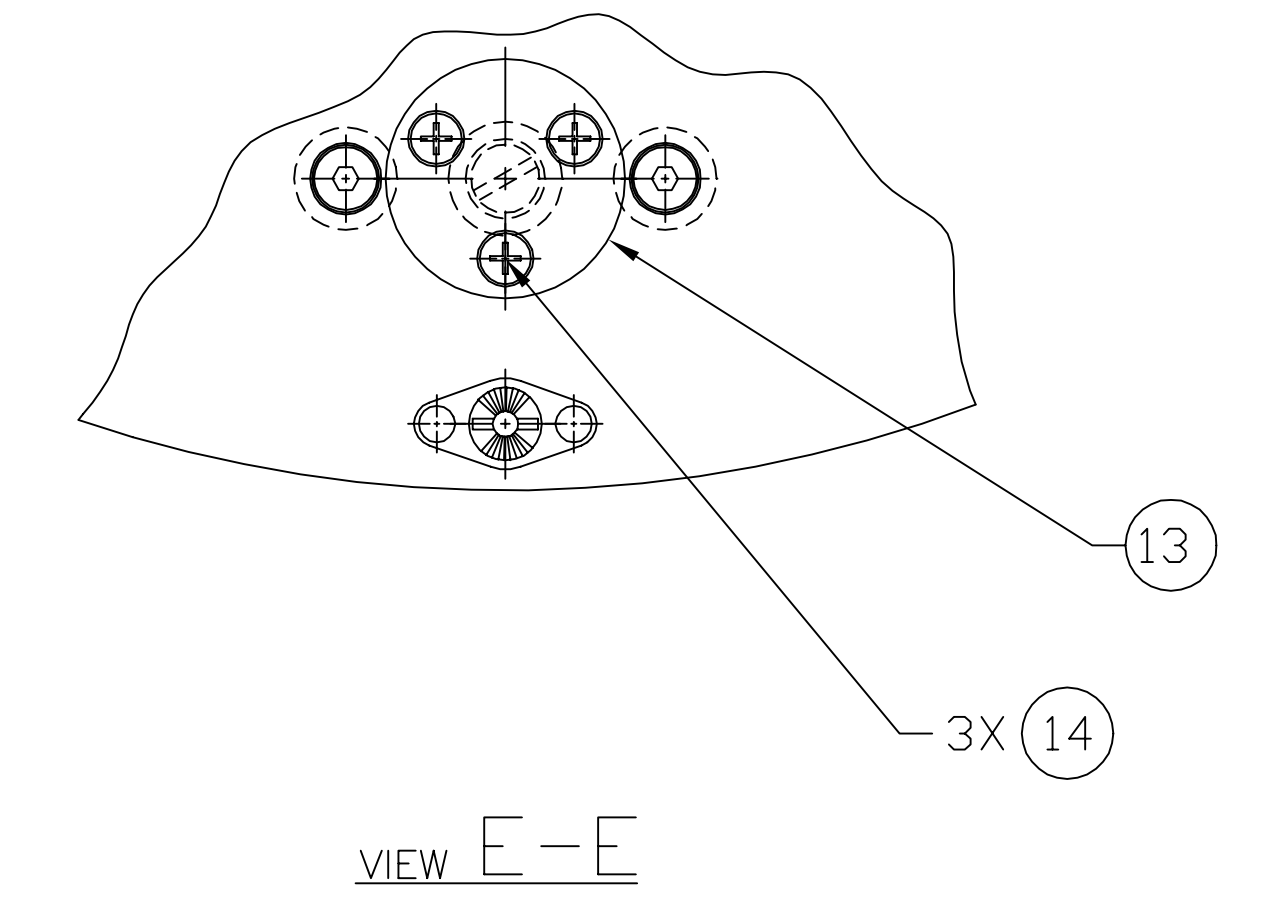


NOTES: (UNLESS OTHERWISE SPECIFIED)
 1. SEE SEPARATE MATERIALS LIST D970006 FOR PARTS, MATERIALS, & VENDOR INFORMATION.

⚠ TORQUE ITEM 9 (SCREW) TO 70-75 in-lb.

⚠ TO INSTALL ITEM 5 (TOP PLATE ASSEMBLY), BACK OFF THE 2 MOUNTING SCREWS (SEE SECTION C-C) FOR EACH OF THE 3 CAPTIVE SCREW BRACKET SUB ASSEMBLIES (D961471 & D961472), UNTIL THE LOCK WASHERS ARE FREE OF COMPRESSION. SET ITEM 5 IN PLACE AND TORQUE THE CAPTIVE SCREWS (6 TOT) TO 65-70 in-lb. THEN, RE-TORQUE THE CAPTIVE SCREW BRACKET MOUNTING SCREWS TO 65-70 in-lb WHILE ITEM 5 REMAINS MOUNTED. REMOVE ITEM 5 FOR NEXT OPERATION, SEE NOTE 4.

⚠ AFTER REMOVING ITEM 5, REMOVE CAPTIVE SCREWS (6 TOT), BY REMOVING WIRE RETAINING RING FROM SHANK USING PLIERS) FROM ITEM 5 AND INSTALL ITEM 7 (EXPANSION PLUG) USING D970004 EXPANSION PLUG INSTALLATION TOOL. DO NOT MAR BOTTOM SURFACE OF ITEM 5 WITH ANVIL. INSTALLATION TOOL MAY BE MODIFIED AS NECESSARY FOR PROPER COMPRESSION OF EXPANSION PLUG BY CUTTING BACK SHOULDER. FINALLY, REPLACE CAPTIVE SCREWS.



DWG. NO.		DESCRIPTION		REFERENCE DRAWINGS	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN FEET (cm)		TOLERANCES: FRACTIONAL # ANGULAR/RADIUS # BEND # THREE PLACE DECIMAL # FINISHED SURFACE, ANG. DUTY BREAK CORNERS ON REMOVE ALL BURNS		DO NOT SCALE THIS DRAWING		USED ON:		NEXT ASS'Y: N/A		REV		DESCRIPTION		ISSUE DESCRIPTION		DCC		SYS		DET		CDS		VE		CC		BT		DRWN		CHECK		DATE		SCALE		NTS		SHEET		1 OF 1	

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**LARGE CORE OPTIC COMPONENT
 CARRIER ASSEMBLY**

CAD FILE: D961460-B.dwg
 SIZE: E
 DWG. NO.: D961460-B-D
 SHEET: 1 OF 1