)

1. INTERPRET DRAWINGS PER ANSI Y14.5M-1982
2. INSTALL ITEM 2 (THREAD INSERT) FROM FAR SIDE, TO WITHIN 1/4 THREAD PITCH FLUSH WITH NEAR END OF TAPPED HOLE, NO PROTRUSION. ALTER LENGTH FLUSH WITH FAR SIDE WITHIN 1/2 THREAD PITCH, NO PROTRUSION.
3. FOR VENDOR INFORMATION, SEE TOP ASSEMBLY MATERIALS LIST D970006 OR D970007.

REF	QTY	PART or DRWG No.	NOMENCLATURE OR DESCRIPTION	MATERIAL
3	2	SPECIAL-T #KN420J	LT. WT. THD. "KEENSERT" 1/4-20 X 5/8	STAINLESS STEEL
2	2	EMHART FST #1185-4CN625	THREAD INSERT "HELI-COIL" 1/4-20 X 5/8	STAINLESS STEEL
1	1	-	.75 X 2.50 RECTANGULAR BAR	(SEE MAT'L/H.T. BLKS)
PARTS and MATERIAL LIST				

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES

TOLERANCES:
FRACTIONAL ±
ANGULAR ± 0.5°
ANGULAR MACH ± BEND ±
TWO PLACE DECIMAL ± .03

THREE PLACE DECIMAL ± .005
FINISHED SURFACE 32 MICROINCH AVERAGE
BREAK CORNERS IN "DUT" .005-.010
REMOVE ALL BURRS

MATERIAL:
6061 ALU BAR
PER QQ-A-225/8

HEAT TREAT:
T6 PER AMS 2770

FINISH:

USED ON:
NEXT ASS'Y: D961444

REV	DESCRIPTION	DCC	SYS	DET	CDS	VE	CC	BT	CHECK	DRWN	DATE
A	DCN No. E960157										
00	RELEASE FOR FAB										

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

LARGE CORE OPTIC COMPONENT
CARRIER HINGED STANDOFF

CAD FILE: D961442-Adwg
SCALE: NTS
SIZE: B
DWG. NO.: D961442-A-D
SHEET: 1 OF 1